

Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Notice of
Construction No. 5006

Date JUL 8 1993

Addition of a Dry Sorbent Silo (90 tons), venting a Day 16PJF6 Baghouse 750 cfm.

RALPH JONES, PLANT ENGINEER

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ASH GROVE CEMENT COMPANY (E MARG.,)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

O ASH GROVE CEMENT COMPANY (E MARG.,)
W 3801 E MARGINAL WY S
E
R SEATTLE WA 98134-1113

INSTALLATION ADDRESS

ASH GROVE CEMENT COMPANY (E MARG.,) 3801 E MARGINAL WY S, SEATTLE, WA, 98134

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Air Pollution Control Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of PSAPCA.
2. Compliance with this ORDER and its conditions does not relieve the owner or operator from the responsibility of compliance with Regulations I, II or III, RCW 70.94 or any other emission control requirements, nor from the resulting liabilities and/or legal remedies for failure to comply. Section 5.05(e) of Regulation I requires that the owner or operator must develop and implement an operation and maintenance (O&M) plan to assure continuous compliance with Regulations I, II, and III.
3. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.

Fredrick L. Austin
FREDRICK L. AUSTIN P.E.
Reviewing Engineer
MEJ

Jay M. Willenberg
JAY M. WILLENBERG P.E.
Reviewing Engineer

David D. Kirk
for ANITA J. FRANKEL
Air Pollution Control Officer

Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Notice of
Construction No. 5276

Date JAN 19 1994

Two Baghouses at 20,000 acfm each connected to the Finish Mill Grinding System.

RALPH C JONES, PLANT ENGINEER

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ASH GROVE CEMENT COMPANY (E MARG.)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

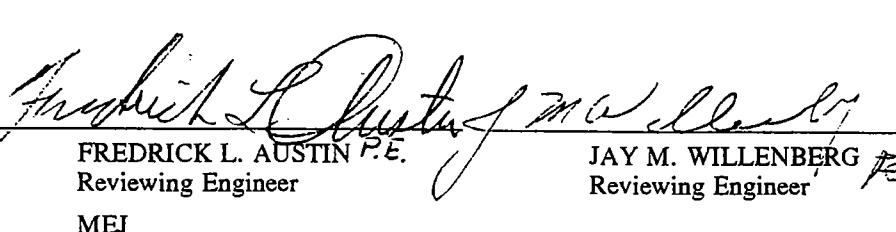
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ASH GROVE CEMENT COMPANY (E MARG.)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

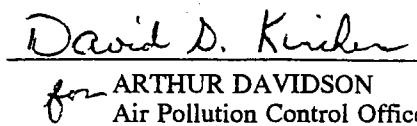
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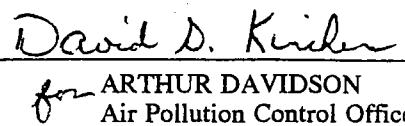
ASH GROVE CEMENT COMPANY (E MARG.), 3801 E MARGINAL WY S, SEATTLE, WA, 98134

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3. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
4. Particulate emissions shall not exceed 0.01 gr/dscf as measured by EPA Method 5 with the back half. Ash Grove shall submit a testing plan to PSAPCA for approval within 60 days of the approval date of this Order of Approval.
5. Ash Grove shall perform a compliance source test within 60 days of startup.
6. Ash Grove shall not exceed 10% opacity for an aggregate of 3 minutes in any 1 hour from the baghouse exhaust.
7. Ash Grove shall measure and record pressure drop across the baghouse, and maintain the pressure drop between 3 and 6 inches.


FREDRICK L. AUSTIN P.E.
Reviewing Engineer
MEJ


JAY M. WILLENBERG
Reviewing Engineer


ARTHUR DAVIDSON
Air Pollution Control Officer

Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

One DCL FS-175 Baghouse at 1,000 cfm for Rail Car Loading.

Registration No. 11339

Notice of
Construction No. 5351

Date MAR 15 1994

GERALD BROWN

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ASH GROVE CEMENT COMPANY (E MARG.,)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

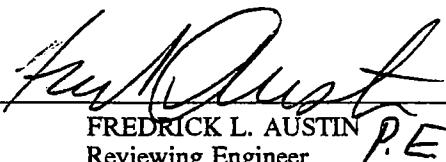
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3801 E MARGINAL WY S
SEATTLE WA 98134-1113

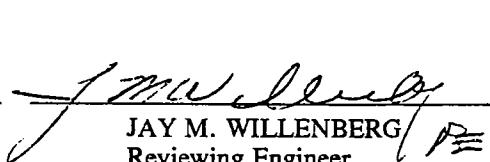
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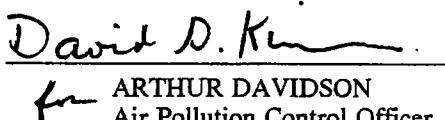
ASH GROVE CEMENT COMPANY (E MARG.,) 3801 E MARGINAL WY S, SEATTLE, WA, 98134

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FREDRICK L. AUSTIN P.E.
Reviewing Engineer
MEJ


JAY M. WILLENBERG P.E.
Reviewing Engineer


ARTHUR DAVIDSON
Air Pollution Control Officer

Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Notice of
Construction No. 5687

Date JAN 11 1995

Ash Grove Cement Kiln (rated at 92 ton/hr) burning waste derived fuels injected at the calciner level of preheater at feed end of kiln during normal operations.

GERALD BROWN

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ASH GROVE CEMENT COMPANY (E MARG.)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

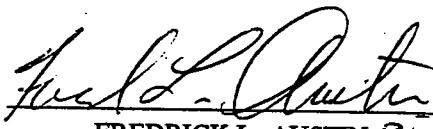
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SEATTLE WA 98134-1113

INSTALLATION ADDRESS

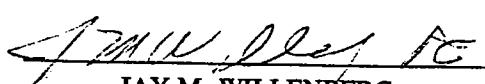
ASH GROVE CEMENT COMPANY (E MARG.), 3801 E MARGINAL WY S, SEATTLE, WA, 98134

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

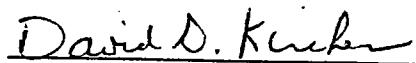
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3. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
4. Ash Grove shall burn only waste derived fuels generated on site and not to exceed 6,000 pounds of greases and 4,800 pounds of oils per year.
5. Ash Grove shall limit waste derived fuels to fuels that are non-hazardous as defined by WAC 173-303-515, Special Requirements for Used Oil Burned for Energy Recovery, or by WAC 173-303-090, Dangerous Waste Characteristics, as appropriate.
6. Ash Grove shall maintain records of date, type, and quantity of material incinerated.



FREDRICK L. AUSTIN P.E.
Reviewing Engineer
MEJ



JAY M. WILLEMBERG
Reviewing Engineer



for DENNIS J. McLERRAN
Air Pollution Control Officer

Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Notice of
Construction No. 6644

Date OCT 18 1996

Barge Unloading, Transfer and Stockpiling of Solid Raw Materials and Fuels used in the manufacture of Portland Cement including the use of Water Sprays to control dust at two locations along the existing Conveyor System at the discharge ends of each conveyor and as necessary at Transfer Towers #10A and #11.

