



STATE OF MAINE
DEPARTMENT OF ENVIRONMENTAL PROTECTION

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COMMISSIONER

True Textiles, Inc.)
Piscataquis County)
Guilford, Maine)
A-367-71-M-R/A (SM)

Departmental
Findings of Fact and Order
Air Emission License

After review of the air emissions license renewal 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., Section 344 and Section 590, the Department finds the following facts:

I. REGISTRATION

A. Introduction

1. True Textiles, Inc, (True Textiles) of Guilford, Maine has applied to renew the Air Emission License permitting the operation of emission sources associated with their textile manufacturing facility.
2. This renewal shall also include the addition of previously unlicensed inspection stations and the installation of at least one new texturing machine.
3. True Textiles has also requested that this renewal include the ability to install up to two #2 fuel oil fired temporary boilers to be installed should a catastrophic event occur.
4. The True Textiles facility is located at 9 Oak Street, Guildford, Maine.

B. Emission Equipment

True Textiles is authorized to operate the following equipment:

Fuel Burning Equipment

Equipment	Maximum Capacity (MMBtu/hr)	Maximum Firing Rate (gal/hr)	Fuel Type, % sulfur	Stack #
Boiler #1	16.5	118	#2 fuel oil, 0.5%, biodiesel;	1
	16.9	----	Wood	
Boiler #2	16.5	118	#2 fuel oil, 0.5%, biodiesel;	2
	16.9	----	wood	

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AUGUSTA, MAINE 04333-0017
(207) 287-7688 FAX: (207) 287-7826
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Fuel Burning Equipment cont.

Boiler #3	12.8	91	#2 fuel oil, 0.5%, biodiesel	1
Boiler #4	2.8	19.8	#2 fuel oil, 0.5%, biodiesel	3
Boiler #5	3.5	25	#2 fuel oil, 0.5%, biodiesel	3

True Textiles has additional insignificant fuel burning activities which do not need to be listed in the emission table above but can be found in Air Emission License applications.

C. Application Classification

This air emission license renewal incorporates conditions established in amendments made subsequently to the facility's previous air emission license renewal. The application includes the licensing of previously unlicensed emissions and installation of previously unlicensed equipment, therefore, this license is to be a renewal and amendment. True Textiles has the potential to emit VOCs and HAPs at greater than major source thresholds, however, True Textiles has accepted federally enforceable facility wide limits for VOC and HAP emissions to maintain the facility at below these major source thresholds, therefore, this air emission license is considered a Synthetic Minor (SM).

II. BEST PRACTICAL TREATMENT (BPT)

Process Description

True Textiles produces fabric for commercial, residential, healthcare, and hospitality interiors. The fiber (95% polyester recycled from soda bottles, 5% olefin, wool and virgin polyester) is received in two forms: "stock" or yarn fiber. The stock fibers are unprocessed, "fluff" fibers. They are received in bales, dyed, and then shipped to another True Textiles facility to be made into yarn, and then returned to the Guilford facility for further processing. The yarn fiber is received in "packages" that may or may not already be dyed.

The stock fiber moves from the receiving area to the dye area. It is placed into a vessel where it is soaked in hot water to relax the kink in the fibers and then compressed into a "cake". Next the fiber is moved to a dye machine, where dyes that have been mixed according to the desired color are added and the water is heated. Inside the machine, the dye is pumped through the fiber in two directions, to insure even color distribution. After it is dyed the fiber is spun in a centrifugal spinner to remove excess water.

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Fiber received as yarn is dyed in the "package dye" area. Similar to stock dyeing, the yarn packages are loaded into dye machines where dyes and auxiliaries are added with water and heated under pressure.

Wastewater from both dye houses is discharged to a heat recovery system prior to being discharged to the onsite equalization basin.

Some yarn at True Textiles is processed through yarn texturing machines. These machines draw the yarn across a jet of compressed air with water and heat, to rough up the surface and change the appearance of the yarn. Textured yarn has a softer feel and a less reflective appearance. True Textiles is proposing to install an additional yarn texturing machine.

The finished yarn is wound onto cardboard tubes in preparation for being woven into cloth. By rewinding the yarn, True Textiles can control the density and packing of the yarn, which will impact the quality of the woven cloth. As many as 10,600 yarns are arranged on a warp beam, and the fabric is woven in a variety of patterns on computer controlled looms. Finished fabric is shipped out of state for finishing prior to being sold to the consumer.

True Textiles operates two wood/oil fired boilers and one oil fired boiler to heat the dye machines to the temperatures necessary for fiber dyeing. Other smaller boilers are utilized for building heat and employee comfort.

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 new sources and modifications requires a demonstration that emissions are receiving Best Available Control Technology (BACT), as defined in 06-096 CMR 100. BACT is a top-down approach to selecting air emission controls considering economic, environmental and energy impacts.

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 emission from the source being considered; and
- the economic feasibility for the type of establishment involved.

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B. Facility Boilers

1. Boilers #1 and #2

Boilers #1 and #2 were both manufactured in 1948, with maximum capacities of 16.9 MMBtu/hr each while firing wood and 16.5 MMBtu/hr each while firing #2 fuel oil. Both boilers are capable of firing either #2 fuel oil, or wood/wood waste. Section (II)(B)(3) of the Findings of Fact of this Air Emission License establishes the sulfur content restrictions for fuel oil fired in Boilers #1 and #2.

Air Emission License amendment A-367-71-H-M established that True Textiles could fire wood-derived products in Boilers #1 and #2. Air Emission License amendment A-367-71-K-M established that True Textiles could fire biodiesel as an alternative to #2 fuel oil in Boilers #1 and #2.

Boilers #1 and #2 were manufactured in 1948 and are therefore not subject to EPA's New Source Performance Standard (NSPS) Subpart Dc, for boilers with heat input capacities of 10 MMBtu/hr or greater and manufactured after June 9, 1989.

Emissions from Boiler #1 are vented through a single cyclone; designated Stack #1. Boiler #2 is equipped with two sets of single cyclones arranged in series: designated Stack #2. In Boiler #2 the ash collected from the first cyclone is reintroduced back into the boiler. Ash collected from the Boiler #1 cyclone and the Boiler #2 second cyclone is periodically screw conveyed to a covered container which is emptied into a covered dumpster for disposal.

