



STATE OF MAINE  
DEPARTMENT OF ENVIRONMENTAL PROTECTION

PAUL R. LEPAGE  
GOVERNOR

PATRICIA W. AHO  
COMMISSIONER

**Specialty Minerals, Inc.  
Franklin County  
Jay, Maine  
A-647-71-G-R/A (SM)**

**Departmental  
Findings of Fact and Order  
Air Emission License  
Renewal/Amendment**

After review of the air emission license renewal/amendment application, staff investigation reports, and other documents in the applicant's file in the Bureau of Air Quality, pursuant to 38 M.R.S.A., §344 and §590, the Department finds the following facts:

**I. REGISTRATION**

**A. Introduction**

Specialty Minerals, Inc. (SMI) has applied to renew their Air Emission License permitting the operation of emission sources associated with this precipitated calcium carbonate (PCC) manufacturing facility. The facility has also requested that their license be changed to more accurately account for the composition of one of the raw materials used at the SMI facility. This facility receives some of their raw material from and delivers product to the Verso Androscoggin LLC pulp and paper manufacturing facility in Jay, Maine, which operates under a separate air emission license.

The equipment addressed in this license is located at Gate 15, Riley Road, Jay, Maine.

**B. Emission Equipment**

The following equipment is addressed in this air emission license:

<u>Equipment</u>	<u>Production Rate</u>	<u>Pollution Control Equipment</u>	<u>Stack #</u>
Carbonator 1	2.1 ton/hr lime; 3.5 ton/hr product	Mist Eliminator	1
Carbonator 2	2.1 ton/hr lime; 3.5 ton/hr product	Mist Eliminator	2
Carbonator 3	2.1 ton/hr lime; 3.5 ton/hr product	Mist Eliminator	3
Carbonator 4	2.1 ton/hr lime; 3.5 ton/hr product	Mist Eliminator	4
Lime Silo 1	20 ton/hr lime (received)	Bin Vent Dust Collector	5
Lime Silo 2	20 ton/hr lime (received)	Bin Vent Dust Collector	6

AUGUSTA  
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1235 CENTRAL DRIVE, SKYWAY PARK  
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C. Application Classification

The application for SMI does not include the licensing of increased emissions or the installation of new or modified equipment. The included amendment will not increase emissions of any pollutant. In fact, the requested license changes result in a net decrease in tons per year emissions from this facility. Therefore, the license is considered to be a minor revision and renewal of currently licensed emission units only and has been processed through *Major and Minor Source Air Emission License Regulations*, 06-096 CMR 115 (as amended). With the limit on the hours of operation of the carbonators, the facility is licensed below the major source thresholds and is considered a synthetic minor.

II. BEST PRACTICAL TREATMENT (BPT)

A. Introduction

In order to receive a license, the applicant must control emissions from each unit to a level considered by the Department to represent Best Practical Treatment (BPT), as defined in *Definitions Regulation*, 06-096 CMR 100 (as amended). Separate control requirement categories exist for new and existing equipment as well as for those sources located in designated non-attainment areas.

BPT for existing emissions equipment means that method which controls or reduces emissions to the lowest possible level considering

- the existing state of technology;
- the effectiveness of available alternatives for reducing emissions from the source being considered; and
- the economic feasibility for the type of establishment involved.

Before proceeding with the control requirements for each unit, a general process description is provided to identify where the equipment fits into the process.

Process Description

SMI uses lime (calcium oxide) to produce precipitated calcium carbonate. The raw material, lime, is stored in the lime silos prior to use in the process. Lime reacts with water in the slakers to make calcium hydroxide (slake). Because this reaction is highly exothermic, heat exchangers are utilized to cool the product.

The calcium hydroxide then reacts with carbon dioxide from Verso Androscoggin's lime kilns' exhaust to make calcium carbonate. This reaction takes place in the four carbonators. The carbonators are equipped with mist eliminators for particulate control. The final product, precipitated calcium carbonate, is sent to Verso Androscoggin's paper mills to be used in the papermaking process.

SMI uses a portion of the lime kilns' exhaust gas from Verso Androscoggin as a raw material. This gas contains carbon dioxide which is used in the production of PCC. The gas also contains other combustion products, including NO<sub>x</sub>. Any NO<sub>x</sub> that enters SMI's process is emitted without change.

