

ALLEGHENY COUNTY HEALTH DEPARTMENT

IN RE:

Hercules Incorporated	)	PLAN APPROVAL ORDER
State Highway 837	)	AND AGREEMENT NO. 257
Allegheny County	)	<u>UPON CONSENT</u>
West Elizabeth, PA 15088	)	

AND NOW, this 14th day of January, 1998, <sup>59th</sup> 97

WHEREAS, the Allegheny County Health Department, (hereafter referred to as "Department"), has determined that the Hercules Incorporated (hereafter referred to as "HERCULES"), State Highway 837, Allegheny County, West Elizabeth, PA 15088, is the owner and operator of synthetic hydrocarbon resin production facilities at State Highway 837, Allegheny County, West Elizabeth, PA 15088 (hereafter referred to as "the facility"), is a major stationary source of volatile organic compounds (hereafter referred to as "VOCs") emissions as defined in Section 2101.20 of Article XXI, Rules and Regulations of the Allegheny County Health Department, Air Pollution Control (hereafter referred to as "Article XXI"); and

WHEREAS, the Department has determined that Section 2105.06.a. of Article XXI, entitled "Major Sources of NO<sub>x</sub> & VOCs" is applicable to HERCULES's operations at this facility; and

WHEREAS, HERCULES promptly submitted to the Department all documents required by Section 2105.06.b of Article XXI (hereafter referred to as "the proposal"); and

WHEREAS, the Department, after a review of the submitted proposal, has determined the proposal to be complete; and

WHEREAS, the Department has further determined, after review of the submitted proposal, that it constitutes Reasonably Available Control Technology (hereafter referred to as "RACT") for control of VOC emissions from HERCULES; and

WHEREAS, the Department and HERCULES desire to memorialize the details of the submitted proposal by entry of a Plan Approval Order and Agreement Upon Consent; and

WHEREAS, pursuant to Section 2109.03 of Article XXI, the Director of the Allegheny County Health Department or his designated representative may issue such orders as are necessary to aid in the enforcement of the provisions of Article XXI;

NOW, THEREFORE, this day first written above, the Department, pursuant to Section 2109.03 of Article XXI, and upon agreement of the parties as hereinafter set forth, hereby issues this Plan Approval Order and Agreement upon Consent:

## I. ORDER

- 1.1. HERCULES shall at no time operate the following process equipment while generating VOC emissions unless all non-fugitive emissions are processed through cooling tower water-cooled condensers. Such condensers shall be properly maintained and operated at all times while treating VOC emissions from the subject equipment, with the exception of activities to mitigate emergency conditions, with a coolant inlet temperature no greater than ten degrees fahrenheit above ambient air temperature, except that at no time will coolant temperature be required to be less than 50°F.

### Subject Process Equipment Per Process Unit:

- A. V-8 Polymerization Unit Process Equipment:
1. First and second flashers and OVDHS accumulators
  2. Mixpot
  3. No. twenty-five (25) agitator
- B. Water-White Polymerization Unit Process Equipment:

1. Reclaimer
- C. MP Polymerization Unit
1. Reactor
- D. Suspension Polymerization Unit Process Equipment:
1. North, South and West reactors
- E. Pilot Plant Process Equipment:
1. Reactor
  2. Neutralizer
  3. Funda Filter
- F. No. three (3) LTC Finishing Unit Process Equipment:
1. First and second stage reactor vacuum jets
- G. C-5 Polymerization Unit Process Equipment:
1. Resin kettles no. eight (8), when containing volatile organic compounds.
  2. Solvent flush, irganox, reclaim and precoat tanks
- H. No.s one (1) and two (2) LTC Finishing Unit Process Equipment:
1. No.s one (1) and two (2) flasher feed

2. No.s one (1) and two (2) flasher jets

I. C-Polymerization Unit Process Equipment:

1. Reactors no. 1-1, 1-2, 2-1 and 2-2

1.2. HERCULES shall at no time operate the following process equipment while generating VOC emissions unless all such non-fugitive emissions are processed through refrigerated condensers. Such condensers shall be properly maintained and operated at all times while treating VOC emissions, with the exception of activities to mitigate emergency conditions, with coolant inlet temperatures no greater than those listed below.

