

**AIR EMISSION PERMIT NO. 09900002- 003  
IS ISSUED TO**

**Hormel Foods Corporation**  
Quality Pork Processors (QPP)  
Hormel Foods Corp - Austin  
500 - 14th Avenue Northeast  
Austin, Mower County, Minnesota 55912

The emission units, control equipment and emission stacks at the stationary source authorized in this permit are as described in the following permit application(s):

<b>Permit Type</b>	<b>Application Date</b>
Total Facility Operating Permit	January 1995
Minor Amendment	July 21, 1999
Moderate Amendment	February 2000

This permit authorizes the permittee to operate the stationary source at the address listed above unless otherwise noted in Table A. The permittee must comply with all the conditions of the permit. Any changes or modifications to the stationary source must be performed in compliance with Minn. R. 7007.1150 to 7007.1500. Terms used in the permit as defined in the state air pollution control rules unless the term is explicitly defined in the permit.

**Permit Type:** Moderate Amendment to a Part 70 Permit

**Issue Date:** May 8, 2000

**Expiration:** August 5, 2004

Title I Conditions do not expire.

Carolina Schutt

Rodney E. Massey, P.E.

Director

South District

for

Karen A. Studders

Commissioner

Minnesota Pollution Control Agency

JR:lk

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**NOTICE TO THE PERMITTEE:**

Your stationary source may be subject to the requirements of the Minnesota Pollution Control Agency's (MPCA) solid waste, hazardous waste, and water quality programs. If you wish to obtain information on these programs, including information on obtaining any required permits, please contact the MPCA general information number at:

Metro Area	(651) 296-6300
Outside Metro Area	1-800-657-3864
TTY	(651) 282-5332

The rules governing these programs are contained in Minn. R. chs. 7000-7105. Written questions may be sent to: Minnesota Pollution Control Agency, 520 Lafayette Road North, St. Paul, Minnesota 55155-4194.

Questions about this air emission permit or about air quality requirements can also be directed to the telephone numbers and address listed above.

**PERMIT SHIELD:**

Subject to the limitations in Minn. R. 7007.1800, compliance with the conditions of this permit shall be deemed compliance with the specific provision of the applicable requirement identified in the permit as the basis of each condition. Certain requirements, which have been determined not to apply, are listed in Table A of this permit.

**MODIFICATION DESCRIPTION:**

This permit authorizes Hormel to modify an existing bacon bits cook line. Currently, bacon is loaded, conveyed through microwave cavities, precooked in two microwave ovens, and packaged. Energy is supplied to the process via electricity through four transmitters. The installation of eight additional transmitters and two additional ovens will allow the bacon bits line to operate at a higher capacity. Current capacity is approximately 1,876 pounds per hour of raw bacon. After the installation of the new microwave transmitters, the line will be capable of processing a maximum of 7000 pounds per hour. Emissions from the process are controlled by a mist eliminator.

The facility is a synthetic minor one for new source review purposes. This modification does not change the status of the facility.

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Table A contains limits and other requirements with which your facility must comply. The limits are located in the first column of the table (What To do). The limits can be emission limits or operational limits. This column also contains the actions that you must take and the records you must keep to show that you are complying with the limits. The second column of Table A (Why to do it) lists the regulatory basis for these limits. Appendices included as conditions of your permit are listed in Table A under total facility requirements.**

