



GENERAL AIR CONTAMINANT DISCHARGE PERMIT

Department of Environmental Quality
 Air Quality Program
 811 SW Sixth Avenue Portland, OR 97204-1390
 Telephone: 503-229-5359

This permit is issued in accordance with the provisions of ORS 468A.040 and OAR 340-216-0060

ISSUED BY THE DEPARTMENT OF ENVIRONMENTAL QUALITY

Signed copy on file at DEQ Headquarters Office

 Lydia Emer, Operations Division Administrator

 Dated

Table 1 Code	Source Description	SIC	NAICS
Part B, 23	Coffee roasting, 30 tons per year or more roasted product	2095	311920

TABLE OF CONTENTS

1.0	PERMIT ASSIGNMENT	2
2.0	GENERAL EMISSION STANDARDS AND LIMITS	2
3.0	OPERATION AND MAINTENANCE REQUIREMENTS	3
4.0	PLANT SITE EMISSION LIMITS	4
5.0	COMPLIANCE DEMONSTRATION	5
6.0	RECORDKEEPING REQUIREMENTS.....	6
7.0	REPORTING REQUIREMENTS.....	7
8.0	ADMINISTRATIVE REQUIREMENTS.....	9
9.0	FEES	11
10.0	GENERAL CONDITIONS AND DISCLAIMERS.....	11
11.0	ABBREVIATIONS, ACRONYMS, AND DEFINITIONS.....	13

1.0 PERMIT ASSIGNMENT

- 1.1 Qualifications** All of the following conditions must be met in order to qualify for assignment to this permit:
- a. The permittee is performing coffee roasting as described on the cover page of this permit, including supporting activities.
 - b. A Simple or Standard ACDP is not required for the source.
 - c. The source is not having ongoing, recurring or serious compliance problems.
- 1.2 Assignment** DEQ will assign qualifying permittees to this permit that have and maintain a good record of compliance with DEQ's Air Quality regulations and that DEQ determines would be appropriately regulated by a General ACDP. DEQ may rescind assignment if the permittee no longer meets the requirements of OAR 340-216-0060 and the conditions of this permit.
- 1.3 Permitted Activities** The permittee is allowed to discharge air contaminants from processes and activities related to the air contaminant source(s) listed on the first page of this permit until this permit expires, is modified, revoked or rescinded as long as conditions of this permit are complied with. If there are other emissions activities occurring at the site besides those listed on the cover page of this permit, the permittee may be required to obtain a Simple or Standard ACDP or General ACDP Attachment(s), if applicable.
- 1.4 Relation to Local Land Use Laws** This permit is not valid in Lane County, or at any location where the operation of the permittee's processes, activities, and insignificant activities would be in violation of any local land use or zoning laws. For operation in Lane County, contact Lane Regional Air Protection Agency for any necessary permits at (541) 736-1056. It is the permittee's sole responsibility to obtain local land use approvals as, or where, applicable before operating this facility at any location.

2.0 GENERAL EMISSION STANDARDS AND LIMITS

- 2.1 Visible Emissions** The permittee must comply with the following visible emission limits, as applicable:
- a. Emissions from any air contaminant source must not equal or exceed 20% opacity for a period aggregating more than 3 minutes in any one hour.

- b. In Clackamas, Columbia, Multnomah, or Washington Counties, emissions from any air contaminant source other than fuel burning equipment must not equal or exceed 20% opacity for a period aggregating more than 30 seconds in any one hour.
- 2.2 **Particulate Matter Emissions** Particulate matter emissions from any air contaminant source, other than fugitive emission sources, must not exceed 0.1 grain per dry standard cubic foot.
- 2.3 **Fugitive Emissions** The permittee must take reasonable precautions at all times to prevent particulate matter from becoming airborne, such as but not limited to:
 - a. Treating vehicular traffic areas of the plant site under the control of the permittee, including parking lots and dry work yards.
 - b. Operating all air contaminant-generating processes so that fugitive type dust associated with the operation will be adequately controlled at all times.
 - c. Storing process materials, products or materials collected from air pollution control equipment in a covered container or other method equally effective in preventing the material from becoming airborne during storage and transfer.
- 2.4 **Particulate Matter Fallout** The permittee must not cause or permit the emission of any particulate matter larger than 250 microns in size at sufficient duration or quantity, as to create an observable deposition upon the real property of another person. DEQ will verify that the deposition exists and will notify the permittee that the deposition must be controlled.
- 2.5 **Nuisance and Odors** The permittee must not allow the emission of odorous or other emissions so as to create nuisance conditions off the permittee's property. Nuisance conditions will be verified by DEQ personnel. The creation of nuisance conditions may, in addition to other action DEQ may take, result in rescinding assignment to the permit and the permittee will be required to obtain a Simple or Standard ACDP, whichever is applicable.