GERALD BROWN

A ASH GROVE CEMENT COMPANY (E MARG.)
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WA 98134-1113

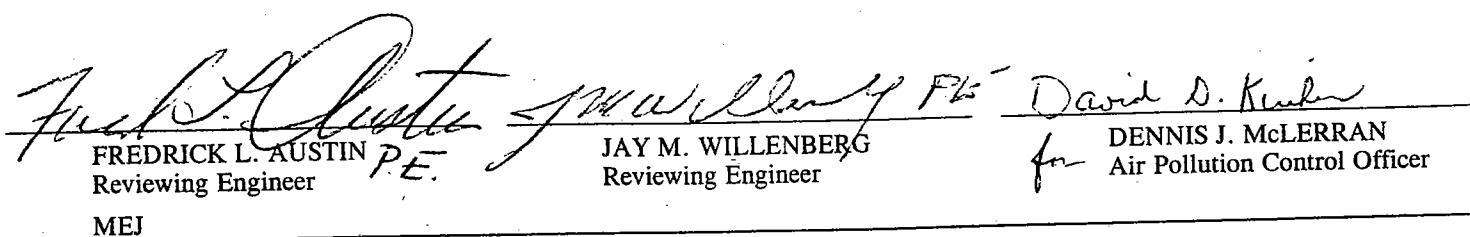
O ASH GROVE CEMENT COMPANY (E MARG.)
W
N 3801 E MARGINAL WY S
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R SEATTLE
WA 98134-1113

INSTALLATION ADDRESS

ASH GROVE CEMENT COMPANY (E MARG.), 3801 E MARGINAL WY S, SEATTLE, WA, 98134

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2. Compliance with this ORDER and its conditions does not relieve the owner or operator from the responsibility of compliance with Regulations I, II or III, RCW 70.94 or any other emission control requirements, nor from the resulting liabilities and/or legal remedies for failure to comply. Section 5.05(e) of Regulation I requires that the owner or operator must develop and implement an operation and maintenance (O&M) plan to assure continuous compliance with Regulations I, II, and III.
3. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
4. This Order of Approval No. 6644, issued to allow water sprays to control dust at transfer towers #10A and #11, hereby supersedes and cancels Orders of Approval No. 2399 dated Feb 28, 1983 and No. 5696 dated Jan 11, 1995.


FREDRICK L. AUSTIN P.E. JAY M. WILLEMBERG P.E. for DENNIS J. McLERRAN
Reviewing Engineer Reviewing Engineer Air Pollution Control Officer
MEJ

Puget Sound Air Pollution Control Agency

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Notice of
Construction No. 7242

Date JAN 6 1998

One 45,000 ton Cement Storage Dome with a Pneumatic Material Transport System controlled by an Alanco Baghouse rated at 6,000 acfm, and one Alanco Baghouse rated at 6,000 acfm on the Steel Scale Tank (replaces Baghouse 920.070).

GERALD J BROWN

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ASH GROVE CEMENT COMPANY (E MARG.,)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

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ASH GROVE CEMENT COMPANY (E MARG.,)
3801 E MARGINAL WY S
SEATTLE WA 98134-1113

INSTALLATION ADDRESS

ASH GROVE CEMENT COMPANY (E MARG.,) 3801 E MARGINAL WY S, SEATTLE, WA, 98134

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2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. Ash Grove Cement shall comply with requirements of 40 CFR Subpart A and Subpart F, and notify the U.S. Environmental Protection Agency and PSAPCA in writing according to 40 CFR Subpart A.
4. Ash Grove Cement shall install and maintain gauges to measure the pressure drop across the two Alanco baghouse exhaust filters. Within 90 days after beginning operations, the acceptable ranges for the gauges shall be clearly marked on or nearby the gauges.
5. Once during each shift either Alanco baghouse is used, Ash Grove Cement shall determine and record if the pressure drop across the exhaust filters is in the acceptable range.
6. If the pressure drop across the exhaust filters of either Alanco baghouse is not within the acceptable range, Ash Grove Cement shall take corrective action as specified in the facility's Operation and Maintenance Plan.
7. The PM-10 emissions from each of the Alanco baghouses shall not exceed 0.005 grains/dscf over a twenty-four hour period. Ash Grove may demonstrate compliance with this condition by any of the following:
 - (a) By performing a PSAPCA-approved source test according to EPA Method 5 or EPA Method 201A;
 - (b) By demonstrating no visible emissions for 15 consecutive seconds;
 - (c) By demonstrating no visible emissions for 3 consecutive minutes; or
 - (d) By repairing within 24 hours any baghouse that has visible emissions for more than three consecutive minutes. Compliance shall be determined for visible emissions using EPA Method 22. PSAPCA may require a source test for any baghouse that has sustained visible emissions, unless such emissions are unavoidable under WAC 173-400-107.

Fred L. Austin
FREDRICK L. AUSTIN P.E.
Reviewing Engineer
MEJ

Jay M. Willenberg P.E.
JAY M. WILLEMBERG
Reviewing Engineer

David P. Kuehne
for DENNIS J. McLERRAN
Air Pollution Control Officer

Puget Sound Clean Air Agency

Clean Air Agency

Notice of
Construction No. 8318

Registration No. 11339

Date **JAN 8 2001**

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

One NBE/2000-3940 Bulk Loading Station with emissions controlled by a 6BR40PPB-RC Pulse Jet Fabric Filter
Collector rated at 500 cfm.

APPLICANT

Don Ugelstad, Production Superintendent
Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134-1113

OWNER

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134-1113

INSTALLATION ADDRESS

Ash Grove Cement Company (E Marginal), 3801 E Marginal Way S, Seattle, WA, 98134

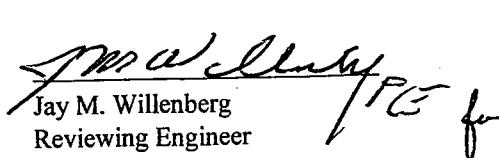
THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

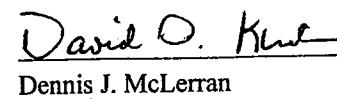
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2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. There shall be no visible emissions or fallout from the dust collector.
4. The dust collector shall be inspected at least once per week for visible emissions, fallout, and pressure drop across the filters.
5. If visible emissions, fallout, or abnormal pressure drop are observed, Ash Grove Cement shall investigate the cause and either initiate repairs or shut down the equipment vented to the baghouse within 24 hours of the observation.
6. Records of all weekly inspections and corrective actions shall be maintained for at least two years and made available to Puget Sound Clean Air Agency personnel upon request.

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.


Fredrick Austin P.E.
Reviewing Engineer
mej


Jay M. Willenberg P.E.
Reviewing Engineer


Dennis J. McLellan
Air Pollution Control Officer

Puget Sound Clean Air Agency



Notice of
Construction No. 8415

Registration No. 11339

Date MAR 20 2001

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Fuller FK Material Pump and Ramsey Horizontal Rotary Gravimetric Metering System controlled by an existing Fly Ash Storage Silo 750 cfm baghouse (NC No. 5338).

APPLICANT

Gerald Brown
Ash Grove Cement Company (E Marginal)
3801 E Marginal Way S
Seattle, WA 98134-1113

OWNER

Ash Grove Cement Company (E Marginal)
3801 E Marginal Way S
Seattle, WA 98134-1113

INSTALLATION ADDRESS

Ash Grove Cement Company (E Marginal), 3801 E Marginal Way S, Seattle, WA, 98134

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2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.

APPEAL RIGHTS

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Fredrick Austin P.E.
Reviewing Engineer
mej

Jay M. Willenberg
Reviewing Engineer

Dennis J. McLellan
Air Pollution Control Officer



Puget Sound Clean Air Agency

Notice of
Construction No. 8600

Registration No. 11339

Date 2/8/2002

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

One Pulse Jet R-08-88-81 Baghouse rated at 20,000 cfm to control dust emissions from the Clinker Storage Shed during clinker transfer.

APPLICANT

Gerald J Brown
Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134-1113

OWNER

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134-1113

INSTALLATION ADDRESS

Ash Grove Cement Company (E Marginal), 3801 E Marginal Way S, Seattle, WA, 98134

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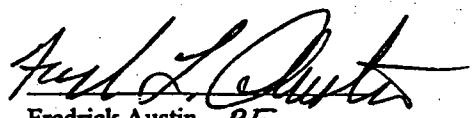
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2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. The PM-10 emissions from the Pulse Jet R-08-88-81 Baghouse shall not exceed 0.005 grains/dscf over a 24-hour period. Ash Grove may demonstrate compliance with this condition by any of the following:
 - (a) By performing a Puget Sound Clean Air Agency-approved EPA Method 5 or EPA Method 201A;
 - (b) Demonstrating no visible emissions for 15 consecutive seconds;
 - (c) Demonstrating no visible emissions for 3 consecutive minutes; or
 - (d) Repairing within 24 hours, any baghouse that has visible emissions for more than 3 consecutive minutes.
4. Compliance shall be determined for visible emissions using 40 CFR 60 Method 22. Puget Sound Clean Air Agency may require a source test for any baghouse that has sustained visible emissions, unless such emissions are unavoidable under WAC 173-400-107.