**Subject Item:****Total Facility**

<b>What to do</b>	<b>Why to do it</b>
Operation and Maintenance Plan: Retain at the stationary source an operation and maintenance plan for all air pollution control equipment.	Minn. R. 7007.0800, subp. 14 and Minn. R. 7007.0800, subp. 16(J)
Performance Testing: Conduct all performance tests in accordance with Minn. R. ch. 7017 unless otherwise noted in Tables A, B, and/or C.	Minn. R. ch. 7017
Limits set as a result of a performance test (conducted before or after permit issuance) apply until superseded as specified by Minn. R. 7017.2025 following formal review of a subsequent performance test on the same unit.	Minn. R. 7017.2025
Performance Test Notifications and Submittals:  Performance Tests are due as outlined in Tables A and B of the permit. See Table B for additional testing requirements.  Performance Test Notification (written): due 30 days before each Performance Test Performance Test Plan: due 30 days before each Performance Test Performance Test Pre-test Meeting: due 7 days before each Performance Test Performance Test Report: due 45 days after each Performance Test Performance Test Report - Microfiche Copy: due 105 days after each Performance Test	Minn. R. 7017.2030, subp. 1-4 and Minn. R. 7017.2035, subp. 1-2.
Monitoring Equipment: Install or make needed repairs to monitoring equipment within 60 days of issuance of the permit if monitoring equipment is not installed and operational on the date the permit is issued.	Minn. R. 7007.0800, subp. 4(D)
Monitoring Equipment Calibration: Annually calibrate all required monitoring equipment (any requirements applying to continuous emission monitors are listed separately in this permit).	Minn. R. 7007.0800, subp. 4(D)
Operation of Monitoring Equipment: Unless otherwise noted in Tables A, B, and/or C, monitoring a process or control equipment connected to that process is not necessary during periods when the process is shutdown, or during checks of the monitoring systems, such as calibration checks and zero and span adjustments. If monitoring records are required, they should reflect any such periods of process shutdown or checks of the monitoring system.	Minn. R. 7007.0800, subp. 4(D)
Circumvention: Do not install or use a device or means that conceals or dilutes emissions, which would otherwise violate a federal or state air pollution control rule, without reducing the total amount of pollutant emitted.	Minn. R. 7011.0020
Shutdown Notifications: Notify the Commissioner at least 24 hours in advance of a planned shutdown of any control equipment or process equipment if the shutdown would cause any increase in the emissions of any regulated air pollutant. If the owner or operator does not have advance knowledge of the shutdown, notification shall be made to the Commissioner as soon as possible after the shutdown. However, notification is not required in the circumstances outlined in Items A, B and C of Minn. R. 7019.1000, subp. 3.  At the time of notification, the owner or operator shall inform the Commissioner of the cause of the shutdown and the estimated duration. The owner or operator shall notify the Commissioner when the shutdown is over.	Minn. R. 7019.1000, subp. 3
Breakdown Notifications: Notify the Commissioner within 24 hours of a breakdown of more than one hour duration of any control equipment or process equipment if the breakdown causes any increase in the emissions of any regulated air pollutant. The 24-hour time period starts when the breakdown was discovered or reasonably should have been discovered by the owner or operator. However, notification is not required in the circumstances outlined in Items A, B and C of Minn. R. 7019.1000, subp. 2.  At the time of notification or as soon as possible thereafter, the owner or operator shall inform the Commissioner of the cause of the breakdown and the estimated duration. The owner or operator shall notify the Commissioner when the breakdown is over.	Minn. R. 7019.1000, subp. 2
Notification of Deviations Endangering Human Health or the Environment: As soon as possible after discovery, notify the Commissioner or the state duty officer, either orally or by facsimile, of any deviation from permit conditions which could endanger human health or the environment.	Minn. R. 7019.1000, subp. 1

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

Notification of Deviations Endangering Human Health or the Environment Report: Within 2 working days of discovery, notify the Commissioner in writing of any deviation from permit conditions which could endanger human health or the environment. Include the following information in this written description: 1. the cause of the deviation; 2. the exact dates of the period of the deviation, if the deviation has been corrected; 3. whether or not the deviation has been corrected; 4. the anticipated time by which the deviation is expected to be corrected, if not yet corrected; and 5. steps taken or planned to reduce, eliminate, and prevent reoccurrence of the deviation.	Minn. R. 7019.1000, subp. 1
Operation Changes: In any shutdown, breakdown, or deviation the Permittee shall immediately take all practical steps to modify operations to reduce the emission of any regulated air pollutant. The Commissioner may require feasible and practical modifications in the operation to reduce emissions of air pollutants. No emissions units that have an unreasonable shutdown or breakdown frequency of process or control equipment shall be permitted to operate.	Minn. R. 7019.1000, subp. 4
Air Pollution Control Equipment: Operate all pollution control equipment whenever the corresponding process equipment and emission units are operated, unless otherwise noted in Table A.	Minn. R. 7007.0800, subp. 2; Minn. R. 7007.0800, subp. 16(J)
Fugitive Emissions: Do not cause or permit the handling, use, transporting, or storage of any material in a manner which may allow avoidable amounts of particulate matter to become airborne. Comply with all other requirements listed in Minn. R. 7011.0150.	Minn. R. 7011.0150
Application for Permit Amendment: If a permit amendment is needed, submit an application in accordance with the requirements of Minn. R. 7007.1150 through Minn. R. 7007.1500. Submittal dates vary, depending on the type of amendment needed.	Minn. R. 7007.1150 through Minn. R. 7007.1500
Extension Requests: The Permittee may apply for an Administrative Amendment to extend a deadline in a permit by no more than 120 days, provided the proposed deadline extension meets the requirements of Minn. R. 7007.1400, subp. 1(H).	Minn. R. 7007.1400, subp. 1(H)
Record keeping: Maintain records describing any insignificant modifications (as required by Minn. R. 7007. 1250, subp. 3) or changes contravening permit terms (as required by Minn. R. 7007.1350 subp. 2), including records of the emissions resulting from those changes.	Minn. R. 7007.0800, subp. 5(B)
Record keeping: Retain all records at the stationary source for a period of five (5) years from the date of monitoring, sample, measurement, or report. Records which must be retained at this location include all calibration and maintenance records, all original recordings for continuous monitoring instrumentation, and copies of all reports required by the permit. Records must conform to the requirements listed in Minn. R. 7007.0800, subp. 5(A).	Minn. R. 7007.0800, subp. 5(C)
Noise: The Permittee shall comply with the noise standards set forth in Minn. R. 7030.0010 to 7030.0080 at all times during the operation of any emission units. This is a state only requirement and is not federally enforceable.	Minn. R. 7030.0010 - 7030.0080
The Permittee shall comply with the General Conditions listed in Minn. R. 7007.0800, subp. 16.	Minn. R. 7007.0800, subp. 16
Inspections: Upon presentation of credentials and other documents as may be required by law, allow the Agency, or its representative, to enter the Permittee's premises to have access to and copy any records required by this permit, to inspect at reasonable times (which include any time the source is operating) any facilities, equipment, practices or operations, and to sample or monitor any substances or parameters at any location.	Minn. R. 7007.0800, subp. 9(A)
Emission Fees: due 60 days after receipt of an MPCA bill.	Minn. R. 7002.0005 through Minn. R. 7002.0095