3.0 OPERATION AND MAINTENANCE REQUIREMENTS

- 3.1 **Rule Citation** OAR 340-226-0120 gives DEQ the authority to require Operating, Maintenance, and Work Practice Requirements (See Condition 3.2) to ensure that the permittee is operating and maintaining air

pollution control equipment at the highest reasonable efficiency and effectiveness to minimize emissions.

3.2 Afterburner Operation

If the permittee has installed an afterburner to control odor or visible emissions, then the permittee must comply with the following conditions:

- a. Gas effluents from process afterburners must be maintained at:
 - i. a temperature of 1,400°F for at least a 0.5-second residence time; or
 - ii. a lower temperature as approved by DEQ;
- b. The permittee must maintain and operate a continuous monitoring system for final combustion chamber temperature; and
- c. The permittee must install and operate the monitoring system in accordance with the manufacturer’s instructions. The permittee must calibrate the continuous temperature monitor and all associated equipment at least once per calendar year.

3.3 Fugitive Emissions Control Plan

While operating in the Medford-Ashland AQMA, the permittee must prepare and implement site-specific plans for the control of fugitive emissions in accordance with OAR 340-240-0180. While operating in the Lakeview Urban Growth Area (UGA), the permittee must prepare and implement site-specific plans for the control of fugitive emissions in accordance with OAR 340-240-0410.

3.4 O&M Plan

While operating in the Medford-Ashland AQMA, the permittee must prepare and implement an operation and maintenance (O&M) plan in accordance with OAR 340-240-0190. While operating in the Lakeview UGA, the permittee must prepare and implement an O&M plan in accordance with OAR 340-240-0420.

4.0 PLANT SITE EMISSION LIMITS

4.1 Plant Site Emission Limits (PSEL)

The permittee must not allow plant site emissions to exceed the following:

Pollutant	Limit	Units
PM	24	tons per year
PM ₁₀	14	tons per year
SO ₂	39	tons per year

NO _x	39	tons per year
CO	99	tons per year
VOC	39	tons per year

4.2 PM₁₀ PSEL for Medford-Ashland AQMA

For sources operating in the Medford-Ashland AQMA, the permittee must not allow the plant site emissions of PM₁₀ to exceed the following:

Pollutant	Limit	Units
PM ₁₀	4.5	tons per year
	49	pounds per day

4.3 Annual Period

The annual plant site emissions limits apply to any 12-consecutive calendar month period.

5.0 COMPLIANCE DEMONSTRATION

5.1 PSEL Compliance Monitoring

Compliance with the PSEL is determined for each 12-consecutive calendar month period based on the following calculation for each pollutant: [Note: calculations are not required unless requested by DEQ]

$$E = \Sigma(EF \times P) \times CE/2000$$

where

- E = pollutant emissions (tons/yr);
- EF = pollutant emission factor (see Condition 5.2);
- P = process production (tons of coffee roasted)
- CE = control efficiency (see Condition 5.3)

5.2 Emission Factors

The permittee must use the default emission factors provided below for calculating pollutant emissions, unless alternative emission factors are approved by DEQ. The permittee may request or DEQ may require using alternative emission factors provided they are based on actual test data or other documentation (e.g., AP-42 compilation of emission factors) that has been reviewed and approved by DEQ.