B. Carbonators

1. Description, Explanation of License Changes

SMI operates four carbonators, all four of which are batch PCC reactors manufactured and installed in 1996. Each carbonator exhausts through its own 60 ft above ground level (AGL) stack, Carbonator 1 through Stack #1, Carbonator 2 through Stack #2, Carbonator 3 through Stack #3, and Carbonator 4 through Stack #4. Each carbonator is equipped with a two-stage demister with removal efficiency of approximately 90% to control particulate matter emissions.

In the four carbonators, carbon dioxide from the lime kilns' exhaust reacts with calcium hydroxide to form precipitated calcium carbonate, the final product of this manufacturing process. The conditions that occur in the carbonators cause them to act as alkaline scrubbers, resulting in an approximately 80% reduction in the concentrations of sulfur dioxide (SO<sub>2</sub>) and total reduced sulfur (TRS) in the incoming lime kiln exhaust. Carbon monoxide (CO), nitrogen oxides (NO<sub>x</sub>), and VOC emission rates for the carbonators are based on licensed emission rates for Verso Androscoggin's lime kilns and stack tests of flue gases transported from Verso Androscoggin's lime kilns to SMI's facility.

Original calculations of NO<sub>x</sub> emission limits for SMI were based on an emission rate from Verso Androscoggin of 12 lb/hr NO<sub>x</sub> per lime kiln, a portion of which is an input feed stream for the SMI carbonators. After receiving notification that NO<sub>x</sub> emissions from Verso Androscoggin's lime kilns had been measured at a rate above 12 lb/hr per kiln (but still below Verso Androscoggin's licensed limit), SMI reevaluated their own operating conditions and license limits to more accurately reflect the actual, measured values. Based on the Verso Androscoggin's licensed NO<sub>x</sub> concentration limit of 120 ppm wet basis at 10% O<sub>2</sub> for the lime kilns and the maximum capacity of the blowers that transfer exhaust gases from the lime kilns to SMI's process, the maximum potential NO<sub>x</sub> emissions per carbonator is 6.9 lb/hr. This assumes that the blowers consistently operate at maximum capacity, which is a conservative assumption compared to actual SMI operation.

Using this value, SMI proposes that total operation time of all four carbonators be limited to 25,600 hours per year. SMI also investigated and concluded that the CO and SO<sub>2</sub> limits do not need to be adjusted. The Department concurs with the logic supporting the change and the resulting emission limit and operating time limitation for SMI carbonators.

2. BACT/BPT Findings

The BACT/BPT emission limits for the carbonators were based on the following:

- PM, PM<sub>10</sub> – 5585 dscfm maximum blower capacity on each carbonator and 0.012 gr/dscf (previously licensed limit; SMI historical stack test data)
- SO<sub>2</sub> – Verso’s limit of 6.7 lb/hr each kiln and 80% reduction in the carbonators
- NO<sub>x</sub> – Verso’s limit of 120 ppmv wet corrected to 10% O<sub>2</sub>
- CO – SMI historical test data of 5 lb/hr from each kiln and previously licensed limit
- VOC – 33.7 lb/day each kiln (Verso lime kiln historical stack test data, equivalent to Verso’s licensed limit of 1.4 lb/hr)
- TRS – Verso’s limit of 20 ppm and 80% reduction in the carbonators, 5585 dscfm maximum blower capacity on each carbonator
- Opacity – 06-096 CMR 101 (2)(B)(3)(d)

Because several of the emission limits for SMI are directly related to the operations of and resulting emissions from Verso Androscoggin’s lime kilns, those factors are consistent with the most recent licensing of Verso Androscoggin’s lime kilns, license amendment A-203-77-13-A, issued January 19, 2012.

Emissions from each carbonator shall not exceed the following:

**Carbonator Emission Limits  
Per Carbonator**

<u>Pollutant</u>	<u>lb/hr</u>
PM	0.57
PM <sub>10</sub>	0.57
SO <sub>2</sub>	0.67
NO <sub>x</sub>	6.9
CO	2.5
VOC	0.7
TRS	0.13

Visible emissions from each of the four carbonators shall not exceed 20% opacity on a 6-minute block average basis, except for no more than one six-minute block average in a one-hour period.