# TABLE A: LIMITS AND OTHER REQUIREMENTS

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item:** GP 001 Boilers (49, 49, 49, 25 & 7.14 MMBtu/hr)

**Associated Items:** EU 001 Gas/Oil Fired Boiler

EU 002 Gas/Oil Fired Boiler

EU 003 Gas/Oil Fired Boiler

EU 004 Gas/Oil Fired Boiler

EU 005 Gas/Oil Fired Boiler

SV 001 Boiler Stack

What to do	Why to do it
EMISSION LIMITS	hdr
Total Particulate Matter: less than or equal to 0.4 lbs/million Btu heat input (applies individually to each boiler).	Minn. R. 7011.0515, subp. 1
Opacity: less than or equal to 20 percent opacity except for one six-minute period per hour of not more than 60 percent opacity.	Minn. R. 7011.0515, subp. 2
Sulfur Dioxide: less than or equal to 247 tons/year on a 12 month rolling sum.	Title I Condition: To limit potential SO2 emissions to less than major source levels as defined by 40 CFR Section 52.21
Sulfur Dioxide: less than or equal to 2.0 lbs/million Btu heat input ( 1.89% percent sulfur)	Minn. R. 7011.0510, subp. 1
OPERATING LIMITS	hdr
Fuel allowed: limited to natural gas, No. 6 fuel oil, and used oil.	Minn. R. 7007.0800, subp. 2.
The used oil combusted in EU 001 through EU 005 shall be used oil which is defined as any oil which has been used and as a result of such use has become contaminated by physical or chemical impurities. The used oil shall not contain any hazardous waste listed in Minn. R. 7045.0135. The used oil must be on-specification and meet the following restrictions: 1) Total Arsenic not to exceed 5 ppm 2) Total Cadmium not to exceed 2 ppm 3) Total Chromium not to exceed 10 ppm 4) Total Lead not to exceed 100 ppm 5) Flash point not less than 100 degrees F 6) Total Halogens not to exceed 1,000 ppm The Permittee must obtain and keep on-site for at least five years a laboratory analysis demonstrating that the used oil is on-specification.	Minn. R. 7007.0800, subp. 2
Fuel Usage: less than or equal to 15000 gallons/year using 12-month Rolling Sum of used oil as a total in all boilers.	Minn. R. 7007.0800, subp. 2
Limit boiler operation to a level at or below that of the most recent particulate matter performance test that measured emissions at or below the applicable particulate matter emission limit.	Minn. R. 7007.0800, subp. 2
MONITORING AND RECORDKEEPING	hdr
Residual and Used oil: Keep a daily log of the usage of residual and used oil. By the 15th of each month: 1) Calculate and record the residual and used oil usage for the previous calendar month (in gallons), 2) Calculate the average sulfur content of the residual oil and of the used oil for the month. The average sulfur content shall be determined by summing the daily sulfur percentage from the fuel supplier certifications for the previous month, and dividing by the number of certifications received during the previous month, 3) Calculate the number of tons of SO2 emitted during the previous month using the following equation:  $SO_2 = (0.157(A)(X) + 0.157(B)(Y))/2000$	Title I Condition: To limit potential SO2 emissions to less than major source levels as defined by 40 CFR Section 52.21
where: SO2 = sulfur dioxide emitted during the previous month in tons A = the number of gallons of residual oil burned during the previous month B = the number of gallons of used oil burned during the previous month X = the average sulfur content of residual oil (%) Y = the average sulfur content of used oil (%)	Title I Condition continued from above
4) Calculate the 12 month rolling sum of emissions by summing the results of the above equation for the most recent 12 months.	Title I Condition continued from above
Fuel Oil Sulfur Content Recordkeeping: Obtain a fuel supplier certification stating the percent sulfur by weight in the fuel oil does not exceed 1.89% sulfur, daily.	Title I Condition: To limit potential SO2 emissions to less than major source levels as defined by 40 CFR Section 52.21
PERFORMANCE TESTING	hdr

