

STATE OF FLORIDA  
DEPARTMENT OF ENVIRONMENTAL PROTECTION  
NOTICE OF FINAL PERMIT

In the Matter of an  
Application for Permit by:

Aaron P. Corkum, Plant Manager  
Cutrale Citrus Juices USA, Inc.  
602 McKean Street  
Auburndale, Florida 33823

DEP File No. 1050023-014-AC  
Auburndale Facility, Fifth WHE  
Polk County

Enclosed is Final Permit Number 1050023-014-AC. This permit authorizes Cutrale Citrus Juices USA, Inc. to construct a fifth waste heat evaporator and make related changes to provide for the connection of the two existing citrus peel dryers to five waste heat evaporators, connected in parallel through common inlet and exit flue gas manifolds, with exhaust directed to a new stack. This permit is issued pursuant to Chapter 403, Florida Statutes.

Any party to this order has the right to seek judicial review of it under section 120.68 of the Florida Statutes, by filing a notice of appeal under rule 9.110 of the Florida Rules of Appellate Procedure with the clerk of the Department of Environmental Protection in the Office of General Counsel, Mail Station #35, 3900 Commonwealth Boulevard, Tallahassee, Florida, 32399-3000, and by filing a copy of the notice of appeal accompanied by the applicable filing fees with the appropriate District Court of Appeal. The notice must be filed within thirty days after this order is filed with the clerk of the Department.

Executed in Tallahassee, Florida.

  
for C. H. Fancy, P.E., Chief  
Bureau of Air Regulation

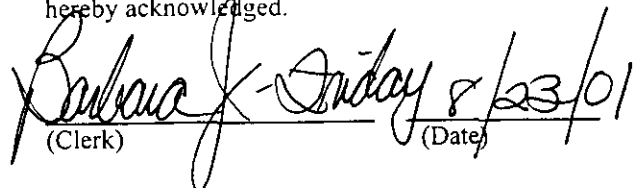
CERTIFICATE OF SERVICE

The undersigned duly designated deputy agency clerk hereby certifies that this Notice of Final Permit (including the Final permit) was sent by certified mail (\*) and copies were mailed by U.S. Mail before the close of business on 8/23/01 to the person(s) listed:

Aaron P. Corkum \*  
Kenneth E. Given, P.E., Air Testing & Consulting  
Bill Thomas, P.E., DEP SW District

Clerk Stamp

**FILING AND ACKNOWLEDGMENT FILED**, on this date, pursuant to §120.52, Florida Statutes, with the designated Department Clerk, receipt of which is hereby acknowledged.

  
(Clerk) 8/23/01 (Date)

| SENDER: COMPLETE THIS SECTION  | COMPLETE THIS SECTION ON DELIVERY   |
|--|---|
| <ul style="list-style-type: none"> <li>Complete items 1, 2, and 3. Also complete item 4 if Restricted Delivery is desired.</li> <li>Print your name and address on the reverse so that we can return the card to you.</li> <li>Attach this card to the back of the mailpiece, or on the front if space permits.</li> </ul> | <p>A. Received by (Please Print Clearly) <i>Patricia J Neupert</i> B. Date of Delivery <i>8-25</i></p>  |
| <p>1. Article Addressed to:</p> <p>Aaron P. Corkum, Plant Mgr.<br/>Cutrale Citrus Juices USA<br/>602 Mc Kean St.<br/>Auburndale, FL 33823</p>  | <p>C. Signature <i>Patricia J Neupert</i> <input checked="" type="checkbox"/> Agent <input type="checkbox"/> Addressee</p>  |
| <p>2. Article Number (Copy from service label)<br/>7000 0600 0026 4129 8108</p>  | <p>D. Is delivery address different from item 1? <input type="checkbox"/> Yes<br/>If YES, enter delivery address below: <input type="checkbox"/> No</p>   |
| <p>PS Form 3811, July 1999</p>   | <p>3. Service Type<br/> <input checked="" type="checkbox"/> Certified Mail <input type="checkbox"/> Express Mail<br/> <input type="checkbox"/> Registered <input type="checkbox"/> Return Receipt for Merchandise<br/> <input type="checkbox"/> Insured Mail <input type="checkbox"/> C.O.D.</p> <p>4. Restricted Delivery? (Extra Fee) <input type="checkbox"/> Yes</p> <p>Domestic Return Receipt <span style="float: right;">102595-99-M-1789</span></p> |