Subject Process Equipment Per Process Unit:

A. MP Polymerization Unit Process Equipment:

1. Preblend, receiver, solvent filtrate and filtrate receiver tanks

with inlet coolant temperatures no greater

than ten (10) degrees centigrade.

B. C-5 Polymerization Unit Process Equipment:

1. Neutralizers and Filtrate Receiver
2. Reactor
3. Toluene column

with inlet coolant temperatures no greater than zero (0) degrees Fahrenheit.

- 1.3. By no later than May 1, 1997, HERCULES shall complete installation of refrigerated condenser systems, for the purpose of reducing VOC emissions, from the subject process equipment listed below.

Subject Process Equipment Per Process Unit:

A. Hydrogenation Unit Process Equipment:

1. Storage tanks no.s T-101, T-102, T-105 and T-106
2. Autoclave vent tank
3. Product tank, T-501 & Solvent tank, T-502
2. Metering tank
3. Pall and Sweetland filter blowing
4. Autoclaves no.s one (1) and two (2)

B. Water-White Polymerization Unit Process

Equipment:

1. Feed dryers
2. Reactors
3. Neutralizer
4. Filtrate receiver

1.4. By no later than August 1, 1997, HERCULES shall commence operation of the refrigerated condenser Systems, for the purpose of reducing VOC emissions, from the subject equipment listed in paragraph 1.3 above. Such condensers shall be properly maintained and operated at all times while treating VOC emissions, with the exception of activities to mitigate emergency conditions, with coolant inlet temperatures no greater than ten (10) degrees centigrade.

1.5. HERCULES shall at all times maintain all appropriate records to demonstrate compliance with the requirements of both Section 2105.06 Article XXI and this Order. Data and information required to determine compliance shall be recorded and maintained by HERCULES and shall include, but not be limited, the following.

A. Production records and condenser coolant temperatures

1.6. HERCULES shall retain all records required by both Section 2105.06 of Article XXI and this Order for the facility for at least two (2) years and shall make the same available to the Department upon request.

1.7. HERCULES shall properly maintain and operate all existing process equipment and VOC control equipment at all times while such equipment is emitting VOCs, with the exception of activities to mitigate emergency situations, according to good engineering and air pollution control practices.

## II. AGREEMENT

The foregoing Order shall be enforced in accordance with and is subject to the following agreement of the parties, to wit:

2.1. The contents of this Order shall be submitted to The U.S. Environmental Protection Agency as a revision to the Commonwealth of Pennsylvania's State Implementation Plan (hereafter referred to

as "SIP").

2.2. This Order establishes the extent of HERCULES' obligation with respect to the control of VOCs from this facility. Compliance with the requirements stated in the Order portion of this Order and Agreement shall be deemed compliance with all VOC control requirements for equipment described in HERCULES' RACT Plan. Failure of HERCULES to comply with this Enforcement Order and Agreement by Consent shall subject HERCULES to only the remedies provided for violations of Article XXI.

2.3. If any event occurs which is beyond the control of HERCULES and which causes or may cause delays in the achievement of the deadlines contained in paragraphs 1.3 and 1.4 of this Order.

a. HERCULES shall notify the Department in writing within ten (10) days of the delay or anticipated delay, describing in detail the nature of the delay, the anticipated length of the delay, the precise cause or causes of the delay, the measures taken and to be taken by HERCULES to prevent or minimize the delay,

and the timetable by which those measures will be implemented. HERCULES shall adopt all reasonable measures to avoid or minimize any such delay. Failure by HERCULES to comply with the notice requirement of this subparagraph, (2.3.a.) specifically may in sole discretion of the Department render the remaining provisions of this paragraph (2.3.b. - 2.3.c.) void and of no effect as to the particular incident involved.