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

Performance Test: due 180 days after 08/05/1999 to measure Total Particulate Matter and Opacity emissions while combusting No. 6 fuel oil from any one unit from EU001- EU003 and either EU004 or EU005 (thus a total of two tests are required from GP001).	Minn. R. 7007.0800, subp. 2
For additional applicable performance test requirements, see 'General Performance Test Requirements' in Table A, Subject Item "Total Facility".	

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item: GP 003 Natural Smoke Process**

**Associated Items:**

- CE 001 Venturi Scrubber
- CE 002 Venturi Scrubber
- CE 003 Venturi Scrubber
- CE 004 Venturi Scrubber
- CE 005 Venturi Scrubber
- EU 006 Smoked Meat Oven #6 with recirculated wood smoke
- EU 007 Smoked Meat Oven #7 with recirculated wood smoke
- EU 008 Smoked Meat Oven #8 with recirculated wood smoke
- EU 009 Smoked Meat Oven #9 with recirculated wood smoke
- EU 010 Smoked Meat Oven #10 with recirculated wood smoke
- EU 031 Natural Smoke Generator
- EU 032 Natural Smoke Generator
- SV 002 Natural Smoke Meat Oven (For EU006)
- SV 003 Natural Smoke Meat Oven (Bypass for SV002)
- SV 004 Natural Smoke Meat Oven (For EU007)
- SV 005 Natural Smoke Meat Oven (Bypass for SV004)
- SV 006 Natural Smoke Meat Oven (For EU008)
- SV 007 Natural Smoke Meat Oven (Bypass for SV006)
- SV 008 Natural Smoke Meat Oven (For EU009)
- SV 009 Natural Smoke Meat Oven (Bypass for SV008)
- SV 010 Natural Smoke Meat Oven (For EU0010)
- SV 011 Natural Smoke Meat Oven (Bypass for SV010)

What to do	Why to do it
EMISSION LIMITS	hdr
Total Particulate Matter: less than 0.30 grains/dry standard cubic foot unless required to reduce emissions to meet the less stringent limit of either 7011.0730 or 7011.0735 (table 1 and 2, respectively).	Minn. R. 7011.0715, subp. 1(A)
Opacity: less than or equal to 20 percent	Minn. R. 7011.0715, subp. 1(B)
OPERATING REQUIREMENTS	hdr
Vent all emissions through one or more of the venturi scrubbers, CE001-005, when the natural smoke generators are operating.	Minn. R. 7007.0800, subp. 2
MONITORING & RECORDKEEPING	hdr
Control Equipment Check: A differential pressure reading shall be taken once each day on the scrubber associated with the natural smoke generators when they are operating. The scrubber shall operate within the manufacturer's recommended pressure rating. This rating should be listed in the O & M Plan for these units.  If any readings are taken that are not in the recommended differential pressure range, the permittee shall implement corrective action according to the O & M Plan for the respective unit(s). Records shall be kept of the date, time and result of each observation taken along with any corrective actions taken.	Minn. R. 7007.0800, subp. 4 and 5
PERFORMANCE TESTING	hdr
Performance Test: due 180 days after 08/05/1999 to measure Total Particulate Matter and Opacity emissions.  For additional applicable performance test requirements, see 'General Performance Test Requirements' in Table A, Subject Item "Total Facility".	Minn. R. 7007.0800, subp. 2