The wood fuel fired by True Textiles consists primarily of purchased wood chips, or hogged wood and may contain or be blended with wood waste (i.e. bark, sawdust, other biomass, etc.) and ground paper cores prior to firing. The wood fuel fired may also occasionally contain small amounts of cotton swab waste and paper wrappers from True Textiles' wood supplier.

A summary of the BPT analysis for Boilers #1 and #2 when firing #2 fuel oil of biodiesel is as follows:

- a. The SO₂ emission limits are based on the firing of fuel which meets the criteria in ASTM D396 for #2 fuel oil.
- b. *Fuel Burning Equipment Particulate Emission Standard*, 06-096 CMR 103 (as amended) regulates PM emission limits. PM₁₀ limits are based on PM limits.
- c. As previously licensed, NO_x emissions limits are based on data from boilers of similar size and age and that fire #2 fuel oil.

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- d. SO₂, CO and VOC emission limits are based upon AP-42 emission factors dated 9/98.
- e. *Visible Emissions Regulation*, 06-096 CMR 101 (as amended) regulates visible emission limits. Visible emissions from Stacks #1 and #2 during periods of #2 fuel oil/biodiesel firing shall each not exceed 20% opacity on a 6-minute block average, except for no more than one 6-minute block average in a continuous 3-hour period.

A summary of the BPT analysis for Boilers #1 and #2 when firing wood fuel, wood waste or any other wood-derived product is as follows:

- a. The SO₂ emission limits are based on the firing of fuel which meets the criteria in ASTM D396 for #2 fuel oil.
- b. 06-096 CMR 103 (as amended) regulates PM emission limits. PM₁₀ limits are based on PM limits.
- c. SO₂, NO_x, CO and VOC emission limits are based upon AP-42 emission factors for firing wood fuels dated 9/03.
- d. 06-096 CMR 101 (as amended) regulates visible emission limits. Visible emissions from Stacks #1 and #2 during periods of wood firing shall each not exceed 30% opacity on a 6-minute block average, except for no more than two 6-minute block average in a continuous 3-hour period.

2. Boilers #3, #4 and #5

Boilers #3, #4 and #5 have maximum design heat inputs of 12.8 MMBtu/hr, 2.8 MMBtu/hr and 3.5 MMBtu/hr respectively and are used to supply facility hot water, steam, and heat. Boilers #3, #4 and #5 were manufactured in 1968, 1986 and 1990, respectively, each firing #2 fuel oil. Section (II)(B)(3) of the Findings of Fact of this Air Emission License establishes the sulfur content restrictions for fuel oil fired in Boilers #1 and #2.

Air Emission License amendment A-367-71-K-M established that True Textiles could fire biodiesel as an alternative to #2 fuel oil in Boilers #3, #4 and #5. Boiler #3 shares a common stack (Stack #1) with Boiler #1. Boilers #4 and #5 exhaust to a common stack, designated Stack #3. Stack #3 is a dual flue stack.

Boilers #3 and #4 were manufactured before the applicability date and are therefore not subject to NSPS 40 CFR 60, Subpart Dc, for Boilers with maximum capacities greater than 10 MMBtu/hr and constructed after June 9, 1989. The heat input capacity of Boiler #5 is below the applicability threshold and is therefore not subject to NSPS 40 CFR 60, Subpart Dc.

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A summary of the BPT analysis for Boilers #3, #4 and #5 when firing #2 fuel oil of biodiesel is as follows:

- a. The SO₂ emission limits are based on the firing of fuel which meets the criteria in ASTM D396 for #2 fuel oil.
- b. 06-096 CMR 103 regulates PM emission limits. PM₁₀ limits are based on PM limits.
- c. As previously licensed, NO_x emissions limits are based on data from boilers of similar size and age and that fire #2 fuel oil.
- d. SO₂, CO and VOC emission limits are based upon AP-42 emission factors dated 9/98.
- e. 06-096 CMR 101 regulates visible emission limits. Visible emissions from Boilers #3, #4 and #5 during periods of #2 fuel oil or biodiesel firing shall each not exceed 20% opacity on a 6-minute block average, except for no more than one 6-minute block average in a continuous 3-hour period.

3. #2 Fuel Oil/Biodiesel Fuel Use Restrictions

True Textiles was previously restricted to the use of #2 fuel oil with a sulfur content no greater than 0.35% sulfur by weight, however, since the issuance of this facility's previous Air Emission License, the Department has made a more restrictive BPT determination concerning sulfur content of #2 fuel oil fired in licensed boilers. Until December 31, 2015, the #2 fuel oil fired in the True Textiles boilers shall be ASTM D396 compliant #2 fuel oil (maximum sulfur content of 0.5% by weight). Per 38 MRSA §603-A(2)(A)(3), beginning January 1, 2016, the facility shall fire #2 fuel oil with a maximum sulfur content limit of 0.005% by weight (50 ppm), and beginning January 1, 2018, the facility shall fire #2 fuel oil with a maximum sulfur content limit of 0.0015% by weight (15 ppm).

True Textiles is subject to a facility wide #2 fuel oil/Biodiesel use restriction of no greater than 1,298,000 gallons per year (gal/yr), based on a twelve-month rolling total. As discussed above, to satisfy BPT, True Textiles shall only fire fuel oil that meets the sulfur content criteria of ASTM D396 (0.5% sulfur by weight).

True Textiles shall demonstrate compliance with the above sulfur content fuel use restrictions by means of a fuel purchase record which shall include fuel purchase receipts indicating the amount of fuel purchased and certification from the supplier indicating the sulfur content of the purchased fuel. The fuel purchase record shall be maintained on a monthly and twelve-month rolling total basis.

