

**Iowa Department of Natural Resources
Title V Operating Permit**

Name of Permitted Facility: Benson Hill Ingredients, LLC
Facility Location: 1310 East Howard St., Creston, IA 50801
Air Quality Operating Permit Number: 03-TV-016R2-M001
Expiration Date: August 11, 2026
Permit Renewal Application Deadline: February 11, 2026

EIQ Number: 92-6881
Facility File Number: 88-01-021

Responsible Official

Name: Trent Collins
Title: SVP Ingredients Operations
Mailing Address: 1001 North Warson Rd, St. Louis, MO 63132
Phone #: 314-222-8212

Permit Contact Person for the Facility

Name: Isaac Arndt
Title: Plant Manager
Mailing Address: 1310 E Howard St, Creston, IA 50801
Phone #: 507-382-9528

This permit is issued in accordance with 567 Iowa Administrative Code Chapter 22, and is issued subject to the terms and conditions contained in this permit.

For the Director of the Department of Natural Resources



01/23/2023

Marnie Stein, Supervisor of Air Operating Permits Section

Date

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Abbreviations

acfm.....	actual cubic feet per minute
CFR.....	Code of Federal Regulation
CE	control equipment
CEM.....	continuous emission monitor
°F.....	degrees Fahrenheit
EIQ.....	emissions inventory questionnaire
EP	emission point
EU	emission unit
gr./dscf	grains per dry standard cubic foot
gr./100 cf.....	grains per one hundred cubic feet
IAC.....	Iowa Administrative Code
IDNR.....	Iowa Department of Natural Resources
MVAC.....	motor vehicle air conditioner
NAICS.....	North American Industry Classification System
NSPS.....	new source performance standard
ppmv	parts per million by volume
lb./hr	pounds per hour
lb./MMBtu	pounds per million British thermal units
SCC	Source Classification Codes
scfm.....	standard cubic feet per minute
SIC	Standard Industrial Classification
TPY.....	tons per year
USEPA.....	United States Environmental Protection Agency

Pollutants

PM.....	particulate matter
PM ₁₀	particulate matter ten microns or less in diameter
SO ₂	sulfur dioxide
NO _x	nitrogen oxides
VOC	volatile organic compound
CO.....	carbon monoxide
HAP.....	hazardous air pollutant

I. Facility Description and Equipment List

Facility Name: Benson Hill Ingredients, LLC

Permit Number: 03-TV-016R2-M001

Facility Description: Soybean Oil and Meal Production (SIC 2075)

Equipment List

Emission Point Number	Emission Unit Number	Emission Unit Description	IDNR Construction Permit Number
EP 101	EU 101	Natural Gas Boiler #1	97-A-955-S1
EP 101A	EU 101A	Natural Gas Boiler #2	99-A-497-S1
EP 102	EU 102	Soybean Oil Extraction	97-A-956-S3
	EU 116	Flash Desolventizer System	
EP 104	EU 104	Soybean Meal Drying – Deck 1	97-A-957-S2
	EU 105	Soybean Meal Drying – Deck 2	
	EU 106	Soybean Meal Cooling	
EP 107	EU 107a	Whole Bean Aspiration	97-A-960-S7
	EU 107b	Vertical Seed Conditioner	
	EU 107c	Jet Dryer	
	EU 107d	Cascade Dryer	
	EU 107e	Cascade Cooler	
	EU 107f	Secondary Aspiration	
	EU 107g	Pneumatic Conveying	
	EU 109a	Hull Grinder	
	EU 109b	Hull Grinder	
EU 110	Flaking Mills 1, 2, & 3		
EP 108	EU 108	Meal Grinding & Sizing	97-A-961-S4
EP 111	EU 111	Product Loadout	97-A-964-S3
EP 112	EU 112	Hulls Silo	97-A-965-S1
EP 114	EU 114	Soybean Meal Storage Bin	01-A-920
EP 114a			01-A-921
EP 115	EU 115	Whole Soybean Storage Bin	01-A-922
EP 115a			01-A-923
EP 117	EU 117	Soybean Meal Storage Bin	01-A-924
EP 117a			01-A-925
EP 119	EU 119	White Flake Cooling & Conveying	13-A-552
EP FP	EU FP	Emergency Fire Pump Engine	NA

Insignificant Activities Equipment List

Insignificant Emission Unit Number	Insignificant Emission Unit Description
I2	Repair Shop Welding
T1	Soybean Oil Shift Tank
T2	Soybean Oil Shift Tank
T3	Soybean Oil Shift Tank
T4	Raw Soybean Oil Tank A
T5	Raw Soybean Oil Tank B
T6	Raw Soybean Oil Tank C
T8	Raw Vegetable Oil Storage Tank
T9	Raw Vegetable Oil Storage Tank
FPDT	Fire Pump Diesel Tank (440 gallons)
PW	Maintenance Parts Washer
112b	Hull Silo Bin Vents
205	White Flake Conveying
206	White Flake Bins
207c	Bagging (Internal Exhaust System)
207	Packaging (50lb bagger) & Surge Bin
208	Grit Conveying
209	Grit Shaker
210	Grit Bin
211	Flour Conveying
212	Flour Grinding/Sizing 1
213	Flour Grinding/Sizing 2
214	Flour Grinding/Sizing 3
215	Flour Bins
216	Reject Bin
217	Vacuum System
218	Reject Toaster
CT	Cooling Tower
DT	Diesel Tank (1,000 gallons)
GT	Gasoline Tank (560 gallons)

II. Plant-Wide Conditions

Facility Name: Benson Hill Ingredients, LLC
Permit Number: 03-TV-016R2-M001

Permit conditions are established in accord with 567 Iowa Administrative Code rule 22.108

Permit Duration

The term of this permit is: Five (5) years from permit issuance
Commencing on: August 12, 2021
Ending on: August 11, 2026

Amendments, modifications and reopenings of the permit shall be obtained in accordance with 567 Iowa Administrative Code rules 22.110 - 22.114. Permits may be suspended, terminated, or revoked as specified in 567 Iowa Administrative Code Rules 22.115.

Emission Limits

Unless specified otherwise in the Source Specific Conditions, the following limitations and supporting regulations apply to all emission points at this plant:

Opacity (visible emissions): 40% opacity
Authority for Requirement: 567 IAC 23.3(2)"d"

Sulfur Dioxide (SO₂): 500 parts per million by volume
Authority for Requirement: 567 IAC 23.3(3)"e"

Particulate Matter:

No person shall cause or allow the emission of particulate matter from any source in excess of the emission standards specified in this chapter, except as provided in 567 – Chapter 24. For sources constructed, modified or reconstructed on or after July 21, 1999, the emission of particulate matter from any process shall not exceed an emission standard of 0.1 grain per dry standard cubic foot of exhaust gas, except as provided in 567 – 21.2(455B), 23.1(455B), 23.4(455B) and 567 – Chapter 24.

For sources constructed, modified or reconstructed prior to July 21, 1999, the emission of particulate matter from any process shall not exceed the amount determined from Table I, or amount specified in a permit if based on an emission standard of 0.1 grain per standard cubic foot of exhaust gas or established from standards provided in 23.1(455B) and 23.4(455B).
Authority for Requirement: 567 IAC 23.3(2)"a"

Fugitive Dust: Attainment and Unclassified Areas - A person shall take reasonable precautions to prevent particulate matter from becoming airborne in quantities sufficient to cause a nuisance as defined in Iowa Code section 657.1 when the person allows, causes or permits any materials to be handled, transported or stored or a building, its appurtenances or a construction haul road to be

used, constructed, altered, repaired or demolished, with the exception of farming operations or dust generated by ordinary travel on unpaved roads. Ordinary travel includes routine traffic and road maintenance activities such as scarifying, compacting, transporting road maintenance surfacing material, and scraping of the unpaved public road surface. (the preceding sentence is State Only) All persons, with the above exceptions, shall take reasonable precautions to prevent the discharge of visible emissions of fugitive dusts beyond the lot line of the property on which the emissions originate. The public highway authority shall be responsible for taking corrective action in those cases where said authority has received complaints of or has actual knowledge of dust conditions which require abatement pursuant to this subrule. Reasonable precautions may include, but not be limited to, the following procedures.

1. Use, where practical, of water or chemicals for control of dusts in the demolition of existing buildings or structures, construction operations, the grading of roads or the clearing of land.
2. Application of suitable materials, such as but not limited to asphalt, oil, water or chemicals on unpaved roads, material stockpiles, race tracks and other surfaces which can give rise to airborne dusts.
3. Installation and use of containment or control equipment, to enclose or otherwise limit the emissions resulting from the handling and transfer of dusty materials, such as but not limited to grain, fertilizer or limestone.
4. Covering, at all times when in motion, open-bodied vehicles transporting materials likely to give rise to airborne dusts.
5. Prompt removal of earth or other material from paved streets or to which earth or other material has been transported by trucking or earth-moving equipment, erosion by water or other means.
6. Reducing the speed of vehicles traveling over on-property surfaces as necessary to minimize the generation of airborne dusts.

Authority for Requirement: 567 IAC 23.3(2)"c"

III. Emission Point-Specific Conditions

Facility Name: Benson Hill Ingredients, LLC
Permit Number: **03-TV-016R2-M001**

Emission Point ID Numbers: EP 101 & EP 101A

Associated Equipment

Emission Point	Emission Unit	Emission Unit Description	Raw Material	Rated Capacity	Construction Permit
EP 101	EU 101	Natural Gas Boiler #1	Natural Gas	33.5 MMBtu/hr	97-A-955-S1
EP 101A	EU 101A	Natural Gas Boiler #2	Natural Gas	33.5 MMBtu/hr	99-A-497-S1

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from each emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permits 97-A-955-S1 & 99-A-497-S1
567 IAC 23.3(2)"d"

⁽¹⁾ An exceedance of the indicator opacity of "no visible emissions" will require the owner or operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the Department may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 0.25 lb/hr

Authority for Requirement: DNR Construction Permits 97-A-955-S1 & 99-A-497-S1

Pollutant: Particulate Matter

Emission Limit(s): 0.25 lb/hr, 0.6 lb/MMBtu

Authority for Requirement: DNR Construction Permits 97-A-955-S1 & 99-A-497-S1
567 IAC 23.3(2)"b"

Pollutant: Sulfur Dioxide (SO₂)

Emission Limit(s): 500 ppmv

Authority for Requirement: DNR Construction Permits 97-A-955-S1 & 99-A-497-S1
567 IAC 23.3(3)"e"

Operational Limits & Reporting/Record keeping Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. The owner or operator shall operate, inspect and maintain the boilers, Boilers #1 & #2, according to the manufacturer's specifications. The facility shall maintain a log of all maintenance and inspection activities performed on the emission units. This log shall include, but is not limited to:
 - (1) The date and time any inspection and/or maintenance was performed on the emission units;
 - (2) Any issue(s) identified during the inspection and the date each issue(s) was resolved; and,
 - (3) Any issue(s) addressed during the maintenance activities and the date each issue(s) was resolved.
- B. These emission units (Boilers #1 & #2) shall combust only natural gas.
 - (1) As specified in 40 CFR Part 60 §60.48c(g), the owner or operator of these emission units, Boilers #1 & #2, shall record and maintain records of the fuels combusted during each calendar month.
- C. The amount of natural gas consumed by Boiler #1 (EU-101) & Boiler #2 (EU-101A) shall not exceed 425.45 MMscf per rolling 12 month period.
 - (1) The facility shall calculate and record the total amount of natural gas combusted in Boiler #1 (EU-101) & Boiler #2 (EU-101A) per month.
 - (2) The facility shall monthly update and record the 12-month rolling total amount of natural gas combusted in Boiler #1 (EU-101) & Boiler #2 (EU-101A) per month.
- D. The owner or operator shall follow the applicable standards of Subpart Dc, 40 CFR 60.40c through 60.48c.