**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item: GP 005 Precook Bacon Process**

**Associated Items:** CE 006 Mist Eliminator - High Velocity, i.e., V>250 Ft/Min  
 CE 007 Mist Eliminator - High Velocity, i.e., V>250 Ft/Min  
 CE 011 Mist Eliminator - High Velocity, i.e., V>250 Ft/Min  
 EU 018 Precooked Bacon, South  
 EU 019 Precooked Bacon, North  
 EU 020 Precooked Bacon, East  
 EU 021 Precooked Bacon, West  
 EU 029 Bacon Bits Precooked Line  
 SV 019 Precooked Bacon Stack (For EU018 & EU019)  
 SV 020 Precooked Bacon Stack (For EU020 & EU021)  
 SV 028 Bacon Bits Line (For EU029)

What to do	Why to do it
EMISSION LIMITS	hdr
Total Particulate Matter: less than 0.30 grains/dry standard cubic foot unless required to reduce emissions to meet the less stringent limit of either 7011.0730 or 7011.0735 (table 1 and 2, respectively).	Minn. R. 7011.0715, subp. 1(A)
Opacity: less than or equal to 20 percent opacity	Minn. R. 7011.0715, subp. 1(B)
OPERATING REQUIREMENTS	hdr
Vent all emissions from the precooked bacon fryers through mist eliminators, CE006 and CE007.	Minn. R. 7007.0800, subp. 2
MONITORING AND RECORDKEEPING	hdr
Precooked Bacon Control Equipment Check: A differential pressure reading shall be taken once each operating day for each mist eliminator associated with the Precooked Bacon Line(s). The mist eliminator shall operate within the manufacturer's recommended differential pressure rating. This rating should be listed in the O & M Plan for these units.  If any readings are taken that are not in the recommended differential pressure range, the permittee shall implement corrective action according to the O & M Plan for the respective unit(s). Records shall be kept of the date, time and result of each observation taken along with any corrective actions taken.	Minn. R. 7007.0800, subp. 4 and 5

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item:** GP 008 Boilers (29.4, 29.4 MMBtu/hr- Natural Gas)**Associated Items:** EU 044 Boiler #6 (29.4 MMBtu/hr)

EU 045 Boiler #7 (29.4 MMBtu/hr)

What to do	Why to do it
Fuel Type: Natural gas only	Minn. R. 7007.0800, subp. 2
Record and maintain records of the quantity of natural gas that each of the Dc boilers combust on a monthly basis.	40 CFR 60.48(g)

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item:** EU 026 Belt Grill Precooked Line**Associated Items:** CE 010 Mist Eliminator - High Velocity, i.e., V>250 Ft/Min

SV 025 Koppens Grill Stack

What to do	Why to do it
EMISSION LIMIT	hdr
Total Particulate Matter: less than or equal to 0.30 grains/dry standard cubic foot unless required to reduce emissions to meet the less stringent limit of either 7011.0730 or 7011.0735 (table 1 and 2, respectively).	Minn. R. 7011.0715, subp. 1(A)
Opacity: less than or equal to 20 percent opacity	Minn. R. 7011.0715, subp. 1(B)
MONITORING AND RECORDKEEPING	hdr
Koppens Grill Control Equipment Check: A differential pressure reading shall be taken once each operating day for the mist eliminator associated with the Koppens Grill. The mist eliminator shall operate within the manufactures recommended differential pressure rating. This rating should be listed in the O & M Plan for these units.  If any readings are taken that are not in the recommended differential pressure range, the permittee shall implement corrective action according to the O & M Plan for the respective unit(s). Records shall be kept of the date, time and result of each observation taken along with any corrective actions taken.	Minn. R. 7007.0800, subp. 4 and 5

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item:** EU 027 Rendering Area**Associated Items:** CE 008 Room Air Scrubber

SV 026 Rendering Room Scrubber Stack

What to do	Why to do it
EMISSION LIMITS	hdr
Total Particulate Matter: less than or equal to 8.38 lbs/hour	Title I Condition: to limit particulate emissions to less than major source levels as defined by 40 CFR 52.21. Also meets Minn. R. 7011.0715, subp. 1(A)
Opacity: less than or equal to 20 percent opacity	Minn. R. 7011.0715, subp. 1(B)
MONITORING AND RECORDKEEPING	hdr
Rendering Area Control Equipment Check: A differential pressure reading shall be taken once each operating day for the scrubber associated with the Rendering Area Room Air. The scrubber shall operate within the recommended pressure range listed in the O & M Plan for these units.  If any readings are taken that are not in the recommended differential pressure range, the permittee shall implement corrective action according to the O & M Plan for the respective unit(s). Records shall be kept of the date, time and result of each observation taken along with any corrective actions taken.	Minn. R. 7007.0800, subp. 4 and 5

