

COMMONWEALTH OF PENNSYLVANIA
DEPARTMENT OF ENVIRONMENTAL PROTECTION
FIELD OPERATIONS - BUREAU OF AIR QUALITY

OPERATING PERMIT
(Revised 8/1/2001)

In accordance with provisions of the Air Pollution Control Act, the act of January 8, 1960, P.L. 2119, as amended, and after due consideration of an application received under Chapter 127 of the Rules and Regulations of the Department of Environmental Protection, the Department hereby issues this permit for the operation of the air contamination source(s) described below:

Permit No.	<u>OP-23-0014A</u>	Source(s)	<u>Paper Machines and Boilers</u>
Owner	<u>Kimberly-Clark Corporation</u>	Air	<u></u>
Address	<u>Front and Avenue of the States</u>	Cleaning	<u></u>
	<u>Chester, PA 19013</u>	Device	<u></u>
Attention	<u>Mr. Gary Baker</u>	Location	<u>Front and Avenue of the States</u>
	<u>Environmental Manager</u>		<u>City of Chester</u>
			<u>Delaware County</u>

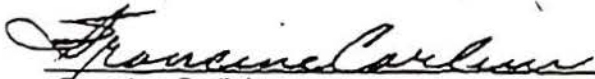
This permit is subject to the following conditions:

1. That the source(s) and any associated air cleaning devices are to be:
 - a. operated in such a manner as not to cause air pollution;
 - b. in compliance with the specifications and conditions of all applicable plan approvals issued;
 - c. operated and maintained in a manner consistent with good operating and maintenance practices.
2. This permit is valid only for the specific equipment, location and owner named above.

(SEE ADDITIONAL CONDITIONS ATTACHED)

Failure to comply with the conditions placed on this permit is a violation of Section 127.444. Violation of this or any other provision of Article III of the Rules and Regulations of the Department of Environmental Protection will result in suspension or revocation of this permit and/or prosecution under Section 9 of the Air Pollution Control Act.

Issued June 24, 1998


Francine Carlini
Regional Manager
Air Quality

cc: Division of Permits, RCSOB
Administration
SEFO
Re 30 (RN01)171-12

AMENDED

OPERATING PERMIT CONDITIONS
PERMIT NO. OP-23-0014A
KIMBERLY-CLARK CORPORATION
(Revised 8/1/2001)

CONDITIONS (continued):

3. This revised Operating Permit is issued to Kimberly-Clark Tissue Company (Kimberly-Clark) for the operation of their NOx and VOC emitting sources located at Front and Avenue of the States, City of Chester, Delaware County.

4. No. 10 Circulating Fluidized Bed Boiler
(Combustion Engineering/Lurgi CFB Boiler)

B. The following fuels are permitted to burn in the No. 10 boiler:

1. Anthracite Culm
2. Anthracite Coal
3. Bituminous Coal
4. Natural Gas
5. No. 6 Fuel oil
6. Petroleum Coke
7. Kimberly-Clark's wastewater treatment sludge
8. No. 2 Fuel oil

No other fuels shall be burned without prior Department approval.

C. The emissions from the boiler shall not exceed the limitations specified below:

Nitrogen Oxides (NOx:)	0.11 lb/MM BTU on a 30-day rolling; average
Volatile Organic Compounds (VOC)	23.94 tons per year as a 12-month rolling sum

E. The company shall retain records of boiler firing rate, type of fuel burned and all stack emissions and monitoring data for a period of five (5) years and make these records available to the Department upon request.

F. Data and information required to determine compliance shall be recorded and maintained in a time frame such that the emission limits prescribed in 4.C. can be calculated and compared.

G. The company shall continue to operate the Continuous In stack Nitrogen Oxide (NOx) monitors at its current installed position and operate and maintain them as approved by the Department.