Emissions device or activity	Pollutant	Emission Factor (EF)	Emission factor units
Destoner	PM/PM ₁₀	1.4	lb/ton of coffee roasted
Roaster	PM	4.2	lb/ton of coffee roasted

	PM ₁₀	0.6	lb/ton of coffee roasted
	VOC	2.6	lb/ton of coffee roasted
Natural Gas Combustion	NO _x	100	lb/10 ⁶ cubic feet of natural gas burned

5.3 Control Efficiency The permittee must meet the following control efficiencies, as applicable:

Control Device	Pollutant	Control Efficiency
Direct-flame Afterburner	PM/PM ₁₀	60%
	VOC	95%
Catalytic Converter	PM/PM ₁₀	95%
	VOC	95%

6.0 RECORDKEEPING REQUIREMENTS

6.1 Monitoring Requirements The permittee must monitor and maintain the following records related to the operation and maintenance of the plant and associated air contaminant control devices:

- a. Amount of raw (green) beans roasted – tons per month
- b. Amount of natural gas used – cubic feet per month
- c. Temperature in the final combustion chamber - °F continuously

6.2 Operation and Maintenance The permittee must maintain all records associated with continuous temperature monitoring system in the secondary chamber of the afterburner, including, but not limited to, original data sheets, charts, calculations, calibration data, production records and final reports related to the operation and maintenance of the plant and associated air contaminant control devices.

6.3 Excess Emissions The permittee must maintain records of excess emissions as defined in OAR 340-214-0300 through 340-214-0340 (recorded on occurrence). Typically, excess emissions are caused by process upsets, startups, shutdowns, or scheduled maintenance. In many cases, excess emissions are evident when visible emissions are greater than 20% opacity for 3 minutes or more in any 60 minute period.

6.4 Complaint log The permittee must maintain a log of all written complaints and

complaints received via telephone that specifically refer to air pollution concerns associated to the permitted facility. The log must include a record of the permittee's actions to investigate the validity of each complaint and a record of actions taken for complaint resolution.

6.5 Retention of Records

Unless otherwise specified, all records must be maintained on site for a period of two (2) years and will be made available to DEQ upon request.

7.0 REPORTING REQUIREMENTS

7.1 Excess Emissions

The permittee must notify DEQ by telephone or in person of any excess emissions which are of a nature that could endanger public health.

- a. The permittee must provide such notice as soon as possible, but never more than one hour after becoming aware of the problem. Notice must be made to the regional office identified in Condition 8.3.
- b. If the excess emissions occur during non-business hours, the permittee must notify DEQ by calling the Oregon Emergency Response System (OERS). The current number is 1-800-452-0311.
- c. The permittee must also submit follow-up reports when required by DEQ.

7.2 Annual Report

The permittee must submit to DEQ by **February 15** of each year this permit is in effect, two (2) copies of the following information for the preceding calendar year:

- a. Operating parameters:
 - i. Amount of raw (green) beans roasted (tons per calendar year)
 - ii. Highest amount of raw (green) beans roasted within a month
 - iii. Amount of natural gas used (therms or cubic feet per calendar year)
 - iv. Highest amount of natural gas used (therms or cubic feet in any one month))
- b. Records of all planned and unplanned excess emissions events.
- c. Summary of complaints relating to air quality received by

permittee during the year.

- d. List permanent changes made in plant process, production levels, and pollution control equipment which affected air contaminant emissions.
- e. List major maintenance performed on pollution control equipment.
- f. List the current plant site contact. Provide name, title, phone number and email address.
- g. All reports and certifications submitted to DEQ under Divisions 200 to 264 must accurately reflect the monitoring, record keeping and other documentation held or performed by the owner or operator.

- 7.3 Initial Startup Notice**

The permittee must notify DEQ in writing of the date a new facility is started up. The notification must be submitted no later than seven (7) days after startup.
- 7.4 Notice of Change of Ownership or Company Name**

The permittee must notify DEQ in writing using a DEQ "Permit Application Form" within 60 days after the following:

 - a. Legal change of the name of the company as registered with the Corporations Division of the State of Oregon; or
 - b. Sale or exchange of the activity or facility.
- 7.5 Construction or Modification Notices**

The permittee must notify DEQ in writing using a DEQ "Notice of Construction Form," or "Permit Application Form," and obtain approval in accordance with OAR 340-210-0205 through 340-210-0250 before:

 - a. Constructing or installing any new source of air contaminant emissions, including air pollution control equipment;
 - b. Modifying or altering an existing source that may significantly affect the emission of air contaminants;
 - c. Making any physical change which increases emissions; or
 - d. Changing the method of operation, the process, or the fuel use, or increasing the normal hours of operation that result in increased emissions.
- 7.6 Where to Send Reports and Notices**

Except in Clackamas, Clatsop, Columbia, Multnomah, Tillamook, and Washington Counties, reports and notices, with the permit number prominently displayed, must be sent to the Permit Coordinator for the region where the source is located as identified in Condition 8.2. In Clackamas, Clatsop, Columbia,

Multnomah, Tillamook, and Washington Counties, reports and notices, with the permit number prominently displayed, must be sent to the Gresham Office as identified in Condition 8.3.