3. Periodic Monitoring

Periodic monitoring for the carbonators shall include recordkeeping to document hours of operation both on a monthly and 12-month rolling total basis. Documentation shall include the hours of operation and identification of which carbonator(s) are running.

C. Lime Silos

1. Description

SMI operates two bulk lime storage silos, both of which were installed in 1996. Emissions of particulate matter during pneumatic unloading of bulk trucks are controlled by a bin vent fabric filter with reverse jet cleaning on each silo. Each filter exhausts through its own 75 ft AGL stack, identified as stacks #5 and #6.

2. BACT/BPT Findings

BPT for the lime silos is the continued use and maintenance of the fabric filters. Previously licensed limits and BPT dictate that emissions from each lime silo shall not exceed the following [06-096 CMR 115, BPT]:

**Lime Silo Emissions  
Per Silo**

<u>Pollutant</u>	<u>gr/dscf</u>	<u>lb/hr</u>
PM	0.01	0.09
PM <sub>10</sub>	0.01	0.09

Visible emissions from the lime silos shall not exceed 10% opacity on a six (6) minute block average basis, except for no more than one (1) six (6) minute block average in a 1-hour period. The facility shall take corrective action if visible emissions from either baghouse exceed 5% opacity. [06-096 CMR 101 (2)(B)(3)(c)]

D. Parts Washer

SMI may operate a parts washer subject to and in accordance with the requirements of *Solvent Cleaners*, 06-096 CMR 130 (as amended). Records shall be kept documenting compliance.

E. Fugitive Emissions

Visible emissions from any fugitive emission source (including stockpiles and roadways) shall not exceed 20% opacity, except for no more than five (5) minutes in any 1-hour period. Compliance shall be determined by an aggregate of the

individual fifteen (15)-second opacity observations which exceed 20% in any one (1) hour.

F. Annual Emissions

1. Total Licensed Annual Emissions

SMI shall be restricted to the following annual emissions, based on a 12-month rolling total. The tons per year limits were calculated based on the total combined carbonator operation time of 25,600 hours per year.

**Total Licensed Annual Emissions for the Facility**  
**Tons/year**  
(used to calculate the annual license fee)

	<u>PM</u>	<u>PM<sub>10</sub></u>	<u>SO<sub>2</sub></u>	<u>NO<sub>x</sub></u>	<u>CO</u>	<u>VOC</u>	<u>TRS</u>
Carbonators (total from all 4)	7.3	7.3	8.5	88.3	32.0	9.0	1.7
Lime Silos (total from both)	1.13	1.13	--	--	--	--	--
<b>Total TPY</b>	<b>8.43</b>	<b>8.43</b>	<b>8.5</b>	<b>88.3</b>	<b>32.0</b>	<b>9.0</b>	<b>1.7</b>

2. Greenhouse Gases

Greenhouse gases are considered regulated pollutants as of January 2, 2011, through 'Tailoring' revisions made to EPA's *Approval and Promulgation of Implementation Plans*, 40 CFR Part 52, Subpart A, §52.21 Prevention of Significant Deterioration of Air Quality rule. Greenhouse gases, as defined in 06-096 CMR 100 (as amended), are the aggregate group of the following gases: carbon dioxide, nitrous oxide, methane, hydrofluorocarbons, perfluorocarbons, and sulfur hexafluoride. For licensing purposes, greenhouse gases (GHG) are calculated and reported as carbon dioxide equivalents (CO<sub>2</sub>e).

Potential greenhouse gases emitted by SMI are from the lime kilns of the Verso Androscoggin facility that provide an exhaust gas feed stream to SMI. These GHG emissions have undergone Best Available Control Technology (BACT) analysis in Verso Androscoggin LLC license amendment A-203-77-13-A issued January 19, 2012. In addition, the chemical reaction to produce SMI's product consumes CO<sub>2</sub> from the kilns' exhaust gases, effectively reducing the GHG content.

Based on SMI's operational limits and the worst case emission factors from AP-42, IPCC (Intergovernmental Panel on Climate Change), and *Mandatory Greenhouse Gas Reporting*, 40 CFR Part 98, and the global warming potentials contained in 40 CFR Part 98, SMI is below the major source

threshold of 100,000 tons of CO<sub>2</sub>e per year. No additional licensing requirements are needed to address GHG emissions at this time.