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4. 40 CFR Part 63 Subpart JJJJJ For Boilers #1, #2, #3, #4 and #5

Boilers #1, #2, #3, #4 and #5 are subject to the *National Emission Standards for Hazardous Air Pollutants for Industrial, Commercial, and Institutional Boilers Area Sources* (40 CFR Part 63 Subpart JJJJJ). Boilers #1, #2 and #3 have capacities rated at greater than 10 MMBtu/hr and are considered existing large oil fired boilers. Boilers #4 and #5 have capacities rated at lower than 10 MMBtu/hr and are considered existing small oil fired boilers. As Boilers #1, #2, #3, #4 and #5 each are oil fired, none are not subject to PM, CO, or mercury emission limits from 40 CFR Part 63 Subpart JJJJJ. As Boilers #1, #2, #3, #4 and #5 are not subject to PM, CO, or mercury emission limits, compliance with 40 CFR Part 63 Subpart JJJJJ is required by no later than March 21, 2012.

For informational purposes, a summary of the applicable federal 40 CFR Part 63 Subpart JJJJJ requirements are listed below. At this time the Maine Department of Environmental Protection has not taken delegation of this area source MACT (Maximum Achievable Control Technology) rule promulgated by EPA, however True Textiles is still subject to the requirements.

The following list includes, but is not limited to, requirements established in 40 CFR Part 63 Subpart JJJJJ:

a. Compliance Dates and Work Practice Requirements

1. Initial Notification of Compliance

In accordance with 40 CFR Part 63.11225(a)(2), True Textiles was required to submit to EPA an Initial Notification of Applicability no later than September 17, 2011 stating that Boilers #1, #2, #3, #4 and #5 at the True Textiles facility are subject to Subpart JJJJJ. Example notification forms can be found at the following website: <http://www.epa.gov/ttn/atw/boiler/boilerpg.html>, under the icon "Implementation Tools".

2. True Textiles shall implement a boiler tune-up program for Boilers #1, #2, #3, #4 and #5 which shall include, but not be limited to, the following:

- i. As established in 40 CFR Part 63.11196(a)(1), True Textiles shall conduct an initial boiler tune-up for Boilers #1, #2, #3, #4 and #5 no later than March 21, 2012. The tune-up shall be conducted in accordance with the tune-up parameters established in 40 CFR Part 63.11223(b)(1) through (7).

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- ii. In accordance with 40 CFR Part 63.11225(a)(4)(i), no later than July 19, 2012, True Textiles shall submit an Initial Notice of Compliance demonstrating compliance with the requirement of an initial tune-up of Boilers #1, #2, #3, #4 and #5.
- iii. Following the initial tune-up, True Textiles shall undertake biennial boiler tune-ups for Boilers #1, #2, #3, #4 and #5. In accordance with 40 CFR Part 63.11223(a), biennial tune-ups shall be conducted no greater than 25 months after the previous tune-up and shall be conducted in accordance with the tune-up parameters established in 40 CFR Part 63.11223(b)(1) through (7).
- iv. In accordance with 40 CFR Part 63.11225(a)(4)(i), no later than July 19, 2012, True Textiles shall submit an Initial Notice of Compliance demonstrating compliance with the requirement of an initial tune-up of Boilers #1, #2, #3, #4 and #5. In accordance with 40 CFR Part 63.11225(a)(4), no later than 120 days following the required biennial tune-up, True Textiles shall submit a Notice of Compliance Status demonstrating compliance with the requirement of the Boilers #1, #2, #3, #4 and #5 tune-up.

As required by 40 CFR Part 63.11223(b)(7), if a unit is not operating on the required date for a tune-up, the tune-up must be conducted within one week of start-up.

- 3. As established in 40 CFR Part 63.11196(a)(3), True Textiles is subject to a one-time energy assessment requirement for the existing large oil fired boilers. The energy assessment requires True Textiles to undertake a one-time energy assessment on Boilers #1, #2 and #3 performed by a qualified assessor in accordance with the energy assessment requirements established in Table 2 to Subpart JJJJJ of 40 CFR Part 63 no later than March 21, 2014.

In accordance with 40 CFR Part 63.11225(a)(4)(ii), no later than July 19, 2014, True Textiles shall submit an Initial Notice of Compliance demonstrating compliance with the requirement of the one-time energy assessment of Boilers #1, #2 and #3.

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b. Record Keeping

- i. In accordance with 40 CFR Part 63.11225(b), True Textiles must prepare biennially and submit to the delegated Authority upon request a biennial compliance certification report for the previous two calendar years which shall include the required information established in 40 CFR Part 63.11225(b)(1) through (4).
- ii. In accordance with 40 CFR Part 63.11225(c), True Textiles must maintain records which shall include the required information established in 40 CFR Part 63.11225(c)(1) through (7). In accordance with 40 CFR Part 63.11225(c), records shall be in a form suitable and readily available for expeditious review and maintained for 5 years.

5. Temporary Boilers

True Textiles has included in this application, a request to permit the operation of up to two #2 fuel oil fired temporary boilers that would be installed in the event of a catastrophic occurrence. This is an effort to ensure that True Textiles can minimize any interruptions in business should a catastrophic event, such as a flood, occur. To satisfy the needs of the facility, the temporary boilers may need to have a combined heat input capacity of up to 29 MMBtu/hr, although, the actual boilers rented at the time of such an event would depend on availability of rental boilers at that time.

Should the rental boiler(s) have heat input capacities between 10 and 100 MMBtu/hr, the boiler(s) may be subject to EPA's New Source Performance Standard (NSPS) Subpart Dc, for boilers with heat input capacities of 10 MMBtu/hr or greater and manufactured after June 9, 1989. If the boiler(s) are subject to NSPS Subpart Dc, True Textiles shall be required to satisfy all the applicable requirements established in (NSPS) Subpart Dc for each effected unit.

A summary of the BACT analysis for the Temporary Boilers when firing #2 fuel oil or biodiesel is as follows:

- a. Potential hourly emission rates for the temporary emergency boilers, shall be based on 4380 hours (6 months) of operation and a total predicted heat input capacity of 29 MMBtu/hr.
- b. The SO₂ emission limits are based on the firing of fuel which meets the criteria in ASTM D396 for #2 fuel oil.