Authority for Requirement: DNR Construction Permits 97-A-955-S1 & 99-A-497-S1
567 IAC 23.1(2)"III"
40 CFR 60 Subpart Dc

Emission Point Characteristics

Each emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 30

Stack Opening, (inches, dia.): 37.7

Exhaust Flow Rate (scfm): 6,525

Exhaust Temperature (°F): 400

Discharge Style: Vertical Obstructed

Authority for Requirement: DNR Construction Permits 97-A-955-S1 & 99-A-497-S1

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall

submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 102

Associated Equipment

Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 102	Soybean Oil Extraction	CE 102: Mineral Oil Absorber	Soybeans	1,000 tons/day	97-A-956-S3
EU 116	Flash Desolventizer System				

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Volatile Organic Compounds (VOC's)

Emission Limit(s): 248 tons/yr

Authority for Requirement: DNR Construction Permit 97-A-956-S3

Pollutant: Total HAP

Emission Limit(s): Compliance Ratio $\leq 1.00^{(1)}$

Authority for Requirement: DNR Construction Permit 97-A-956-S3

567 IAC 23.1(4)"cg"

40 CFR 63 Subpart GGGG

⁽¹⁾ In accordance with 40 CFR §63.2840, the formula used to determine the Compliance Ratio is:

$$\text{Compliance Ratio} = \frac{f * \text{Actual Solvent Loss}}{0.64 * \sum_{i=1}^n ((\text{Oilseed})_i \times (\text{SLF})_i)}$$

Where:

Compliance Ratio = the ratio of the actual HAP loss in gallons from the previous twelve (12) operating months to an allowable HAP loss in gallons.

f = the weighted average volume fraction of HAP in solvent received during the previous twelve (12) operating months, as determined in 40 CFR §63.2854 (dimensionless).

Actual Solvent Loss = gallons of actual solvent loss during previous twelve (12) operating months, as determined in 40 CFR §63.2853.

Oilseed = tons of each oilseed type "i" processed during the previous twelve (12) operating months, as shown in 40 CFR §63.2855.

SLF = the corresponding solvent loss factor (gal/ton) for oilseed "i" listed in Table 1 of 40 CFR §63.2840. For existing corn germ, wet milling facilities the SLF is 0.4 gal/ton.

Operational Limits & Reporting/Record keeping Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. The extractant solvent usage shall not exceed 87,788 gallons per twelve-month rolling total. For demonstrating compliance with the VOC emission limit listed above, the owner or operator shall keep the following records:
 - (1) The owner or operator shall calculate and record the monthly and rolled 12-month totals of plant-wide extractant solvent usage in gallons.
 - (2) The owner or operator shall monthly determine the solvent loss (both in gallons and tons) from the facility (plant number 88-01-021) for each month of operation and determine the solvent loss (both in gallons and tons) from the facility (plant number 88-01-021) on a rolling twelve (12) month basis.
- B. For demonstrating compliance with the NESHAP Subpart GGGG requirements (See Total HAP limit above), the owner or operator shall determine the solvent loss to soybeans processed in accordance with 40 CFR §63.2840 and 40 CFR §63.2850 – 40 CFR §63.2855.
- C. Per 40 CFR §63.2851, the owner or operator shall develop and implement a written plan for demonstrating compliance that provides the detailed procedures to be followed to monitor and record data necessary for demonstrating compliance with NESHAP Subpart GGGG. The plan for demonstrating compliance shall include the following:
 - (1) The name and address of the owner or operator.
 - (2) The physical address of the vegetable oil production process.
 - (3) A detailed description of all methods of measurement the owner or operator will use to determine the solvent losses, HAP content of solvent, and the tons of each type of oilseed processed.
 - (4) When each measurement will be made.
 - (5) Examples of each calculation the owner or operator will use to determine the compliance status of the facility (plant number 88-01-021). The owner or operator shall include examples of how data measured with one parameter will be converted to other terms for use in the compliance determination.
 - (6) Example logs of how the data will be recorded.
 - (7) A plan to ensure that the data continue to meet compliance demonstration needs.
- D. Per 40 CFR §63.2862(c) and in accordance with the plan for demonstrating compliance required by 40 CFR §63.2851, the owner or operator shall record the following:
 - (1) For the solvent inventory, record the following information:
 - a. Dates that define each operating status period during a calendar month.
 - b. The operating status of the facility (plant number 88-01-021) such as normal operation, nonoperation, initial startup period, malfunction period, or exempt operation for each recorded time interval.
 - c. Record the gallons of extraction solvent in the inventory on the beginning and ending dates of each normal operating period.
 - d. The gallons of all extraction solvent received, purchased, and recovered during each calendar month.
 - e. All extraction solvent inventory adjustments, additions or subtractions.

- The owner or operator must document the reason for the adjustment and justify the quantity of the adjustment.
- f. The total solvent loss for each calendar month, regardless of the source operating status.
 - g. The actual solvent loss in gallons for each operating month.
- (2) For the weighted average volume fraction of HAP in the extraction solvent, the owner or operator must record the following items:
- a. The gallons of extraction solvent received in each delivery.
 - b. The volume fraction of each HAP exceeding one percent (1%) by volume in each delivery of extraction solvent.
 - c. The weighted average volume fraction of HAP in extraction solvent received since the end of the last operating month as determined in accordance with 40 CFR §63.2854(b)(2).
- (3) For each type of listed oilseed processed, record the following items:
- a. The dates that define each operating status period. These dates must be the same as the dates entered for the extraction solvent inventory.
 - b. The operating status of the facility (plant number 88-01-021) such as normal operation, nonoperation, initial startup period, malfunction period, or exempt operation for each recorded time interval. On the log for each type of listed oilseed that is not being processed during a normal operating period, the owner or operator shall record which type of listed oilseed is being processed in addition to the source operating status.
 - c. The oilseed inventory for the type of listed oilseed being processed on the beginning and ending dates of each normal operating period.
 - d. The tons of each type of listed oilseed received at the facility (plant number 88-01-021) each normal operating period.
 - e. All listed oilseed inventory adjustments, additions or subtractions for normal operating periods. The owner or operator shall document the reason for the adjustment and justify the quantity of the adjustment.
 - f. The tons of each type of listed oilseed processed during each operating month.
- E. Per 40 CFR §63.2862(d), after the facility (plant number 88-01-021) has processed a listed oilseed for twelve (12) operating months and is not operating during an initial startup period as described in 40 CFR §63.2850(c)(2) or 40 CFR §63.2850(d)(2), or a malfunction period as described in 40 CFR §63.2850(e)(2), the owner or operator shall record the following items by the end of the calendar month following each operating month:
- (1) The twelve (12) operating months rolling sum of the actual solvent loss in gallons as described in 40 CFR §63.2853(c).
 - (2) The weighted average volume fraction of HAP in extraction solvent received for the previous twelve (12) operating months as described in 40 CFR §63.2854(b)(3).
 - (3) The twelve (12) operating months rolling sum (in tons) of each type of listed oilseed processed at the facility (plant number 88-01-021) as described in 40 CFR §63.2855(c).
 - (4) A determination of the compliance ratio. The owner or operator shall use the values from 40 CFR §63.2853, 40 CFR §63.2854, 40 CFR §63.2855, and Table 1 of 40 CFR §63.2840 along with Equation 2 of 40 CFR §63.2840 to calculate the

compliance ratio.

- (5) A statement of whether the source is in compliance with all of the requirements of NESHAP Subpart GGGG. This includes a determination of whether the facility (plant number 88-01-021) has met all of the applicable requirements in 40 CFR §63.2850.
- F. Per 40 CFR §63.2852, the owner or operator shall develop a written startup, shutdown, and malfunction (SSM) plan in accordance with 40 CFR §63.6(e)(3). The SSM plan:
- (1) Shall be completed before the compliance date for the facility (plant number 88-01-021).
 - (2) Shall be kept on-site and readily available as long as the facility (plant number 88-01-021) is operational.
 - (3) Provides detailed procedures for operating and maintaining the facility (plant number 88-01-021) to minimize emissions during a qualifying SSM event for which the owner or operator chooses the 40 CFR §63.2850(e)(2) malfunction period or the 40 CFR §63.2850(c)(2) or 40 CFR §63.2850(d)(2) initial startup period.
 - (4) Shall specify a program of corrective action for malfunctioning process and air pollution control equipment and reflect the best practices now in use by the industry to minimize emissions.
 - (5) Some or all of the procedures may come from plans the owner or operator has developed for other purposes such as a Standard Operating Procedure (SOP) manual or an Occupational Safety and Health Administration (OSHA) Process Safety Management plan. To qualify as a SSM plan, other such plans must meet all of the applicable requirements of 40 CFR Part 63.
- G. Per 40 CFR §63.2862(e), for each SSM event subject to an initial startup period as described in 40 CFR §63.2850(c)(2) or 40 CFR §63.2850(d)(2), or a malfunction period as described in 40 CFR §63.2850(e)(2), the owner or operator shall record the following items by the end of the calendar month following each month in which the initial startup period or malfunction period occurred:
- (1) A description and date of the SSM event, its duration, and reason it qualifies as an initial startup or malfunction.
 - (2) An estimate of the solvent loss (in gallons) for the duration of the initial startup or malfunction period with supporting documentation.
 - (3) A checklist or other mechanism to indicate whether the SSM plan was followed during the initial startup or malfunction period.
- H. The owner or operator shall operate the emission units (EUs 102 and 116) and the control equipment (CE 102) according to the manufacturer's specifications with inspections occurring at a minimum of once per year. The owner or operator shall maintain a log of all maintenance and inspection activities performed on the emission units (EUs 102 and 116) and the control equipment (CE 102). This log shall include, but is not necessarily limited to:
- (1) The date and time any inspection and/or maintenance was performed on any of the emission units (EUs 102 and 116) or any of the control equipment (CE 102);
 - (2) Any issues identified during the inspection and the date each issue was resolved;
 - (3) Any issues addressed during the maintenance activities and the date each issue was resolved;

- (4) Identification of the staff member performing the maintenance or inspection.
- I. All notifications for NESHAP Subpart GGGG at the facility (88-01-021) shall be submitted as required per 40 CFR §63.2860.
 - J. All reports for NESHAP Subpart GGGG at the facility (88-01-021) shall be submitted as required per 40 CFR §63.2861.