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.

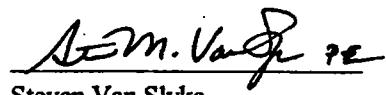
Order of Approval for NC No. 8600

FEB 08 2002



Fredrick Austin, P.E.
Reviewing Engineer

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Steven Van Slyke
Supervising Engineer



Puget Sound Clean Air Agency

Clean Air Agency

Notice of
Construction No. 8643

Registration No. 11339

Date

MAR 21 2002

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Two Pulse Jet Dust Collector Conversions (64 Filters @ 41.5"x6.13" each, @2.26 cfm/ft²) and Fans rated at 4200 CFM each to convert existing Sly Dust Collectors on Group II Cement Silos

APPLICANT

Henrik Voldbaek
Ash Grove Cement Company (E Marginal)
3801 E Marginal Way S
Seattle, WA 98134-1113

OWNER

Ash Grove Cement Company (E Marginal)
3801 E Marginal Way S
Seattle, WA 98134-1113

INSTALLATION ADDRESS

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2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. The PM-10 emissions from these Two Pulse Jet Dust Collectors shall not exceed 0.005 grains/dscf over a 24-hour period. Ash Grove may demonstrate compliance with this condition by any of the following:
 - (a) By performing a Puget Sound Clean Air Agency-approved EPA Method 5 or EPA Method 201A;
 - (b) Demonstrating no visible emissions for 15 consecutive seconds;
 - (c) Demonstrating no visible emissions for 3 consecutive minutes; or
 - (d) Repairing within 24 hours, any baghouse that has visible emissions for more than 3 consecutive minutes.
4. Compliance shall be determined for visible emissions using 40 CFR 60 Method 22. Puget Sound Clean Air Agency may require a source test for any baghouse that has sustained visible emissions, unless such emissions are unavoidable under WAC 173-400-107.

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.

Order of Approval for NC No. 8643



Fredrick Austin
Reviewing Engineer

ns

P.E.



Steven Van Slyke
Supervising Engineer

Puget Sound Clean Air Agency



Notice of
Construction No. 9578

Registration No. 11339

Date 2/13/2007

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Limestone Conveyor Belt #311.BC4 at Tower TT3/4 controlled by existing 4800 cfm Baghouse (#311.BF2, PSCAA CE (37)) and Limestone Bucket Elevator at the 331 Tower controlled by existing 10,600 cfm Baghouse #331.BF4 (PSCAA CE (25)).

APPLICANT

Gerald Brown
Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

OWNER

Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

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NSPS & NESHAPS

3. The Bucket Elevator and Conveyor Belt are subject to 40 CFR 60, Subpart F and 40 CFR 63, Subpart LLL.

BAGHOUSE EMISSION LIMITS

4. Ash Grove shall not allow the emissions of PM-10 emissions from the Bucket Elevator baghouse and the Conveyor baghouse to exceed 0.005 gr/dscf over a 24-hour period. Ash Grove may demonstrate compliance with this condition by any of the following:
 - (a) By performing a Puget Sound Clean Air Agency approved EPA Method 5 or EPA Method 201A;
 - (b) Demonstrating no visible emissions for 15 consecutive seconds;
 - (c) Demonstrating no visible emissions for 3 consecutive minutes; or
 - (d) Repairing within 24 hours, any baghouse that has visible emissions for more than 3 consecutive minutes.

5. Compliance shall be determined for visible emissions using 40 CFR 60 Method 22. Puget Sound Clean Air Agency may require a source test for any baghouse that has sustained visible emissions, unless such emissions are unavoidable under WAC 173-400-107.

Order of Approval for NC No. 9578

BAGHOUSE MONITORING

FEB 13 2007

6. Ash Grove shall conduct monthly inspections of the facility for visible emissions. Inspections are to be performed while the equipment is in operation during daylight hours. If, during the scheduled inspection or at any other time, visible emissions other than uncombined water are observed, Ash Grove shall, as soon as possible, but no later than 24 hours after the initial observation, take corrective action until there are no visible emissions, shut down the unit or activity until it can be repaired or conduct a reference method opacity observation. If a reference method opacity observation reveals an exceedance of the applicable visible emissions limit, report the observation as a deviation and shut the unit down until repairs are complete and a non-reference method visible emissions observation reveals no visible emissions.

RECORDS

7. Ash Grove shall maintain written records required by this Order of Approval on site. In addition, Ash Grove shall retain each record for at least five years and make them available to Puget Sound Clean Air Agency personnel upon request.

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.



Fred Austin
Reviewing Engineer

ns



Steven Van Slyke
Supervising Engineer

Puget Sound Clean Air Agency



Notice of
Construction No. 9711

Registration No. 11339

Date 1/2/2008

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

One 45,000 ton Cement Storage Dome with a pneumatic conveyor controlled by a Baghouse rated at 6,000 acfm (replaces BH 920.070).

APPLICANT

Gerald Brown
Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

OWNER

Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

Ash Grove Cement Co, E Marginal, 3801 E Marginal Way S, Seattle, WA, 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

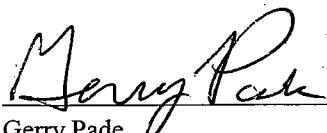
1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. The new cement storage dome is subject to 40 CFR Part 60, Subparts F and A.
4. There shall be no visible emissions or fallout from the new cement storage dome and baghouse.
5. The baghouse shall be equipped with a gauge to measure the pressure drop across the filters. The acceptable range shall be clearly marked on or near the gauge within 90 days of initial startup.
6. Ash Grove Cement shall record the pressure drop across the filters during each shift when the baghouse is in operation. If the pressure drop across the exhaust filters of the baghouse is not within the acceptable range, Ash Grove Cement shall take corrective actions within 24 hours in accordance with the O&M Plan or cease adding cement to the storage dome until the problem is repaired. Ash Grove shall maintain records of these corrective actions on site for at least two years and make them available to Puget Sound Clean Air Agency personnel upon request.

APPEAL RIGHTS

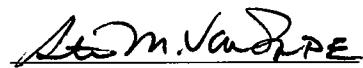
Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.

Order of Approval for NC No. 9711

JAN 02 2008



Gerry Pade
Reviewing Engineer
ns



Steven Van Slyke
Supervising Engineer



Puget Sound Clean Air Agency

Notice of
Construction No. 9769

Registration No. 11339

Date

FEB 12 2008

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Replacement of clinker/gypsum conveyor (511.BC5).

APPLICANT

Gerald Brown
Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

OWNER

Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

Ash Grove Cement Co, E Marginal, 3801 E Marginal Way S, Seattle, WA, 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. The new clinker/gypsum conveyor is subject to 40 CFR Part 60, Subparts F and A.
4. There shall be no visible emissions or fallout from the new clinker/gypsum conveyor and baghouses.
5. Each baghouse shall be equipped with a gauge to measure the pressure drop across the filters. The acceptable range shall be clearly marked on or near the gauge within 90 days of initial startup.
6. Ash Grove Cement shall record the pressure drop across the filters during each shift when the baghouse is in operation. If the pressure drop across the exhaust filters of the baghouse is not within the acceptable range, Ash Grove Cement shall take corrective actions within 24 hours in accordance with the O&M Plan or cease operation of the equipment until the problem is repaired. Ash Grove shall maintain records of these corrective actions on site for at least two years and make them available to Puget Sound Clean Air Agency personnel upon request.

APPEAL RIGHTS

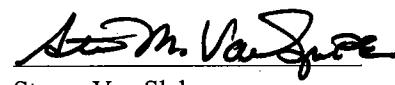
Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.

Order of Approval for NC No. 9769

FEB 12 2008



Gerry Pade
Reviewing Engineer
ns



Steven Van Slyke
Supervising Engineer



Puget Sound Clean Air Agency

Notice of
Construction No. 10695

Registration No. 11339

Date FEB 04 2014

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Substantial alteration of Group II silo baghouses 611.BF1 (truck loadout) and 611.BF2 (rail loadout) to decrease fugitive emissions. This is to be accomplished by changing the fan motor drive ratios to increase airflows from 1770 cfm to 3350 cfm and by changing from fabric to pleated cartridge filters.

