



DEPARTMENT ORDER

**Danisco USA Inc.  
Knox County  
Rockland, Maine  
A-366-70-N-A**

**Departmental  
Findings of Fact and Order  
Part 70 Air Emission License  
Amendment #1**

**FINDINGS OF FACT**

After review of the Part 70 License amendment application, staff investigation reports, and other documents in the applicant's file in the Bureau of Air Quality, pursuant to 38 Maine Revised Statutes (M.R.S.) § 344 and § 590, the Maine Department of Environmental Protection (Department) finds the following facts:

**I. REGISTRATION**

**A. Introduction**

FACILITY	Danisco USA Inc.
LICENSE TYPE	Part 70 Significant License Modification
NAICS CODES	311999, 325412
NATURE OF BUSINESS	Refined Hydrocolloid Products
FACILITY LOCATION	Crocketts Point, Rockland

On July 29, 2024, International N&H USA, Inc. was issued a Part 70 license renewal for its facility in Rockland, Maine that manufactures carrageenan, clarified locust bean gum, and other hydrocolloids used mostly as food additives. The facility also manufactures agarose for use in molecular biology.

On March 11, 2025, the Part 70 license was transferred from International N&H USA, Inc. to Danisco USA Inc. (Danisco).

NO<sub>x</sub> RACT license A-366-77-9-A, issued October 20, 2025, addressed new requirements contained in *Reasonably Available Control Technology for Facilities that Emit Nitrogen Oxides (NO<sub>x</sub> RACT)*, 06-096 Code of Maine Rules (C.M.R.) ch. 138. Danisco has requested that the provisions of this NO<sub>x</sub> RACT license be incorporated into their Part 70 license.

## B. Emission Equipment

The following emission units are addressed by this Part 70 License:

### Boilers

Equipment (Asset #)	Maximum Heat Input Capacity (MMBtu/hr)	Max. Firing Rate	Fuel Type	Install. Date	Stack #
Boiler #3 (E9030)	85.6	83,107 scf/hr 611 gal/hr	natural gas distillate fuel	1966	5-1
Boiler #4 (E9040)	48.6	47,184 scf/hr 347 gal/hr	natural gas distillate fuel	1965	5-1
Boiler #5 (E9050)	48.4	46,990 scf/hr 346 gal/hr	natural gas distillate fuel	1963	5-1

## C. Definitions

Distillate fuel means the following:

- Fuel oil that complies with the specifications for fuel oil numbers 1 or 2, as defined by the American Society for Testing and Materials (ASTM) in ASTM D396;
- Diesel fuel oil numbers 1 or 2, as defined in ASTM D975;
- Kerosene, as defined in ASTM D3699;
- Biodiesel, as defined in ASTM D6751; or
- Biodiesel blends, as defined in ASTM D7467.

Mid-size boiler means a steam generating unit that has a heat input equal to or greater than 50 MMBtu/hr and less than 1,500 MMBtu/hr

Records or Logs mean either hardcopy or electronic records.

Small boiler means a steam generating unit that has a heat input equal to or greater than 20 MMBtu/hr and less than 50 MMBtu/hr.

## D. Application Classification

All rules, regulations, or statutes referenced in this air emission license refer to the amended version in effect as of the issued date of this license.

Danisco has requested incorporation into the Part 70 Air License the relevant terms and conditions of NO<sub>x</sub> RACT license A-366-77-9-A issued October 20, 2025 pursuant to *Major and Minor Source Air Emission License Regulations*, 06-096 C.M.R. ch. 115 and 06-096 C.M.R. ch. 138. This license application was considered a Part 70 Significant

License Modification and processed under *Part 70 Air Emission License Regulations*, 06-096 C.M.R. ch. 140.

#### **E. NO<sub>x</sub> RACT Requirements**

Danisco operates three boilers (Boilers #3, #4, and #5) that are licensed to fire distillate fuel and natural gas.

Boiler #3 (also known as Unit #20 or E9030) was manufactured by Union Iron Works in 1966 with a heat input capacity of 85.6 MMBtu/hr.

Boiler #4 (also known as Unit #21 or E9040) was manufactured by Union Iron Works in 1965 with a heat input capacity of 48.6 MMBtu/hr.

Boiler #5 (also known as Unit #22 or E9050) was manufactured by Union Iron Works in 1963 with a heat input capacity of 48.4 MMBtu/hr.

The boilers were all originally designed to fire #6 fuel oil. However, New Source Review License A-366-77-6-A (issued 3/26/14) addressed the conversion of the boilers from firing #6 fuel oil to firing natural gas or distillate fuel. With this conversion, the ability to fire #6 fuel oil was removed from the facility.

Revisions to 06-096 C.M.R. ch. 138 went into effect May 7, 2025. These changes included the establishment of new standards for emission units located within the 2022 Ozone Transport Region, as defined in that chapter. Danisco is located within the 2022 Ozone Transport Region.

Danisco must either comply with the new applicable standards in 06-096 C.M.R. ch. 138, § 4 by May 1, 2026, or apply for and receive approval of an alternative RACT determination pursuant to 06-096 C.M.R. ch. 138, § 4(H). Danisco elected to comply with the applicable requirements in section 4 of the rule.