Authority for Requirement: DNR Construction Permit 97-A-956-S3
 567 IAC 23.1(4)"cg"
 40 CFR 63 Subpart GGGG

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 56
 Stack Opening, (inches, dia.): 4
 Exhaust Flow Rate (scfm): 200
 Exhaust Temperature (°F): 68
 Discharge Style: Vertical Unobstructed
 Authority for Requirement: DNR Construction Permit 97-A-956-S3

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 104

Associated Equipment

Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 104	Soybean Meal Drying – Deck 1	CE 104: Cyclone	Soybean Meal	41.67 tons/hr	97-A-957-S2
EU 105	Soybean Meal Drying – Deck 1	CE 105: Cyclone	Soybean Meal	41.67 tons/hr	
EU 106	Soybean Meal Cooler	CE 106: Cyclone	Soybean Meal	41.67 tons/hr	

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permit 97-A-957-S2
567 IAC 23.3(2)"d"

⁽¹⁾ An exceedance of the indicator opacity of “no visible emissions” will require the owner or operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the Department may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 0.94 lb/hr

Authority for Requirement: DNR Construction Permit 97-A-957-S2

Pollutant: Particulate Matter

Emission Limit(s): 0.94 lb/hr, 0.1 gr/dscf

Authority for Requirement: DNR Construction Permit 97-A-957-S2
567 IAC 23.4(7)

Operational Limits & Reporting/Record keeping Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. The owner or operator shall operate all emission units and control equipment described in this permit according to the respective manufacturer’s specifications with inspections occurring, at a minimum, of once per year.

(1) The owner or operator shall maintain a log of all maintenance and inspection

activities performed on the emission units and control equipment described in this permit. At a minimum, this log shall include:

- a. The date that any inspection and/or maintenance was performed on any of the emission units and control equipment associated with this permit;
- b. Any issues identified during the inspection and the date each issue was resolved;
- c. Any issues addressed during the maintenance activities and the date each issue was resolved; and,
- d. Identification of the staff member performing the maintenance or inspection.

Authority for Requirement: DNR Construction Permit 97-A-957-S2

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 20.5

Stack Opening, (inches): 27 x 27

Exhaust Flow Rate (scfm): 12,000

Exhaust Temperature (°F): 138

Discharge Style: Horizontal

Authority for Requirement: DNR Construction Permit 97-A-957-S2

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 107

Associated Equipment

Emission Unit	Emission Unit Description	1 st Control Equipment	2 nd Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 107a	Whole Bean Aspiration	CE 107a: Cyclone	CE FLD-1010: Baghouse	Soybeans	41.67 tons/hr	97-A-960-S7
EU 107d	Cascade Dryer	CE 107d: Cyclone		Soybeans	41.67 tons/hr	
EU 107e	Cascade Cooler	CE 107e: Cyclone		Soybeans	41.67 tons/hr	
EU 107f	Secondary Aspiration	NA		Soybeans	41.67 tons/hr	
EU 107g	Pneumatic Conveying	NA		Soybeans	1.5 tons/hr	
EU 109a	Hull Grinder	CE 109: Cyclone		Soybean Hulls	2.3 tons/hr	
EU 109b	Hull Grinder	CE 107h: Cyclone		Soybean Hulls	3 tons/hr	
EU 107b	Vertical Seed Conditioner	NA	CE 107b: Cyclone	Soybeans	41.67 tons/hr	
EU 107c	Jet Dryer	NA	CE FLD-1220: Baghouse	Soybeans	41.67 tons/hr	
EU 110	Flaking Mills 1, 2, & 3	NA	CE 110: High Efficiency Cyclone	Soybeans	41.67 tons (combined)	

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permit 97-A-960-S7
567 IAC 23.3(2)"d"

⁽¹⁾ An exceedance of the indicator opacity of “no visible emissions” will require the owner or operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the Department may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 4.27 lb/hr

Authority for Requirement: DNR Construction Permit 97-A-960-S7

Pollutant: Particulate Matter

Emission Limit(s): 7.90 lb/hr, 0.1 gr/dscf

Authority for Requirement: DNR Construction Permit 97-A-960-S7
567 IAC 23.4(7)

Operational Limits & Reporting/Record keeping Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. The owner or operator shall operate the control equipment at all times that the emission units described above are in operation, with the following exceptions:
 - (1) The owner or operator may shut down the high efficiency cyclone [CE-110 (CYC-1500)] while performing repairs and maintenance on any of the flaking mills associated with Emission Unit 110.
 - (2) The owner or operator shall shut down the fan associated with the high efficiency cyclone [CE-110 (CYC-1500)] whenever this cyclone is not operating.
- B. The owner or operator shall operate all emission units and control equipment described above according to the respective manufacturer's specifications with inspections occurring, at a minimum, of once per year.
 - (1) The owner or operator shall maintain a log of all maintenance and inspection activities performed on the emission units and control equipment described above. At a minimum, this log shall include:
 - a. The date that any inspection and/or maintenance was performed on any of the emission units and control equipment described above;
 - b. Any issues identified during the inspection and the date each issue was resolved;
 - c. Any issues addressed during the maintenance activities and the date each issue was resolved; and,
 - d. Identification of the staff member performing the maintenance or inspection.
- C. The pressure drop across baghouse (CE FLD-1010) shall be maintained between 0.17 inches water column and 8.0 inches water column (1-hour block average) during normal operations conditions (i.e., excluding periods of startup, shutdown, and malfunction).
 - (1) The owner or operator shall install, calibrate, operate, and maintain equipment to continuously monitor the pressure drop across the baghouse (CE FLD-1010).
 - (2) The owner or operator shall record the 1-hour block average pressure drop readings from the monitoring equipment.
 - (3) The owner or operator shall report deviations of the pressure drop range to the Compliance Section of the Department only if the excursions outside of the range exceed 5% of the operating hours during a semi-annual reporting period (January 1 – June30 or July 1 – December 31) or if excursions outside of the range last for more than eight (8) consecutive hours.

- D. The pressure drop across baghouse (CE FLD-1220) shall be maintained 2.3 inches water column and 8.0 inches water column (1-hour block average) during normal operations conditions (i.e., excluding periods of startup, shutdown, and malfunction).
- (1) The owner or operator shall install, calibrate, operate, and maintain equipment to continuously monitor the pressure drop across the baghouse (CE FLD-1220).
 - (2) The owner or operator shall record the 1-hour block average pressure drop readings from the monitoring equipment.
 - (3) The owner or operator shall report deviations of the pressure drop range to the Compliance Section of the Department only if the excursions outside of the range exceed 5% of the operating hours during a semi-annual reporting period (January 1 – June 30 or July 1 – December 31) or if excursions outside of the range last for more than eight (8) consecutive hours.
- E. The owner or operator shall evaluate the pressure drop requirements every calendar year to determine if the pressure drop monitoring range must be adjusted or maintenance activities initiated to correct the pressure drop monitored during operations. Should the pressure drop range need to be adjusted, the facility (88-01-021) shall submit a permit amendment request to the Department.
- F. The owner or operator shall install, calibrate, operate, and maintain a high level switch that notifies the operator of a possible high fill level in the cyclone [CE-107b (CYC-1150)].
- (1) If a high level alarm is triggered for the cyclone [CE-107b (CYC-1150)], the owner or operator shall visually inspect the cyclone.
 - (2) The owner or operator shall record the date and action taken for each high fill level alarm for the cyclone [CE-107b (CYC-1150)].
- G. The owner or operator shall install, calibrate, operate, and maintain a high level switch that notifies the operator of a possible high fill level in the cyclone [CE-110 (CYC-1500)].
- (1) If a high level alarm is triggered for the cyclone [CE-110 (CYC-1500)], the owner or operator shall visually inspect the cyclone.
 - (2) The owner or operator shall record the date and action taken for each high fill level alarm for the cyclone [CE-110 (CYC-1500)].

Authority for Requirement: DNR Construction Permit 97-A-960-S7

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 135
Stack Opening, (inches, dia.): 47
Exhaust Flow Rate (scfm): 24,500 – 49,900
Exhaust Temperature (°F): 115-130
Discharge Style: Vertical Unobstructed
Authority for Requirement: DNR Construction Permit 97-A-960-S7

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 108

Associated Equipment

Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 108	Meal Grinding & Sizing	CE 108: Cyclone CE 108A: Baghouse	Soybean Meal/ White Flake	25 tons/hr	97-A-961-S4

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permit 97-A-961-S4
567 IAC 23.3(2)"d"

⁽¹⁾ An exceedance of the indicator opacity of "no visible emissions" will require the owner/operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the DNR may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 0.20 lb/hr

Authority for Requirement: DNR Construction Permit 97-A-961-S4

Pollutant: Particulate Matter

Emission Limit(s): 0.20 lb/hr, 0.1 gr/dscf

Authority for Requirement: Iowa DNR Construction Permit 97-A-961-S4
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Control equipment parameters:

- A. The control equipment shall be operated and maintained according to manufacturer's specifications and instructions.

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. Maintain a record of all maintenance and repair of the control equipment.

Authority for Requirement: Iowa DNR Construction Permit 97-A-961-S4

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 23

Stack Opening, (inches): 24 x 14

Exhaust Flow Rate (scfm): 4,700

Exhaust Temperature (°F): Ambient

Discharge Style: Horizontal

Authority for Requirement: Iowa DNR Construction Permit 97-A-961-S4

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No
(Required for CE 108 & CE 108A)

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Facility operation and maintenance plans must be sufficient to yield reliable data from the relevant time period that are representative of the source’s compliance with the applicable requirements.

