



REPORT

2023 Annual Compliance Reporting

Environmental Compliance Approval Reference Number 5005-CSYL97

Submitted to:

Heidelberg Materials Canada Limited

1370 Highway 49
Picton, Ontario
K0K 2T0

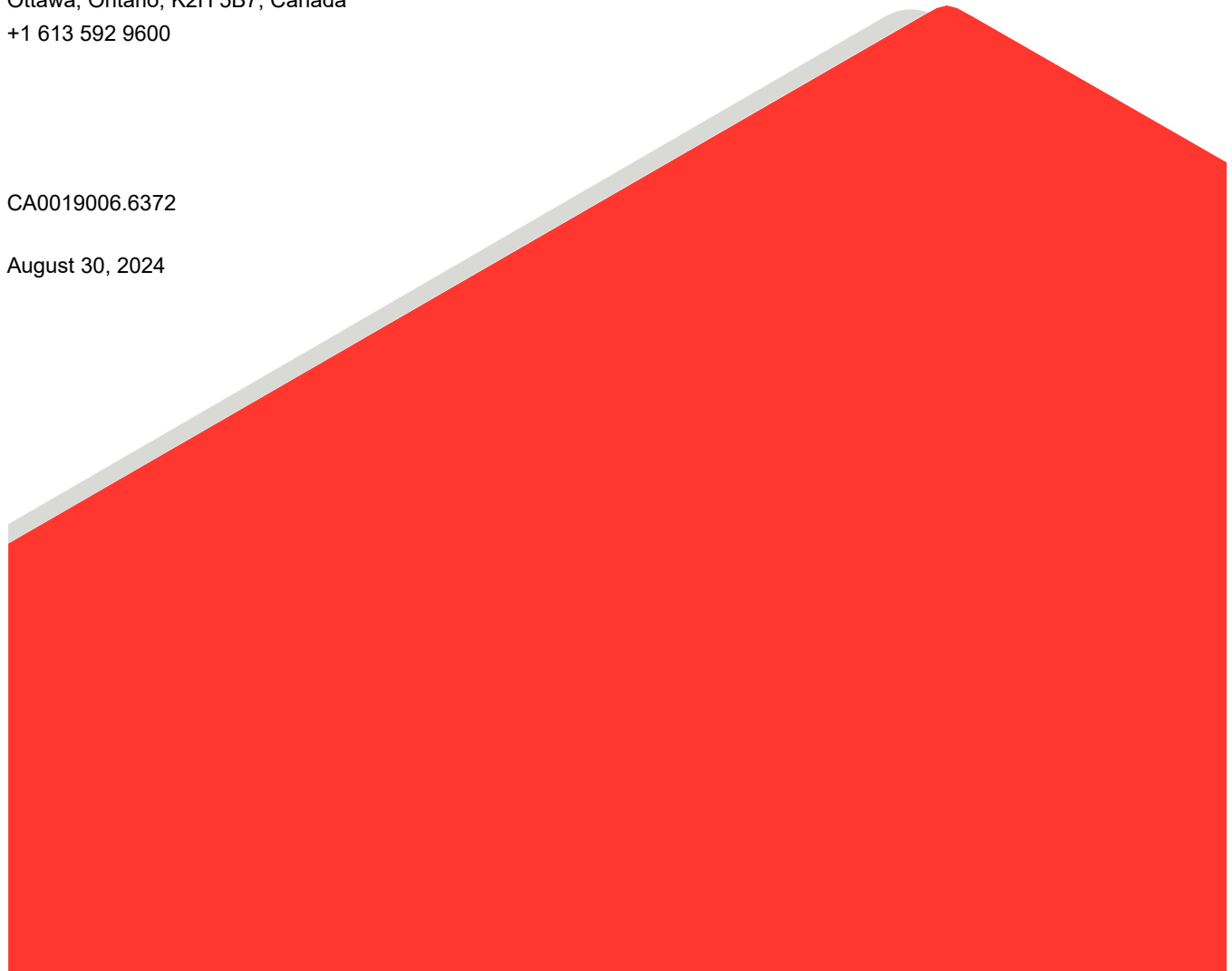
Submitted by:

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August 30, 2024



Distribution List

Electronic Copy - Heidelberg Materials Canada Limited

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Table of Contents

1.0 INTRODUCTION 1

2.0 ECA CONDITION 16.1(A): COMPLIANCE STATEMENT 1

3.0 ECA CONDITION 16.1(B): EMISSIONS SUMMARY TABLE AND ACOUSTIC ASSESSMENT
SUMMARY TABLE 1

4.0 ECA CONDITION 16.1(C): CLINKER AND CEMENT PRODUCTION 2

5.0 ECA CONDITION 16.1(D): ALCF FEED RATE AND WEIGHT PERCENTAGE 2

6.0 ECA CONDITION 16.1(E): ALCF THERMAL REPLACEMENT OF CONVENTIONAL FUELS 2

7.0 ECA CONDITION 16.1(F): ALCF CEM, CPM, SOURCE TESTING AND CARBON DIOXIDE
EMMISSIONS INTENSITY TESTING 2

8.0 ECA CONDITION 16.1(G): SUMMARY OF OPERATIONAL EVENTS THAT MAY HAVE
NEGATIVELY IMPACTED THE ENVIRONMENT 2

9.0 ECA CONDITION 16.1(H): SUMMARY OF COMPLAINTS 2

10.0 LIMITATIONS 3

11.0 CLOSURE 3

TABLES

Table 1: 2023 Clinker and Cement Production 2

ATTACHMENTS

- Attachment 1**
Compliance and Performance Limit Signed Statement
- Attachment 2**
Emissions Summary Tables
- Attachment 3**
Acoustic Assessment Summary Table
- Attachment 4**
Summary of Operational Events that May Have Negatively Impacted the Environment

1.0 INTRODUCTION

Heidelberg Materials Canada Limited (Heidelberg) was issued Amended Environmental Compliance Approval for Air & Noise (ECA) No. 5005-CSYL97 with Limited Operational Flexibility on May 30, 2024. The ECA approves the operation of the Heidelberg facility (the Facility) and provides Limited Operational Flexibility (LOF) until May 30, 2034.

As outlined in Condition 16.1 of the ECA, Heidelberg is required to prepare and submit by August 30 of each year to the District Manager, an Annual Report summarizing the operation of the Facility, covering the previous calendar year. The Annual Report shall include, as a minimum, the following information:

- a. a statement of whether the Facility was in compliance with this Approval, including compliance with the Performance Limits;
- b. the Emission Summary Table and Acoustic Assessment Summary Table for the Facility as of December 31 from the previous calendar year;
- c. clinker and cement production in tonnes per year;
- d. maximum daily feed rate and average daily feed rate of ALCF and Conventional Fuels in the cement kiln for each month of the preceding calendar year, and the weight percentage of each category of ALCF, as approved by this Approval, of the total monthly ALCF used.
- e. maximum and average percent thermal replacement of Conventional Fuels by combined ALCF for each month;
- f. a summary of data from CEM Systems, CPM Systems, Source Testing and Carbon Dioxide Emission Intensity testing and status of compliance with the Performance Limits and the ALCF operational requirements;
- g. a summary of dates, duration and reasons for any operational events, that may have negatively impacted the quality of the environment and corrective measures taken to address these impacts;
- h. details of environmental complaints including a summary of complaints received, causes of complaints and action taken to avoid the recurrence of similar incidents.

2.0 ECA CONDITION 16.1(A): COMPLIANCE STATEMENT

Attachment 1 provides a statement confirming the Facility was in compliance with the ECA, including compliance with the Performance Limits in 2023.

3.0 ECA CONDITION 16.1(B): EMISSIONS SUMMARY TABLE AND ACOUSTIC ASSESSMENT SUMMARY TABLE

The Emissions Summary Tables for both normal and transitional operating conditions for operations at the Facility as of December 31, 2023, are included in Attachment 2.