Boilers #3 is a mid-size boiler with a heat input less than 100 MMBtu/hr and fires only distillate fuel and natural gas. Boilers #4 and #5 are small boilers each with a heat input less than 50 MMBtu/hr. Pursuant to 06-096 C.M.R. ch. 138, §§ 4(B)(1) and 4(C), these boilers are each subject to the following work practice standards in section 4(C) of the rule.

1. Each boiler shall be equipped with an oxygen trim system that automatically maintains an optimum air-to-fuel ratio.
2. Danisco shall perform a boiler tune-up at least once every five years. The first boiler tune-up is due no later than May 1, 2031. A tune-up conducted to comply with

40 C.F.R. Part 63, Subpart JJJJJ shall satisfy this requirement provided it complies with the requirements of the following paragraph.

3. Boiler tune-ups shall be performed as specified below:
  - a. As applicable, inspect the burner, and clean or replace any component of the burner as necessary. Delay of the burner inspection until the next scheduled shutdown is permitted for up to 72 months from the previous inspection.
  - b. Inspect the flame pattern, as applicable, and adjust the burner as necessary to optimize the flame pattern, consistent with the manufacturer's specifications.
  - c. Inspect the system controlling the air-to-fuel ratio, as applicable, and ensure it is correctly calibrated and functioning properly. Delay of the inspection until the next scheduled shutdown is permitted for up to 72 months from the previous inspection.
  - d. If a unit is not operating on the required date for a tune-up, the tune-up shall be conducted within 30 days of start-up.
4. Danisco shall keep the following records in a form suitable and readily available for expeditious review:
  - a. Identification of each boiler, the date of tune-up, procedures followed for tune-up, and the manufacturer's specifications to which the boiler was tuned;
  - b. Records of the occurrence and duration of each malfunction of each boiler; and
  - c. Records of actions taken during periods of malfunction to minimize emissions, including corrective actions to restore operation of the malfunctioning boiler.

Danisco does not demonstrate compliance with NO<sub>x</sub> standards for Boilers #3, #4, or #5 through use of a CEMS. Therefore, the alternative emission limits for startup and shutdown in 06-096 C.M.R. ch. 138, § 6 do not apply.

#### **F. Facility Annual Emissions**

This license amendment will not change the facility's licensed annual emissions.

## ORDER

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

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

The Department hereby grants the Part 70 License Amendment A-366-70-N-A pursuant to 06-096 C.M.R. 140 and the licensing requirements of 06-096 C.M.R. chs. 115 and 138 and subject to the conditions found in Air Emission License A-366-70-K-R and license transfer A-366-70-M-T, and the following conditions.

Federally enforceable conditions in this Part 70 license must be changed pursuant to the applicable requirements in 06-096 C.M.R. ch. 115 for making such changes and pursuant to the applicable requirements in 06-096 C.M.R. ch. 140.

For each specific condition which is state enforceable only, state-only enforceability is designated with the following statement: **Enforceable by State-only**.

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

## SPECIFIC CONDITIONS

**Beginning May 1, 2026, Conditions (14)(F)(6) and (7) of Part 70 license A-366-70-K-R are deleted and the following new Condition shall apply.**

### (14) **Boilers #3, #4, and #5**

Boilers #3, #4 and #5 are each subject to the following work practice standards beginning May 1, 2026:

- A. Each boiler shall be equipped with an oxygen trim system that automatically maintains an optimum air-to-fuel ratio.
- B. Danisco shall perform a boiler tune-up at least once every five years. The first boiler tune-up is due no later than May 1, 2031. A tune-up conducted to comply with 40 C.F.R. Part 63, Subpart JJJJJ shall satisfy this requirement provided it complies with the requirements of the following paragraph.

C. Boiler tune-ups shall be performed as specified below:

1. As applicable, inspect the burner, and clean or replace any component of the burner as necessary. Delay of the burner inspection until the next scheduled shutdown is permitted for up to 72 months from the previous inspection.
2. Inspect the flame pattern, as applicable, and adjust the burner as necessary to optimize the flame pattern, consistent with the manufacturer's specifications.
3. Inspect the system controlling the air-to-fuel ratio, as applicable, and ensure it is correctly calibrated and functioning properly. Delay of the inspection until the next scheduled shutdown is permitted for up to 72 months from the previous inspection.
4. If a unit is not operating on the required date for a tune-up, the tune-up shall be conducted within 30 days of start-up.

D. Danisco shall keep the following records in a form suitable and readily available for expeditious review:

1. Identification of each boiler, the date of tune-up, procedures followed for tune-up, and the manufacturer's specifications to which the boiler was tuned;
2. Records of the occurrence and duration of each malfunction of each boiler; and
3. Records of actions taken during periods of malfunction to minimize emissions, including corrective actions to restore operation of the malfunctioning boiler.

[06-096 C.M.R. ch. 138, §§ 4(B)(1) and 4(C)]

DONE AND DATED IN AUGUSTA, MAINE THIS 16 DAY OF DECEMBER, 2025.

DEPARTMENT OF ENVIRONMENTAL PROTECTION

BY:  for  
MELANIE LOYZIM, COMMISSIONER

**The term of this amendment shall be concurrent with the term of Air Emission License A-366-70-K-R.**

PLEASE NOTE ATTACHED SHEET FOR GUIDANCE ON APPEAL PROCEDURES

Date of initial receipt of application: 8/18/2025

Date of application acceptance: 8/20/2025

This Order prepared by Lynn Muzzey, Bureau of Air Quality.