- c. 06-096 CMR 103 regulates hourly PM hourly emission limits. 06-096 CMR 103 establishes an emission restriction of no greater than 0.12 lb/MMBtu for boilers installed after December 22, 1982. PM₁₀ hourly emission limits are based on PM limits.
- d. NO_x, SO₂, CO and VOC hourly emission limits are based upon AP-42 emission factors dated 9/98.
- e. 06-096 CMR 101 regulates visible emission limits. Visible emissions from the temporary boiler(s) during periods of #2 fuel oil firing shall not exceed 20% opacity on a 6-minute block average, except for no more than one 6-minute block average in a continuous 3-hour period.

As it is assumed at this point that the installation of the temporary emergency boiler(s) will be as replacements to currently licensed boilers and the operation of the currently licensed boilers will be halted, the inclusion of the temporary emergency boilers in the Air Emission License will not affect the facility's current annual potential to emit for any criteria pollutants.

C. Back-up Generator

True Textiles utilizes a Kohler manufactured Back-up Generator for emergency purposes. This generator has an HP rating of approximately 40 HP and fires propane at a rate of approximately 5.8 gal/hr.

The federal regulation 40 CFR Part 63, Subpart ZZZZ, *National Emission Standards for Hazardous Air Pollutants (NESHAP) for Stationary Reciprocating Internal Combustion Engines* is applicable to the Back-up Generator listed above. The Back-up Generator is considered existing, emergency stationary reciprocating internal combustion engines at an area HAP source and is not subject to New Source Performance Standards regulations. EPA's August 9, 2010 memo specifically does not exempt these units from the federal requirements.

Emergency Definition:

Emergency stationary reciprocating internal combustion engine (RICE) is defined in 40 CFR Part 63, Subpart ZZZZ as any stationary internal combustion engine whose operation is limited to emergency situations and required testing and maintenance. Examples include stationary RICE used to produce power for critical networks or equipment (including power supplied to portions of a facility) when electric power from the local utility (or the normal power source, if the facility runs on its own power production) is interrupted, or stationary RICE used to pump water in the case of fire or flood, etc. Stationary RICE used for peak shaving are not considered emergency stationary RICE. Stationary RICE used to supply power to an electric grid or that supply non-emergency power as part of a financial arrangement with another entity are not considered to be emergency engines, except as permitted under §63.6640(f).

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§63.6640(f) limits maintenance checks and readiness testing of the Back-up Generator to 100 hours per year. Emergency stationary RICE may operate up to 50 hours per year in non-emergency situations, but those 50 hours are counted towards the 100 hours per year provided for 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; except that owners and operators may operate the emergency engine for a maximum of 15 hours per year as part of a demand response program if the regional transmission organization or equivalent balancing authority and transmission operator has determined there are emergency conditions that could lead to a potential electrical blackout, such as unusually low frequency, equipment overload, capacity or energy deficiency, or unacceptable voltage level. The engine may not be operated for more than 30 minutes prior to the time when the emergency condition is expected to occur, and the engine operation must be terminated immediately after the facility is notified that the emergency condition is no longer imminent. The 15 hours per year of demand response operation are counted as part of the 50 hours of operation per year provided for non-emergency situations. The supply of emergency power to another entity or entities pursuant to financial arrangement is not limited by this paragraph, as long as the power provided by the financial arrangement is limited to emergency power.

40 CFR Part 63, Subpart ZZZZ Requirements:

	Compliance Dates	Operating Limitations* (40 CFR §63.6603(a) and Table 2(d))
Spark ignition (natural gas, propane) units:	No later than October 19, 2013	<ul style="list-style-type: none"> - Change oil and filter every 500 hours of operation or annually, whichever comes first; - Inspect spark plugs every 1000 hours of operation or annually, whichever comes first; - Inspect all hoses and belts every 500 hours of operation or annually, whichever comes first, and replace as necessary

* Note: Due to the 500 hour operation limit on each generator, the inspections and oil/filter changes shall be performed annually to meet the requirements of 40 CFR Part 63, Subpart ZZZZ.

The Back-up Generator shall be operated and maintained according to the manufacturer's emission-related written instructions or True Textiles shall develop a 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. [40 CFR §63.6625(e)]

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A non-resettable hour meter shall be installed and operated on each generator. [40 CFR §63.6625(f)]

The Back-up Generator shall be limited to 100 hours/year for maintenance and testing. Up to 50 hours/year of the 100 hours/year may be used in non-emergency situations (this does not include peak shaving or generating income or a financial arrangement with another entity). A maximum of 15 hours per year (of the 50 hours/year) may be used as part of a demand response program. [40 CFR §63.6640(f)(1)]

True Textiles shall keep records that include maintenance conducted on the Back-up Generator and the hours of operation of each engines recorded through the non-resettable hour meter. Documentation shall include the hours spent for emergency operation, including what classified the operation as emergency and how many hours spent for non-emergency. If the Back-up Generator is used for demand response operation, True Textiles must keep records of the notification of the emergency situation, and the time the engine was operated as part of demand response. [40 CFR §63.6655(e) and (f)]

Also, True Textiles' Back-up Generator is subject to the following requirements as established by the BACT determination for the Back-up Generator (40 hp or 30 kW) found in Air Emission License amendment A-367-71-J-M:

1. The Back-up Generator shall be licensed to fire propane.
2. The Back-up Generator shall be limited to 500 hr/yr of operation based on a 12-month rolling total. Compliance shall be demonstrated by a written log of all generator operating hours.
3. Visible emissions from the Back-up Generator shall each not exceed 20% opacity on a six (6) minute block average, except for no more than two (2) six (6) minute block averages in a continuous 3-hour period.

D. Process Emissions

1. Stock and Yarn Fiber Dyeing

True Textiles dyes much of the stock and yarn fiber used at the True Textiles facility. Dyeing is a batch process performed by loading the textile substrate (stock and yarn fiber) into a dyeing machine with a solution containing dye. Because the dyes have an affinity for adhesion to the fibers, the dye molecules leave the dye solution and enter the fibers. Auxiliary chemicals and controlled bath conditioners (i.e. temperature and pressure) accelerate and optimize the dyeing process.

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Some of the dyes and dye chemicals used in the dyeing process may contain VOCs and HAPs. As materials (stock and yarn fibers, dyes and auxiliary chemicals) are constantly being evaluated by operations personnel and adjusted based on their cost, performance and customer feedback, it is not possible to determine specific emission rates for the dyeing process.

