the in-line kiln/raw mill, or the alkali bypass in excess of 41 μg/dscm if the source is a new or reconstructed source that commenced construction after December 2, 2005. As an alternative to meeting the 41 μg/dscm standard you may route the emissions through a packed bed or spray tower wet scrubber with a liquid-to-gas (l/g) ratio of 30 gallons per 1000 actual cubic feet per minute (acfm) or more and meet a site-specific emissions limit based on the measured performance of the wet scrubber.

(d) Existing kilns located at area sources. No owner or operator of an existing kiln or an existing in-line kiln/raw mill located at a facility that is an area source subject to the provisions of this subpart shall cause to be discharged into the atmosphere from these affected sources any gases which:

(1) Contain D/F in excess of 0.20 ng per dscm (8.7 × 10⁻¹¹ gr per dscf) (TEQ); or

(2) Contain D/F in excess of 0.40 ng per dscm (1.7 × 10⁻¹⁰ gr per dscf) (TEQ) when the average of the performance test run average temperatures at the inlet to the particulate matter control device is 204 °C (400 °F) or less.

(e) New or reconstructed kilns located at area sources. No owner or operator of a new or reconstructed kiln or new or reconstructed in-line kiln/raw mill located at a facility that is an area source subject to the provisions of this subpart shall cause to be discharged into the atmosphere from these affected sources any gases which:

(1) Contain D/F in excess of:
   (i) 0.20 ng per dscm (8.7 × 10⁻¹¹ gr per dscf) (TEQ); or
   (ii) 0.40 ng per dscm (1.7 × 10⁻¹⁰ gr per dscf) (TEQ) when the average of the performance test run average temperatures at the inlet to the particulate matter control device is 204 °C (400 °F) or less.

(2) Contain total hydrocarbons (THC), from the main exhaust of the kiln, or main exhaust of the in-line kiln/raw mill, or the alkali bypass in excess of 20 ppmv if the source is a new or reconstructed source that commenced construction after December 2, 2005. As an alternative to meeting the 20 ppmv standard you may demonstrate a 98 percent reduction of THC emissions from the exit of the kiln to discharge to the atmosphere. If the source is a greenfield kiln that commenced construction on or prior to December 2, 2005, then the THC limit is 50 ppmv.

(3) Contain mercury from the main exhaust of the kiln, or main exhaust of the in-line kiln/raw mill, or the alkali bypass in excess of 41 μg/dscm if the source is a new or reconstructed source that commenced construction after December 2, 2005. As an alternative to meeting the 41 μg/dscm standard you may route the emissions through a packed bed or spray tower wet scrubber with a liquid-to-gas (l/g) ratio of 30 gallons per 1000 actual cubic feet per minute (acfm) or more and meet a site-specific emissions limit based on the measured performance of the wet scrubber.

[71 FR 76549, Dec. 20, 2006]
of this section and established during the performance test, with or without
the raw mill operating, is not exceeded.
(b) The temperature limit for affected sources meeting the limits of
paragraph (a) of this section or paragraphs (a)(1) through (a)(3) of this sec-
tion is determined in accordance with §63.1349(b)(3)(iv).
(c) The owner or operator of an affected source subject to a mercury,
THC or D/F emission limitation under §63.1343 that employs carbon injection
as an emission control technique must operate the carbon injection system in
accordance with paragraphs (c)(1) and (c)(2) of this section.
(1) The three-hour rolling average activated carbon injection rate shall be
equal to or greater than the activated carbon injection rate determined in ac-
cordance with §63.1349(b)(3)(vi).
(2) The owner or operator shall either:
(i) Maintain the minimum activated carbon injection carrier gas flow rate,
as a three-hour rolling average, based on the manufacturer’s specifications.
These specifications must be document-
ted in the test plan developed in accordance with §63.7(c), or
(ii) Maintain the minimum activated carbon injection carrier gas pressure drop, as a three-hour rolling average, based on the manufacturer’s specifications.
These specifications must be document-
ted in the test plan developed in accordance with §63.7(c).
(d) Except as provided in paragraph (e) of this section, the owner or oper-
ator of an affected source subject to a mercury, THC or D/F emission limitation
under §63.1343 that employs carbon injection as an emission control technique
must specify and use the brand and type of activated carbon used during the performance test until
a subsequent performance test is con-
ducted, unless the site-specific perfor-
mance test plan contains docu-
mentation of key parameters that af-
flect adsorption and the owner or oper-
ator establishes limits based on those
parameters, and the limits on these pa-
rameters are maintained.
(e) The owner or operator of an af-
fected source subject to a D/F, THC, or
mercury emission limitation under
§63.1343 that employs carbon injection
as a control technique may substitute, at any time, a different brand or type of activated carbon pro-
vided that the replacement has equiva-
lent or improved properties compared
to the activated carbon specified in the
site-specific performance test plan and
used in the performance test. The
owner or operator must maintain docu-
mentation that the substitute acti-
vated carbon will provide the same or
better level of control as the original
activated carbon.
(f) Existing kilns and in-line kilns/ raw mills must implement good com-
bustion practices (GCP) designed to
minimize THC from fuel combustion.
GCP include training all operators and
supervisors to operate and maintain
the kiln and calciner, and the pollution
control systems in accordance with
good engineering practices. The train-
ing shall include methods for mini-
mizing excess emissions.
(g) No kiln and in-line kiln/raw mill
may use as a raw material or fuel any
fly ash where the mercury content of
the fly ash has been increased through
the use of activated carbon, or any
other sorbent unless the facility can
demonstrate that the use of that fly
ash will not result in an increase in
mercury emissions over baseline emis-
sions (i.e. emissions not using the fly
ash). The facility has the burden of
proving there has been no emissions in-
crease over baseline.
(b) All kilns and in-line kilns/raw
mills must remove (i.e. not recycle to
the kiln) from the kiln system suffi-
cient cement kiln dust to maintain the
desired product quality.
(i) New and reconstructed kilns and
in-line kilns/raw mills must not exceed
the average hourly CKD recycle rate
measured during mercury performance
testing. Any exceedance of this average
hourly rate is considered a violation of
the standard.
[64 FR 31925, June 14, 1999, as amended at 67
FR 72585, Dec. 6, 2002; 71 FR 76550, Dec. 20,
2006]
§ 63.1345 Standards for clinker coolers.
(a) No owner or operator of a new or
existing clinker cooler at a facility
which is a major source subject to the
provisions of this subpart shall cause
to be discharged into the atmosphere