### III. AMBIENT AIR QUALITY ANALYSIS

According to 06-096 CMR 115, the level of air quality analyses required for a renewal source shall be determined on a case-by case basis. Modeling is not required for a renewal if the total emissions of any pollutant released do not exceed the following and there are no extenuating circumstances:

<u>Pollutant</u>	<u>Tons/Year</u>
PM	25
PM <sub>10</sub>	25
SO <sub>2</sub>	50
NO <sub>x</sub>	100
CO	250

Based on the total facility licensed emissions, SMI is below the emissions level required for modeling.

### ORDER

Based on the above Findings and subject to conditions listed below, the Department concludes that the emissions from this source

- will receive Best Practical Treatment,
- will not violate applicable emission standards,
- will not violate applicable ambient air quality standards in conjunction with emissions from other sources.

The Department hereby grants Air Emission License A-647-71-G-R/A (SM) subject to the following conditions.

Severability. The invalidity or unenforceability of any provision, or part thereof, of this License shall not affect the remainder of the provision or any other provisions. This License shall be construed and enforced in all respects as if such invalid or unenforceable provision or part thereof had been omitted.

### STANDARD CONDITIONS

- (1) Employees and authorized representatives of the Department shall be allowed access to the licensee's premises during business hours, or any time during which any emissions units are in operation, and at such other times as the Department deems necessary for the purpose of performing tests, collecting samples,

conducting inspections, or examining and copying records relating to emissions (38 M.R.S.A. §347-C).

- (2) The licensee shall acquire a new or amended air emission license prior to commencing construction of a modification, unless specifically provided for in Chapter 115. [06-096 CMR 115]
- (3) Approval to construct shall become invalid if the source has not commenced construction within eighteen (18) months after receipt of such approval or if construction is discontinued for a period of eighteen (18) months or more. The Department may extend this time period upon a satisfactory showing that an extension is justified, but may condition such extension upon a review of either the control technology analysis or the ambient air quality standards analysis, or both. [06-096 CMR 115]
- (4) The licensee shall establish and maintain a continuing program of best management practices for suppression of fugitive particulate matter during any period of construction, reconstruction, or operation which may result in fugitive dust, and shall submit a description of the program to the Department upon request. [06-096 CMR 115]
- (5) The licensee shall pay the annual air emission license fee to the Department, calculated pursuant to Title 38 M.R.S.A. §353-A. [06-096 CMR 115]
- (6) The license does not convey any property rights of any sort, or any exclusive privilege. [06-096 CMR 115]
- (7) The licensee shall maintain and operate all emission units and air pollution systems required by the air emission license in a manner consistent with good air pollution control practice for minimizing emissions. [06-096 CMR 115]
- (8) The licensee shall maintain sufficient records to accurately document compliance with emission standards and license conditions and shall maintain such records for a minimum of six (6) years. The records shall be submitted to the Department upon written request. [06-096 CMR 115]
- (9) The licensee shall comply with all terms and conditions of the air emission license. The filing of an appeal by the licensee, the notification of planned changes or anticipated noncompliance by the licensee, or the filing of an application by the licensee for a renewal of a license or amendment shall not stay any condition of the license. [06-096 CMR 115]
- (10) The licensee may not use as a defense in an enforcement action that the disruption, cessation, or reduction of licensed operations would have been

necessary in order to maintain compliance with the conditions of the air emission license. [06-096 CMR 115]