The Acoustic Assessment Summary Table for operations at the Facility as of December 31, 2023, is included as Attachment 3.

4.0 ECA CONDITION 16.1(C): CLINKER AND CEMENT PRODUCTION

The amount of clinker and cement produced at the Facility in 2023 is summarized in Table 1 below:

Table 1: 2023 Clinker and Cement Production

Product	Value	Unit
Clinker	758,192	Tonnes
Cement	886,650	Tonnes

5.0 ECA CONDITION 16.1(D): ALCF FEED RATE AND WEIGHT PERCENTAGE

Not applicable as the Facility has not co-fired the kiln with Alternative Low-Carbon Fuels (ALCF) as of December 31, 2023.

6.0 ECA CONDITION 16.1(E): ALCF THERMAL REPLACEMENT OF CONVENTIONAL FUELS

Not applicable as the Facility has not co-fired the kiln with Alternative Low-Carbon Fuels (ALCF) as of December 31, 2023.

7.0 ECA CONDITION 16.1(F): ALCF CEM, CPM, SOURCE TESTING AND CARBON DIOXIDE EMISSIONS INTENSITY TESTING

Not applicable as the Facility has not co-fired the kiln with Alternative Low-Carbon Fuels (ALCF) as of December 31, 2023.

8.0 ECA CONDITION 16.1(G): SUMMARY OF OPERATIONAL EVENTS THAT MAY HAVE NEGATIVELY IMPACTED THE ENVIRONMENT

Attachment 4 provides a table that summarizes the operational events that may have negatively impacted the quality of the environment and the corrective measure take to address these impacts.

9.0 ECA CONDITION 16.1(H): SUMMARY OF COMPLAINTS

Heidelberg received one complaint on August 1, 2023, related to dust on a vehicle at a neighboring property. The resident indicated that dust had built up on their vehicle and patio table between June and Early August. No specific date was tied to the incident, but the resident called in on August 1, 2023. The resident requested a cleaning product to address the issue themselves. Facility staff provided a cleaning product although the Facility staff was not clear that the material buildup was from the cement plant. The complaint and response information were shared with the local MECF office following the complaint.

10.0 LIMITATIONS

This Annual Compliance Report was prepared to fulfill the requirements of Condition 16.1 of ECA No. 5005-CSYL97. It is for the exclusive use of Heidelberg and is intended to fulfil the documentation and reporting requirements as stated in the Facility's ECA. The report is based on the ESDM Report and Acoustic Assessment Report dated June 2024 prepared by WSP Canada Inc.; and discussions with Heidelberg about Facility operations in 2023.

No assurances are made by WSP Canada Inc. regarding changes in Facility conditions and operational practices subsequent to submission of this report to the District Manager. Any use of this document or the observations, conclusions or recommendations provided in this report by any person other than Heidelberg and the other above-mentioned persons is at the sole risk of such user.

The report was developed by WSP Canada Inc. using data and information received from Heidelberg. In evaluating the Facility, WSP Canada Inc. has relied in good faith on information provided by others and the regulatory authorities. WSP Canada Inc. accepts no responsibility for any deficiency, misstatements, or inaccuracies contained in this report as a result of omissions, misinterpretations or fraudulent acts of the persons involved.

11.0 CLOSURE

We trust that the information presented in this report meets your requirements. Should you have any questions or concerns, please do not hesitate to contact the undersigned.

WSP Canada Inc.