APPLICANT

Gerald Brown
Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

OWNER

Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

Ash Grove Cement Co, E Marginal, 3801 E Marginal Way S, Seattle, WA, 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. There shall be no visible emissions or fallout from these dust collectors.
4. These dust collectors shall be equipped with gauges to measure the pressure drop across the filters. The normal operating range of pressure drop shall be clearly marked on (or near) the gauges within 30 days after startup and shall be included in the Operation & Maintenance plan.
5. These dust collectors shall be inspected monthly while in operation. If any exhibit visible emissions or fallout or are operating outside of the normal pressure drop range, Ash Grove shall take corrective actions (as specified in the Operations and Maintenance Plan) within 24 hours of the initial observation.
6. Records fully documenting all inspections and corrective actions shall be maintained for at least 5 years and be made available to Puget Sound Clean Air Agency personnel upon request

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.

Order of Approval for NC No. 10695

FEB 04 2014

Gerry Pade
Gerry Pade
Reviewing Engineer
ns

Carole Cenci PE
Carole Cenci
Senior Engineer



Puget Sound Clean Air Agency

Notice of
Construction No. 10742

Registration No. 11339

Date

MAY 22 2014

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Pneumatic conveying system for shuttling CKD from the main baghouse to the finish mills, including the installation of a 300 ton CKD storage silo controlled by a FLS Model 64TA10FM baghouse and a FLS Model 25TA10FM baghouse for the existing 25 ton fringe bin (located in the finish mill building). This permit authorizes a change to the make and model of baghouses previously permitted to be installed under Order of Approval No. 10482.

APPLICANT

Gerald Brown
Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

OWNER

Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

Ash Grove Cement Co, E Marginal, 3801 E Marginal Way S, Seattle, WA, 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

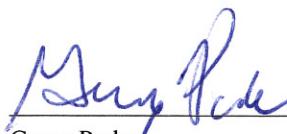
1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. The conveyor transfer points (baghouse dust storage silo and fringe bin) are subject to NSPS Subparts F and A.
4. There shall be no visible emissions from the conveyor transfer points (CKD storage silo and fringe bin).
5. There shall be no visible emissions or fallout from the baghouses.
6. The baghouses shall be equipped with a gauge to measure the pressure drop across the filters. The normal operating range of pressure drop shall be clearly marked on (or near) the gauge and be included in the Operation & Maintenance plan.
7. The baghouses shall be inspected during each month of operation. If the baghouses exhibit visible emissions or fallout or are operating outside of the normal pressure drop range, Ash Grove Cement shall discontinue CKD transfer operations until corrective action has been taken.
8. Records documenting all inspections and corrective actions shall be maintained for at least 5 years and be made available to Puget Sound Clean Air Agency personnel upon request.
9. This Order of Approval No. 10742, issued for changes to the size, make and model of baghouses previously permitted, hereby cancels and supersedes Order of Approval No. 10482 (dated 11/26/12).

Order of Approval for NC No. 10742

MAY 22 2014

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.



Gerry Pade
Reviewing Engineer
ns



Carole Cenci
Senior Engineer

GENERAL REGULATORY ORDER

Under the authority of Puget Sound Clean Air Agency Regulation I, Section 3.03, General Regulatory Orders, this Order is issued to:

Ash Grove Cement Co, E Marginal

for the facility located at:

**3801 E Marginal Way S
Seattle, WA 98134-1113**

1. Ash Grove Cement (Ash Grove) shall comply with emission limits pursuant to Consent Decree (CD) Civil Action Case No. 2:13-cv-02299-JTM-DJW. District of Kansas, entered on August 14, 2013, as incorporated into this Order.
2. The following definitions shall apply to this Order:
 - a. *“30-Day Rolling Average Emission Limit”* shall mean the maximum allowable rate of emission of a specified air pollutant and shall be expressed as pounds of such air pollutant emitted per Ton of clinker produced. Compliance with the 30-Day Rolling Average Emission Limit shall be determined in accordance with the following procedure: first, sum the total pounds of the air pollutant in question emitted from the Kiln during that Operating Day and the previous twenty-nine (29) Operating Days as measured for NO_x or SO₂, as applicable; second, sum the total Tons of clinker produced by the Kiln during the same Operating Day and previous 29 Operating Days; and third, divide the total number of pounds of the air pollutant emitted from the Kiln during the thirty (30) Operating Days by the total Tons of clinker produced by such Kiln during the same 30 Operating Days. A new compliance determination of the 30-Day Rolling Average Emission Limit shall be calculated for each new Operating Day in accordance with the provisions of this Order. In calculating each compliance determination of the 30-Day Rolling Average Emission Limit in accordance with this Order for NO_x or SO₂, the total pounds of such air pollutant emitted from the Kiln during a specified period (Operating Day or 30-Day Period) shall include all emissions of that pollutant from the subject Kiln that occur during the specified period, including emissions during each Startup, Shutdown, or Malfunction. Compliance with the 30-Day Rolling Average Emission Limits established in this Order for PM Control Technology and Emission Limits shall be demonstrated by operating the PM CPMS at the Kiln consistent with the performance testing and continuous parametric monitoring requirements for PM Continuous Parametric Monitoring Systems in this Order.
 - b. *“30-Day Rolling Average Emission Rate”* shall mean the rate of emission of NO_x expressed as pounds (lbs.) per Ton of clinker produced and calculated in accordance with the following procedure: first, sum the total pounds of the pollutant in question emitted from the Kiln during an Operating Day and the previous twenty-nine (29) Operating Days, as measured for NO_x; second, sum the total Tons of clinker produced by the Kiln during the same Operating Day and previous 29 Operating Days; and third, divide the total number of pounds of NO_x emitted from the Kiln during the thirty (30) Operating Days referred to above by the total Tons of clinker produced at such Kiln during the same 30 Operating Days. A new 30-Day Rolling Average Emission Rate shall be calculated for each new Operating Day. In calculating each 30-Day Rolling Average Emission Rate, the total pounds of NO_x emitted from a Kiln during a specified period (Operating Day or 30-Day Period) shall include all emissions of that pollutant from the

General Regulatory Order for NC No. 10825 JAN 28 2016

subject Kiln that occur during the specified period, including emissions during each Startup, Shutdown, or Malfunction.

- c. "*Baghouse*" shall mean a pollution control system used for the removal and collection of Particulate Matter from Kiln flue gases.
- d. "*CEMS*" or "*Continuous Emission Monitoring System*" shall mean, for obligations involving NO_x and SO₂, under this Order, the total equipment and software required to sample and condition (if applicable), to analyze, and to provide a record of NO_x and SO₂ emission rates, and the raw data necessary to support the reported emission rates, and that have been installed and calibrated in accordance with 40 C.F.R. § 60.13 and 40 C.F.R. Part 60 Appendix B and Appendix F.
- e. "*CPMS*" or "*Continuous Parametric Monitoring System*" shall mean, for obligations involving PM under this Order, the total equipment and software required to establish and monitor a site-specific operating limit corresponding to the results of the performance test demonstrating compliance with the PM limit in accordance with 40 C.F.R. § 63.1350.
- f. "*Consent Decree*" or "*Decree*" shall mean Consent Decree (CD) Civil Action Case No. 2:13-cv-02299-JTM-DJW. District of Kansas, entered on August 14, 2013 and any Appendix attached thereto.
- g. "*Continuously Operate*" or "*Continuous Operation*" shall mean that when a Control Technology is used at the Kiln, it shall be operated at all times of Kiln Operation, excluding Malfunction of the Control Technology, consistent with the technological limitations, manufacturers' specifications, and good engineering and maintenance practices for such Control Technology and the Kiln.
- h. "*Control Technology*" shall mean Baghouse for the kiln.
- i. "*Day*" shall mean a calendar day.
- j. "*Demonstration Phase*" shall mean that period of time identified in Appendix A of the Consent Decree, following optimization, and at the conclusion of which, Ash Grove will propose a 30-Day Rolling Average Emission Limit for NO_x that is consistent with optimized operation of the Seattle Kiln and that will be applied in accordance with this Order and the originating Consent Decree.
- k. "*Emission Limit*" shall mean the maximum allowable Emission Rate of a specified air pollutant from any Kiln and shall be expressed as pounds of such air pollutant emitted per Ton of clinker produced.
- l. "*Emission Rate*" for a specified air pollutant from any Kiln shall mean the number of pounds of such air pollutant emitted per Ton of clinker measured in accordance with this Order.
- m. "*Kiln*" as used in this Order shall mean a device, including any associated preheater or precalciner devices, inline raw mills, inline coal mills that produces clinker by heating limestone and other materials for subsequent production of portland cement. Because the inline raw mill is considered an integral part of the Kiln, for purposes of determining the appropriate emissions limit, the term Kiln also applies to the exhaust of the inline raw mill.