As previously licensed, True Textiles shall be subject to a VOC emission limit for the dyeing process of no greater than 38.8 tons per year (ton/yr). Also, as previously licensed, True Textiles shall be subject to a HAP emission limit for the dyeing process of no greater than 12.0 ton/yr of total HAPs and no greater than 3.0 ton/yr of any individual HAP. Compliance with the VOC and HAP emission limits shall be demonstrated by means of VOC and HAP emission log. True Textiles shall maintain the log on a monthly basis and VOC and HAP emissions from the dyeing operation shall be calculated as follows:

A = Beginning of the month facility storage;
B = Monthly facility purchases
C = End of month facility storage
D = Quantity shipped off-site

Monthly VOC emissions = (A * VOC content) + (B * VOC content) – (C * VOC content) – (D * VOC content)

Monthly total HAP emissions = (A * HAP content) + (B * HAP content) – (C * HAP content) – (D * HAP content)

Monthly individual HAP emissions = (A * individual HAP content) + (B * individual HAP content) – (C * individual HAP content) – (D * individual HAP content)

The VOC and HAP emission log shall also be maintained on a twelve-month rolling total basis.

2. Yarn Texturing

True Textiles operates three yarn texturing machines. Yarn texturing operations consist of machines that draw yarn across a jet of compressed air to roughen the yarn fiber surfaces. Water is applied to the yarn immediately prior to texturing to minimize fiber damage during the texturing process. The tension with which the wetted yarn is processed can be adjusted to increase the length of the yarn as it is being textured.

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The yarn texturing operations consists of three machines (64 spindles). The spindles from each machine vent to a common duct system for each machine. The duct systems for Texturing Machines #1 and #2 exhaust to atmosphere via a common roof mounted stack, designated Stack #10. The duct system for Texturing Machine #3 exhausts to atmosphere via a second roof mounted stack, designated Stack #11.

The yarn texturing operations has the potential to emit particulate matter (PM). The PM from this operation is believed to consist of oils and yarn fiber associated with the yarn production. PM emissions from the texturing equipment are calculated using the exhaust flow rates for the texturing machines and an assumed exit grain loading of 0.02 grains per dry standard cubic foot (gr/dscf). It is conservatively assumed that all PM is PM₁₀.

Based on previously licensed PM emission limits from the texturing process, True Textiles is limited to no greater than 0.64 pounds per hour (lb/hr) of PM emissions from Stack #10 and no greater than 0.47 lb/hr of PM emissions from Stack #11. These calculations are based on process rates of 125 pounds of yarn per hour (lb yarn/hr) combined through Texturing Machines #1 and #2 and 75 lb yarn/hr through Texturing Machine #3. Calculated as an annual limit, True Textiles is limited to annual PM emissions of no greater than 2.8 tons of yarn per year (ton yarn/yr) combined from Texturing Machines #1 and #2 (Stack #10) and 2.1 ton yarn/yr from Texturing Machine #3 (Stack #11).

06-096 CMR 101 regulates visible emission limits. Visible emissions from the texturing processes shall not exceed 10% opacity on a 6-minute block average.

3. Steam Dryer

True Textiles operates a steam dryer that utilizes steam to remove wrinkles from finished textiles. The unit wets incoming fabric using a pad-applicator and then dries the textiles in the steam heated dryer section. True Textiles operates the dryer primarily with water but at times it is necessary to apply an aqueous-based starch or other additive with the pad-applicator. The dryer is vented outside the building via a roof mounted exhaust stack. In order to allow operational flexibility for the potential substitution of materials with different VOC contents, VOC emissions from the Steam Dryer shall not exceed 2.0 tons/year on a 12-month rolling total. Compliance with this restriction shall be demonstrated by means of a VOC emissions log that shall include a record of any additive (soap, starch or other) used in the drying process and the VOC content of the additive. If additives containing VOCs are used, the log shall include calculations for VOC emissions based on material throughput and additive usage.

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4. Inspection Stations

True Textiles utilizes several inspection stations to allow personnel to visually inspect finished textiles for defects, blemishes and other abnormalities that impact product quality. Blemishes caused by dirt, grease, grime, etc., picked up during manufacturing will be cleaned by hand using a spray-on stain remover and rags.

This process results in Fugitive VOC emissions from the use of the stain remover. The stain remover proposed for use is 100% VOC by weight. Based on data from a similar facility, annual VOC emissions are thought to be close to 1.10 ton/yr. In order to allow operational flexibility for the potential substitution of materials with different VOC contents, VOC emissions from the Inspection Station shall not exceed 2.0 tons/year on a 12-month rolling total. Compliance with the annual VOC emission restriction from inspections stations shall be demonstrated via a spray-on stain remover use log. The log shall be maintained on a monthly and 12-month rolling total basis and will consist of entries of spray-on stain remover monthly use as well as VOC emissions calculations based on the spray-on stain remover use and VOC content.

E. Parts Washers

True Textiles makes use of three parts washers to support the maintenance activities at the True Textiles facility. Two of the parts washers have volumetric capacities of 30 gallons and the third parts washer has a volumetric capacity of 5 gallons. All of the parts washers at the True Textiles facility use Zep Dyna 143 solvent. The Department has determined that these units are subject to the requirements established in *Solvent Cleaners*, 06-096 CMR 130 for solvent cleaners and True Textiles shall operate and maintain the parts washers, as well as maintain records, in accordance with 06-096 CMR 130.

F. VOC RACT

Pursuant to 06-096 CMR 134, §1(C)(2), the following VOC-emitting equipment or processes are exempted in determining a facility's total VOC emissions since they have previously been determined to achieve Best Available Control Technology (BACT) for VOC:

1. Wood or oil fired Boilers #1 and #2 underwent BACT prior to the issuance of Air Emission License A-367-74-A-R in 1986.
2. Oil fired Boiler #3 underwent BACT prior to the issuance of Air Emission License A-367-74-A-R in 1986.

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3. The Steam Dryer and Inspection Stations underwent BACT in Air Emission License amendment A-367-71-I-M

When the facility's VOC emissions are calculated with the above exemptions taken into consideration, True Textiles is not subject to the requirements of 06-096 CMR 134 at this time.