The data pertaining to the plan shall be maintained on site for at least 5 years. The plan and associated recordkeeping provides documentation of this facility’s implementation of its obligation to operate according to good air pollution control practice.

Good air pollution control practice is achieved by adoption of quality control standards in the operation and maintenance procedures for air pollution control that are comparable to industry quality control standards for the production processes associated with this emission point.

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 111

Associated Equipment

Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 111	Product Loadout Station	CE 111: Baghouse	Meal	150 tons/hr	97-A-964-S3

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permit 97-A-964-S3
567 IAC 23.3(2)"d"

⁽¹⁾ Visible emissions will require the owner or operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the Department may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 1.2 lb/hr

Authority for Requirement: DNR Construction Permit 97-A-964-S3

Pollutant: Particulate Matter

Emission Limit(s): 1.2 lb/hr, 0.1 gr/dscf

Authority for Requirement: DNR Construction Permit 97-A-964-S3
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Control equipment parameters:

- A. The control equipment shall be inspected and maintained according to manufacturer's specifications.
- B. The pressure drop across the baghouse (CE 111) shall be maintained between 0.5 inches and 10 inches of water.

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. The owner or operator shall keep records of control equipment inspections and maintenance.
- B. The owner or operator shall record daily the pressure drop of the fabric filter. If an excursion is detected, the owner or operator shall determine the cause and correct the situation.

Authority for Requirement: DNR Construction Permit 97-A-964-S3

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 30

Stack Opening, (inches, dia.): 24

Exhaust Flow Rate (scfm): 20,000

Exhaust Temperature (°F): Ambient

Discharge Style: Vertical Unobstructed

Authority for Requirement: DNR Construction Permit 97-A-964-S3

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 112

Associated Equipment

Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 112	Hulls Silo	CE 112: Baghouse	Hulls	8 tons/hr	97-A-965-S1

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permit 97-A-965-S1
567 IAC 23.3(2)"d"

⁽¹⁾ An exceedance of the indicator opacity of 10% will require the owner/operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the DNR may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 0.07 lb/hr

Authority for Requirement: DNR Construction Permit 97-A-965-S1

Pollutant: Particulate Matter

Emission Limit(s): 0.07 lb/hr, 0.1 gr/dscf

Authority for Requirement: DNR Construction Permit 97-A-965-S1
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Process throughput:

A. The Hulls Silo shall store hulls only. It is not allowed to store grain, meal or flakes.

Authority for Requirement: DNR Construction Permit 97-A-965-S1

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

A. The owner/operator shall record the material that is stored in this silo.

Authority for Requirement: 567 IAC 22.108(4)

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 102
Stack Opening, (inches, dia.): 10
Exhaust Flow Rate (scfm): 255
Exhaust Temperature (°F): Ambient
Discharge Style: Downward
Authority for Requirement: DNR Construction Permit 97-A-965-S1

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Facility operation and maintenance plans must be sufficient to yield reliable data from the relevant time period that are representative of the source’s compliance with the applicable requirements.

The data pertaining to the plan shall be maintained on site for at least 5 years. The plan and associated recordkeeping provides documentation of this facility’s implementation of its obligation to operate according to good air pollution control practice.

Good air pollution control practice is achieved by adoption of quality control standards in the operation and maintenance procedures for air pollution control that are comparable to industry quality control standards for the production processes associated with this emission point.

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Numbers: EP 114 and EP 114a

Associated Equipment

Emission Point	Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EP 114	EU 114	Soybean Meal Storage Bin	CE 114: 3 Bin Vent Filters	Soybean Meal/ White Flake	25 tons/hr	01-A-920
EP 114a			CE 114a: 3 Bin Vent Filters			01-A-921

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from each emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permits 01-A-920 & 01-A-921
567 IAC 23.3(2)"d"

⁽¹⁾An exceedance of the indicator opacity of (25%) will require the owner/operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If the exceedance continues after the corrections, the DNR may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: Particulate Matter

Emission Limit(s): 0.1 gr/dscf

Authority for Requirement: DNR Construction Permits 01-A-920 & 01-A-921
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Process throughput:

A. Soybean Meal Storage Bin shall not store grain (i.e. soybeans).

Authority for Requirement: DNR Construction Permits 01-A-920 & 01-A-921

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

A. The owner/operator shall record the material that is stored in this silo.

Authority for Requirement: 567 IAC 22.108(4)

Emission Point Characteristics

Each emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 102

Stack Opening, (inches, dia.): 20

Exhaust Flow Rate (scfm): 50

Exhaust Temperature (°F): Ambient

Discharge Style: Downward

Authority for Requirement: DNR Construction Permits 01-A-920 & 01-A-921

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Numbers: EP 115 & EP 115a

Associated Equipment

Emission Point	Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EP 115	EU 115	Whole Soybean Storage Bin	CE 115: 3 Bin Vent Filters	Soybeans	65 tons/hr	01-A-922
EP 115a			CE 115a: 3 Bin Vent Filters			01-A-923

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from each emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permits 01-A-922 & 01-A-923
567 IAC 23.3(2)"d"

⁽¹⁾An exceedance of the indicator opacity of (25%) will require the owner/operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If the exceedance continues after the corrections, the DNR may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: Particulate Matter

Emission Limit(s): 0.1 gr/dscf

Authority for Requirement: DNR Construction Permits 01-A-922 & 01-A-923
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Process throughput:

A. Whole Soybean Storage Bin shall not store meal of flakes.

Authority for Requirement: DNR Construction Permits 01-A-922 & 01-A-923

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

A. The owner/operator shall record the material that is stored in this silo.

Authority for Requirement: 567 IAC 22.108(4)

Emission Point Characteristics

Each emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 102

Stack Opening, (inches, dia.): 20

Exhaust Flow Rate (scfm): 50

Exhaust Temperature (°F): Ambient

Discharge Style: Downward

Authority for Requirement: DNR Construction Permits 01-A-922 & 01-A-923

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Numbers: EP 117 & EP 117a

Associated Equipment

Emission Point	Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EP 117	EU 117	Soybean Meal Storage Bin	CE 117: 3 Bin Vent Filters	Soybean Meal/ White Flake	23.3 tons/hr	01-A-924
EP 117a			CE 117a: 3 Bin Vent Filters			01-A-925

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from each emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permits 01-A-924 & 01-A-925
567 IAC 23.3(2)"d"

⁽¹⁾An exceedance of the indicator opacity of (25%) will require the owner/operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If the exceedance continues after the corrections, the DNR may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: Particulate Matter

Emission Limit(s): 0.1 gr/dscf

Authority for Requirement: DNR Construction Permits 01-A-924 & 01-A-925
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Process throughput:

A. Soybean Meal Storage Bin shall not store grain (i.e. soybeans).

Authority for Requirement: DNR Construction Permits 01-A-924 & 01-A-925

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

A. The owner/operator shall record the material that is stored in this silo.

Authority for Requirement: 567 IAC 22.108(4)

Emission Point Characteristics

Each emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 114

Stack Opening, (inches, dia.): 20

Exhaust Flow Rate (scfm): 50

Exhaust Temperature (°F): Ambient

Discharge Style: Downward

Authority for Requirement: DNR Construction Permits 01-A-924 & 01-A-925

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

Emission Point ID Number: EP 119

Associated Equipment

Emission Unit	Emission Unit Description	Control Equipment	Raw Material	Rated Capacity	Construction Permit
EU 119	White Flake Cooling & Conveying	CE 119: Baghouse	White Flake	25 tons/hr	13-A-552

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40%⁽¹⁾

Authority for Requirement: DNR Construction Permit 13-A-552
567 IAC 23.3(2)"d"

⁽¹⁾ Visible emissions will require the owner or operator to promptly investigate the emission unit and make corrections to operations or equipment associated with the exceedance. If exceedances continue after the corrections, the Department may require additional proof to demonstrate compliance (e.g., stack testing).

Pollutant: PM₁₀

Emission Limit(s): 2.7 lb/hr

Authority for Requirement: DNR Construction Permit 13-A-552

Pollutant: Particulate Matter

Emission Limit(s): 2.7 lb/hr, 0.1 gr/dscf

Authority for Requirement: DNR Construction Permit 13-A-552
567 IAC 23.4(7)

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Control equipment parameters:

- A. The control equipment shall be inspected and maintained according to manufacturer's specifications.
- B. The pressure drop across the baghouse (CE 119) shall be maintained between 0.5 inches and 10 inches of water.

Reporting & Record keeping:

Records shall be kept on site for at least five years and shall be available for inspection by the Department.

- A. The owner or operator shall keep records of control equipment inspections and maintenance.
- B. The owner or operator shall record daily the pressure drop of the fabric filter. If an excursion is detected, the owner or operator shall determine the cause and correct the situation.

Authority for Requirement: DNR Construction Permit 13-A-552

Emission Point Characteristics

The emission point shall conform to the specifications listed below.

Stack Height, (ft., from the ground): 75

Stack Opening, (inches, dia.): 60

Exhaust Flow Rate (scfm): 41,190

Exhaust Temperature (°F): 120

Discharge Style: Vertical Unobstructed

Authority for Requirement: DNR Construction Permit 13-A-552

The temperature and flowrate are intended to be representative and characteristic of the design of the permitted emission point. The Department recognizes that the temperature and flow rate may vary with changes in the process and ambient conditions. If it is determined that either the temperature or flowrate above are different than the values stated, the owner or operator shall submit a request to the Department within thirty (30) days of the discovery to determine if a permit amendment is required or submit a permit application requesting to amend the permit.

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

**Compliance Assurance Monitoring Plan for
Benson Hill Ingredients, LLC
EP 119 – White Flake Cooling and Conveying**

I. Background

A. Emissions Unit

Description: White Flake Cooling and Conveying
Identification: EP 119
Facility: Benson Hill Ingredients, LLC

B. Applicable Regulation, Emission Limit, and Monitoring Requirements

Regulation No.: IDNR Permit 13-A-552,
PM emission limit: 2.7 pounds per hour
Current Monitoring requirements: Daily pressure drop readings, control equipment inspections and maintenance according to manufacturer's specifications.

C. Control Technology

Baghouse

II. Monitoring Approach

A. Indicator

Daily pressure drop checks will be used as an indicator.

B. Measurement Approach

Pressure drop will be checked daily to ensure that pressure drop is between 0.5 inH₂O and 10 inH₂O greater during the material handling operation of the unit.