| <b>U.S. Postal Service</b><br><b>CERTIFIED MAIL RECEIPT</b><br><i>(Domestic Mail Only; No Insurance Coverage Provided)</i>  |                                       |    |               |  |  |  |   |  |                                 |           |                          |
|---|---------------------------------------|----|---------------|--|--|--|---|--|---------------------------------|-----------|--------------------------|
| 7000 0600 0026 4129 8108  | <p>Aaron P. Corkum, Plant Manager</p> |    |               |  |  |  |   |  |                                 |           |                          |
| <table border="1"> <tr> <td>Postage</td> <td>\$</td> </tr> <tr> <td>Certified Fee</td> <td></td> </tr> <tr> <td>Return Receipt Fee<br/>(Endorsement Required)</td> <td></td> </tr> <tr> <td>Restricted Delivery Fee<br/>(Endorsement Required)</td> <td></td> </tr> <tr> <td><b>Total Postage &amp; Fees</b></td> <td><b>\$</b></td> </tr> </table> | Postage                               | \$ | Certified Fee |  | Return Receipt Fee<br>(Endorsement Required) |  | Restricted Delivery Fee<br>(Endorsement Required) |  | <b>Total Postage &amp; Fees</b> | <b>\$</b> | <p>Postmark<br/>Here</p> |
| Postage   | \$                                    |    |               |  |  |  |   |  |                                 |           |                          |
| Certified Fee   |                                       |    |               |  |  |  |   |  |                                 |           |                          |
| Return Receipt Fee<br>(Endorsement Required)  |                                       |    |               |  |  |  |   |  |                                 |           |                          |
| Restricted Delivery Fee<br>(Endorsement Required)   |                                       |    |               |  |  |  |   |  |                                 |           |                          |
| <b>Total Postage &amp; Fees</b>   | <b>\$</b>                             |    |               |  |  |  |   |  |                                 |           |                          |
| <p>Recipient's Name (Please Print Clearly) (to be completed by mailer)<br/>           Cutrale Citrus Juices USA, Inc.<br/> <small>Street, Apt. No., or P.O. Box No.</small><br/>           602 McKean St.<br/> <small>City, State, ZIP</small><br/>           Auburndale, FL 33823</p>  |                                       |    |               |  |  |  |   |  |                                 |           |                          |
| <p>PS Form 3800, February 2000 <span style="float: right;">See Reverse for Instructions</span></p>  |                                       |    |               |  |  |  |   |  |                                 |           |                          |

## TECHNICAL EVALUATION AND DETERMINATION

### 1 APPLICANT NAME AND ADDRESS

Cutrale Citrus Juices USA, Inc., Auburndale Facility  
602 McKean Street  
Auburndale, Florida 33823

Authorized Representative: Aaron P. Corkum, Plant Manager

### 2 FACILITY DESCRIPTION, PROJECT DETAILS AND RULE APPLICABILITY

The facility is an existing citrus juice processing facility. The project is the installation of a fifth waste heat evaporator (WHE) to the existing four WHEs that are associated with the two existing citrus peel dryers 1 and 2 (previously emissions units 001 and 003, respectively). The five WHEs, with a combined heat recovery rating of 276,000 lb/hr of water (evaporation rate), will be combined in parallel through common exhaust manifolds, with gas flow regulated by variable frequency drive ID fans for each WHE. The exhaust from all WHEs will be combined and directed to a new 68 inch diameter stack. As with the existing WHEs, the proposed WHE E will include a water spray system to clean the evaporator walls and serve to reduce emissions of particulate matter.

There is no increase in annual potential emissions associated with this project. The applicant indicated that the purpose of this project is to increase heat recovery and provide flexibility of operation. Emissions of particulate matter may decrease because of the additional scrubber capacity associated with the proposed fifth WHE. However, the owner or operator will be allowed to operate with a minimum of two WHEs operating for each dryer in operation, subject to the limitations of the permit discussed further below. Allowable emissions of particulate matter will be reduced from 65.8 lb/hr (288.2 tons/year) to 36.72 lb/hr (160.8 tons/year).

The conditions of the permit shall revise and supplement conditions imposed by previous permitting actions, particularly the current valid Title V permit, number 1050023-002-AV. Except for the conditions of the permit, no other conditions of previous permitting actions shall be changed by this permitting action. This project results in the creation of a new emissions unit:

| EMISSIONS UNIT NO. | EMISSIONS UNIT DESCRIPTION                                  |
|--------------------|---|
| 013                | Citrus peel dryers 1 and 2 with five waste heat evaporators |

This emissions unit is composed of two citrus peel dryers, dryers 1 and 2, and their respective waste heat evaporators (WHEs), which were formerly emissions units 001 and 003, respectively. The two citrus peel dryers will be connected through a common manifold to five WHEs, with exhaust exiting a common 68-inch diameter stack, and this combination of process equipment will now be considered one emissions unit, with a new identifying number.

Citrus peel dryer 1 has a design water removal capacity of 60,000 lb/hr, and a maximum process input rate of 55 tons/hr of pressed peel. The peel dryer's furnace is fired with natural gas, or fuel oil with a maximum sulfur content of 1.95% by weight, at a maximum heat input rate of 90.0 mmBtu/hr. Citrus peel dryer 2 has a design water removal capacity of 60,000 lb/hr, and a maximum process input rate of 55 tons/hr of pressed peel. The peel dryer's furnace is fired with natural gas, or fuel oil with a maximum sulfur content of 1.95% by weight, at a maximum heat input rate of 90.0 mmBtu/hr. The exhaust gas from the peel dryers will now be sent via a common manifold to WHEs A/B, with a design water removal capacity of 106,000 lb/hr; WHE C, with a design water removal capacity of 50,000 lb/hr; WHE D, with a design water removal capacity of 60,000 lb/hr; and the new WHE E, with a design water removal

## TECHNICAL EVALUATION AND DETERMINATION

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capacity of 60,000 lb/hr. Each WHE functions as an indirect heat exchanger to drive moisture from the press liquor (from the peel presses), and also acts as a particulate scrubber control device.