G. Annual Emission Restrictions

- True Textiles is subject to a facility wide #2 fuel oil/Biodiesel use restriction of no greater than 1,298,000 gal/yr. True Textiles shall only fire fuel oil that meets the sulfur content criteria of ASTM D396 (0.5% sulfur by weight).
- Emissions calculations for wood firing in Boilers #1 and #2 were based on 8760 hours per year of operations while firing wood.

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

	PM	PM ₁₀	SO ₂	NO _x	CO	VOC
Wood Fired Boilers	25.2	25.2	1.20	18.6	44.5	0.96
Oil Fired Boilers	18.1	18.1	31.8	27.1	3.23	0.13
Yarn Texturing	4.9	4.9	--	--	--	--
Dyeing	--	--	--	--	--	38.8
Steam Dryer	--	--	--	--	--	2.0
Inspection Station	--	--	--	--	--	2.0
Total TPY	48.17	48.17	33.0	45.7	47.73	43.89

True Textiles is also limited to 3.0 ton/yr for each individual HAP and 12.0 ton/yr of total HAPs.

III. AMBIENT AIR QUALITY ANALYSIS

According to 06-096 CMR 115, the level of air quality analyses required for a minor source shall be determined on a case-by case basis. Based on the information available in the file, and the similarity to existing sources, Maine Ambient Air Quality Standards (MAAQS) will not be violated by this source. Based on the total facility emissions, True Textiles is below the emissions level required for modeling and monitoring.

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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-367-71-M-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 06-096 CMR 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]

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- (5) The licensee shall pay the annual air emission license fee to the Department, calculated pursuant to Title 38 M.R.S.A. §353. [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

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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]

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- (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) Boilers #1 and #2 (Wood firing)
- A. True Textiles is permitted to fire wood fuels which consists primarily of purchased wood chips, or hogged wood and may contain or be blended with wood waste (i.e. bark, sawdust, other biomass, etc.) and ground paper cores prior to firing. The wood fuel fired may also occasionally contain small amounts of cotton swab waste and paper wrappers from True Textiles' wood supplier. [06-096 CMR 115, BPT]
- B. Emissions from Boilers #1 and #2 during periods of wood fuel firing shall not exceed the following:

Equipment		PM	PM ₁₀	SO ₂	NO _x	CO	VOC
Boiler #1	lb/MMBtu	0.34	n/a	n/a	n/a	n/a	n/a
	lb/hr	5.75	5.75	0.3	4.2	10.1	0.2
Boiler #2	lb/MMBtu	0.34	n/a	n/a	n/a	n/a	n/a
	lb/hr	5.75	5.75	0.3	4.2	10.1	0.2

[06-096 CMR 115, BPT]

- C. Visible emissions from firing wood fuel from Stack #1 and Stack #2 (Stack #1 serves Boilers #1 and #3; Stack #2 serves Boiler #2) shall each not exceed 30% opacity on a 6 minute block average, except for no more than 2 six minute block averages in a 3-hour period. [06-096 CMR 101]

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D. Visible emissions from the ash handling systems shall not exceed 20% opacity, except for no more than five minutes in any 1-hour period. Compliance shall be determined by an aggregate of the individual 15-second opacity observations which exceed 20% in any 1-hour. [06-096 CMR 101]

(17) Boilers #1, #2, #3, #4 and #5 (Oil firing)

- A. True Textiles is subject to a facility wide #2 fuel oil/Biodiesel use restriction of no greater than 1,298,000 gallons per year (gal/yr) based on a twelve-month rolling total.[06-096 CMR 115, BPT]
- B. Until December 31, 2015, the #2 fuel oil fired in the True Textiles boilers shall be ASTM D396 compliant #2 fuel oil (maximum sulfur content of 0.5% by weight). Per 38 MRSA §603-A(2)(A)(3), beginning January 1, 2016, the facility shall fire #2 fuel oil with a maximum sulfur content limit of 0.005% by weight (50 ppm), and beginning January 1, 2018, the facility shall fire #2 fuel oil with a maximum sulfur content limit of 0.0015% by weight (15 ppm). [06-096 CMR 115, BPT]
- C. True Textiles shall demonstrate compliance with the above fuel use restriction by means of a fuel purchase record which shall include fuel purchase receipts indicating the amount of fuel purchased and certification from the supplier indicating the sulfur content of the purchased fuel.[06-096 CMR 115, BPT]
- D. Emissions from Boilers #1, #2, #3, #4 and #5 during periods of #2 fuel oil firing shall not exceed the following:

Equipment		PM	PM ₁₀	SO ₂	NO _x	CO	VOC
Boiler #1	lb/MMBtu	0.2	-	-	-	-	-
	lb/hr	3.3	3.3	5.8	3.3	0.6	0.02
Boiler #2	lb/MMBtu	0.2	-	-	-	-	-
	lb/hr	3.3	3.3	5.8	3.3	0.6	0.02
Boiler #3	lb/MMBtu	0.2	-	-	-	-	-
	lb/hr	2.6	2.6	4.5	2.6	0.5	0.02
Boiler #4	lb/hr	0.3	0.3	1.0	0.6	0.1	0.004
Boiler #5	lb/hr	0.4	0.4	1.2	0.7	0.1	0.005

[06-096 CMR 115, BPT]

- E. Visible emissions from firing #2 fuel oil from Stack #1 and Stack #3 (Stack #1 serves Boilers #1 and #3; Stack #3 serves Boiler #4 and #5) shall each not exceed 30% opacity on a 6 minute block average, except for no more than 2 six minute block averages in a 3-hour period. [06-096 CMR 101]