C. Indicator Range

0.5 to 10 inches of H₂O

D. QIP (Quality Improvement Plan) Threshold

The QIP threshold is six excursions in a six month reporting period

E. Performance Criteria

Data representativeness: An increase in pressure drop above 10 inches of water would indicate a decrease in the performance of the baghouse and potentially indicate an increase of particulate emissions.

Verification of operational status: Records of pressure drop readings will be maintained for five years.

QA/QC practices and criteria:

The facility shall check the pressure drop daily when the emission unit on this emission point is in operation. If a pressure drop greater than ten inches of water is observed, corrective action will be taken.

Monitoring frequency and data Collection procedure:

Pressure drop readings shall be conducted daily during a period when the emission unit on this emission point is in operation. Records of the readings shall be maintained for five years.

III. Justification

A. Background

This emission point is in part of the coproduct process at the facility. EP 119 involves the white flake cooling and conveying process where white flakes are sent to storage after completing the desolventizing process. The emissions from this source are controlled by a bagfilter.

Rationale for Selection of Performance Indicator

The daily pressure drop readings were selected as the performance indicator because it is indicative of operation of the baghouse in a manner necessary to comply with the particulate emission standard. An increase in pressure drop beyond ten inches of water would indicate a reduced performance of this baghouse. Therefore, the detection of excessive pressure drop is used as a performance indicator.

B. Rationale for Selection of Indicator Level

The selected indicator range is a pressure drop of 0.5 to 10 inches of water. If a pressure drop greater than ten inches of water is observed, corrective action will be taken.

A pressure drop of 0.5 to 10 inches of water was selected as an indicator range because a pressure drop greater than 10 inches of water is indicative of a potential increase in particulate emissions due to a decrease in the performance of this baghouse. If this baghouse is operating properly, there will not be a pressure drop greater than 10 inches of water except during start up, shut down, and upset conditions.

The selected QIP threshold for the baghouse is 6 excursions in a 6-month reporting period. If the QIP threshold is exceeded in a semiannual reporting period, a QIP will be developed and implemented.

Emission Point ID Number: EP FP

Associated Equipment

Emission Unit	Emission Unit Description	Raw Material	Rated Capacity	Construction Permit
EU FP	Emergency Fire Pump Engine	Diesel Fuel	302 hp	NA

Applicable Requirements

Emission Limits (lb./hr, gr./dscf, lb./MMBtu, % opacity, etc.)

The emissions from this emission point shall not exceed the levels specified below.

Pollutant: Opacity

Emission Limit(s): 40 %

Authority for Requirement: 567 IAC 23.3(2)"d"

Pollutant: Particulate Matter

Emission Limit(s): 0.1 gr/scf

Authority for Requirement: 567 IAC 23.3(2)"a"

Operational Limits & Requirements

The owner/operator of this equipment shall comply with the operational limits and requirements listed below.

Process throughput:

- A. No person shall allow, cause or permit the combustion of number 1 or number 2 fuel oil exceeding a sulfur content of 0.5 percent by weight.

Authority for Requirement: 567 IAC 23.3(3)"b"(1)

Reporting & Record keeping:

The following records shall be maintained on-site for five (5) years and available for inspection upon request by representatives of the Department of Natural Resources:

- A. The facility shall monitor the percent of sulfur by weight in the fuel oil as delivered. The documentation may be vendor supplied or facility generated.

Authority for Requirement: 567 IAC 22.108(3)

NESHAP:

The emergency engine is subject to 40 CFR 63 Subpart ZZZZ - National Emission Standards for Hazardous Air Pollutants for Stationary Reciprocating Internal Combustion Engines (RICE).

According to 40 CFR 63.6590(a)(1)(ii) this compression ignition emergency engine, located at a major source, is an existing stationary RICE as it was constructed prior to June 12, 2006.

Compliance Date

Per 63.6595(a)(1) you must comply with the provisions of Subpart ZZZZ that are applicable by May 3, 2013.

Operation and Maintenance Requirements 40 CFR 63.6602, 63.6625, 63.6640 and Tables 2c and 6 to Subpart ZZZZ

- A. Change oil and filter every 500 hours of operation or annually, whichever comes first. (See 63.6625(i) for the oil analysis option to extend time frame of requirements.)
- B. Inspect air cleaner every 1000 hours of operation or annually, whichever comes first, and replace as necessary.
- C. Inspect all hoses and belts every 500 hours of operation or annually, whichever comes first, and replace as necessary.
- D. Operate and maintain the stationary RICE and after-treatment control device (if any) according to the manufacturer's emission related written instructions or develop your own maintenance plan which must provide to the extent practicable for the maintenance and operation of the engine in a manner consistent with good air pollution control practice for minimizing emissions.
- E. Install a non-resettable hour meter if one is not already installed.
- F. Minimize the engine's time spent at idle during startup and minimize the engine's startup time to a period needed for appropriate and safe loading of the engine, not to exceed 30 minutes.

Operating Limits 40 CFR 63.6640(f)

- A. Any operation other than emergency operation, maintenance and testing and operation in non-emergency situations (up to) 50 hours per year is prohibited.
- B. There is no time limit on the use of emergency stationary RICE in emergency situations.
- C. You may operate your emergency stationary RICE up to 100 combined hours per calendar year for maintenance checks and readiness testing. See 40 CFR 63.6640(f)(2) for additional information and restrictions.
- D. You may operate your emergency stationary RICE up to 50 hours per calendar year for non-emergency situations, but those 50 hours are counted toward the 100 hours of maintenance and testing. The 50 hours per year for non-emergency situations cannot be used for peak shaving, or to generate income for a facility to supply power to an electric grid or otherwise supply power as part of a financial arrangement with another entity.

Recordkeeping Requirements 40 CFR 63.6655

- A. Keep records of the maintenance conducted on the stationary RICE.
- B. Keep records of the hours of operation of the engine that is recorded through the non-resettable hour meter. Document how many hours are spent for emergency operation, including what classified the operation as emergency and how many hours are spent for non-emergency operation. See 40 CFR 63.6655(f) for additional information.

Notification and Reporting Requirements 40 CFR 63.6645, 63.6650 and Table 2c to Subpart ZZZZ

- A. An initial notification is not required per 40 CFR 63.6645(a)(5).
- B. A report may be required for failure to perform the work practice requirements on the schedule required in Table 2c. (See Footnote 1 of Table 2c for more information.)

Authority for Requirement: 40 CFR Part 63 Subpart ZZZZ
567 IAC 23.1(4)"cz"

Monitoring Requirements

The owner/operator of this equipment shall comply with the monitoring requirements listed below.

Agency Approved Operation & Maintenance Plan Required? Yes No

Facility Maintained Operation & Maintenance Plan Required? Yes No

Compliance Assurance Monitoring (CAM) Plan Required? Yes No

Authority for Requirement: 567 IAC 22.108(3)

IV. General Conditions

This permit is issued under the authority of the Iowa Code subsection 455B.133(8) and in accordance with 567 Iowa Administrative Code chapter 22.

G1. Duty to Comply

1. The permittee must comply with all conditions of the Title V permit. Any permit noncompliance constitutes a violation of the Act and is grounds for enforcement action; for a permit termination, revocation and reissuance, or modification; or for denial of a permit renewal application. *567 IAC 22.108(9)"a"*
2. Any compliance schedule shall be supplemental to, and shall not sanction noncompliance with, the applicable requirements on which it is based. *567 IAC 22.105 (2)"h"(3)*
3. Where an applicable requirement of the Act is more stringent than an applicable requirement of regulations promulgated under Title IV of the Act, both provisions shall be enforceable by the administrator and are incorporated into this permit. *567 IAC 22.108 (1)"b"*
4. Unless specified as either "state enforceable only" or "local program enforceable only", all terms and conditions in the permit, including provisions to limit a source's potential to emit, are enforceable by the administrator and citizens under the Act. *567 IAC 22.108 (14)*
5. It shall not be a defense for a permittee, in an enforcement action, that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of the permit. *567 IAC 22.108 (9)"b"*
6. For applicable requirements with which the permittee is in compliance, the permittee shall continue to comply with such requirements. For applicable requirements that will become effective during the permit term, the permittee shall meet such requirements on a timely basis. *567 IAC 22.108(15)"c"*

G2. Permit Expiration

1. Except as provided in rule 567—22.104(455B), permit expiration terminates a source's right to operate unless a timely and complete application for renewal has been submitted in accordance with rule 567—22.105(455B). *567 IAC 22.116(2)*
2. To be considered timely, the owner, operator, or designated representative (where applicable) of each source required to obtain a Title V permit shall submit on forms or electronic format specified by the Department to the Air Quality Bureau, Iowa Department of Natural Resources, Air Quality Bureau, Wallace State Office Building, 502 E 9th St., Des Moines, IA 50319-0034, two copies (three if your facility is located in Linn or Polk county) of a complete permit application, at least 6 months but not more than 18 months prior to the date of permit expiration. An additional copy must also be sent to U.S. EPA Region VII, Attention: Chief of Air Permitting & Standards Branch, 11201 Renner Blvd., Lenexa, KS 66219. Additional copies to local programs or EPA are not required for application materials submitted through the electronic format specified by the Department. The application must include all emission points, emission units, air pollution control equipment, and monitoring devices at the facility. All emissions generating activities, including fugitive emissions, must be included. The definition of a complete application is as indicated in 567 IAC 22.105(2). *567 IAC 22.105*

G3. Certification Requirement for Title V Related Documents

Any application, report, compliance certification or other document submitted pursuant to this permit shall contain certification by a responsible official of truth, accuracy, and completeness. All certifications shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate, and complete. *567 IAC 22.107 (4)*

G4. Annual Compliance Certification

By March 31 of each year, the permittee shall submit compliance certifications for the previous calendar year. The certifications shall include descriptions of means to monitor the compliance status of all emissions sources including emissions limitations, standards, and work practices in accordance with applicable requirements. The certification for a source shall include the identification of each term or condition of the permit that is the basis of the certification; the compliance status; whether compliance was continuous or intermittent; the method(s) used for determining the compliance status of the source, currently and over the reporting period consistent with all applicable department rules. For sources determined not to be in compliance at the time of compliance certification, a compliance schedule shall be submitted which provides for periodic progress reports, dates for achieving activities, milestones, and an explanation of why any dates were missed and preventive or corrective measures. The compliance certification shall be submitted to the administrator, director, and the appropriate DNR Field office. *567 IAC 22.108 (15)"e"*