Jeff Zywicki, B.Sc.Eng
Senior Air Quality Scientist



Jamie McEvoy, P.Eng
Senior Air Quality Engineer

JJZ/JM/rc

ATTACHMENT 1

**Compliance and Performance Limit
Signed Statement**



Heidelberg Materials North America

Picton Cement Plant

1370 Highway 49 South

Picton, Ontario K0K 2T0

Phone (613) 476-3233

August 30, 2024

Ministry of the Environment, Conservation and Parks
Director, Environmental Assessment and Permissions Branch
135 St. Clair Avenue West, 1st floor
Toronto ON, M4V 1L5

Re: **Written Summary and Compliance Reporting for Reporting Year 2023**
Amended Environmental Compliance Approval –
Number 5005-CSYL97

This is to confirm that the Heidelberg Materials Canada Limited facility located at 1370 Highway 49 in Picton, Ontario operated in compliance with section 9 of the *EPA, O. Reg. 419/05* and the conditions and performance limits, with the exception to Condition 4(9), set forth in our Environmental Compliance Approval (ECA) with Limited Operational Flexibility (LOF) as noted below throughout 2023.

Opacity events were the result of operational incidents related to various equipment issues (e.g., gas flame loss and power failures), which were corrected forthwith. Opacity events continue to trend lower on an annual basis as a result of yearly improvements to dust control systems.

SO₂ events were generally a result of issues with the dry sorbent emissions control system. These issues were corrected forthwith, which led to the Facility returning to compliance with the ECA Performance Limits. Heidelberg Materials has initiated a project to replace existing dry sorbent emissions controls with an upgraded system.

The submission of this letter satisfies Conditions 6.1 and 16.1.a of the above noted ECA.

Sincerely,

Dan Miller
Environmental Manager
Picton Cement Plant
Cc: MECP Kingston District Office

ATTACHMENT 2

Emissions Summary Tables

Normal Operating Conditions
Emission Summary Table
Operations as of December 31, 2023