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item:** EU 028 Rendering Machinery**Associated Items:** CE 009 Venturi Scrubber/pkd twr

SV 027 Rendering Process Scrubber Stack (For EU028)

What to do	Why to do it
EMISSION LIMITS	hdr
Total Particulate Matter: less than or equal to 7.34 lbs/hour	Title I Condition: To limit potential particulate emissions to less than major source levels as defined by 40 CFR 52.21. Also meets limit set by Minn. R. 7011.0715, subp. 1(A)
Opacity: less than or equal to 20 percent opacity	Minn. R. 7011.0715, subp. 1(B)
MONITORING & RECORDKEEPING	hdr
Rendering Machinery Control Equipment Check: A differential pressure reading shall be taken once each operating day for the venturi scrubber associated with the Rendering Machinery. The scrubber shall operate within the recommended pressure range listed in the O & M Plan for these units.  If any readings are taken that are not in the recommended differential pressure range, the permittee shall implement corrective action according to the O & M Plan for the respective unit(s). Records shall be kept of the date, time and result of each observation taken along with any corrective actions taken.	Minn. R. 7007.0800, subp. 4 and 5

**TABLE A: LIMITS AND OTHER REQUIREMENTS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

**Subject Item:** EU 036 Blood Dryer**Associated Items:** CE 018 Packed-Gas Adsorption Column

SV 033 Blood Dryer

What to do	Why to do it
EMISSION LIMITS	hdr
Total Particulate Matter: less than or equal to 0.3 grains/dry standard cubic foot unless required to reduce emissions to meet the less stringent limit of either 7011.0730 or 7011.735 (table 1 and 2, respectively.)	Minn. R. 7011.0715, subp. 1(A)
Opacity: less than or equal to 20 percent	Minn. R. 7011.0715, subp. 1(B)
OPERATING REQUIREMENTS	hdr
Vent emissions through CE012 and CE013, the venturi and packed tower.	Minn. R. 7007.0800, subp. 2
MONITORING AND RECORDKEEPING	hdr
Control Equipment Check: A differential pressure reading shall be taken once each operating day on the venturi scrubber associated with the Blood Dryer. The venturi scrubber shall operate within a pressure range recommended in the operation and maintenance plan.  If any readings are taken that are not in the recommended differential pressure range, the permittee shall implement corrective action according to the O & M Plan for the respective unit(s). Records shall be kept of the date, time and result of each observation taken, along with any corrective actions taken.	Minn., R. 7007.0800, subp. 4 and 5

## TABLE B: SUBMITTALS

05/08/00

Facility Name: Hormel Foods Corp - Austin  
Permit Number: 09900002 - 003

Table B lists most of the submittals required by this permit. Please note that some submittal requirements may appear in Table A or, if applicable, within a compliance schedule located in Table C. Table B is divided into two sections in order to separately list one-time only and recurrent submittal requirements.

Each submittal must be postmarked or received by the date specified in the applicable Table. Those submittals required by parts 7007.0100 to 7007.1850 must be certified by a responsible official, defined in Minn. R. 7007.0100, subp. 21. Other submittals shall be certified as appropriate if certification is required by an applicable rule or permit condition.

Send any application for a permit or permit amendment to:

Permit Technical Advisor  
Permit Section  
Air Quality Division  
Minnesota Pollution Control Agency  
520 Lafayette Road North  
St. Paul, Minnesota 55155-4194

Also, where required by an applicable rule or permit condition, send to the Permit Technical Advisor notices of:

- accumulated insignificant activities,
- installation of control equipment,
- replacement of an emissions unit, and
- changes that contravene a permit term.

