

## Subpart F—Standards of Performance for Portland Cement Plants

### § 60.60 Applicability and designation of affected facility.

(a) The provisions of this subpart are applicable to the following affected facilities in portland cement plants: Kiln, clinker cooler, raw mill system, finish mill system, raw mill dryer, raw material storage, clinker storage, finished product storage, conveyor transfer points, bagging and bulk loading and unloading systems.

(b) Any facility under paragraph (a) of this section that commences construction or modification after August 17, 1971, is subject to the requirements of this subpart.

[42 FR 37936, July 25, 1977]

### § 60.61 Definitions.

As used in this subpart, all terms not defined herein shall have the meaning given them in the Act and in subpart A of this part.

(a) *Portland cement plant* means any facility manufacturing portland cement by either the wet or dry process.

(b) *Bypass* means any system that prevents all or a portion of the kiln or clinker cooler exhaust gases from entering the main control device and ducts the gases through a separate control device. This does not include emergency systems designed to duct exhaust gases directly to the atmosphere in the event of a malfunction of any control device controlling kiln or clinker cooler emissions.

(c) *Bypass stack* means the stack that vents exhaust gases to the atmosphere from the bypass control device.

(d) *Monovent* means an exhaust configuration of a building or emission control device (e.g., positive-pressure fabric filter) that extends the length of the structure and has a width very small in relation to its length (i.e., length to width ratio is typically greater than 5:1). The exhaust may be an open vent with or without a roof, louvered vents, or a combination of such features.

[36 FR 24877, Dec. 23, 1971, as amended at 39 FR 20793, June 13, 1974; 53 FR 50363, Dec. 14, 1988]

### § 60.62 Standards.

(a) On and after the date on which the performance test required to be conducted by § 60.8 is completed, you may not discharge into the atmosphere from any kiln any gases which:

(1) Contain particulate matter (PM) in excess of:

(i) 0.30 pound per ton of feed (dry basis) to the kiln if construction, reconstruction, or modification of the kiln commences after August 17, 1971 but on or before June 16, 2008.

(ii) 0.01 pound per ton of clinker on a 30-operating day rolling average if construction, reconstruction, or modification of the kiln commenced after June 16, 2008. An operating day includes all valid data obtained in any daily 24-hour period during which the kiln operates and excludes any measurements made during the daily 24-hour period when the kiln was not operating.

(2) Exhibit greater than 20 percent opacity, except that this opacity limit does not apply to any kiln subject to a PM limit in paragraph (a)(1) of this section that uses a PM continuous emissions monitoring system (CEMS).

(3) Exceed 1.50 pounds of nitrogen oxide (NO<sub>x</sub>) per ton of clinker on a 30-operating day rolling average if construction, reconstruction, or modification of the kiln commences after June 16, 2008, except this limit does not apply to any alkali bypass installed on the kiln. An operating day includes all valid data obtained in any daily 24-hour period during which the kiln operates and excludes any measurements made during the daily 24-hour period when the kiln was not operating.

(4) Exceed 0.4 pounds of sulfur dioxide (SO<sub>2</sub>) per ton of clinker on a 30-operating day rolling average if construction, reconstruction, or modification commences after June 16, 2008, unless you are demonstrating a 90 percent SO<sub>2</sub> emissions reduction measured across the SO<sub>2</sub> control device. An operating day includes all valid data obtained in any daily 24-hour period during which the kiln operates, and excludes any measurements made during the daily 24-hour period when the kiln was not operating.

(b) On and after the date on which the performance test required to be conducted by § 60.8 is completed, you

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may not discharge into the atmosphere from any clinker cooler any gases which:

(1) Contain PM in excess of:

(i) 0.10 pound per ton of feed (dry basis) to the kiln if construction, reconstruction, or modification of the clinker cooler commenced after August 17, 1971 but on or before June 16, 2008.

(ii) 0.01 pound per ton of clinker on a 30-operating day rolling average if construction, reconstruction, or modification of the clinker cooler commences after June 16, 2008. An operating day includes all valid data obtained in any daily 24-hour period during which the kiln operates, and excludes any measurements made during the daily 24-hour period when the kiln was not operating.

(2) Exhibit 10 percent opacity, or greater, except that this opacity limit does not apply to any clinker cooler subject to a PM limit in paragraph (b)(1) of this section that uses a PM CEMS.

(3) If the kiln and clinker cooler exhaust are combined for energy efficiency purposes and sent to a single control device, the appropriate kiln PM limit may be adjusted using the procedures in §63.1343(b) of this chapter.

(4) If the kiln has a separate alkali bypass stack, you must combine the PM emissions from the bypass stack with the PM emissions from the main kiln exhaust to determine total PM emissions.

(c) On and after the date on which the performance test required to be conducted by §60.8 is completed, you may not discharge into the atmosphere from any affected facility other than the kiln and clinker cooler any gases which exhibit 10 percent opacity, or greater.

(d) If you have an affected source subject to this subpart with a different emission limit or requirement for the same pollutant under another regulation in title 40 of this chapter, you must comply with the most stringent emission limit or requirement and are not subject to the less stringent requirement.

[75 FR 55034, Sept. 9, 2010]

**§ 60.63 Monitoring of operations.**

(a) [Reserved]

(b) *Clinker production monitoring requirements.* For any kiln subject to an emissions limitation on PM, NO<sub>x</sub>, or SO<sub>2</sub> emissions (lb/ton of clinker), you must:

(1) Determine hourly clinker production by one of two methods:

(i) Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of clinker produced in tons of mass per hour. The system of measuring hourly clinker production must be maintained within ±5 percent accuracy.

(ii) Install, calibrate, maintain, and operate a permanent weigh scale system to measure and record weight rates of the amount of feed to the kiln in tons of mass per hour. The system of measuring feed must be maintained within ±5 percent accuracy. Calculate your hourly clinker production rate using a kiln specific feed-to-clinker ratio based on reconciled clinker production determined for accounting purposes and recorded feed rates. This ratio should be updated monthly. Note that if this ratio changes at clinker reconciliation, you must use the new ratio going forward, but you do not have to retroactively change clinker production rates previously estimated;

(2) Determine, record, and maintain a record of the accuracy of the system of measuring hourly clinker or feed production before initial use (for new sources) or within 30 days of the effective date of this rule (for existing sources). During each quarter of source operation, you must determine, record, and maintain a record of the ongoing accuracy of the system of measuring hourly clinker or feed production.

(3) Record the daily clinker production rates and kiln feed rates; and

(4) Develop an emissions monitoring plan in accordance with paragraphs (i)(1) through (i)(4) of this section.

(c) You must monitor PM emissions of a kiln or clinker cooler subject to a PM emissions limit in §60.62(a)(1)(ii) or (b)(1)(ii) according to the applicable requirements below:

(1) Install and operate a PM CEMS in accordance with Performance Specification 11 of appendix B and Procedure