G5. Semi-Annual Monitoring Report

By March 31 and September 30 of each year, the permittee shall submit a report of any monitoring required under this permit for the 6 month periods of July 1 to December 31 and January 1 to June 30, respectively. All instances of deviations from permit requirements must be clearly identified in these reports, and the report must be signed by a responsible official, consistent with 567 IAC 22.107(4). The semi-annual monitoring report shall be submitted to the director and the appropriate DNR Field office. *567 IAC 22.108 (5)*

G6. Annual Fee

1. The permittee is required under subrule 567 IAC 22.106 to pay an annual fee based on the total tons of actual emissions of each regulated air pollutant. Beginning July 1, 1996, Title V operating permit fees will be paid on July 1 of each year. The fee shall be based on emissions for the previous calendar year.
2. The fee amount shall be calculated based on the first 4,000 tons of each regulated air pollutant emitted each year. The fee to be charged per ton of pollutant will be available from the department by June 1 of each year. The Responsible Official will be advised of any change in the annual fee per ton of pollutant.
3. The emissions inventory shall be submitted annually by March 31 with forms specified by the department documenting actual emissions for the previous calendar year.
4. The fee shall be submitted annually by July 1 with forms specified by the department.
5. If there are any changes to the emission calculation form, the department shall make revised forms available to the public by January 1. If revised forms are not available by January 1, forms from the previous year may be used and the year of emissions documented changed. The department shall calculate the total statewide Title V emissions for the prior calendar year and make this information available to the public no later than April 30 of each year.
6. Phase I acid rain affected units under section 404 of the Act shall not be required to pay a fee for emissions which occur during the years 1993 through 1999 inclusive.
7. The fee for a portable emissions unit or stationary source which operates both in Iowa and out of state shall be calculated only for emissions from the source while operating in Iowa.
8. Failure to pay the appropriate Title V fee represents cause for revocation of the Title V permit as indicated in 567 IAC 22.115(1)"d".

G7. Inspection of Premises, Records, Equipment, Methods and Discharges

Upon presentation of proper credentials and any other documents as may be required by law, the permittee shall allow the director or the director's authorized representative to:

1. Enter upon the permittee's premises where a Title V source is located or emissions-related activity is conducted, or where records must be kept under the conditions of the permit;
2. Have access to and copy, at reasonable times, any records that must be kept under the conditions of the permit;
3. Inspect, at reasonable times, any facilities, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under the permit; and
4. Sample or monitor, at reasonable times, substances or parameters for the purpose of ensuring compliance with the permit or other applicable requirements. *567 IAC 22.108 (15)"b"*

G8. Duty to Provide Information

The permittee shall furnish to the director, within a reasonable time, any information that the director may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the permit or to determine compliance with the permit. Upon request, the permittee also shall furnish to the director copies of records required to be kept by the permit, or for information claimed to be confidential, the permittee shall furnish such records directly to the administrator of EPA along with a claim of confidentiality. *567 IAC 22.108 (9)"e"*

G9. General Maintenance and Repair Duties

The owner or operator of any air emission source or control equipment shall:

1. Maintain and operate the equipment or control equipment at all times in a manner consistent with good practice for minimizing emissions.
2. Remedy any cause of excess emissions in an expeditious manner.
3. Minimize the amount and duration of any excess emission to the maximum extent possible during periods of such emissions. These measures may include but not be limited to the use of clean fuels, production cutbacks, or the use of alternate process units or, in the case of utilities, purchase of electrical power until repairs are completed.
4. Schedule, at a minimum, routine maintenance of equipment or control equipment during periods of process shutdowns to the maximum extent possible. *567 IAC 24.2(1)*

G10. Recordkeeping Requirements for Compliance Monitoring

1. In addition to any source specific recordkeeping requirements contained in this permit, the permittee shall maintain the following compliance monitoring records, where applicable:

- a. The date, place and time of sampling or measurements
- b. The date the analyses were performed.
- c. The company or entity that performed the analyses.
- d. The analytical techniques or methods used.
- e. The results of such analyses; and
- f. The operating conditions as existing at the time of sampling or measurement.
- g. The records of quality assurance for continuous compliance monitoring systems (including but not limited to quality control activities, audits and calibration drifts.)

2. The permittee shall retain records of all required compliance monitoring data and support information for a period of at least 5 years from the date of compliance monitoring sample, measurement report or application. Support information includes all calibration and maintenance records and all original strip chart recordings for continuous compliance monitoring, and copies of all reports required by the permit.

3. For any source which in its application identified reasonably anticipated alternative operating scenarios, the permittee shall:
 - a. Comply with all terms and conditions of this permit specific to each alternative scenario.
 - b. Maintain a log at the permitted facility of the scenario under which it is operating.
 - c. Consider the permit shield, if provided in this permit, to extend to all terms and conditions under each operating scenario. *567 IAC 22.108(4), 567 IAC 22.108(12)*

G11. Evidence used in establishing that a violation has or is occurring.

Notwithstanding any other provisions of these rules, any credible evidence may be used for the purpose of establishing whether a person has violated or is in violation of any provisions herein.

1. Information from the use of the following methods is presumptively credible evidence of whether a violation has occurred at a source:
 - a. A monitoring method approved for the source and incorporated in an operating permit pursuant to 567 Chapter 22;
 - b. Compliance test methods specified in 567 Chapter 25; or
 - c. Testing or monitoring methods approved for the source in a construction permit issued pursuant to 567 Chapter 22.
2. The following testing, monitoring or information gathering methods are presumptively credible testing, monitoring, or information gathering methods:
 - a. Any monitoring or testing methods provided in these rules; or
 - b. Other testing, monitoring, or information gathering methods that produce information comparable to that produced by any method in subrule 21.5(1) or this subrule. *567 IAC 21.5(1)-567 IAC 21.5(2)*

G12. Prevention of Accidental Release: Risk Management Plan Notification and Compliance Certification

If the permittee is required to develop and register a risk management plan pursuant to section 112(r) of the Act, the permittee shall notify the department of this requirement. The plan shall be filed with all appropriate authorities by the deadline specified by EPA. A certification that this risk management plan is being properly implemented shall be included in the annual compliance certification of this permit. *567 IAC 22.108(6)*

G13. Hazardous Release

The permittee must report any situation involving the actual, imminent, or probable release of a hazardous substance into the atmosphere which, because of the quantity, strength and toxicity of the substance, creates an immediate or potential danger to the public health, safety or to the environment. A verbal report shall be made to the department at (515) 725-8694 and to the local police department or the office of the sheriff of the affected county as soon as possible but not later than six hours after the discovery or onset of the condition. This verbal report must be followed up with a written report as indicated in 567 IAC 131.2(2). *567 IAC Chapter 131-State Only*

G14. Excess Emissions and Excess Emissions Reporting Requirements

1. Excess Emissions. Excess emission during a period of startup, shutdown, or cleaning of control equipment is not a violation of the emission standard if the startup, shutdown or cleaning is accomplished expeditiously and in a manner consistent with good practice for minimizing emissions. Cleaning of control equipment which does not require the shutdown of the process equipment shall be limited to one six-minute period per one-hour period. An incident of excess emission (other than an incident during startup, shutdown or cleaning of control equipment) is a

violation. If the owner or operator of a source maintains that the incident of excess emission was due to a malfunction, the owner or operator must show that the conditions which caused the incident of excess emission were not preventable by reasonable maintenance and control measures. Determination of any subsequent enforcement action will be made following review of this report. If excess emissions are occurring, either the control equipment causing the excess emission shall be repaired in an expeditious manner or the process generating the emissions shall be shutdown within a reasonable period of time. An expeditious manner is the time necessary to determine the cause of the excess emissions and to correct it within a reasonable period of time. A reasonable period of time is eight hours plus the period of time required to shut down the process without damaging the process equipment or control equipment. A variance from this subrule may be available as provided for in Iowa Code section 455B.143. In the case of an electric utility, a reasonable period of time is eight hours plus the period of time until comparable generating capacity is available to meet consumer demand with the affected unit out of service, unless, the director shall, upon investigation, reasonably determine that continued operation constitutes an unjustifiable environmental hazard and issue an order that such operation is not in the public interest and require a process shutdown to commence immediately.

2. Excess Emissions Reporting

a. Initial Reporting of Excess Emissions. An incident of excess emission (other than an incident of excess emission during a period of startup, shutdown, or cleaning) shall be reported to the appropriate field office of the department within eight hours of, or at the start of the first working day following the onset of the incident. The reporting exemption for an incident of excess emission during startup, shutdown or cleaning does not relieve the owner or operator of a source with continuous monitoring equipment of the obligation of submitting reports required in 567-subrule 25.1(6). An initial report of excess emission is not required for a source with operational continuous monitoring equipment (as specified in 567-subrule 25.1(1)) if the incident of excess emission continues for less than 30 minutes and does not exceed the applicable emission standard by more than 10 percent or the applicable visible emission standard by more than 10 percent opacity. The initial report may be made by electronic mail (E-mail), in person, or by telephone and shall include as a minimum the following:

- i. The identity of the equipment or source operation from which the excess emission originated and the associated stack or emission point.
- ii. The estimated quantity of the excess emission.
- iii. The time and expected duration of the excess emission.
- iv. The cause of the excess emission.
- v. The steps being taken to remedy the excess emission.
- vi. The steps being taken to limit the excess emission in the interim period.

b. Written Reporting of Excess Emissions. A written report of an incident of excess emission shall be submitted as a follow-up to all required initial reports to the department within seven days of the onset of the upset condition, and shall include as a minimum the following:

- i. The identity of the equipment or source operation point from which the excess emission originated and the associated stack or emission point.
- ii. The estimated quantity of the excess emission.
- iii. The time and duration of the excess emission.
- iv. The cause of the excess emission.

v. The steps that were taken to remedy and to prevent the recurrence of the incident of excess emission.

vi. The steps that were taken to limit the excess emission.

vii. If the owner claims that the excess emission was due to malfunction, documentation to support this claim. *567 IAC 24.1(1)-567 IAC 24.1(4)*

3. Emergency Defense for Excess Emissions. For the purposes of this permit, an “emergency” means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation, and that causes the source to exceed a technology-based emission limitation under the permit due to unavoidable increases in emissions attributable to the emergency. An emergency shall not include non-compliance, to the extent caused by improperly designed equipment, lack of preventive maintenance, careless or improper operation or operator error. An emergency constitutes an affirmative defense to an action brought for non-compliance with technology based limitations if it can be demonstrated through properly signed contemporaneous operating logs or other relevant evidence that:

- a. An emergency occurred and that the permittee can identify the cause(s) of the emergency;
- b. The facility at the time was being properly operated;
- c. During the period of the emergency, the permittee took all reasonable steps to minimize levels of emissions that exceeded the emissions standards or other requirements of the permit; and
- d. The permittee submitted notice of the emergency to the director by certified mail within two working days of the time when the emissions limitations were exceeded due to the emergency. This notice fulfills the requirement of paragraph 22.108(5)"b." – See G15. This notice must contain a description of the emergency, any steps taken to mitigate emissions, and corrective actions taken.