Contaminant	CAS No.	Total Facility Emission Rate [g/s]	Air Dispersion Model Used ⁽¹⁾	Maximum POI Concentration [µg/m³]	Averaging Period	MECP POI Limit [µg/m³]	Limiting Effect	Schedule	Source	Benchmark	Percentage of MECP Limit [%]	Model Run Name	Notes	Version of ACB List ⁽²⁾
Acenaphthylene	208-96-8	2.67E-03	AERMOD	8.54E-04	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
Aluminum	7429-90-5	5.89E-01	AERMOD	1.09E+00	24	12	Health	Sch. 3	SL-JSL	B2	Below B2	Unit Run		v3
Ammonia	7664-41-7	7.19E+00	AERMOD	2.31E+00	24	100	Health	Sch. 3	Standard	B1	2%	Unit Run	URT - Note 8, Table 4	v3
Ammonium	14798-03-9	4.89E+00	AERMOD	9.05E+00	24	14.5	—	—	Previously Approved MAXGLC	—	Below Previously Approved MaxGLC	Unit Run		
Arsenic	7440-38-2	3.26E-04	AERMOD	1.46E-04	24	0.3	Health	Sch. 3	Guideline	B1	<1%	Unit Run		v3
Barium	7440-39-3	1.86E-02	AERMOD	3.78E-02	24	10	Health	Sch. 3	Guideline	B1	<1%	Unit Run		v3
Benzaldehyde	100-52-7	1.09E-03	AERMOD	2.01E-03	24	2	Health	Sch. 3	SL-JSL	B2	Below B2	Unit Run		v3
Benzene	71-43-2	7.25E-02	AERMOD	2.51E-03	Annual	0.45	Health	Sch. 3	Standard	B1	<1%	Unit Run	Note 7, Table 2, 3, URT - Note 8, Table 4	v3
Benzene	71-43-2	7.25E-02	AERMOD	2.33E-02	24	100	—	Sch. 6	DAV	—	Below DAV	Unit Run	Note 7, Table 2, 3, URT - Note 8, Table 4	v3
Benzene	71-43-2	7.25E-02	AERMOD	2.51E-03	Annual	4.5	—	—	AAV	—	Below AAV	Unit Run	Note 7, Table 2, 3, URT - Note 8, Table 4	v3
Benzo(a)pyrene	50-32-8	2.97E-06	AERMOD	1.08E-07	Annual	0.00001	Health	Sch. 3	Standard	B1	1%	Unit Run	Notes 6, 7, Table 2, 3, URT - Note 8, Table 4	v3
Benzo(a)pyrene	50-32-8	2.97E-06	AERMOD	1.02E-06	24	0.005	—	Sch. 6	DAV	—	Below DAV	Unit Run	Notes 6, 7, Table 2, 3, URT - Note 8, Table 4	v3
Benzo(a)pyrene	50-32-8	2.97E-06	AERMOD	1.08E-07	Annual	0.0001	—	—	AAV	—	Below AAV	Unit Run	Notes 6, 7, Table 2, 3, URT - Note 8, Table 4	v3
Beryllium	7440-41-7	1.60E-05	AERMOD	8.19E-06	24	0.01	Health	Sch. 3	Standard	B1	<1%	Unit Run		v3
C3 benzenes	N/A-10	1.18E-04	AERMOD	2.18E-04	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
C4 benzenes	N/A-11	2.72E-04	AERMOD	5.03E-04	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
Cadmium	7440-43-9	1.94E-04	AERMOD	7.26E-05	24	0.025	Health	Sch. 3	Standard	B1	<1%	Unit Run	URT - Note 8, Table 4	v3
Calcium Oxide	1305-78-8	5.44E+00	AERMOD	1.61E+00	24	10	Corrosion	Sch. 3	Standard	B1	16%	Calcium Oxide		v3
Carbon Dioxide	124-38-9	8.15E+04	AERMOD	1.26E+05	24	255800	Health	Sch. 3	SL-PA	B2	Below B2	Carbon Dioxide		v3
Carbon Monoxide	630-08-0	6.02E+01	AERMOD	3.45E+01	½	6000	Health	Sch. 3	Standard	B1	<1%	Carbon Monoxide	Note 17	v3
Chloride	N/A-5	1.54E+01	AERMOD	5.09E+00	24	5.176	—	—	Previously Approved MAXGLC	—	Below Previously Approved MaxGLC	Unit Run		
Chromium	7440-47-3	2.60E-04	AERMOD	2.53E-04	24	0.5	Health	Sch. 3	Standard	B1	<1%	Unit Run	Note 22, URT - Note 8, Table 4	v3
Cobalt	7440-48-4	1.97E-04	AERMOD	2.29E-04	24	0.1	Health	Sch. 3	Guideline	B1	<1%	Unit Run		v3
Copper	7440-50-8	1.18E-01	AERMOD	3.77E-02	24	50	Health	Sch. 3	Standard	B1	<1%	Unit Run		v3
Crystalline Silica	14808-60-7	2.16E+00	AERMOD	2.94E+00	24	5	Health	Sch. 3	Guideline	B1	59%	Crystalline Silica		v3