- n. "*Kiln Operation*" shall mean any period when any raw materials are fed into the Kiln and any combustion is occurring in the Kiln.
- o. "*Malfunction*" as used in this Order shall have the same meaning as defined at 40 C.F.R. § 60.2.
- p. "*NO_x*" shall mean oxides of nitrogen, measured in accordance with the provisions of this Order.
- q. "*Operating Day*" shall mean any Day on which Kiln Operation has occurred.
- r. "*Particulate*," "*Particulate Matter*" or "*PM*" shall have the same meaning as in 40 C.F.R. Part 63, Subpart LLL.
- s. "*Shut Down*" shall mean the cessation of kiln operation. Shutdown begins when feed to the kiln is halted and ends when continuous kiln rotation ceases.
- t. "*Site Specific Operating Limit*" or "*SSOL*" is the parametric limit used to monitor the operation of the particulate control device. The SSOL is also referred to as the "site specific CPMS limit" in 40 CFR Part 63 Subpart LLL. The SSOL requirements are contained in Conditions No. 19-26 of this Order.
- u. "*SO₂*" shall mean the pollutant sulfur dioxide, measured in accordance with the provisions of this Order.
- v. "*Startup*" shall mean the time from when a shutdown kiln first begins firing fuel until it begins producing clinker. Startup begins when a shutdown kiln turns on the induced draft fan and begins firing fuel in the main burner. Startup ends when feed is being continuously introduced into the kiln for at least 120 minutes or when the feed rate exceeds 60 percent of the kiln design limitation rate, whichever occurs first.
- w. "*Ton*" or "*Tons*" shall mean short ton or short tons.

NO_x Emission Limit

- 3. Ash Grove shall submit an optimization protocol to the U.S. EPA for the Seattle Kiln in accordance with the applicable procedures of Appendix A to the Consent Decree, identified as the Seattle Kiln NO_x Emission Reduction Report, for the purpose of optimizing the operation of the Seattle Kiln to reduce NO_x emissions to the maximum extent practicable from that Kiln. The Seattle Kiln NO_x Emission Reduction Report shall conform to the applicable procedures set forth in Appendix A to the Consent Decree for the establishment of a 30-Day Rolling Average Emission Limit for NO_x at the Seattle Kiln. Consistent with the requirements and deadlines specified in Appendix A to the Consent Decree, Ash Grove shall demonstrate compliance and thereafter maintain compliance with the proposed 30-Day Rolling Average Emission Limit for NO_x at the Seattle Kiln. Ash Grove need not demonstrate compliance at the stack venting exhaust gases from the Seattle coal mill. However, Ash Grove shall control indirect-fired coal mill feed gas from the kiln exhaust according to the standard protocol of the coal mill system. Ash Grove shall not adjust, increase or activate the coal mill feed gas in order to affect the emissions at the main stack in any way.
- 4. The U.S. EPA, in consultation with the Puget Sound Clean Air Agency (Agency or the Agency), shall review the Seattle Kiln NO_x Emission Reduction Report in accordance with the Consent Decree. Consistent with the requirements and deadlines specified in Appendix A to the Consent Decree, Ash Grove shall take all actions required pursuant to that review, including but not limited to achieving and maintaining compliance with the 30-Day Rolling Average Emission Limit for NO_x at the Seattle

General Regulatory Order for NC No. 10825 JAN 28 2016

Kiln approved, conditionally approved, or partially approved by U.S. EPA, in accordance with the Consent Decree.

5. Within 120 Days after the establishment of any Emission Limits pursuant to Appendix A of the Consent Decree, Ash Grove shall submit an application to the Agency to incorporate all Appendix A Emission Limits, and any associated requirements and limitations, into federally enforceable construction or other permits (other than Title V permits) which are federally enforceable. Following submission of the permit application by Ash Grove to this Agency, Ash Grove shall cooperate with the Agency by promptly submitting all information that the Agency seeks following its receipt of the permit application.
6. Upon issuance of any permit or approval required by Condition No. 5 of this Order, Ash Grove shall file any applications necessary to incorporate the requirements of that permit into the Title V operating permit. Ash Grove shall not challenge the inclusion in any such permit of the Emission Limits expressly prescribed in this Order and the referenced Consent Decree (including, where applicable, 30-Day Rolling Average Emission Limits determined in accordance with Appendix A). Nothing in this Order and the referenced Consent Decree is intended nor shall it be construed to require the establishment of Emission Limits other than those Emission Limits expressly prescribed in the referenced Consent Decree; nor to preclude Ash Grove from challenging any more stringent Emission Limits should they be proposed for reasons independent of this Order and Consent Decree.

NO_x Continuous Emission Monitoring System

7. Ash Grove shall install and make operational no later than twelve months after the Effective Date of the Consent Decree a NO_x continuous emissions monitoring system (CEMS) at the stack which collects emissions from the Kiln in accordance with the requirements of 40 C.F.R. Part 60. Ash Grove is not required to install or operate NO_x CEMS on the stack(s) of the indirect fired coal mills.
8. Ash Grove shall determine and record the daily clinker production rates by either one of the two following methods:
 - a. Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of clinker produced in tons of mass per hour.; or
 - b. Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of feed to the kiln in tons of mass per hour. Ash Grove shall calculate hourly clinker production rate using a kiln specific feed-to-clinker ratio based on reconciled clinker production determined for accounting purposes and recorded feed rates. This ratio should be updated no less frequently than once per month. If this ratio changes at clinker reconciliation, the new ratio must be used going forward, but it is not necessary to retroactively change clinker production rates previously estimated.
9. Except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments, the CEMS required in Condition No. 7 of this Order shall be operated at all times during Kiln Operation. The CEMS shall be used to demonstrate compliance with the NO_x Emission Limits established through the requirements identified in Conditions Nos. 3,4, 5 and 6 of this Order.
10. The NO_x CEMS required in Condition No. 7 of this Order shall monitor and record the applicable NO_x emission rate from the Kiln stack in units of lbs. of NO_x per Ton of clinker produced and shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 C.F.R. Part 60.
11. For purposes of this Order, all emissions of NO_x from the kiln shall be measured by CEMS. During any time when CEMs are inoperable and otherwise not measuring emissions of NO_x from any Kiln,

Ash Grove shall apply the missing data substitution procedures in 40 C.F.R. Part 75, Subpart D.

SO₂ Emission Limit

12. Ash Grove shall demonstrate compliance and thereafter maintain compliance with the 30-Day Rolling Average Emission Limit for SO₂ of 0.4 lbs. SO₂/Ton of clinker on the 30th Operating Day following September 10, 2013. Ash Grove need not demonstrate compliance with the 30-Day Rolling Average Emission Limit for SO₂ at the stack venting exhaust gases from the coal mill. However, Ash Grove shall control indirect-fired coal mill feed gas from the kiln exhaust according to the standard protocol of the coal mill system. Ash Grove shall not adjust, increase or activate the coal mill feed gas in order to affect the emissions at the main stack in any way.