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(18) Temporary Boilers

- A. In the event of a catastrophic event that limits or denies True Textiles the ability to conduct business, such as, but not limited to, a flood or fire, True Textiles may operate temporary #2 fuel oil fired rental boilers at their Guilford facility. [06-096 CMR 115, BPT]
- B. True Textiles shall only fire fuel oil that meets the sulfur content criteria of ASTM D396 (0.5% sulfur by weight). [06-096 CMR 115, BPT]
- C. The temporary rental boilers shall be subject to emissions rates based on the following:
 - i. Potential annual emission rates for the temporary emergency boilers, shall be based on 4380 hours (6 months) of operation and a total predicted heat input capacity of 29 MMBtu/hr.
 - ii. The SO₂ emission limits are based on the firing of fuel which meets the criteria in ASTM D396 for #2 fuel oil.
 - iii. 06-096 CMR 103 regulates hourly PM hourly emission limits. 06-096 CMR 103 establishes an emission restriction of no greater than 0.12 lb/MMBtu for boilers installed after December 22, 1982. PM₁₀ hourly emission limits are based on PM limits.
 - iv. NO_x, SO₂, CO and VOC hourly emission limits are based upon AP-42 emission factors dated 9/98.
[06-096 CMR 115, BPT]
- D. Visible emissions from the temporary boiler(s) during periods of #2 fuel oil firing shall not exceed 20% opacity on a 6-minute block average, except for no more than one 6-minute block average in a continuous 3-hour period.
[06-096 CMR 101]

(19) Back-up Generator

- A. True Textiles shall limit the Back-up Generator to 500 hr/yr of operation (based on a 12 month rolling total). An hour meter shall be maintained and operated on the Back-up Generator.
[06-096 CMR 115, BPT, 40 CFR §63.6625(f)]
- B. The Back-up Generator shall only be operated for maintenance purposes and for situations arising from sudden and reasonably unforeseeable events beyond the control of the source. The Back-up Generator shall not to be used for prime power when reliable offsite power is available. A log shall be maintained documenting the date, time, and reason for operation.
[06-096 CMR 115, BPT]

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- C. The Back-up Generator shall be limited to firing propane. Compliance shall be based on fuel records from the fuel supplier. [06-096 CMR 115, BPT]
- D. Visible emissions from the Back-up Generator shall not exceed 20% opacity on a six (6) minute block average, except for no more than two (2) six (6) minute block averages in a continuous 3-hour period. [06-096 CMR 101]
- E. The Back-up Generator shall meet the applicable requirements of 40 CFR Part 63, Subpart ZZZZ, including the following:
 - 1. No later than October 19, 2013, True Textiles shall meet the following operational limitations for the Back-up Generator:
 - a. Change the oil and filter annually,
 - b. Inspect the air cleaner annually, and
 - c. Inspect the houses and belts annually and replace as necessary.

A log shall be maintained documenting compliance with the operational limitations.

[40 CFR §63.6603(a) and Table 2(d); and 06-096 CMR 115]

- 2. Maintenance, Testing, and Non-Emergency Operating Situations
 - a. The Back-up Generator shall be limited to 100 hours/year for maintenance and testing. Up to 50 hours/year of the 100 hours/year may be used in non-emergency situations (this does not include peak shaving or generating income or a financial arrangement with another entity). A maximum of 15 hours per year (of the 50 hours/year) may be used as part of a demand response program. These limits are based on a 12 month rolling total. Compliance shall be demonstrated by a written log of all generator operating hours.
[40 CFR §63.6640(f)(1) and 06-096 CMR 115]
 - b. True Textiles shall keep records that include maintenance conducted on the Back-up Generator and the hours of operation of the Back-up Generator recorded through the non-resettable hour meter. Documentation shall include the hours spent for emergency operation, including what classified the operation as emergency and how many hours spent for non-emergency. If the Back-up Generator is used for demand response operation, True Textiles must keep records of the notification of the emergency situation, and the time the engine was operated as part of demand response. [40 CFR §63.6655(e) and (f)]

3. The Back-up Generator shall be operated and maintained according to the manufacturer's emission-related written instructions or True Textiles shall develop a 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.
[40 CFR §63.6625(e)]

(20) Stock and Yarn Fiber Dyeing

- A. True Textiles Shall be subject to an annual VOC emission restriction of no greater than 38.8 ton/yr of VOC emissions from the dyeing process, based on a twelve-month rolling total. [06-096 CMR 115, BPT]
- B. True Textiles Shall be subject to an annual HAP emission restriction of no greater than 12.0 ton/yr of total HAPs emissions from the dyeing process and 3.0 ton/yr of any individual HAP emitted from the dyeing process.
[06-096 CMR 115, BPT]
- C. Compliance with the VOC and HAP emission restrictions shall be demonstrated by means of VOC and HAP emission log. True Textiles shall maintain the log on a monthly basis and VOC and HAP emissions from the dyeing operation shall be calculated as follows:

A = Beginning of the month facility storage;
B = Monthly facility purchases
C = End of month facility storage
D = Quantity shipped off-site

Monthly VOC emissions = (A * VOC content) + (B * VOC content) - (C * VOC content) - (D * VOC content)

Monthly total HAP emissions = (A * HAP content) + (B * HAP content) - (C * HAP content) - (D * HAP content)

Monthly individual HAP emissions = (A * individual HAP content) + (B * individual HAP content) - (C * individual HAP content) - (D * individual HAP content)

The VOC and HAP emission log shall also be maintained on a twelve-month rolling total basis.
[06-096 CMR 115, BPT]

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- D. Visible emissions from the dyeing process shall not exceed 20% opacity, except for no more than one 6-minute block average in a 1-hour period.
[06-096 CMR 101]

(21) Yarn Texturing

- A. True Textiles shall be subject to the following limits for PM emissions from the yarn texturing process:

Emission Source	lb/hr limit	ton/yr limit
Stack #10 (Texturing Machines #1 and #2)	0.64 lb/hr	2.8 ton/yr
Stack #11 (Texturing Machine #3)	0.47 lb/hr	2.1 ton/yr

[06-096 CMR 115, BPT]

- B. Visible emissions from each texturing process stack shall not exceed 10% opacity on a 6-minute block average. [06-096 CMR 101]

(22) Steam Dryer

- A. True Textiles shall be subject to an annual VOC emission restriction of no greater than 2.0 ton/yr of VOC emissions from the Steam Dryer, based on a twelve-month rolling total. [06-096 CMR 115, BPT]