The proposed project is subject to preconstruction review requirements under the provisions of Chapter 403, F.S., and Chapters 62-4, 62-204, 62-210, 62-212, 62-296 and 62-297, F.A.C. The existing facility is located in an area designated, in accordance with Rule 62-204.340, F.A.C., as attainment or unclassifiable for the criteria pollutants ozone, PM<sub>10</sub>, carbon monoxide, SO<sub>2</sub>, nitrogen dioxide and lead. This facility is classified as a Major or Title V Source of air pollution because emissions of at least one regulated air pollutant exceeds 100 tons per year (TPY). At this facility potential emissions of PM/PM<sub>10</sub>, NO<sub>x</sub>, SO<sub>2</sub>, CO and VOC exceed 100 TPY.

This facility is not within an industry included in the list of the 28 Major Facility Categories per Table 62-212.400-1 of Chapter 62-212, F.A.C. Because emissions are greater than 250 TPY for at least one criteria pollutant, the facility is also an existing Major Facility with respect to Rule 62-212.400, Prevention of Significant Deterioration (PSD). There is no net increase in emissions of any criteria pollutant as a result of this project. Therefore the project is not subject to PSD requirements of Rule 62-212.400, F.A.C.

An impact analysis was not required for this project because it is subject to the requirements of PSD.

The emissions unit is subject to the requirements of the current valid Title V permit that are not changed by this permitting action. It is also subject to the requirements of the state rules as indicated in this permit. The emissions unit is not subject to any requirements under the New Source Performance Standards, 40 CFR 60, or any NESHAP requirements of 40 CFR 61 or 63.

### 3 COMPLIANCE

The compliance methods are detailed in Section III of the permit. The conditions will specify the operational limitations that are new or have changed as a result of this project. Primarily, the conditions specify the emission testing requirements for this emissions unit: annual testing is required; both dryers must be operating together, at 90 to 100% of capacity, during testing; testing is required while only four of the five WHEs are in operation, to allow the facility the flexibility to operate in the event that one WHE must be taken offline; each year's test will be conducted with a different one of WHEs C, D and E offline; the initial compliance test must be conducted with WHE E operating; and WHEs A/B, which must operate together, cannot be taken offline for any purpose except malfunction.

### 4 PRELIMINARY DETERMINATION

Based on the foregoing technical evaluation of the application and additional information submitted by the applicant and other available information, the Department has made a preliminary determination that the proposed project will comply with all applicable state and federal air pollution regulations. The Department's preliminary determination is to issue the draft permit to allow construction of this project, subject to the terms and conditions of the draft permit.

### 5 FINAL DETERMINATION

The Department distributed a public notice package on July 16, 2001 to allow the applicant to construct the above project. The Public Notice of Intent to Issue was published in the News Chief (Winter Haven) on July 30, 2001.

No comments were received by the Department from the public. Comments were received from the applicant's consultant by letter dated July 30, 2001, requesting changes to allow the facility to operate each dryer with a minimum of two WHEs rather than with four WHEs for both dryers. The number of WHEs in operation must be matched to the number of dryers in operation to assure proper operational

## TECHNICAL EVALUATION AND DETERMINATION

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efficiency. Since it reflects the Department's original intent, the Department made this change in the final permit. The applicant's consultant also advised by telephone call that the facility may not be able to receive and install the WHE E unit before the beginning of the 2001-2002 processing season, but expected to be able to complete the necessary changes to the exhaust manifolds. The final permit includes a minor change in the condition specifying the testing requirements to require that the first compliance test following the installation of WHE E be conducted with WHE E in operation.

### **DETAILS OF THIS ANALYSIS MAY BE OBTAINED BY CONTACTING:**

Joseph Kahn, P.E.  
Department of Environmental Protection  
Bureau of Air Regulation  
Mail Station #5505  
2600 Blair Stone Road  
Tallahassee, Florida 32399-2400  
Telephone: 850/488-0114



# Department of Environmental Protection

Jeb Bush  
Governor

Twin Towers Office Building  
2600 Blair Stone Road  
Tallahassee, Florida 32399-2400

David B. Struhs  
Secretary

## PERMITTEE

Cutrale Citrus Juices USA, Inc.  
Auburndale Facility  
602 McKean Street  
Auburndale, Florida 33823

|            |                   |
|------------|-------------------|
| Permit No. | 1050023-014-AC    |
| Project    | Fifth WHE         |
| SIC No.    | 2033, 2037, 2048  |
| Expires:   | December 31, 2003 |

## Authorized Representative:

Aaron P. Corkum, Plant Manager

## PROJECT AND LOCATION

This permit authorizes Cutrale Citrus Juices USA, Inc. to construct a fifth waste heat evaporator and make related changes to provide for the connection of the two existing citrus peel dryers to five waste heat evaporators, connected in parallel through common inlet and exit flue gas manifolds, with exhaust directed to a new common stack, which replaces the two existing stacks.

This facility is located at 602 McKean Street, Auburndale, Polk County. The UTM coordinates are: Zone 17; 421.6 km E and 3103.7 km N.