SO₂ Continuous Emission Monitoring Systems

13. Ash Grove shall install and make operational no later than twelve months after the Effective Date of the Consent Decree, a SO₂ continuous emissions monitoring system (CEMS) at the stack which collects emissions from the Kiln in accordance with the requirements of 40 C.F.R. Part 60. Ash Grove is not required to install or operate SO₂ CEMS on the stack(s) of the indirect fired coal mills.
14. Except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments, the CEMS required in Condition No. 13 of this Order shall be operated at all times during Kiln Operation. The CEMS shall be used to demonstrate compliance with the SO₂ Emission Limits established through the requirements identified in Condition No. 12 of this Order.
15. The SO₂ CEMS required in Condition No. 13 of this Order shall monitor and record the applicable SO₂ emission rate from the Kiln stack in units of lbs. of SO₂ per Ton of clinker produced and shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 C.F.R. Part 60.
16. For purposes of this Order, all emissions of SO₂ from the Kiln shall be measured by CEMS. During any time when CEMs are inoperable and otherwise not measuring emissions of SO₂ from the Kiln, Ash Grove shall apply the missing data substitution procedures in 40 C.F.R. Part 75, Subpart D.

PM Control Technology and Emission Limit

17. Ash Grove shall demonstrate compliance and thereafter maintain compliance with the PM limit of 0.07 lbs. PM/Ton of clinker no later than September 10, 2013. Compliance shall be demonstrated using a three run EPA Method 5 or Method 5I performance test and that performance test shall be repeated no less frequently than every 365 Operating Days thereafter. If performance testing would be required less than 15 Operating Days after the Kiln has completed Startup after being down for more than 24 hours, then performance testing may be deferred up to 15 Operating Days after completion of the Startup. Ash Grove need not demonstrate compliance at the stack venting exhaust gases from the coal mills. However, Ash Grove shall control indirect-fired coal mill feed gas from the kiln exhaust according to the standard protocol of the coal mill system. Ash Grove shall not adjust, increase or activate the coal mill feed gas in order to affect the emissions at the main stack in any way. The methods specified in this condition of this Order for demonstrating compliance with the PM limits are not intended to change the means by which Ash Grove demonstrates compliance with standards not addressed by this Order.
18. For each performance test, Ash Grove shall conduct three separate runs under the conditions that exist when the Kiln is operating at the highest load or capacity level reasonably expected to occur. Ash Grove shall conduct each test run to collect a minimum sample volume of 2 dry standard cubic meters ("dscm") for determining compliance with a new source limit and 1 dscm for determining compliance with an existing source limit. Ash Grove shall calculate the average of the results from three runs to determine compliance. Ash Grove need not determine the PM collected in the impingers ("back half") of the EPA Method 5 or Method 5I particulate sampling train to demonstrate compliance with the PM Emission Limits of this Order. This shall not preclude the Agency from

General Regulatory Order for NC No. 10825 JAN 28 2016

requiring a determination of the “back half” for other purposes nor shall it be deemed to exempt Ash Grove from any other applicable PM limit.

PM Continuous Parametric Monitoring Systems

19. Ash Grove shall install and make operational a PM continuous parametric monitoring system (CPMS) at the stack from which the Kiln directly discharges emissions, in accordance with the requirements of Conditions No. 20-26 of this Order and 40 C.F.R. §63.1350(b) and (d). Ash Grove is not required to install or operate PM CPMS on the stack(s) of the indirect fired coal mills unless otherwise required to do so under any other applicable regulation.
20. Ash Grove shall use a PM CPMS to establish a Site-Specific Operating Limit (SSOL) for PM corresponding to the results of the performance test demonstrating compliance with the PM limit. Ash Grove shall conduct a performance test using EPA Method 5 or Method 5I at appendix A-3 of 40 C.F.R. Part 60.
21. Except during CPMS breakdowns, repairs, calibration checks, and zero span adjustments, the CPMS required by Conditions No. 19 and 20 of this Order shall be operated at all times during Kiln Operation.
22. Ash Grove shall reassess and adjust each SSOL, developed in accordance with Conditions No. 19, 20, 22, and 23 of this Order and in accordance with the results of each most recent PM performance test demonstrating compliance with the PM Emission Limit. The SSOL will correspond to the highest 1 hour average CPMS output value recorded during any performance test demonstrating compliance.
23. The CPMS required in Condition No. 19 of this Order shall monitor and record the output data for all periods of Kiln Operation and the CPMS is not out-of-control. Compliance with the SSOL must be demonstrated by using all quality-assured hourly average data collected by the CPMS for all hours of Kiln Operation to calculate the arithmetic average operating parameter in units of the operating limit (e.g., millamps, PM concentration, raw data signal) on a 30 Operating Day rolling average basis, updated at the end of each new Kiln Operating Day.
24. To determine continuous compliance, Ash Grove must record the PM CPMS output data for all periods of Kiln Operation when the PM CPMS is not out-of-control. Ash Grove must demonstrate continuous compliance by using all quality-assured hourly average data collected by the PM CPMS for all operating hours to calculate the arithmetic average operating parameter in units of the operating limit (e.g., millamps, PM concentration, raw data signal) on a 30 operating day rolling average basis, updated at the end of each new kiln operating day. Use the following equation to determine the 30 kiln operating day average:

$$30 \text{ kiln operating day} = \frac{\sum_{i=1}^n H_{pvi}}{n}$$

where:

H_{pvi} = The hourly parameter value for hour i ; n is the number of valid hourly parameter values collected over 30 kiln operating days

25. For any deviation from the SSOL established in accordance with Condition No. 20 of this Order, Ash Grove shall:
 - a. Within 48 hours of the deviation, visually inspect the PM Control Technology;
 - b. If inspection of the PM Control Technology identifies the cause of the deviation, take corrective action as soon as possible, and return the CPMS measurement to within the SSOL;

General Regulatory Order for NC No. 10825 JAN 28 2016

and

c. Within 45 Days of the deviation or at the time of the annual compliance test, whichever comes first, conduct a PM emissions compliance test to determine compliance with the PM emissions limit and to verify or re-establish the SSOL consistent with Conditions No. 20, 22, and 23 of this Order. Ash Grove is not required to conduct additional testing for any deviations that occur between the time of the original deviation and the PM emissions compliance test required under this condition of the Order.

26. Ash Grove shall not have deviations of the 30 day rolling average from the established SSOL leading to more than four required performance tests in a 12-consecutive month period (rolling monthly).

APPEAL RIGHTS

Pursuant to Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, an appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of receiving this Order.



Gerry Pade
Reviewing Engineer



Carole Cenci
Compliance Manager



Puget Sound Clean Air Agency

Notice of
Construction No.

11436

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Date NOV 14 2017

One MB America model BF 120.4 S2 crusher bucket rated at 65 yd³/hr for crushing of kiln refractory brick, kiln coating (clinker), and raw mill rejects (oversize limestone or gypsum), and finish mill (oversize clinker) rejects.

APPLICANT

**Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134**

OWNER

**Ash Grove Cement Co, E Marginal
3801 E Marginal Way S
Seattle, WA 98134**

INSTALLATION ADDRESS

Ash Grove Cement Co, E Marginal, 3801 E Marginal Way S, Seattle, WA 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

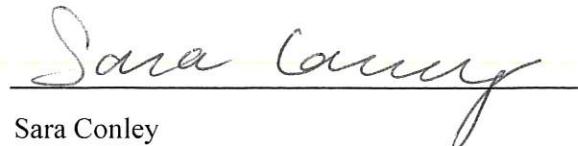
1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. This crusher is subject to NSPS Subparts F and A.
4. Within 30 days after initial startup of the crusher, the owner or operator of such facility shall conduct an opacity test and furnish the Agency a written report and the results of such performance test.
5. Opacity tests shall be conducted and data reduced in accordance with EPA test Method 9.
6. Opacity shall not exceed 10% as measured using EPA method 9 and as outlined in NSPS Subparts F and A.

Order of Approval for NC No. 11436

NOV 14 2017

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.



Sara Conley
Reviewing Engineer



Carole Cenci
Compliance Manager

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339

Date APR 08 2019

Replace main kiln baghouse with a Dustex 10-module pulse jet baghouse with rated flow rate of 185,000 ACFM and incorporate previously approved existing equipment (previous NOC7381 consisting of one dry process 92-ton/hour (2200 ton/day, 750,000 ton/year) coal-fired Cement Plant including the following existing equipment:

- a. systems 216, 311-Limestone Reclaim, 312-Clay/Shale Reclaim, 314-Iron Reclaim, 41A-Coal Silo, 315-Raw Mill Feed, 316-Raw Mill, 317-Transport to Blending, 411-Feed Blending and Storage (Dry), 416-Kiln #1 tube, 41B-Raw Coal Bin and Feed and Coal Mill, 41C-Coal Mill and firing equipment, and 419-Clinker Conveying, with 24 Baghouses of various sizes (1990); and
- b. two 60-ton/hour Finish Mill High Efficiency Separators with two 77,000 cfm Baghouses (515.BF2, 525.BF2) (1995);

APPLICANT

OWNER

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

Ash Grove Cement Company , 3801 E Marginal Way S, Seattle, WA 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.