- B. True Textiles shall maintain a Steam Dryer VOC emissions log that shall include a record of any additive (soap, starch or other) used in the drying process and the VOC content of the additive. If additives containing VOCs are used, the log shall include calculations for VOC emissions based on material throughput and additive usage. [06-096 CMR 115, BPT]

- C. Visible emissions from the Steam Dryer shall not exceed 20% opacity on a 6-minute block average basis, except for no more than one 6-minute block average in a 1-hour period. [06-096 CMR 101]

(23) Inspection Stations

- A. True Textiles shall be subject to an annual VOC emission restriction of no greater than 2.0 ton/yr of VOC emissions from Inspection Station activities, based on a twelve-month rolling total. [06-096 CMR 115, BPT]

- B. True Textiles shall maintain an Inspection Station VOC emissions log that shall include a record of spray-on stain remover used during Inspection Station activities and the VOC content of the spray-on stain remover. The log shall also include calculations for VOC emissions based on spray-on stain remover usage. [06-096 CMR 115, BPT]

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C. Visible emissions from Inspection Station activities shall not exceed 20% opacity on a 6-minute block average basis, except for no more than one 6-minute block average in a 1-hour period. [06-096 CMR 101]

(24) Parts Washers

A. True Textiles shall maintain a record of Zep Dyna 143 solvent use that shall include the amount added to the degreaser units and the dates that the solvent was added. For the purposes of record keeping, the amount of solvent used shall be considered as the difference between the amount of solvent added and the amount of solvent removed. [06-096 CMR 115, BPT]

B. In accordance with 06-096 CMR 130, Section 3A, True Textiles shall follow equipment and operational standards when making use of the facility's parts washers. [06-096 CMR 130]

C. True Textiles shall be subject to the following compliance standards:

1. Immersion cold cleaning machines shall have a freeboard ratio of 0.75 or greater unless the machines are equipped with covers that are kept closed except when parts are being placed into or being removed from the machine.

2. Immersion cold cleaning machines and remote reservoir cold cleaning machines shall:

a. Have a permanent, conspicuous label summarizing the operating requirements in Subsection c below;

b. Be equipped with a cover that shall be closed at all times except during cleaning of parts or the addition or removal of solvent. For remote reservoir cold cleaning machines which drain directly into the solvent storage reservoir, a perforated drain with a diameter of not more than six inches shall constitute an acceptable cover;

c. Cold cleaning machines shall be operated in accordance with the following procedures:

1. Waste solvent shall be collected and stored in closed containers. The closed containers may contain a device that allows pressure relief, but does not allow liquid solvent to drain from the container;

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2. Cleaned parts shall be drained at least 15 seconds or until dripping ceases, whichever is longer. Parts having cavities or blind holes shall be tipped or rotated while the part is draining. During the draining, tipping or rotating, the parts shall be positioned so that solvent drains directly back to the cold cleaning machine;
3. Flushing of parts using a flexible hose or other flushing device shall be performed only within the freeboard area of the cold cleaning machine. The solvent spray shall be a solid fluid stream, not an atomized or shower spray at a pressure that does not exceed 10 pounds per square inch gauge (psig);
4. The owner or operator shall ensure that, when the cover is open, the cold cleaning machine is not exposed to drafts greater than 40 meters per minute (132 feet per minute), as measured between 1 and 2 meters (3.3 and 6.6 feet) upwind and at the same elevation as the tank lip;
5. Sponges, fabric, wood, leather, paper products and other absorbent materials shall not be cleaned in the cold cleaning machine;
6. When a pump-agitated solvent bath is used, the agitator shall be operated to produce a rolling motion of the solvent with no observable splashing of the solvent against the tank walls or the parts being cleaned. Air agitated solvent baths may not be used;
7. Spills during solvent transfer and use of the cold cleaning machine shall be cleaned up immediately, and the wipe rags or other sorbent material shall be immediately stored in covered containers for disposal or recycling;
8. Work area fans shall be located and positioned so that they do not blow across the opening of the degreaser unit; and
9. The owner or operator shall ensure that the solvent level does not exceed the fill line.

[06-096 CMR 130]

- D. If, in the future, True Textiles switches to a solvent that contains less than 5% VOC for use in the parts washers, to satisfy record keeping requirements True Textiles need only keep a copy of the MSDS sheet that demonstrates the VOC content of the solvent on file at the True Textiles facility.

[06-096 CMR 115, BPT, 06-096 CMR 130]

(25) True Textiles shall emit less than 12 tons per year of total Hazardous Air Pollutants (HAP) and 3 ton/yr of any individual HAP (HAP as defined in 06-096 CMR 115, Appendix B, Section C) from units or activities which are not listed as “insignificant” in 06-096 CMR 115, Appendix B, Section B and shall keep a record of all the HAP emitted from units or activities which are not listed as “insignificant” in 06-096 CMR 115, Appendix B, Section B on a twelve-month rolling average. [06-096 CMR 115, BPT]

(26) *Emissions Statements*, 06-096 CMR 137 Reporting

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:

- 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.

Reports and questions should be directed to:

Attn: Criteria Emission Inventory Coordinator
Maine DEP
Bureau of Air Quality
17 State House Station
Augusta, ME 04333-0017

Phone: (207) 287-2437

(27) Fugitive Emissions

Visible emissions from a fugitive emission source (including stockpiles and roadways) shall not exceed an opacity of 20%, 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]

True Textiles, Inc.)
Piscataquis County)
Guilford, Maine)
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(28) General Process Sources

Visible emissions from any general process source shall not exceed an opacity of 20% 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. [06-096 CMR 101]

- (29) True Textiles 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 MRSA §605-C).

DONE AND DATED IN AUGUSTA, MAINE THIS 21th DAY OF November 2011.

DEPARTMENT OF ENVIRONMENTAL PROTECTION

BY: Patricia W. Aho
PATRICIA W. AHO, COMMISSIONER

PLEASE NOTE ATTACHED SHEET FOR GUIDANCE ON APPEAL PROCEDURES

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

Date of initial receipt of application: May 14, 2008

Date of application acceptance: June 3, 2008

Date filed with the Board of Environmental Protection: _____

This Order prepared by, Peter G. Carleton, Bureau of Air Quality