## STATEMENT OF BASIS

This construction permit is issued under the provisions of Chapter 403 of the Florida Statutes (F.S.), and the Florida Administrative Code (F.A.C.) Chapters 62-4, 62-204, 62-210, 62-212, 62-296, and 62-297. The above named permittee is authorized to construct the emissions units in accordance with the conditions of this permit and as described in the application, approved drawings, plans, and other documents on file with the Department of Environmental Protection (Department).

## APPENDICES

The attached appendix is a part of this permit:

Appendix GC General Permit Conditions

Howard L. Rhodes, Director  
Division of Air Resources  
Management

**AIR CONSTRUCTION PERMIT**  
**SECTION I. FACILITY INFORMATION**

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**FACILITY AND PROJECT DESCRIPTION**

The facility is an existing citrus juice processing facility. The project is the installation of a fifth waste heat evaporator (WHE) to the existing four WHEs that are associated with the two existing citrus peel dryers 1 and 2 (previously emissions units 001 and 003, respectively). WHEs A/B, with a combined heat recovery rating of 106,000 lb/hr of water (each approximately 53,000 lb/hr), which previously served dryer 1, and WHEs C and D, which have heat recovery ratings of 50,000 and 60,000 lb/hr of water, respectively, will be combined in parallel through common exhaust manifolds with the proposed fifth WHE "E", so that all five WHEs serve both dryers. WHE E has a heat recovery rating of 60,000 lb/hr of water. The exhaust from all WHEs will be combined and directed to a new common 68 inch diameter stack, which will replace the two existing stacks. As with the existing WHEs, the proposed WHE E will include a water spray system to clean the evaporator walls and serve to reduce emissions of particulate matter.

There is no increase in annual potential emissions associated with this project. The applicant indicated that the purpose of this project is to increase heat recovery and provide flexibility of operation. Emissions of particulate matter may decrease because of the additional scrubber capacity associated with the proposed fifth WHE. Allowable particulate matter emissions are being reduced from 65.8 lb/hr (288 tons/yr) to 36.7 lb/hr (161 tons/yr). The facility information, project scope, emissions and rule applicability are further described in the Department's Technical Evaluation and Determination.

**REVIEWING AND PROCESS SCHEDULE**

|               |  |
|---------------|--|
| June 1, 2001  | Received permit application and fee, application considered complete |
| July 16, 2001 | Distributed Notice of Intent to Issue and supporting documents       |
| July 30, 2001 | Notice of Intent published in the News Chief (Winter Haven)          |

**RELEVANT DOCUMENTS**

The documents listed below are the basis of the permit. They are specifically related to this permitting action. These documents are on file with the Department.

- Permit application
- Department's Technical Evaluation and Determination
- Department's Intent to Issue

## AIR CONSTRUCTION PERMIT

### SECTION II. FACILITY-WIDE SPECIFIC CONDITIONS

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The following specific conditions apply to all emissions units at this facility addressed by this permit.

#### ADMINISTRATIVE

1. Regulating Agencies: All documents related to applications for permits to construct or modify the emissions units addressed by this permit should be submitted to the Bureau of Air Regulation (BAR), Florida Department of Environmental Protection, unless otherwise directed by the Department, at Mail Station #5505, 2600 Blair Stone Road, Tallahassee, Florida 32399-2400, phone number 850/488-0114. All documents related to permits to operate, reports, tests, and notifications shall be submitted to the Department's Southwest District office at 3804 Coconut Palm Drive, Tampa, Florida 33619-8218, and phone number 813-744-6100. [See also condition 8 for specific requirements related to apply for a modification to the Title V operation permit.]
2. General Conditions: The owner and operator is subject to and shall operate under the attached General Permit Conditions G.1 through G.15 listed in Appendix GC of this permit. General Permit Conditions are binding and enforceable pursuant to Chapter 403 of the Florida Statutes. [Rule 62-4.160, F.A.C.]
3. Terminology: The terms used in this permit have specific meanings as defined in the corresponding chapters of the Florida Administrative Code.
4. Applicable Regulations, Forms and Application Procedures: Unless otherwise indicated in this permit, the construction and operation of the subject emissions unit shall be in accordance with the capacities and specifications stated in the application. The facility is subject to all applicable provisions of Chapter 403, F.S. and Florida Administrative Code Chapters 62-4, 62-110, 62-204, 62-210, 62-212, 62-213, 62-296, 62-297 and the Code of Federal Regulations Title 40, Part 60, adopted by reference in the Florida Administrative Code (F.A.C.) regulations. The permittee shall use the applicable forms listed in Rule 62-210.900, F.A.C. and follow the application procedures in Chapter 62-4, F.A.C. Issuance of this permit does not relieve the facility owner or operator from compliance with any applicable federal, state, or local permitting or regulations. [Rules 62-204.800, 62-210.300 and 62-210.900, F.A.C.]
5. New or Additional Conditions: Pursuant to Rule 62-4.080, F.A.C., for good cause shown and after notice and an administrative hearing, if requested, the Department may require the permittee to conform to new or additional conditions. The Department shall allow the permittee a reasonable time to conform to the new or additional conditions, and on application of the permittee, the Department may grant additional time. [Rule 62-4.080, F.A.C.]
6. Expiration: This air construction permit shall expire on December 31, 2003. The permittee, for good cause, may request that this construction permit be extended. Such a request shall be submitted to the Department's Bureau of Air Regulation prior to 60 days before the expiration of the permit. [Rules 62-210.300(1), 62-4.070(4), 62-4.080, and 62-4.210, F.A.C.]
7. Modifications: No emissions unit or facility subject to this permit shall be constructed or modified without obtaining an air construction permit from the Department. Such permit must be obtained prior to the beginning of construction or modification. [Rules 62-210.300(1) and 62-212.300(1)(a), F.A.C.]