Specific Conditions:

3. This source is subject to Subpart A, F, and Y of 40 CFR Part 60 and Subpart LLL of 40 CFR Part 63.
4. PM-10 emissions from each baghouse, except the main kiln baghouse, shall not exceed 0.005 grains/dscf over a 24-hour period. Ash Grove may demonstrate compliance with this condition by any of the following:
 - a. Performing a Puget Sound Clean Air Agency-approved source test according to EPA Method 5 or EPA Method 201A;
 - b. Demonstrating no visible emissions for 15 consecutive seconds;

Order of Approval for NC No. 11681

- c. Demonstrating no visible emissions for three consecutive minutes; or
- d. Repairing within 24 hours, any baghouse that has visible emissions for more than three consecutive minutes.

Compliance shall be determined for visible emissions using EPA Method 22. The Puget Sound Clean Air Agency may require a source test for any baghouse that has sustained visible emissions, unless such emissions are unavoidable under WAC 173-400-107.

5. Except during startup and shutdown of the kiln, scheduled maintenance and for emissions considered unavoidable under WAC 173-400-107, emissions from the main baghouse shall not exceed the most stringent of PSD limits or the following limits:
 - a. Carbon monoxide (CO) emissions shall not exceed 1049 ppm (parts per million) corrected to 10% oxygen (O₂) for an 8-hour average, and CO shall not exceed 2353 tons per year;
 - b. Nitrogen oxides (NO_x) emissions shall not exceed 650 ppm corrected to 10% O₂ as a 24-hour rolling average, and NO_x emissions shall not exceed 1846 tons as a 12-month running total; and if the NO_x emissions exceed 1400 tons as a 12-month running total, Ash Grove shall notify the Puget Sound Clean Air Agency (Attn: Facility Submittal) describing actions that will be implemented to assure compliance with the annual NO_x limit.
 - c. Sulfur dioxide (SO₂) emissions shall not exceed 180 ppm corrected to 10% O₂ for a one-hr average, and 176 tpy;
 - d. Particulate matter (PM) emissions shall not exceed 10.6 pounds per hour, and 46 tpy.

6. Particulate matter (PM) emissions shall not exceed 0.07 lb/ton clinker on a 30-day rolling average.
7. To determine continuous compliance, Ash Grove must record the PM CPMS output data for all periods of Kiln Operation when the PM CPMS is not out-of-control. Ash Grove must demonstrate continuous compliance by using all quality-assured hourly average data collected by the PM CPMS for all operating hours to calculate the arithmetic average operating parameter in units of the operating limit (e.g., millamps, PM concentration, raw 1 data signal) on a 30 operating day rolling average basis, updated at the end of each new kiln operating day. Use the following equation to determine the 30 kiln operating day average.

$$30\text{ kiln operating day} = \frac{\sum_{i=1}^n H_{pvi}}{n}$$

where: H_{pvi} = The hourly parameter value for hour i; n is the number of valid hourly parameter values collected over 30 kiln operating days.

8. During startup and shutdown of the kiln, and during scheduled maintenance on the main kiln baghouse, all of the emission limits stated in Condition No. 5 apply, except that emissions from the main kiln stack shall not exceed the following limits.
 - a. During the kiln startup-preheating period prior to kiln feed introduction, the SO₂ emission limit for the main kiln stack shall consist of compliance with the following work practices and fuel restrictions:
 - i. Only natural gas shall be used as fuel and the facility must comply with the start-up and shutdown requirements outlined in 40 CFR Part 63.1346 (g), and

Order of Approval for NC No. 11681

- ii. Sulfur rings shall be removed from the kiln prior to startup, if sulfur ring formation had required the kiln to be shut down.
- b. During the kiln startup-feed introduction period, SO₂ emissions from the main kiln stack shall not exceed 200 ppm corrected to 10% O₂ for a one-hr average.
- 9. Any shutdown of the kiln shall follow the normal rotation and cool down procedures and remove of as much material from the kiln as possible without damaging system components.
- 10. Ash Grove shall log as part of the Operations and Maintenance Plan and report to the Puget Sound Clean Air Agency as part of the monthly Continuous Emission Monitoring Report:
 - a. The date, start and end times, and the fuel used for kiln startup-preheating periods prior to feed introduction;
 - b. The sulfur ring removal from the kiln, if the ring formation required the kiln to be shut down;
 - c. The date, start and end times for kiln startup-feed introduction periods; and
 - d. The cause for kiln shut down, the duration of kiln cool down and the kiln rotation schedule in kiln cool down.
- 11. Ash Grove shall monitor and report CO, NO_x, SO₂, and opacity emissions from the main kiln baghouse according to Article 12 of Regulation I. SO₂ emissions from the main stack shall be monitored at all times following the introduction of feed to the kiln.
- 12. Ash Grove shall monitor and report PM emissions from the main kiln baghouse according to Regulation I Article 12.03 (d), 12.03 (e), and 12.03 (f)(1-3).

Main Kiln Baghouse Operation and Maintenance

- 13. Main kiln baghouse shall be operated continuously while the kiln is in operation.
- 14. The differential pressures across the baghouse shall be maintained according to the manufacturer's recommended design minimum and maximum differential pressure. The established manufacturer's design minimum and maximum differential pressures must be clearly marked nearby the monitoring interfaces of the baghouse.
- 15. Records of all baghouse inspections, corrective actions, and logs shall be maintained for at least five years and made available to Puget Sound Clean Air Agency personnel upon request.
- 16. This Order of Approval No. 11681 cancels and supersedes Order of Approval 7381, dated 6/6/2001 on startup of the baghouse approved under this Order.

Order of Approval for NC No. 11681

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.



Sara Conley
Reviewing Engineer



Carole Cenci
Compliance Manager



Clean Air Agency

Puget Sound Clean Air Agency

Notice of
Construction No.

11983

HEREBY ISSUES AN ORDER OF APPROVAL TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339
Date

APR 29 2022

Selective NonCatalytic Reduction (SNCR) for NOx control from the cement kiln.

Incorporate the 30-Day Rolling Average Emission Limit for NOx required by 2013 Global Consent Decree (GCD) into Federally Enforceable Permit Limit [GCD Global Consent Decree Civil Action Case No. 2:13-cv-02299-JTM-DJW. District of Kansas, entered on August 14, 2013 and terminated April 30, 2020].

OWNER

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134

INSTALLATION ADDRESS

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. There shall be no visible detached plume from the main stack. Ash Grove shall conduct monthly visual observations for detached plumes while the SNCR is in operation during daylight hours. No monitoring is required for any month during which the SNCR did not operate during daylight hours. The monitoring frequency may be reduced to quarterly after 2 years, if no detached plumes are observed. However, it shall revert back to monthly in the event a detached plume is observed.
4. As an alternative to complying with Condition 3 of this Order, the ammonia slip shall not exceed 10 ppmvd (@7% oxygen, 3-hr average), as determined either by an ammonia CEMS or stack tests (BAAQMD Method ST-1B, EPA Method CTM-027, or EPA Method 320) conducted at least once every 12 months.

NOx Emission Limit

5. Ash Grove shall maintain compliance with the 30-Day Rolling Average Emission Limit for NOx of 5.1 lb NOx/ton clinker at the Seattle Kiln. Ash Grove need not demonstrate compliance at the stack venting exhaust gases from the Seattle coal mill. However, Ash Grove shall control indirect-fired coal mill feed gas from the kiln exhaust according to the standard protocol of the coal mill system. Ash Grove shall not adjust, increase, or activate the coal mill feed gas in order to affect the emissions at the main stack in any way.