8.0 ADMINISTRATIVE REQUIREMENTS

8.1 Reassignment to the General Permit

A complete application for reassignment to this permit is due within 60 days after the permit is reissued. DEQ will notify the permittee when the permit is reissued. The application must be sent to the appropriate regional office.

- a. If DEQ is delinquent in renewing the permit, the existing permit will remain in effect and the permittee must comply with the conditions of the permit until such time that the permit is reissued and the source is reassigned to the permit.
- b. The permittee may submit an application for either a Simple or Standard ACDP at any time, but the permittee must continue to comply with the General ACDP until DEQ takes final action on the Simple or Standard ACDP application.
- c. If a complete application for reassignment to the General ACDP or Simple or Standard ACDP is filed with DEQ in a timely manner, the permit will not be deemed to expire until final action has been taken on the application.

8.2 Permit Coordinator Addresses

All reports, notices, and applications should be directed to the Permit Coordinator for the area where the source is located. The Permit Coordinator addresses are as follows:

Counties	Permit Coordinator Address and Telephone
Clackamas, Clatsop, Columbia, Multnomah, Tillamook, and Washington	Department of Environmental Quality Northwest Region 700 NE Multnomah Street, Suite 600 Portland, OR 97232 Telephone: (503) 229-5582
Benton, Coos, Curry, Douglas, Jackson, Josephine, Lincoln, Linn, Marion, Polk, and Yamhill	Department of Environmental Quality Western Region 4026 Fairview Industrial Drive Salem, OR 97302 Telephone: (503) 378-8240 ext. 225
Baker, Crook, Deschutes, Gilliam, Grant, Harney, Hood River, Jefferson, Klamath, Lake, Malheur, Morrow, Sherman, Umatilla, Union, Wallowa, Wasco, Wheeler	Department of Environmental Quality Eastern Region 475 NE Bellevue, Suite 110 Bend, OR 97701 Telephone: (541) 388-6146 ext. 223

8.3 DEQ Contacts

Information about air quality permits and DEQ’s regulations may be obtained from the DEQ web page:

<http://www.oregon.gov/DEQ/AQ/>

All inquiries about this permit should be directed to the regional office for the area where the source is located. DEQ’s regional offices are as follows:

Counties	Office Address and Telephone
Clackamas, Clatsop, Columbia, Multnomah, Tillamook, and Washington	Department of Environmental Quality Northwest Region 700 NE Multnomah Street, Suite 600 Portland, OR 97232 Telephone: (503) 229-5263
Benton, Lincoln, Linn, Marion, Polk, and Yamhill	Department of Environmental Quality Salem Office 4026 Fairview Industrial Drive Salem, OR 97302 Telephone: (503) 378-8240
Coos, Curry, and Western Douglas	Department of Environmental Quality Coos Bay Office 381 N Second Street Coos Bay, OR 97420 Telephone: (541) 269-2721
Eastern Douglas, Jackson, and Josephine	Department of Environmental Quality Medford Office 221 Stewart Avenue, Suite 201 Medford, OR 97501 Telephone: (541) 776-6010
Crook, Deschutes, Harney, Hood River, Jefferson, Sherman, Wasco, and Wheeler	Department of Environmental Quality Bend Office 475 NE Bellevue, Suite 110 Bend, OR 97701 Telephone: (541) 388-6146
Baker, Gilliam, Grant, Malheur, Morrow, Umatilla, Union, and Wallowa	Department of Environmental Quality Pendleton Office 800 SE Emigrant Avenue, Suite 330 Pendleton, OR 97801 Telephone: (541) 276-4063
Klamath and Lake	Department of Environmental Quality Klamath Falls Office 317 South 7 th Street, Suite 231 Klamath Falls, OR 97601 Telephone: (541) 273-7002