- (11) In accordance with the Department's air emission compliance test protocol and 40 CFR Part 60 or other method approved or required by the Department, the licensee shall:
- A. perform stack testing to demonstrate compliance with the applicable emission standards under circumstances representative of the facility's normal process and operating conditions:
    - 1. within sixty (60) calendar days of receipt of a notification to test from the Department or EPA, if visible emissions, equipment operating parameters, staff inspection, air monitoring or other cause indicate to the Department that equipment may be operating out of compliance with emission standards or license conditions; or
    - 2. pursuant to any other requirement of this license to perform stack testing.
  - B. install or make provisions to install test ports that meet the criteria of 40 CFR Part 60, Appendix A, and test platforms, if necessary, and other accommodations necessary to allow emission testing; and
  - C. submit a written report to the Department within thirty (30) days from date of test completion.
- [06-096 CMR 115]
- (12) If the results of a stack test performed under circumstances representative of the facility's normal process and operating conditions indicate emissions in excess of the applicable standards, then:
- A. within thirty (30) days following receipt of such test results, the licensee shall re-test the non-complying emission source under circumstances representative of the facility's normal process and operating conditions and in accordance with the Department's air emission compliance test protocol and 40 CFR Part 60 or other method approved or required by the Department; and
  - B. the days of violation shall be presumed to include the date of stack test and each and every day of operation thereafter until compliance is demonstrated under normal and representative process and operating conditions, except to the extent that the facility can prove to the satisfaction of the Department that there were intervening days during which no violation occurred or that the violation was not continuing in nature; and
  - C. the licensee may, upon the approval of the Department following the successful demonstration of compliance at alternative load conditions, operate under such alternative load conditions on an interim basis prior to a demonstration of compliance under normal and representative process and operating conditions.
- [06-096 CMR 115]
- (13) Notwithstanding any other provisions in the State Implementation Plan approved by the EPA or Section 114(a) of the CAA, any credible evidence may be used for

the purpose of establishing whether a person has violated or is in violation of any statute, regulation, or Part 70 license requirement. [06-096 CMR 115]

- (14) The licensee shall maintain records of malfunctions, failures, downtime, and any other similar change in operation of air pollution control systems or the emissions unit itself that would affect emission and that is not consistent with the terms and conditions of the air emission license. The licensee shall notify the Department within two (2) days or the next state working day, whichever is later, of such occasions where such changes result in an increase of emissions. The licensee shall report all excess emissions in the units of the applicable emission limitation. [06-096 CMR 115]
- (15) Upon written request from the Department, the licensee shall establish and maintain such records, make such reports, install, use and maintain such monitoring equipment, sample such emissions (in accordance with such methods, at such locations, at such intervals, and in such a manner as the Department shall prescribe), and provide other information as the Department may reasonably require to determine the licensee's compliance status. [06-096 CMR 115]

#### SPECIFIC CONDITIONS

(16) **Carbonators**

- A. The carbonators shall not exceed a combined total of 25,600 hours of operation per year on a 12-month rolling total basis. SMI shall keep a log recording the date and duration of operation (in hours) every time each carbonator is operated and maintain documentation of monthly and 12-month rolling totals. The log shall be maintained for a minimum of six years and shall be made available to the Department upon request.
- B. SMI shall continue to operate and maintain mist eliminators on the carbonators. SMI shall keep a maintenance log recording all routine maintenance of each mist eliminator, the date and duration of all mist eliminator malfunctions, and notation of whether or not the associated carbonator was operating at the time of malfunction. [06-096 CMR 115, BPT]
- C. Emissions from the carbonators shall not exceed the following:

**Carbonator Emission Limits, Per Carbonator**  
[06-096 CMR 115, BPT]

	<u>PM</u>	<u>PM<sub>10</sub></u>	<u>SO<sub>2</sub></u>	<u>NO<sub>x</sub></u>	<u>CO</u>	<u>VOC</u>	<u>TRS</u>
From each Carbonator, lb/hr	0.57	0.57	0.67	6.9	2.5	0.7	0.13

- D. PM and PM<sub>10</sub> shall each not exceed 0.012 grains per dry standard cubic foot from each carbonator. Compliance shall be demonstrated by stack testing performed at the Department's request. [06-096 CMR 115, BPT]
- E. TRS shall not exceed 4 ppmv (measured as H<sub>2</sub>S) from each carbonator. Compliance shall be demonstrated by stack tests performed at the Department's request. [06-096 CMR 115, BPT]
- F. Visible emissions from each of the four carbonators shall not exceed 20% opacity on a 6-minute block average basis, except for no more than one six-minute block average in a one-hour period. [06-096 CMR 101 (2)(B)(3)(d)]

(17) **Lime Silos**

- A. SMI shall maintain and operate fabric filters on the lime silos. To document maintenance of the fabric filters, SMI shall keep a maintenance log recording the date and location of all filter failures as well as all routine maintenance. [06-096 CMR 115, BPT]
- B. Emissions from the lime silo fabric filters shall not exceed the following:  
[06-096 CMR 115, BPT]

**Lime Silo Emission Limits, Per Silo**

<b>Pollutant</b>	<b>gr/dscf</b>	<b>lb/hr</b>
PM	0.01	0.09
PM <sub>10</sub>	0.01	0.09

- C. Visible emissions from the lime silos shall not exceed 10% opacity on a six (6) minute block average basis, except for no more than one (1) six (6) minute block average in a 1-hour period. The facility shall take corrective action if visible emissions from any baghouse exceed 5% opacity. [06-096 CMR 101 (2)(B)(3)(c)]

(18) **Parts Washer**

The parts washer at SMI is subject to *Solvent Cleaners*, 06-096 CMR 130 (as amended).