## AIR CONSTRUCTION PERMIT

### SECTION II. FACILITY-WIDE SPECIFIC CONDITIONS

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8. Title V Operation Permit Required: This permit authorizes construction and/or installation of the permitted emissions unit and initial operation to determine compliance with Department rules. A revision to the Title V operation permit is required for regular operation of the permitted emissions unit. The owner or operator shall apply for a Title V operation permit at least ninety days prior to expiration of this permit, but no later than 180 days after commencing operation. To apply for a Title V operation permit, the applicant shall submit the appropriate application form, compliance test results, and such additional information as the Department may by law require. The application shall be submitted to the Department's Southwest District office. [Rules 62-4.030, 62-4.050, 62-4.220, and Chapter 62-213, F.A.C.]

[Note: To provide for sufficient time to process the revision to the Title V operation permit, the owner or operator is encouraged to make application at least 180 days prior to expiration date of this permit.]

#### OPERATIONAL REQUIREMENTS

9. Plant Operation - Problems: If temporarily unable to comply with any of the conditions of the permit due to breakdown of equipment or destruction by hazard of fire, wind or by other cause, the permittee shall immediately notify the Department's Southwest District office. The notification shall include pertinent information as to the cause of the problem, and what steps are being taken to correct the problem and to prevent its recurrence, and where applicable, the owner's intent toward reconstruction of destroyed facilities. Such notification does not release the permittee from any liability for failure to comply with Department rules. [Rule 62-4.130, F.A.C.]
10. Circumvention: No person shall circumvent any air pollution control device or allow the emission of air pollutants without the applicable air pollution control device operating properly. [Rule 62-210.650, F.A.C.]
11. Excess Emissions: This permit does not change any authorization for excess emissions provided by other Department permits for all emissions units at this facility addressed by this permit. [Rules 62-4.070(3) and 62-210.700, F.A.C.]

#### COMPLIANCE MONITORING AND TESTING REQUIREMENTS

12. Determination of Process Variables: [Rule 62-297.310(5), F.A.C.]
- (a) Required Equipment. The owner or operator of an emissions unit for which compliance tests are required shall install, operate, and maintain equipment or instruments necessary to determine process variables, such as process weight input or heat input, when such data are needed in conjunction with emissions data to determine the compliance of the emissions unit with applicable emission limiting standards.
- (b) Accuracy of Equipment. Equipment or instruments used to directly or indirectly determine process variables, including devices such as belt scales, weight hoppers, flow meters, and tank scales, shall be calibrated and adjusted to indicate the true value of the parameter being measured with sufficient accuracy to allow the applicable process variable to be determined within 10% of its true value.

**AIR CONSTRUCTION PERMIT**  
**SECTION II. FACILITY-WIDE SPECIFIC CONDITIONS**

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**REPORTING AND RECORD KEEPING REQUIREMENTS**

13. Duration of Record Keeping: Upon request, the permittee shall furnish all records and plans required under Department rules. During enforcement actions, the retention period for all records will be extended automatically unless otherwise stipulated by the Department. The permittee shall hold at the facility or other location designated by this permit records of all monitoring information (including all calibration and maintenance records and all original strip chart recordings for continuous monitoring instrumentation) required by the permit, copies of all reports required by this permit, and records of all data used to complete the application for this permit. These materials shall be retained at least five years from the date of the sample, measurement, report, or application unless otherwise specified by Department rule. [Rules 62-4.160(14)(a)&(b) and 62-213.440(1)(b)2.b., F.A.C.]
14. Excess Emissions Report: In case of excess emissions resulting from malfunction, the owner or operator shall notify the Department's Southwest District office within one working day of: the nature, extent, and duration of the excess emissions; the cause of the excess emissions; and the actions taken to correct the problem. In addition, the Department may request a written summary report of the incident. A full written report on the malfunctions shall be submitted in a quarterly report if requested by the Department. [Rules 62-4.130 and 62-210.700(6), F.A.C.]
15. Annual Operating Report for Air Pollutant Emitting Facility: The Annual Operating Report for Air Pollutant Emitting Facility shall be completed each year and shall be submitted to the Department's Southwest District office and, if applicable, the appropriate local program by March 1 of the following year. [Rule 62-210.370(3), F.A.C.]