Unless another person is identified in the applicable Table, send all other submittals to:

Supervisor  
Compliance Determination Unit  
Air Quality Division  
Minnesota Pollution Control Agency  
520 Lafayette Road North  
St. Paul, Minnesota 55155-4194

Send submittals that are required to be submitted to the U.S. EPA regional office to:

Mr. George Czerniak  
Air and Radiation Branch  
EPA Region V  
77 West Jackson Boulevard  
Chicago, Illinois 60604

Send submittals that are required by the Acid Rain Program to:

U.S. Environmental Protection Agency  
Clean Air Markets Division  
1200 Pennsylvania Avenue NW (6204N)  
Washington, D.C. 20460

**TABLE B: ONE TIME SUBMITTALS OR NOTIFICATIONS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

What to send	When to send	Portion of Facility Affected
Computer Dispersion Modeling Protocol	due 1,096 days after Permit Issuance. This protocol will describe the proposed modeling methodology and input data, in accordance with all requirements of 40 CFR pt. 51, App. W. Modeling shall address SO <sub>2</sub> , Total Particulate Matter, NO <sub>x</sub> and PM <sub>10</sub> emissions.	Total Facility
Computer Dispersion Modeling Results	due 1,462 days after Permit Issuance To be submitted after the MPCA has reviewed and approved the modeling protocol.	Total Facility
Notification of the Actual Date of Initial Startup	due 15 days after Initial Startup	GP008
Notification of the Anticipated Date of Initial Startup	due 30 days before Anticipated Date of Initial Startup	GP008
Notification of the Date Construction Began	due 30 days after Start Of Construction	GP008
Testing Frequency Plan	due 90 days after Initial Performance Test for Total Particulate Matter. The plan shall specify a testing frequency for Total Particulate Matter based on the initial performance test and MPCA guidance. A testing frequency shall be established for each boiler group (EU001-EU003) and (EU004-EU005). Future performance tests at a year (12-month), 36-month, or 60-month intervals or as applicable shall be required upon written approval of the plan by MPCA per Minn. R. 7017.2020, subp. 1.	GP001
Testing Frequency Plan	due 90 days after Initial Performance Test for Total Particulate Matter. The plan shall specify a testing frequency for Total Particulate Matter based on the initial performance test and MPCA guidance. Future performance tests at a year (12-month), 36-month, or 60-month intervals or as applicable shall be required upon written approval of the plan by MPCA per Minn. R. 7017.2020, subp. 1.	GP003



**TABLE B: RECURRENT SUBMITTALS**

05/08/00

Facility Name: Hormel Foods Corp - Austin

Permit Number: 09900002 - 003

What to send	When to send	Portion of Facility Affected
Semiannual Deviations Report	due 30 days after end of each calendar half-year following Permit Issuance. The first semiannual report submitted by the Permittee shall cover the calendar half-year in which the permit is issued. The first report of each calendar year covers January 1 - June 30. The second report of each calendar year covers July 1 - December 31.	Total Facility
Compliance Certification	due 31 days after end of each calendar year following Permit Issuance (for the previous calendar year). To be submitted on a form approved by the Commissioner, both to the Commissioner, and to the U.S. EPA regional office in Chicago. This report covers all deviations experienced during the calendar year. The EPA copy shall be sent to: Mr. George Czerniak, Chief, Air Enforcement and Compliance Assurance Branch, Air and Radiation Division, EPA Region V, 77 West Jackson Boulevard, Chicago, Illinois 60604>	Total Facility
Emissions Inventory Report	due 91 days after end of each calendar year following Permit Issuance (April 1). To be submitted on a form approved by the Commissioner.	Total Facility

**TECHNICAL SUPPORT DOCUMENT**  
**For**  
**DRAFT AIR EMISSION PERMIT NO. 09900002-013**

This technical support document is for all the interested parties of the draft permit. The purpose of this document is to set forth the legal and factual basis for the draft permit conditions, including references to the applicable statutory or regulatory provisions.

**1. General Information**

1.1. Applicant and Stationary Source Location:

Owner and Operator Address and Phone Number (list both if different)	Facility Address (SIC Code: 2013)
Hormel Foods Corp 1 Hormel Place Austin, MN 55912-0367 507/437-5253	Hormel Foods 500 14 <sup>th</sup> Ave NE Austin, MN 55912

1.2. Description of the facility

The Hormel Foods Corporation facility, located in Austin, Minnesota, is a meat processing plant. At the plant, Quality Pork Processors (QPP) slaughters hogs, and Hormel Foods processes hogs and produces ham, bacon, dry sausage, fresh sausage, Spam<sup>™</sup>, and other meat products. Byproducts consist of blood, cracklings, bone meal, and choice white grease.