NOx Continuous Emission Monitoring System

6. Ash Grove shall use a NOx continuous emissions monitoring system (CEMS) at the Main Kiln Stack to show compliance with condition 5.
7. Ash Grove shall determine and record the daily clinker production rates by either one of the two following methods:
 - a. Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of clinker produced in tons of mass per hour.; or

Order of Approval for NC No. 11983

b. Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of feed to the kiln in tons of mass per hour. Ash Grove shall calculate hourly clinker production rate using a kiln specific feed to clinker ratio based on reconciled clinker production determined for accounting purposes and recorded feed rates. This ratio should be updated no less frequently than once per month. If this ratio changes at clinker reconciliation, the new ratio must be used going forward, but it is not necessary to retroactively change clinker production rates previously estimated.

8. Except during CEMS breakdowns, repairs, calibration checks, and zero span adjustments, the CEMS required in Condition No. 6 of this Order shall be operated at all times during Kiln Operation. The CEMS shall be used to demonstrate compliance with the NOx Emission Limit.
9. The NOx CEMS required in Condition No. 6 of this Order shall monitor and record the applicable NOx emission rate from the Kiln stack in units of lbs. of NOx per Ton of clinker produced and shall be installed, certified, calibrated, maintained, and operated in accordance with the applicable requirements of 40 CFR Part 60.
10. For purposes of this Order, all emissions of NOx from the kiln shall be measured by CEMS. During any time when CEMs are inoperable and otherwise not measuring emissions of NOx from any Kiln, Ash Grove shall apply the missing data substitution procedures in 40 CFR Part 75, Subpart D.
11. Upon issuance, this permit will cancel and supersede NOC 11091 issued June 23, 2016.

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.


for
Carl Slimp
Reviewing Engineer


John Dawson
Engineering Manager



Clean Air Agency

Puget Sound Clean Air Agency

Notice of
Construction No.

12003

HEREBY ISSUES AN ORDER OF APPROVAL
TO CONSTRUCT, INSTALL, OR ESTABLISH

Registration No. 11339
Date

DEC 05 2026

Operation of One AGC-Seattle Whole Tire Feed System for injecting whole tires as replacement fuel at the Calciner level of the Preheater Tower above the Kiln, which is controlled by an existing Baghouse. This Order does not authorize any physical changes to the existing Whole Tire Feed System.

OWNER

INSTALLATION ADDRESS

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134

Ash Grove Cement Company
3801 E Marginal Way S
Seattle, WA 98134-1113

THIS ORDER IS ISSUED SUBJECT TO THE FOLLOWING RESTRICTIONS AND CONDITIONS

1. Approval is hereby granted as provided in Article 6 of Regulation I of the Puget Sound Clean Air Agency to the applicant to install or establish the equipment, device or process described hereon at the INSTALLATION ADDRESS in accordance with the plans and specifications on file in the Engineering Division of the Puget Sound Clean Air Agency.
2. This approval does not relieve the applicant or owner of any requirement of any other governmental agency.
3. Ash Grove shall measure and record, each calendar day, the total weight of whole tires injected as non-hazardous secondary material fuel as defined by 40 CFR 241.4(a)(1).
4. Ash Grove shall submit a Fuel Monitoring Plan for injection of whole tires within 60 days after this approval. The plan shall contain the method for complying with condition 3, the replacement fuel composition (i.e., Btu content, percent ash, etc.), and the maximum rate of whole tires that will be used. The rate established in this submitted plan will become the new allowable maximum TDF firing percentage and will be the tire injection rate required during the testing for conditions 5, 7 and 9.
5. Within 60 days after the submittal of the updated fuel monitoring plan, Ash Grove shall complete a study to determine if this operational change results in an increase in the emission rate of metallic TAPs listed in WAC 173-460-150. The metals to be tested include arsenic, beryllium, cadmium, chromium, lead, manganese, nickel, and selenium. Ash Grove shall submit a test plan that includes fuel rates for each condition. Tests will be in accordance with EPA Method 29, and the methodology for determining if there is an increase in emissions of a pollutant will be in accordance with Appendix C to 40 CFR Part 60. Based on the results of this test, one of the following two conditions shall take effect:
 - a. If the study shows that modification does not lead to an increase in emissions of any tested TAP, the maximum rate of whole tires that will be used as defined in the Fuel Monitoring Plan required in condition 4 shall replace the previously established permitted tire consumption rate.
 - b. If the study shows that this modification results in an increase in the emission rate to the atmosphere of any TAP, then the previous established rate 30% TDF by weight, daily average limit shall remain in place.

A limit of 30% TDF by weight, daily average limit shall remain in effect until the results of this study are

Order of Approval for NC No. 12003

DEC 05 2025

reported, except for the days needed to conduct this study. During the days of this study, the TDF limit shall be defined in the fuel monitoring plan required by condition 4.

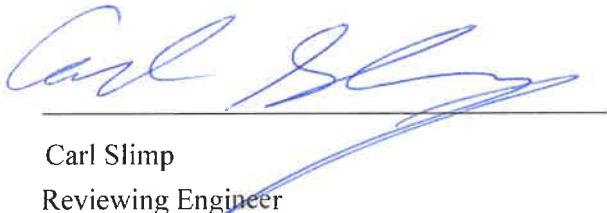
6. Ash Grove shall submit an Emission Monitoring Plan within 60 days after this approval. The plan shall contain the following elements:
 - a. Measurement methods, analytical procedure and testing dates for demonstrating compliance with the requirements of 40 CFR 63.1343(b)(1).
 - b. The measurement methods shall include a combination of Continuous Emission Rate Monitoring Systems, Continuous Emission Monitoring Systems and source tests to show compliance with 40 CFR 60 subpart F and 40 CFR 63 Subpart LLL.
7. Within 60 days after the submittal of the updated fuel monitoring plan, Ash Grove shall conduct source tests to demonstrate compliance with the following previously established emission limits:
 - a. Kiln exhaust shall not exceed 0.30 lb of particulate per ton of feed (dry basis) except during SSM periods.
 - b. Kiln exhaust shall not exceed 0.07 lb of particulate per ton of clinker except during SSM periods, per 40 CFR 63.1343(b)(1)
 - c. Ash Grove shall not cause to be discharged into the atmosphere from the kiln exhaust Dioxin/Furan (D/F) exceeding 0.20 ng/dscm (TEQ) @ 7% O₂. If the average temperature at the inlet to the baghouse during the D/F performance test is 400°F or less, this limit is changed to 0.40 ng/dscm (TEQ).
Ash Grove shall conduct the tests at the maximum rate of whole tire injection specified in condition 4. These source tests shall use EPA Method 5 or EPA method 201 A (particulate) and EPA method 23 (dioxins/ furans). Ash Grove shall submit a report of the test results within 60 days of testing.
8. Ash Grove shall report any deviation from the fuel monitoring plan that represent a potential threat to human health or safety as soon as possible but no later than 12 hours after such a deviation is discovered. Ash Grove shall report other deviations in writing to Puget Sound Clean Air Agency Operating Permit Certification no later than 30 days after the end of the month during which the deviation is discovered.
9. Within 60 days after the submittal of the updated fuel monitoring plan, Ash Grove shall conduct stack testing for hydrogen chloride per EPA Method 26 or 26A in accordance with PSCAA Regulation I 3.07. Ash Grove shall conduct the tests at the maximum rate of whole tire injection specified in condition 4 and shall use the tests to calculate a facility-specific emissions factor for HCl, in units of pounds of HCl per ton of clinker. The tests shall include three runs under raw-mill-up conditions, and three runs under raw-mill-down conditions.
10. This order of approval supersedes and cancels Order of Approval No. 5755, dated March 30, 1995.

Order of Approval for NC No. 12003

DEC 3 5 2020

APPEAL RIGHTS

Pursuant to Puget Sound Clean Air Agency's Regulation I, Section 3.17 and RCW 43.21B.310, this Order may be appealed to the Pollution Control Hearings Board (PCHB). To appeal to the PCHB, a written notice of appeal must be filed with the PCHB and a copy served upon Puget Sound Clean Air Agency within 30 days of the date the applicant receives this Order.



Carl Slimp
Reviewing Engineer



John Dawson PE
Engineering Manager