- A. SMI shall keep records of the amount of solvent added to the parts washer. [06-096 CMR 115, BPT]
- B. The following are exempt from the requirements of 06-096 CMR 130 [06-096 CMR 130]:
  - 1. Solvent cleaners using less than two liters (68 oz) of cleaning solvent with a vapor pressure of 1.00 mmHg, or less, at 20° C (68° F);

2. Wipe cleaning; and,
  3. Cold cleaning machines using solvents containing less than or equal to 5% VOC by weight.
- C. The following standards apply to cold cleaning machines that are applicable sources under Chapter 130.
1. SMI shall attach a permanent conspicuous label to each unit summarizing the following operational standards [06-096 CMR 130]:
    - (i) Waste solvent shall be collected and stored in closed containers.
    - (ii) Cleaned parts shall be drained of solvent directly back to the cold cleaning machine by tipping or rotating the part for at least 15 seconds or until dripping ceases, whichever is longer.
    - (iii) Flushing of parts shall be performed with a solid solvent spray that is a solid fluid stream (not a fine, atomized or shower type spray) at a pressure that does not exceed 10 psig. Flushing shall be performed only within the freeboard area of the cold cleaning machine.
    - (iv) The cold cleaning machine shall not be exposed to drafts greater than 40 meters per minute when the cover is open.
    - (v) Sponges, fabric, wood, leather, paper products and other absorbent materials shall not be cleaned in the degreaser.
    - (vi) When a pump-agitated solvent bath is used, the agitator shall be operated to produce no observable splashing of the solvent against the tank walls or the parts being cleaned. Air agitated solvent baths may not be used.
    - (vii) Spills during solvent transfer shall be cleaned immediately. Sorbent material used to clean spills shall then be immediately stored in covered containers.
    - (viii) Work area fans shall not blow across the opening of the degreaser unit.
    - (ix) The solvent level shall not exceed the fill line.
  2. The remote reservoir cold cleaning machine shall be equipped with a perforated drain with a diameter of not more than six inches. [06-096 CMR 130]

(19) **Fugitive Emissions**

Visible emissions from a fugitive emission source (including stockpiles and roadways) shall not exceed 20% opacity, except for no more than five (5) minutes in any 1-hour period. Compliance shall be determined by an aggregate of the individual fifteen (15)-second opacity observations which exceed 20% in any one (1) hour. [06-096 CMR 101]

Specialty Minerals, Inc.  
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Departmental  
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(20) Annual Emission Statement

In accordance with *Emission Statements*, 06-096 CMR 137 (as amended), the licensee shall annually report to the Department the information necessary to accurately update the State's emission inventory by means of either of the following:

- 1) A computer program and accompanying instructions supplied by the Department; or
- 2) A written emission statement containing the information required in 06-096 CMR 137.

The emission statement must be submitted as specified by the date in 06-096 CMR 137.

- (21) SMI shall notify the Department within 48 hours and submit a report to the Department on a quarterly basis if a malfunction or breakdown in any component causes a violation of any emission standard (38 M.R.S.A. §605).

DONE AND DATED IN AUGUSTA, MAINE THIS 30<sup>th</sup> DAY OF March, 2012.

DEPARTMENT OF ENVIRONMENTAL PROTECTION

BY: Melanie Register  
PATRICIA W. AHO, COMMISSIONER

**The term of this license shall be five (5) years from the signature date above.**

PLEASE NOTE ATTACHED SHEET FOR GUIDANCE ON APPEAL PROCEDURES

Date of initial receipt of application: September 26, 2007

Date of application acceptance: October 18, 2007

Date filed with the Board of Environmental Protection:

This Order prepared by Jane Gilbert, Bureau of Air Quality.