9.0 FEES

- 9.1 Annual Compliance Fee** The Annual Compliance Determination Fee specified in OAR 340-216-0090, Table 2, Part 2(c) for a Class One General ACDP is due on **December 1** of each year this permit is in effect. An invoice indicating the amount, as determined by DEQ regulations, will be mailed prior to the above date.
- 9.2 Change of Ownership or Company Name Fee** The non-technical permit modification fee specified in OAR 340-216-0090, Table 2, Part 3(a) is due with an application for changing the ownership or the name of the company of a source assigned to this permit.
- 9.3 Where to Submit Fees** Fees must be submitted to:
Department of Environmental Quality
Business Office
811 SW Sixth Avenue
Portland, Oregon 97204-1390

10.0 GENERAL CONDITIONS AND DISCLAIMERS

- 10.1 Other Regulations** In addition to the specific requirements listed in this permit, the permittee must comply with all other legal requirements enforceable by DEQ.
- 10.2 Conflicting Conditions** In any instance in which there is an apparent conflict relative to conditions in this permit, the most stringent conditions apply.
- 10.3 Masking of Emissions** The permittee must not cause or permit the installation of any device or use any means designed to mask the emissions of an air contaminant that causes or is likely to cause detriment to health, safety, or welfare of any person or otherwise violate any other regulation or requirement.
- 10.4 DEQ Access** The permittee must allow DEQ's representatives access to the plant site and pertinent records at all reasonable times for the purposes of performing inspections, surveys, collecting samples, obtaining data, reviewing and copying air contaminant emissions discharge records and conducting all necessary functions related to this permit in accordance with ORS 468-095.
- 10.5 Permit Availability** The permittee must have a copy of the permit available at the facility at all times.
- 10.6 Open Burning** The permittee may not conduct any open burning except as allowed by OAR 340 Division 264.
- 10.7 Asbestos** The permittee must comply with the asbestos abatement

requirements in OAR 340, Division 248 for all activities involving asbestos-containing materials, including, but not limit to, demolition, renovation, repair, construction, and maintenance.

10.8 Property Rights

The issuance of this permit does not convey any property rights in either real or personal property, or any exclusive privileges, nor does it authorize any injury to private property or any invasion of personal rights, nor any infringement of federal, state, or local laws or regulations.

10.9 Modification or Revocation

The Commission may modify or revoke this permit pursuant to OAR 340-216-0060(3) and (4).

11.0 ABBREVIATIONS, ACRONYMS, AND DEFINITIONS

ACDP	Air Contaminant Discharge Permit	NSR	New Source Review
ASTM	American Society for Testing and Materials	O ₂	oxygen
AQMA	Air Quality Maintenance Area	OAR	Oregon Administrative Rules
calendar year	The 12-month period beginning January 1st and ending December 31st	ORS	Oregon Revised Statutes
CFR	Code of Federal Regulations	O&M	operation and maintenance
CO	carbon monoxide	Pb	lead
DEQ	Oregon Department of Environmental Quality	PCD	pollution control device
dscf	dry standard cubic foot	PM	particulate matter
EPA	US Environmental Protection Agency	PM ₁₀	particulate matter less than 10 microns in size
FCAA	Federal Clean Air Act	ppm	part per million
gal	gallon(s)	PSD	Prevention of Significant Deterioration
gr/dscf	grains per dry standard cubic foot	PSEL	Plant Site Emission Limit
HAP	Hazardous Air Pollutant as defined by OAR 340-244-0040	PTE	Potential to Emit
ID	identification number	RACT	Reasonably Available Control Technology
I&M	inspection and maintenance	scf	standard cubic foot
lb	pound(s)	SER	Significant Emission Rate
MMBtu	million British thermal units	SIC	Standard Industrial Code
NA	not applicable	SIP	State Implementation Plan
NESHAP	National Emissions Standards for Hazardous Air Pollutants	SO ₂	sulfur dioxide
NO _x	nitrogen oxides	Special Control Area	as defined in OAR 340-204-0070
NSPS	New Source Performance Standard	VE	visible emissions
		VOC	volatile organic compound
		year	A period consisting of any 12-consecutive calendar months