- b. If the Department agrees that the delay or anticipated delay in complying with this Order has been or will be caused by circumstances beyond the control of HERCULES, the time for performance hereunder may be extended for a period no longer than the delay resulting from such circumstances.
  
- c. The burden of proving that any delay is caused by circumstances beyond the control of HERCULES shall rest with HERCULES. Increased costs or expenses associated with the implementation of actions called for by this Order shall not, in any event, be a basis for changes in this Order or extensions of time

under this paragraph. Delay in achievement of one interim step shall not necessarily justify or excuse delay in achievement of subsequent steps.

2.4. HERCULES hereby consents to the foregoing Order and hereby knowingly waives all rights to appeal said Order, and the undersigned represents that he is authorized to consent to the Order and to enter into this Agreement on behalf of HERCULES.

~~2.5. The County shall, upon request by HERCULES, accept and evaluate requests for amendments to Allegheny County's portion of the SIP and if appropriate, submit the amendments to the U.S. EPA for incorporation into the SIP. HERCULES hereby reserves its appeal rights to Article XXI, Rules and Regulations of the AGHD, Hearings and Appeals, for any subject amendments made or failure to make such amendments.~~

IN WITNESS WHEREOF, and intending to be legally bound, the parties hereby consent to all of the terms and conditions of the foregoing Order and Agreement as of the date of the above written.

HERCULES INC.

By: Joseph P. Ziegler  
(signature)

Print or type Name: Joseph P. Ziegler

Title: Plant Manager

Date: 1/3/97

ALLEGHENY COUNTY HEALTH DEPARTMENT

By: Bruce W. Dixon 1/4/97

Bruce W. Dixon, M.D., Director  
Allegheny County Health Department

and By: Thomas J. Puzniak

Thomas J. Puzniak, Engineering Manager  
Air Quality Program

ALLEGHENY COUNTY HEALTH DEPARTMENT

IN RE:

Hercules Incorporated	) AMENDMENT TO PLAN
State Highway 837	) APPROVAL ORDER AND
Allegheny County	) AGREEMENT NO. 257
West Elizabeth, PA 15088	) UPON CONSENT

AND NOW, this 1<sup>st</sup> day of November, 1999,

WHEREAS, Plan Approval Order and Agreement No. 257, upon Consent was issued by the Allegheny County Health Department (the "Department") on January 14 1997 (the "Plan Approval Order"); and

WHEREAS, the Department intends, with the agreement of Hercules Incorporated ("Hercules"), to amend the Plan Approval Order to correct a clerical error,

NOW, THEREFORE, the Department, upon agreement of Hercules, hereby issues this amendment to the Plan Approval Order:

I. ORDER

1. Paragraph 1.1 of the Plan Approval Order is amended by deleting No. two (2) flasher feed from subparagraph H to read as follows:

- H. No.s one (1) and two (2) LTC Finishing Unit Process Equipment:
  - 1. No. one (1) flasher feed
  - 2. No.s one (1) and two (2) flasher jets

IN WITNESS WHEREOF, and intending to be legally bound, the parties hereby consent to all of the terms and conditions of the foregoing Amendment to Order and Agreement No. 257, as of the date of the above written.

HERCULES INCORPORATED

By: Ronald D. Lerario  
(signature)

Print or type Name: Ronald D. Lerario

Title: Plant Manager

Date: 5/17/99

ALLEGHENY COUNTY HEALTH DEPARTMENT

By: Bruce W. Dixon  
Bruce W. Dixon, M.D., Director  
Allegheny County Health Department

Date: Nov 11, 1999

and By: Roger C. Westman  
Roger C. Westman  
Manager, Air Quality Program

Date: 10/28/99