5. No. 8 and No. 9 Boilers
(Combustion Engineering, Vertical Unit Boiler: Model Nos. 17611 and 13795).

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CONDITIONS (continued):

E. The boiler shall be limited to the following emissions:

	<u>NO_x</u>	<u>VOC</u>
No. 8 Boiler	91.08 lb/hour	9.90 lb/hour

	<u>NO_x</u>	<u>VOC</u>
No. 9 Boiler	114.54 lb/hour	12.45 lb/hour

F. Hours of operation of both the boilers shall be recorded.

G. Fuel meters shall be installed so that compliance with Condition 5.D can be verified.

H. Both boilers shall be operated according to the manufacturer's recommended procedures and good engineering practice.

6. No. 16 Paper Machine
(Two identical burners - Hauck Manufacturing Company, Model No. U1RC-566X)

B. The source is to be operated and maintained in a manner consistent with good operating and maintenance practices.

C. Only natural gas shall be used as fuel in the burners.

E. NO_x emission from this source shall be limited to 0.1 lb/MM Btu (i.e., 19.71 tpy as 12-month rolling sum) and VOC emission shall be limited to 0.54 tpy as 12-month rolling sum.

7. Paper Machine No. 19
(Two burners: Wet end - Urqhart Model No. 5; Dry end - Urqhart Model No. 7)

B. The burners supplying heat to the hood of the paper machine No. 19 are to be fired only with natural gas or No. 2 fuel oil.

C. Emission of Oxides of Nitrogen (NO_x) from this source shall be limited to 0.2 lb/MMBtu (i.e., 99 tpy as 12-month rolling sum) and emission of VOC shall be limited to 1.34 tpy as 12-month rolling sum.

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CONDITIONS (continued):

- D. The company shall perform an annual adjustment or tune-up of the burners. This adjustment shall include, at a minimum, the following:
- (i) Inspection, adjustment, cleaning or replacement of fuel burning equipment, including the burners and moving parts as per manufacturer's specifications.
 - (ii) Inspection of the flame pattern or characteristics and adjustments necessary to minimize total emissions of NOx.
 - (iii) Inspection of the air-to-fuel ratio control system and adjustments necessary to ensure proper calibration and operation as specified by the manufacturer.
- E. The company shall record each adjustment conducted under the procedures outlined above in a permanently bound logbook. This log shall contain, at a minimum, the following information:
- (i) The date of the tuning procedure .
 - (ii) The name of the service company and technicians
 - (iii) The final operating rate or load
 - (iv) The final NOx emission rates
 - (v) The final excess oxygen rate
- F. A meter shall be placed on the fuel line for the burners and oil and natural gas consumption shall be recorded for each month.
10. Paper Machine No. 18
- A. The sources covered are: Rebuilt paper machine No. 18, two (2) drying hood burners manufactured by Maxon Corporation, Model No. Ovenpak EB7 Series, and a wet scrubber manufactured by ABB Drying.
- C. The following paper machine components are covered by this Operating Permit in addition to drying hood burners and a wet scrubber:

Yankee Dryer
Forming Section
Reel Section
Headbox
Machine Drive System
Fan Pump and Screens
Furnish Chest
Steam Shower System
Save All and White Water Collection System

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CONDITIONS (continued):

- (iv) The stack shall be designed and erected with test points located on it such that EPA Reference Test Methods can be carried out.
- (v) The emissions of pollutants from the drying hood burners shall be limited to the following:

Pollutants	Emissions lbs/hr
Non-Methane Total Organic Compound (NMTOC)	0.16
Oxides of Nitrogen (NOx)	4.80

11. Emergency Diesel Generators

(950 kw generator: O'Brien Machinery Company; Model No. OB100k-DW63; 350 kw generator: Cummins Genset Model No. 350DFOC)

- A. Both the generators are to be operated on diesel fuel only.
- B. The generators shall be used, as standby and the operating hours for each generator shall not exceed 500 hours in a consecutive 12-month period.
- C. For this source, the Presumptive RACT emission limitations are the installation, maintenance and operation in accordance with manufacturer's specifications.
- D. The date of the maintenance and name of the service company and technicians shall be recorded in a permanently bound logbook.