**AIR CONSTRUCTION PERMIT**

**SECTION III. EMISSIONS UNITS SPECIFIC CONDITIONS**

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The following specific conditions apply to the following emissions unit after construction. These conditions shall revise and supplement conditions imposed by previous permitting actions. Except for the conditions of this section, no other conditions of previous permitting actions shall be changed by this permit.

| EMISSIONS UNIT NO. | EMISSIONS UNIT DESCRIPTION                                  |
|--------------------|---|
| 013                | Citrus peel dryers 1 and 2 with five waste heat evaporators |

[Note: This emissions unit is composed of two citrus peel dryers, dryers 1 and 2, and their respective waste heat evaporators (WHEs), which were formerly emissions units 001 and 003, respectively. The two citrus peel dryers will be connected through a common manifold to five WHEs, with exhaust exiting a common 68-inch diameter stack which will replace the two existing stacks, and this combination of process equipment will now be considered one emissions unit, with a new identifying number.

Citrus peel dryer 1 has a design water removal capacity of 60,000 lb/hr, and a maximum process input rate of 55 tons/hr of pressed peel. The peel dryer's furnace is fired with natural gas, or fuel oil with a maximum sulfur content of 1.95% by weight, at a maximum heat input rate of 90.0 mmBtu/hr. Citrus peel dryer 1 is located to the south of citrus peel dryer 2. Citrus peel dryer 2 has a design water removal capacity of 60,000 lb/hr, and a maximum process input rate of 55 tons/hr of pressed peel. The peel dryer's furnace is fired with natural gas, or fuel oil with a maximum sulfur content of 1.95% by weight, at a maximum heat input rate of 90.0 mmBtu/hr. The exhaust gas from the peel dryers will now be sent via a common manifold to WHEs A/B, with a combined design water removal capacity of 106,000 lb/hr (each approximately 53,000 lb/hr); WHE C, with a design water removal capacity of 50,000 lb/hr; WHE D, with a design water removal capacity of 60,000 lb/hr; and the new WHE E, with a design water removal capacity of 60,000 lb/hr. Each WHE functions as an indirect heat exchanger to drive moisture from the press liquor (from the peel presses), and also acts as a particulate scrubber control device.

The following conditions will specify the operational limitations that are new or have changed as a result of this project. Primarily, the conditions specify the emission testing requirements for this emissions unit: annual testing is required; both dryers must be operating together, at 90 to 100% of capacity, during testing; testing is required while only four of the five WHEs are in operation, to allow the facility the flexibility to operate both dryers in the event that one WHE must be taken offline; each year's test will be conducted with a different one of the WHEs offline; and the first compliance test conducted after the installation of WHE E must be conducted with WHE E operating. This emissions unit is subject to the requirements of the current valid Title V permit that are not changed by this permit, and to the requirements of the state rules as indicated in this permit.]

**OPERATIONAL REQUIREMENTS**

1. Hours of Operation: This emissions unit may operate up to 8,760 hours/year. [Rules 62-4.070(3) and 62-210.200, F.A.C., and limitation on potential to emit]
2. Process Input Capacity Limited: The process input capacity of this emissions unit shall be limited to 110 tons of pressed peel per hour, based on a daily average, with each dryer further limited to 55 tons of pressed peel per hour, based on a daily average. [Rules 62-4.070(3) and 62-210.200, F.A.C., and limitation on potential to emit]

## AIR CONSTRUCTION PERMIT

### SECTION III. EMISSIONS UNITS SPECIFIC CONDITIONS

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3. Methods of Operation: The heat input capacity of this emissions unit shall be limited to 180.0 mmBtu per hour, based on a daily average, with each dryer further limited to 90.0 mmBtu/hr, based on a daily average. This emission unit shall be fired with natural gas or new fuel oil with a maximum sulfur content of 1.95% by weight. [Rules 62-4.070(3), 62-210.200, F.A.C., and limitation on potential to emit]
4. Operation of WHEs: The owner or operator shall ensure that exhaust gas from the each peel dryer is directed to a minimum of two WHEs during any time that the peel dryer is in operation, and that exhaust from two operating peel dryers is directed to a minimum of four WHEs during any time that the peel dryers are in operation, at any process input rate up to that limited by condition 2 of this section. In the event of malfunction that requires two or more of the WHEs to be taken offline, the owner or operator shall cease to operate one or both citrus peel dryers, as necessary to comply with the operation limits of this condition, as soon as practicable until the malfunction is repaired and normal operation as required by this permit can resume. [Rules 62-4.070(3), F.A.C., to accommodate applicant's request]
5. Visible Emissions Limited: Visible emissions from this emissions unit shall not be equal to or exceed 20 percent opacity. [Rule 62-296.320(4)(b), F.A.C.]
6. Particulate Matter Emissions Limited: The maximum allowable particulate matter emission rate from this emissions unit is limited as set by the Process Weight Table of Rule 62-296.320(4)(a)2., F.A.C., so that, given the maximum allowable process input rate of 110 tons/hr, emissions of particulate matter shall not exceed 36.7 lb/hr. At lesser process input rates, the allowable emission rates shall be determined from the appropriate equations of Rule 62-296.320(4)(a)2., F.A.C. [Rule 62-296.320(4)(a), F.A.C.]