Emissions from five gas-oil fired boilers are discharged to the atmosphere from one stack. Emissions from two natural gas fired boilers are discharged to the atmosphere via separate stacks. Emissions from five process ovens that use natural smoke, are treated with venturi scrubbers before discharge to the atmosphere, while emissions from seven process ovens that utilize "liquid smoke" discharge without emission control. Emissions from four precooked bacon units and a bacon bits line are treated in mist eliminators before discharge. A Fulton Heater heats the heat transfer medium for a Koppens Grill which cooks smoked bacon. Emissions from the natural gas fired Fulton Heater are discharged to the atmosphere while the emissions from the Koppens Grill are treated in a mist eliminator before being discharged. Four microwave transmitters supply energy to a bacon bits line. Emissions from the bacon bits line are treated with the same mist eliminator that serves the Koppens Grill.

A natural gas standby emergency generator is vented directly to the atmosphere. The emissions from a series of rendering process units are directly treated in the Rendering Process Scrubber before discharge. Process emissions not collected by the rendering scrubber from this rendering area are treated in the Room Air Scrubber before discharge.

1.3 Description of any changes allowed with this permit issuance

Permit Action Number:

Date: 1/20/2004

Hormel intends to modify an existing bacon bits cook line. Currently, bacon is loaded, conveyed through microwave cavities, precooked in two microwave ovens, and packaged. Energy is supplied to the process via electricity through four transmitters. The installation of eight additional transmitters and two additional ovens will allow the bacon bits line to operate at a higher capacity. Current capacity is approximately 1875 pounds per hour of raw bacon. After the installation of the new microwave transmitters, the line will be capable of processing a maximum of 7000 pounds per hour.

#### 1.4. Facility Emissions:

Table 1. Emissions Change Associated With the Modification:

	PM tpy	PM10 tpy	SO 2 tpy	NO x tpy	CO tpy	VO C tpy	Pb tpy	Singl e HAP tpy	All HAP s tpy
*Existing Total Facility Limited Potential Emissions	218	214	247	178	110	108	Neg	Neg	2.7
Bacon Bits Modification Potential Emissions	17.96	17.96	0	0	0	0.95	Neg	Neg	0
*Total Facility Limited Potential Emissions After Modification	236	232	247	178	110	109	Neg	Neg	2.7

\*Includes Insignificant Activities

Table 2. Facility(TF) and Permit Classification

Classification (put x in appropriate box)	Major/Affected Source	*Synthetic Minor	*Minor
PSD (list pollutant)		SO2, PM, PM10	Nox, CO, VOC
NAAR (list pollutant)			
Part 70 Permit Program (list pollutant)	PM, PM10, SO2, Nox, VOC, CO		Haps

\* Refers to potential emissions that are less than those specified as major by 40 CFR 52.21, 40 CFR pt. 51 Appendix S, and 40 CFR pt. 70.

## 2. Regulatory and/or Statutory Basis

Summary Regulatory and/or Statutory Basis of the Emission or operational Limit

Permit Action Number:

Date: 1/20/2004

## Regulatory Overview of Modified Unit

*EU, GRP, or SV #	Applicable Regulations	**Comments:
EU020	<b><u>Minn. R. 7011.0715</u></b>	Standards of Performance for Industrial Process Equipment

### 3. Technical Information

#### Regulatory Applicability:

New Source Review; 40 CFR 52.21: The facility permit currently has restrictions that limit potential emissions to less than major levels under federal new source review. The potential uncontrolled emissions from the increased throughput of the bacon bits line are less than 20 tons per year, and do not change the facility's minor status. The permit does require control, and the controlled emissions increase is less than five tons per year. Therefore, this modification is issued as a moderate amendment.

Minnesota Performance Standards: The modified unit is subject to Minnesota Performance Standards for Industrial Process Equipment

Federal New Source Performance Standards: There are no new source performance standards under 40 CFR 60 for this type of emission unit.

NESHAPs: There is no existing or pending NESHAP promulgated at 40 CFR 63 for this type of unit.

NESHAPs 112(g): There is not a major increase of HAP emissions from this modified unit.

Environmental Review: This increase is much less than the 100 tons per year that triggers the requirement for completion of an environmental assessment worksheet. A review of the file does not show that the sum of potential particulate emissions from past modifications exceeds the 100 ton per year threshold either.

### 4. Conclusion

Based on the information provided by the Hormel, the MPCA has reasonable assurance that the proposed operation of the emission facility, as described in the Air Emission Permit No. 09900002-013 and this technical support document, will not cause or contribute to a violation of applicable federal regulations and Minnesota Rules.

Staff Members on Permit Team: Jenny L. Reinertsen,  
Attachment: Emission Calculations

Permit Action Number:  
Date: 1/20/2004

Permit Action Number:  
Date: 1/20/2004