12. Hot Water Heaters

(No. 1: Sun Ray Burner Manufacturing Company/Weil McLain Company - Model No. PH034; No. 2: Beckett Burner - Model No. AF-OR-355)

- C. For this source, the Presumptive RACT emission limitations are the installation, maintenance and operation in accordance with manufacturer's specifications.
- D. The date of the maintenance and name of the service company and technicians shall be recorded in a permanently bound logbook.

13. Emergency Fire Pump

(No. 1 - Manufacturer: Chrysler)
(No. 2 - Manufacturer: Detroit - Diesel)

- A. The peak heat input of both the fire pumps shall be 2.8 MM Btu/hr.
- C. Both the fire pumps shall be operated less than 500 hours in a consecutive 12-month period.
- D. The fire pumps shall be used for emergency purposes only besides test runs. The hours of operation shall be recorded in a permanently bound logbook.

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CONDITIONS (continued):

- E. For this source, the Presumptive RACT emission limitations are the installation, maintenance and operation in accordance with manufacturer's specifications.
- F. The date of the maintenance and name of the service company and technicians shall be recorded in a permanently bound logbook.

14. Process Related Emissions:

- A. The emissions of VOC from the different sources at the facility shall be limited to:

- 1. Paper Machine and Pulp Brightening Process Emissions

Process Emission Source	VOC Emission Limit TPY
Paper Machine No. 8	125.0
Paper Machine No. 10	123.6
Paper Machine No. 12	125.0
Paper Machine No. 16	125.0
Paper Machine No. 17	125.0
Paper Machine No. 18	125.0
Paper Machine No. 19	125.0
Pulp Brightening	28.96

- 2. The combined emissions of VOC from paper machine Nos. 8, 10, 12, 16, 17, 18 and 19 shall not exceed 223 tpy as 12-month rolling sum calculated monthly.

4. Tanks and Miscellaneous Sources:

The total emissions of VOC from tanks 036A, 050A, 064A, and 065A, generator tank, building/grounds, and coal yards shall not exceed 4.42 tpy as 12-month rolling sum. Each tank shall be operated with VOC emission rates of no greater than 3 lbs/hr, 15 lbs/day, and 2.7 tons/year.

- B. Kimberly-Clark shall record the following information on a 12 month rolling sum for each paper machine and also for the pulp brightening process and shall make the records available to the Department upon request:
 - 1. The usage rate of biocide, defoamer, release agent, absorbency aid, felt/wire cleaner, Yankee coating, dye fixative, wet strength, charge control, retention aid, bonding agent and dry strength in pounds per month with the generic name of the chemical.
 - 2. The VOC content of each of the chemical compounds in percent by weight.
 - 3. The production in tons per day for each paper machine.
 - 4. The emission of VOC per paper machine in pounds per month.

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CONDITIONS (continued):

15. Recordkeeping and Reporting Requirements

- A. The permittee shall maintain a file containing all the records and other data that are required to be collected to demonstrate compliance with NOx/VOC RACT requirements of 25 Pa. Code Sections 129.91-129.95.
- B. The records shall provide sufficient data and calculations to clearly demonstrate that the requirements of Sections 129.91-129.95 are met.
- C. Data required determining compliance shall be recorded and maintained in a time frame consistent with the averaging period of the requirement.
- D. Records shall be retained for at least five years and shall be made available to the Department on request.
- E. All recordkeeping requirements from existing permits shall continue to be met.

18. 20-inch Experimental Paper Machine

(Two identical burners - Maxon Corporation, Model No. WRF-4)

- A. These burners shall supply hot drying air to the drying hoods of 20-inch experimental paper machine.
- B. Only natural gas shall be used as fuel in the burners.
- E. For this source, the Presumptive RACT emission limitations are the installation, maintenance and operation in accordance with manufacturers specifications.
- F. The hours of operation of the 20-inch experimental paper machine shall be limited to 2,000 hours per calendar year. The hours of operation, each time the paper machine is operated, shall be entered into a logbook.