#### COMPLIANCE MONITORING, TESTING, REPORTING AND RECORD KEEPING REQUIREMENTS

7. Emission Tests Required: The owner or operator shall demonstrate compliance with the particulate matter and visible emissions limits for this emissions unit upon commencement of operation of WHE E, and annually thereafter, using EPA Methods 1 through 5 and 9, as described in 40 CFR 60 Appendix A. The visible emission tests shall be conducted for at least 60 minutes and shall coincide with one run of the particulate matter test. The minimum requirements for stack sampling facilities, source sampling and reporting, shall be in accordance with Chapter 62-297, F.A.C., and 40 CFR 60, Appendix A. When using EPA Method 5, an acetone wash shall be used and the minimum sample volume shall be 32 dry standard cubic feet.

The owner or operator shall, prior to the test each year, if requested by the Department's Southwest District office, provide a test protocol and meet with compliance staff to agree on the test methodology and the measurement of process and heat input rates during the test. The test reports shall be submitted to the Air Compliance Section of the Department's Southwest District office within 45 days of such testing.

[Rules 62-4.070(3), 62-296.320(4)(a)3.a.(i), and 62-297.310(4)(a)2., and 62-297.401, F.A.C.]

[Note: The previous test baseline date was January 30 of each year.]

## AIR CONSTRUCTION PERMIT

### SECTION III. EMISSIONS UNITS SPECIFIC CONDITIONS

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8. Testing with Four WHEs in Operation: To allow for the flexibility of operating the citrus peel dryer(s) with up to one of WHEs offline, as provided by condition 4 of this section, the owner or operator shall perform the annual compliance test while only four of the five WHEs are in operation. Each year's test shall be conducted with a different one of WHEs offline. However, the first compliance test following the installation of WHE E shall be conducted with WHE E in operation. [Rule 62-4.070(3), F.A.C., to accommodate applicant's request]
9. Testing at Capacity Required: The owner or operator shall comply with the testing requirements of condition A.8. of the currently valid Title V permit, number 1050023-002-AV, for the citrus peel dryers. No condition of this permit shall be considered to amend the provisions of that condition for this emissions unit, with the following exceptions: Where that condition refers to the citrus peel dryers as two emissions units, they shall now be considered to be process units of one emissions unit. Testing shall be required with both citrus peel dryers in operation simultaneously, each within 90 - 100% of the dryer's maximum allowable process input rate. [Rule 62-4.070(3), F.A.C.]
10. Monitoring, Record Keeping and Reporting Requirements: The owner or operator shall comply with the requirements of conditions A.9. and A.10. of the currently valid Title V permit, number 1050023-002-AV, for the citrus peel dryers. In addition to those requirements, the owner or operator shall make and maintain records sufficient to demonstrate compliance with the process rate and heat input limits of this permit, for both dryers combined. Other than the preceding requirement, no condition of this permit shall be considered to amend the provisions of those conditions for this emissions unit, with the exception that where those conditions refer to the citrus peel dryers as two emissions units, they shall now be considered to be process units of one emissions unit. [Rule 62-4.070(3), F.A.C.]
11. Notification of Construction: The owner or operator shall, within 14 days of the issuance of this permit, provide a proposed construction schedule to the Air Compliance Section of the Department's Southwest District office. The owner or operator shall also provide written notice of the start of the construction activities, if different from the scheduled starting date, and shall provide written notice of commencement of operation, within five days of such commencement. [Rule 62-4.070(3), F.A.C.]
12. Identification of Dryers and WHEs: The owner or operator shall affix a permanent plaque or label on or near each of the citrus peel dryers which will identify which dryer is dryer 1 and which is dryer 2. The owner shall affix a permanent plaque or label on or near each of the waste heat evaporators which will identify which of the WHEs are units A/B, C, D and E. [Rule 62-4.070(3), F.A.C.]

**APPENDIX GC**  
GENERAL PERMIT CONDITIONS [RULE 62-4.160, F.A.C.]

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- G.1 The terms, conditions, requirements, limitations, and restrictions set forth in this permit are "Permit Conditions" and are binding and enforceable pursuant to Sections 403.161, 403.727, or 403.859 through 403.861, Florida Statutes. The permittee is placed on notice that the Department will review this permit periodically and may initiate enforcement action for any violation of these conditions.
- G.2 This permit is valid only for the specific processes and operations applied for and indicated in the approved drawings or exhibits. Any unauthorized deviation from the approved drawings or exhibits, specifications, or conditions of this permit may constitute grounds for revocation and enforcement action by the Department.
- G.3 As provided in Subsections 403.087(6) and 403.722(5), Florida Statutes, the issuance of this permit does not convey and vested rights or any exclusive privileges. Neither does it authorize any injury to public or private property or any invasion of personal rights, nor any infringement of federal, state or local laws or regulations. This permit is not a waiver or approval of any other Department permit that may be required for other aspects of the total project which are not addressed in the permit.
- G.4 This permit conveys no title to land or water, does not constitute State recognition or acknowledgment of title, and does not constitute authority for the use of submerged lands unless herein provided and the necessary title or leasehold interests have been obtained from the State. Only the Trustees of the Internal Improvement Trust Fund may express State opinion as to title.
- G.5 This permit does not relieve the permittee from liability for harm or injury to human health or welfare, animal, or plant life, or property caused by the construction or operation of this permitted source, or from penalties therefore; nor does it allow the permittee to cause pollution in contravention of Florida Statutes and Department rules, unless specifically authorized by an order from the Department.
- G.6 The permittee shall properly operate and maintain the facility and systems of treatment and control (and related appurtenances) that are installed or used by the permittee to achieve compliance with the conditions of this permit, as required by Department rules. This provision includes the operation of backup or auxiliary facilities or similar systems when necessary to achieve compliance with the conditions of the permit and when required by Department rules.
- G.7 The permittee, by accepting this permit, specifically agrees to allow authorized Department personnel, upon presentation of credentials or other documents as may be required by law and at a reasonable time, access to the premises, where the permitted activity is located or conducted to:
- (a) Have access to and copy and records that must be kept under the conditions of the permit;
  - (b) Inspect the facility, equipment, practices, or operations regulated or required under this permit, and,
  - (c) Sample or monitor any substances or parameters at any location reasonably necessary to assure compliance with this permit or Department rules.
- Reasonable time may depend on the nature of the concern being investigated.
- G.8 If, for any reason, the permittee does not comply with or will be unable to comply with any condition or limitation specified in this permit, the permittee shall immediately provide the Department with the following information:
- (a) A description of and cause of non-compliance; and
  - (b) The period of noncompliance, including dates and times; or, if not corrected, the anticipated time the non-compliance is expected to continue, and steps being taken to reduce, eliminate, and prevent recurrence of the non-compliance.