In any enforcement proceeding, the permittee seeking to establish the occurrence of an emergency has the burden of proof. This provision is in addition to any emergency or upset provision contained in any applicable requirement. *567 IAC 22.108(16)*

G15. Permit Deviation Reporting Requirements

A deviation is any failure to meet a term, condition or applicable requirement in the permit. Reporting requirements for deviations that result in a hazardous release or excess emissions have been indicated above (see G13 and G14). Unless more frequent deviation reporting is specified in the permit, any other deviation shall be documented in the semi-annual monitoring report and the annual compliance certification (see G4 and G5). *567 IAC 22.108(5)"b"*

G16. Notification Requirements for Sources That Become Subject to NSPS and NESHAP Regulations

During the term of this permit, the permittee must notify the department of any source that becomes subject to a standard or other requirement under 567-subrule 23.1(2) (standards of performance of new stationary sources) or section 111 of the Act; or 567-subrule 23.1(3) (emissions standards for hazardous air pollutants), 567-subrule 23.1(4) (emission standards for hazardous air pollutants for source categories) or section 112 of the Act. This notification shall be submitted in writing to the department pursuant to the notification requirements in 40 CFR Section 60.7, 40 CFR Section 61.07, and/or 40 CFR Section 63.9. *567 IAC 23.1(2), 567 IAC 23.1(3), 567 IAC 23.1(4)*

G17. Requirements for Making Changes to Emission Sources That Do Not Require Title V Permit Modification

1. Off Permit Changes to a Source. Pursuant to section 502(b)(10) of the CAAA, the permittee may make changes to this installation/facility without revising this permit if:
 - a. The changes are not major modifications under any provision of any program required by section 110 of the Act, modifications under section 111 of the act, modifications under section 112 of the act, or major modifications as defined in 567 IAC Chapter 22.
 - b. The changes do not exceed the emissions allowable under the permit (whether expressed therein as a rate of emissions or in terms of total emissions);
 - c. The changes are not modifications under any provisions of Title I of the Act and the changes do not exceed the emissions allowable under the permit (whether expressed therein as a rate of emissions or as total emissions);
 - d. The changes are not subject to any requirement under Title IV of the Act (revisions affecting Title IV permitting are addressed in rules 567—22.140(455B) through 567 - 22.144(455B));
 - e. The changes comply with all applicable requirements.
 - f. For each such change, the permitted source provides to the department and the administrator by certified mail, at least 30 days in advance of the proposed change, a written notification, including the following, which must be attached to the permit by the source, the department and the administrator:
 - i. A brief description of the change within the permitted facility,
 - ii. The date on which the change will occur,
 - iii. Any change in emission as a result of that change,
 - iv. The pollutants emitted subject to the emissions trade
 - v. If the emissions trading provisions of the state implementation plan are invoked, then Title V permit requirements with which the source shall comply; a description of how the emissions increases and decreases will comply with the terms and conditions of the Title V permit.
 - vi. A description of the trading of emissions increases and decreases for the purpose of complying with a federally enforceable emissions cap as specified in and in compliance with the Title V permit; and
 - vii. Any permit term or condition no longer applicable as a result of the change.
2. Such changes do not include changes that would violate applicable requirements or contravene federally enforceable permit terms and conditions that are monitoring (including test methods), record keeping, reporting, or compliance certification requirements. *567 IAC 22.110(2)*
3. Notwithstanding any other part of this rule, the director may, upon review of a notice, require a stationary source to apply for a Title V permit if the change does not meet the requirements of subrule 22.110(1). *567 IAC 22.110(3)*
4. The permit shield provided in subrule 22.108(18) shall not apply to any change made pursuant to this rule. Compliance with the permit requirements that the source will meet using the emissions trade shall be determined according to requirements of the state implementation plan authorizing the emissions trade. *567 IAC 22.110(4)*

5. No permit revision shall be required, under any approved economic incentives, marketable permits, emissions trading and other similar programs or processes, for changes that are provided for in this permit. *567 IAC 22.108(11)*

G18. Duty to Modify a Title V Permit

1. Administrative Amendment.

- a. An administrative permit amendment is a permit revision that does any of the following:
 - i. Correct typographical errors
 - ii. Identify a change in the name, address, or telephone number of any person identified in the permit, or provides a similar minor administrative change at the source;
 - iii. Require more frequent monitoring or reporting by the permittee; or
 - iv. Allow for a change in ownership or operational control of a source where the director determines that no other change in the permit is necessary, provided that a written agreement containing a specific date for transfer of permit responsibility, coverage and liability between the current and new permittee has been submitted to the director.
- b. The permittee may implement the changes addressed in the request for an administrative amendment immediately upon submittal of the request. The request shall be submitted to the director.
- c. Administrative amendments to portions of permits containing provisions pursuant to Title IV of the Act shall be governed by regulations promulgated by the administrator under Title IV of the Act.

2. Minor Title V Permit Modification.

- a. Minor Title V permit modification procedures may be used only for those permit modifications that satisfy all of the following:
 - i. Do not violate any applicable requirement;
 - ii. Do not involve significant changes to existing monitoring, reporting or recordkeeping requirements in the Title V permit;
 - iii. Do not require or change a case by case determination of an emission limitation or other standard, or an increment analysis;
 - iv. Do not seek to establish or change a permit term or condition for which there is no corresponding underlying applicable requirement and that the source has assumed in order to avoid an applicable requirement to which the source would otherwise be subject. Such terms and conditions include any federally enforceable emissions caps which the source would assume to avoid classification as a modification under any provision under Title I of the Act; and an alternative emissions limit approved pursuant to regulations promulgated under section 112(i)(5) of the Act;
 - v. Are not modifications under any provision of Title I of the Act; and
 - vi. Are not required to be processed as significant modification under rule 567 - 22.113(455B).
- b. An application for minor permit revision shall be on the minor Title V modification application form and shall include at least the following:
 - i. A description of the change, the emissions resulting from the change, and any new applicable requirements that will apply if the change occurs;

- ii. The permittee's suggested draft permit;
 - iii. Certification by a responsible official, pursuant to 567 IAC 22.107(4), that the proposed modification meets the criteria for use of minor permit modification procedures and a request that such procedures be used; and
 - iv. Completed forms to enable the department to notify the administrator and the affected states as required by 567 IAC 22.107(7).
- c. The permittee may make the change proposed in its minor permit modification application immediately after it files the application. After the permittee makes this change and until the director takes any of the actions specified in 567 IAC 22.112(4) "a" to "c", the permittee must comply with both the applicable requirements governing the change and the proposed permit terms and conditions. During this time, the permittee need not comply with the existing permit terms and conditions it seeks to modify. However, if the permittee fails to comply with its proposed permit terms and conditions during this time period, the existing permit terms and conditions it seeks to modify may be enforced against the facility.

3. Significant Title V Permit Modification.

Significant Title V modification procedures shall be used for applications requesting Title V permit modifications that do not qualify as minor Title V modifications or as administrative amendments. These include but are not limited to all significant changes in monitoring permit terms, every relaxation of reporting or recordkeeping permit terms, and any change in the method of measuring compliance with existing requirements. Significant Title V modifications shall meet all requirements of 567 IAC Chapter 22, including those for applications, public participation, review by affected states, and review by the administrator, as those requirements that apply to Title V issuance and renewal.

The permittee shall submit an application for a significant permit modification not later than three months after commencing operation of the changed source unless the existing Title V permit would prohibit such construction or change in operation, in which event the operation of the changed source may not commence until the department revises the permit. *567 IAC 22.111-567 IAC 22.113*

G19. Duty to Obtain Construction Permits

Unless exempted in 567 IAC 22.1(2) or to meet the parameters established in 567 IAC 22.1(1)"c", the permittee shall not construct, install, reconstruct or alter any equipment, control equipment or anaerobic lagoon without first obtaining a construction permit, or conditional permit, or permit pursuant to rule 567 IAC 22.8, or permits required pursuant to rules 567 IAC 22.4, 567 IAC 22.5, 567 IAC 31.3, and 567 IAC 33.3 as required in 567 IAC 22.1(1). A permit shall be obtained prior to the initiation of construction, installation or alteration of any portion of the stationary source or anaerobic lagoon. *567 IAC 22.1(1)*

G20. Asbestos

The permittee shall comply with 567 IAC 23.1(3)"a", and 567 IAC 23.2(3)"g" when activities involve asbestos mills, surfacing of roadways, manufacturing operations, fabricating, insulating, waste disposal, spraying applications, demolition and renovation operations (*567 IAC 23.1(3)"a"*); training fires and controlled burning of a demolished building (*567 IAC 23.2*).

G21. Open Burning

The permittee is prohibited from conducting open burning, except as provided in 567 IAC 23.2. *567 IAC 23.2 except 23.2(3)"j"; 567 IAC 23.2(3)"j" - State Only*

G22. Acid Rain (Title IV) Emissions Allowances

The permittee shall not exceed any allowances that it holds under Title IV of the Act or the regulations promulgated there under. Annual emissions of sulfur dioxide in excess of the number of allowances to emit sulfur dioxide held by the owners and operators of the unit or the designated representative of the owners and operators is prohibited. Exceedences of applicable emission rates are prohibited. "Held" in this context refers to both those allowances assigned to the owners and operators by USEPA, and those allowances supplementally acquired by the owners and operators. The use of any allowance prior to the year for which it was allocated is prohibited. Contravention of any other provision of the permit is prohibited. *567 IAC 22.108(7)*

G23. Stratospheric Ozone and Climate Protection (Title VI) Requirements

1. The permittee shall comply with the standards for labeling of products using ozone-depleting substances pursuant to 40 CFR Part 82, Subpart E:
 - a. All containers in which a class I or class II substance is stored or transported, all products containing a class I substance, and all products directly manufactured with a class I substance must bear the required warning statement if it is being introduced into interstate commerce pursuant to § 82.106.
 - b. The placement of the required warning statement must comply with the requirements pursuant to § 82.108.
 - c. The form of the label bearing the required warning statement must comply with the requirements pursuant to § 82.110.
 - d. No person may modify, remove, or interfere with the required warning statement except as described in § 82.112.
2. The permittee shall comply with the standards for recycling and emissions reduction pursuant to 40 CFR Part 82, Subpart F, except as provided for MVACs in Subpart B:
 - a. Persons opening appliances for maintenance, service, repair, or disposal must comply with the required practices pursuant to § 82.156.
 - b. Equipment used during the maintenance, service, repair, or disposal of appliances must comply with the standards for recycling and recovery equipment pursuant to § 82.158.
 - c. Persons performing maintenance, service, repair, or disposal of appliances must be certified by an approved technician certification program pursuant to § 82.161.
 - d. Persons disposing of small appliances, MVACs, and MVAC-like appliances must comply with reporting and recordkeeping requirements pursuant to § 82.166. ("MVAC-like appliance" as defined at § 82.152)
 - e. Persons owning commercial or industrial process refrigeration equipment must comply with the leak repair requirements pursuant to § 82.156.
 - f. Owners/operators of appliances normally containing 50 or more pounds of refrigerant must keep records of refrigerant purchased and added to such appliances pursuant to § 82.166.
3. If the permittee manufactures, transforms, imports, or exports a class I or class II substance, the permittee is subject to all the requirements as specified in 40 CFR part 82, Subpart A, Production and Consumption Controls.
4. If the permittee performs a service on motor (fleet) vehicles when this service involves ozone-depleting substance refrigerant (or regulated substitute substance) in the motor vehicle air conditioner (MVAC), the permittee is subject to all the applicable requirements as specified in 40 CFR part 82, Subpart B, Servicing of Motor Vehicle Air Conditioners. The term "motor vehicle" as used in Subpart B does not include a vehicle in which final assembly of the vehicle

has not been completed. The term "MVAC" as used in Subpart B does not include the air-tight sealed refrigeration system used as refrigerated cargo, or system used on passenger buses using HCFC-22 refrigerant,

5. The permittee shall be allowed to switch from any ozone-depleting or greenhouse gas generating substances to any alternative that is listed in the Significant New Alternatives Program (SNAP) promulgated pursuant to 40 CFR part 82, Subpart G, Significant New Alternatives Policy Program. *40 CFR part 82*

G24. Permit Reopenings

1. This permit may be modified, revoked, reopened, and reissued, or terminated for cause. The filing of a request by the permittee for a permit modification, revocation and reissuance, or termination, or of a notification of planned changes or anticipated noncompliance does not stay any permit condition. *567 IAC 22.108(9)"c"*

2. Additional applicable requirements under the Act become applicable to a major part 70 source with a remaining permit term of 3 or more years. Revisions shall be made as expeditiously as practicable, but not later than 18 months after the promulgation of such standards and regulations.

a. Reopening and revision on this ground is not required if the permit has a remaining term of less than three years;

b. Reopening and revision on this ground is not required if the effective date of the requirement is later than the date on which the permit is due to expire, unless the original permit or any of its terms and conditions have been extended pursuant to 40 CFR 70.4(b)(10)(i) or (ii) as amended to May 15, 2001.

c. Reopening and revision on this ground is not required if the additional applicable requirements are implemented in a general permit that is applicable to the source and the source receives approval for coverage under that general permit. *567 IAC 22.108(17)"a"*, *567 IAC 22.108(17)"b"*

3. A permit shall be reopened and revised under any of the following circumstances:

a. The department receives notice that the administrator has granted a petition for disapproval of a permit pursuant to 40 CFR 70.8(d) as amended to July 21, 1992, provided that the reopening may be stayed pending judicial review of that determination;

b. The department or the administrator determines that the Title V permit contains a material mistake or that inaccurate statements were made in establishing the emissions standards or other terms or conditions of the Title V permit;

c. Additional applicable requirements under the Act become applicable to a Title V source, provided that the reopening on this ground is not required if the permit has a remaining term of less than three years, the effective date of the requirement is later than the date on which the permit is due to expire, or the additional applicable requirements are implemented in a general permit that is applicable to the source and the source receives approval for coverage under that general permit. Such a reopening shall be complete not later than 18 months after promulgation of the applicable requirement.

d. Additional requirements, including excess emissions requirements, become applicable to a Title IV affected source under the acid rain program. Upon approval by the administrator, excess emissions offset plans shall be deemed to be incorporated into the permit.

e. The department or the administrator determines that the permit must be revised or

revoked to ensure compliance by the source with the applicable requirements. *567 IAC 22.114(1)*

4. Proceedings to reopen and reissue a Title V permit shall follow the procedures applicable to initial permit issuance and shall effect only those parts of the permit for which cause to reopen exists. *567 IAC 22.114(2)*

5. A notice of intent shall be provided to the Title V source at least 30 days in advance of the date the permit is to be reopened, except that the director may provide a shorter time period in the case of an emergency. *567 IAC 22.114(3)*

G25. Permit Shield

1. The director may expressly include in a Title V permit a provision stating that compliance with the conditions of the permit shall be deemed compliance with any applicable requirements as of the date of permit issuance, provided that:

- a. Such applicable requirements are included and are specifically identified in the permit; or
- b. The director, in acting on the permit application or revision, determines in writing that other requirements specifically identified are not applicable to the source, and the permit includes the determination or a concise summary thereof.

2. A Title V permit that does not expressly state that a permit shield exists shall be presumed not to provide such a shield.

3. A permit shield shall not alter or affect the following:

- a. The provisions of Section 303 of the Act (emergency orders), including the authority of the administrator under that section;
- b. The liability of an owner or operator of a source for any violation of applicable requirements prior to or at the time of permit issuance;
- c. The applicable requirements of the acid rain program, consistent with Section 408(a) of the Act;
- d. The ability of the department or the administrator to obtain information from the facility pursuant to Section 114 of the Act. *567 IAC 22.108 (18)*

G26. Severability

The provisions of this permit are severable and if any provision or application of any provision is found to be invalid by this department or a court of law, the application of such provision to other circumstances, and the remainder of this permit, shall not be affected by such finding. *567 IAC 22.108 (8)*

G27. Property Rights

The permit does not convey any property rights of any sort, or any exclusive privilege. *567 IAC 22.108 (9)"d"*

G28. Transferability

This permit is not transferable from one source to another. If title to the facility or any part of it is transferred, an administrative amendment to the permit must be sought consistent with the requirements of *567 IAC 22.111(1)*. *567 IAC 22.111 (1)"d"*

G29. Disclaimer

No review has been undertaken on the engineering aspects of the equipment or control equipment other than the potential of that equipment for reducing air contaminant emissions. *567 IAC 22.3(3)"c"*

G30. Notification and Reporting Requirements for Stack Tests or Monitor Certification

The permittee shall notify the department's stack test contact in writing not less than 30 days before a required test or performance evaluation of a continuous emission monitor is performed to determine compliance with applicable requirements of 567 – Chapter 23 or a permit condition. Such notice shall include the time, the place, the name of the person who will conduct the test and other information as required by the department. If the owner or operator does not provide timely notice to the department, the department shall not consider the test results or performance evaluation results to be a valid demonstration of compliance with applicable rules or permit conditions. Upon written request, the department may allow a notification period of less than 30 days. At the department's request, a pretest meeting shall be held not later than 15 days prior to conducting the compliance demonstration. A testing protocol shall be submitted to the department no later than 15 days before the owner or operator conducts the compliance demonstration. A representative of the department shall be permitted to witness the tests. Results of the tests shall be submitted in writing to the department's stack test contact in the form of a comprehensive report within six weeks of the completion of the testing. Compliance tests conducted pursuant to this permit shall be conducted with the source operating in a normal manner at its maximum continuous output as rated by the equipment manufacturer, or the rate specified by the owner as the maximum production rate at which the source shall be operated. In cases where compliance is to be demonstrated at less than the maximum continuous output as rated by the equipment manufacturer, and it is the owner's intent to limit the capacity to that rating, the owner may submit evidence to the department that the source has been physically altered so that capacity cannot be exceeded, or the department may require additional testing, continuous monitoring, reports of operating levels, or any other information deemed necessary by the department to determine whether such source is in compliance.

Stack test notifications, reports and correspondence shall be sent to:

Stack Test Review Coordinator
Iowa DNR, Air Quality Bureau
Wallace State Office Building
502 E 9th St.
Des Moines, IA 50319-0034
(515) 725-9526

Within Polk and Linn Counties, stack test notifications, reports and correspondence shall also be directed to the supervisor of the respective county air pollution program.

567 IAC 25.1(7)"a", 567 IAC 25.1(9)

G31. Prevention of Air Pollution Emergency Episodes

The permittee shall comply with the provisions of 567 IAC Chapter 26 in the prevention of excessive build-up of air contaminants during air pollution episodes, thereby preventing the occurrence of an emergency due to the effects of these contaminants on the health of persons.

567 IAC 26.1(1)

G32. Contacts List

The current address and phone number for reports and notifications to the EPA administrator is:

Iowa Compliance Officer
Air Branch
Enforcement and Compliance Assurance Division
U.S. EPA Region 7
11201 Renner Blvd.
Lenexa, KS 66219
(913) 551-7020

The current address and phone number for reports and notifications to the department or the Director is:

Chief, Air Quality Bureau
Iowa Department of Natural Resources
Wallace State Office Building
502 E 9th St.
Des Moines, IA 50319-0034
(515) 725-8200

Reports or notifications to the DNR Field Offices or local programs shall be directed to the supervisor at the appropriate field office or local program. Current addresses and phone numbers are:

Field Office 1

1101 Commercial Court, Suite 10
Manchester, IA 52057
(563) 927-2640

Field Office 2

2300-15th St., SW
Mason City, IA 50401
(641) 424-4073

Field Office 3

1900 N. Grand Ave.
Spencer, IA 51301
(712) 262-4177

Field Office 4

1401 Sunnyside Lane
Atlantic, IA 50022
(712) 243-1934

Field Office 5

Wallace State Office Building
502 E 9th St.
Des Moines, IA 50319-0034
(515) 725-0268

Field Office 6

1023 West Madison Street
Washington, IA 52353-1623
(319) 653-2135

Polk County Public Works Dept.

Air Quality Division
5885 NE 14th St.
Des Moines, IA 50313
(515) 286-3351

Linn County Public Health

Air Quality Branch
1020 6th Street SE
Cedar Rapids, IA 52401
(319) 892-6000