**APPENDIX GC**  
**GENERAL PERMIT CONDITIONS [RULE 62-4.160, F.A.C.]**

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The permittee shall be responsible for any and all damages which may result and may be subject to enforcement action by the Department for penalties or for revocation of this permit.

- G.9 In accepting this permit, the permittee understands and agrees that all records, notes, monitoring data and other information relating to the construction or operation of this permitted source which are submitted to the Department may be used by the Department as evidence in any enforcement case involving the permitted source arising under the Florida Statutes or Department rules, except where such use is prescribed by Sections 403.73 and 403.111, Florida Statutes. Such evidence shall only be used to the extent it is consistent with the Florida Rules of Civil Procedure and appropriate evidentiary rules.
- G.10 The permittee agrees to comply with changes in Department rules and Florida Statutes after a reasonable time for compliance, provided, however, the permittee does not waive any other rights granted by Florida Statutes or Department rules.
- G.11 This permit is transferable only upon Department approval in accordance with Florida Administrative Code Rules 62-4.120 and 62-730.300, F.A.C., as applicable. The permittee shall be liable for any non-compliance of the permitted activity until the transfer is approved by the Department.
- G.12 This permit or a copy thereof shall be kept at the work site of the permitted activity.
- G.13 This permit also constitutes:
- (a) Determination of Best Available Control Technology ( );
  - (b) Determination of Prevention of Significant Deterioration ( ); and
  - (c) Compliance with New Source Performance Standards ( ).
- G.14 The permittee shall comply with the following:
- (a) Upon request, the permittee shall furnish all records and plans required under Department rules. During enforcement actions, the retention period for all records will be extended automatically unless otherwise stipulated by the Department.
  - (b) The permittee shall hold at the facility or other location designated by this permit records of all monitoring information (including all calibration and maintenance records and all original strip chart recordings for continuous monitoring instrumentation) required by the permit, copies of all reports required by this permit, and records of all data used to complete the application or this permit. These materials shall be retained at least three years from the date of the sample, measurement, report, or application unless otherwise specified by Department rule.
  - (c) Records of monitoring information shall include:
    - 1. The date, exact place, and time of sampling or measurements;
    - 2. The person responsible for performing the sampling or measurements;
    - 3. The dates analyses were performed;
    - 4. The person responsible for performing the analyses;
    - 5. The analytical techniques or methods used; and
    - 6. The results of such analyses.
- G.15 When requested by the Department, the permittee shall within a reasonable time furnish any information required by law which is needed to determine compliance with the permit. If the permittee becomes aware that relevant facts were not submitted or were incorrect in the permit application or in any report to the Department, such facts or information shall be corrected promptly.

Florida Department of  
Environmental Protection

Memorandum

TO: Howard L. Rhodes

THRU: ~~Clair Fancy~~  
Al Linero *alg 8/21*

FROM: Joe Kahn *jk*

DATE: August 20, 2001

SUBJECT: Cutrale Citrus Juices USA, Inc., Auburndale Facility  
Addition of Fifth Waste Heat Evaporator  
1050023-014-AC

*BAR*

Attached for approval and signature is a construction permit that authorizes Cutrale Citrus Juices USA, Inc. to construct a fifth waste heat evaporator and make related changes to provide for the connection of the two existing citrus peel dryers to five waste heat evaporators, connected in parallel through common inlet and exit flue gas manifolds, with exhaust directed to a new stack. There is no increase in emissions associated with this project. Allowable PM emissions will decrease. This project is not subject to PSD. The draft permit incorporated comments from the Southwest District office. The final includes minor revisions proposed by the applicant's consultant related to clarifying the requirements for the number of waste heat evaporators and dryers that shall be operated together.

The Public Notice requirements have been met on July 30, 2001 by publishing in the News Chief (Winter Haven).

I recommend your approval and signature.

Day 90 is October 2, 2001.

Attachments

/jk