Dioxins and Furans (TEQ)	N/A	1.87E-09	AERMOD	5.90E-10	24	0.0000001	Health	Sch. 3	Standard	B1	<1%	Dioxins and Furans (TEQ)	Note 21, 30, Table 1, URT - Note 8, Table 4	v3
Fluoranthene	206-44-0	1.99E-04	AERMOD	6.41E-05	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
Fluorene	86-73-7	4.26E-04	AERMOD	1.37E-04	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
Hydrogen chloride	7647-01-0	1.16E+00	AERMOD	3.64E-01	24	20	Health	Sch. 3	Standard	B1	2%	Hydrogen chloride	URT - Note 8, Table 4	v3
Hydrogen Fluoride	7664-39-3	2.57E-02	AERMOD	2.44E-02	24	1.72	Vegetation	Sch. 3	Standard	B1	1%	Unit Run	Notes 10, 24	v3
Hydrogen Fluoride	7664-39-3	2.57E-02	AERMOD	9.51E-03	30-day	0.69	Vegetation	Sch. 3	Standard	B1	1%	Unit Run	Notes 10, 24	v3
Iron	7439-89-6	3.86E-01	AERMOD	1.14E-01	24	4	Health	Sch. 3	Standard	B1	3%	Iron		v3
Lead	7439-92-1	1.63E-02	AERMOD	5.26E-03	24	0.5	Health	Sch. 3	Standard	B1	1%	Unit Run	Note 10, URT - Note 8, Table 4	v3
Lead	7439-92-1	1.63E-02	AERMOD	2.05E-03	30-day	0.2	Health	Sch. 3	Standard	B1	1%	Unit Run	Note 10, URT - Note 8, Table 4	v3
Manganese	7439-96-5	2.80E-02	AERMOD	7.00E-02	24	0.4	Health	Sch. 3	Standard	B1	18%	Manganese	URT - Note 8, Table 4	v3
Mercury	7439-97-6	4.98E-03	AERMOD	1.60E-03	24	2	Health	Sch. 3	Standard	B1	<1%	Unit Run		v3
Nickel	7440-02-0	6.23E-04	AERMOD	2.80E-05	Annual	0.04	Health	Sch. 3	Standard	B1	<1%	Unit Run	Note 7, Table 2, 3, URT - Note 8, Table 4	v3
Nickel	7440-02-0	6.23E-04	AERMOD	2.77E-04	24	2	—	Sch. 6	DAV	—	Below DAV	Unit Run	Note 7, Table 2, 3, URT - Note 8, Table 4	v3
Nickel	7440-02-0	6.23E-04	AERMOD	2.80E-05	Annual	0.4	—	—	AAV	—	Below AAV	Unit Run	Note 7, Table 2, 3, URT - Note 8, Table 4	v3
Nitrate	14797-55-8	2.08E-01	AERMOD	3.85E-01	24	0.62	—	—	Previously Approved MAXGLC	—	Below Previously Approved MaxGLC	Unit Run		
Nitrogen Oxides	10102-44-0	1.23E+02	AERMOD	3.70E+01	24	200	Health	Sch. 3	Standard	B1	18%	Nitrogen Oxides	Notes 10, 28	v3
Nitrogen Oxides	10102-44-0	1.23E+02	AERMOD	1.50E+02	1	400	Health	Sch. 3	Standard	B1	37%	Nitrogen Oxides	Notes 10, 28	v3
PCBs	1336-36-3	1.76E-04	AERMOD	5.68E-05	24	0.15	Health	Sch. 3	Guideline	B1	<1%	Unit Run	Note 21	v3
Phenanthrene	85-01-8	9.06E-03	AERMOD	2.89E-03	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
Phosphorus	7723-14-0	2.32E-02	AERMOD	1.26E-02	24	0.5	Health	Sch. 3	SL-MD	B2	Below B2	Unit Run		v3
Potassium	7440-09-7	8.15E-01	AERMOD	1.51E+00	24	10	Health	Sch. 3	SL-MD	B2	Below B2	Unit Run		v3
Pyrene	129-00-0	9.97E-05	AERMOD	3.22E-05	24	0.1	—	—	De Minimus	—	Below De Minimus	Unit Run		
Selenium	7782-49-2	7.93E-03	AERMOD	1.64E-02	24	10	Health	Sch. 3	Guideline	B1	<1%	Unit Run		v3
Silicon	7440-21-3	3.89E-02	AERMOD	1.69E-02	24	27	Health	Sch. 3	SL-PA	B2	Below B2	Unit Run		v3
Sodium	7440-23-5	1.81E+00	AERMOD	3.35E+00	24	5.39	—	—	Previously Approved MAXGLC	—	Below Previously Approved MaxGLC	Unit Run		
Sulfate	14808-79-8	4.69E+00	AERMOD	2.00E+00	24	2.36	—	—	Previously Approved MAXGLC	—	Below Previously Approved MaxGLC	Unit Run		
Sulfur trioxide	7446-11-9	2.23E+00	AERMOD	1.08E+00	24	5	Health	Sch. 3	SL-JSL	B2	Below B2	Sulfur trioxide		v3
Sulphur dioxide	7446-09-5	1.34E+01	AERMOD	4.23E-01	Annual	10	Health & Vegetative	Sch. 3	Standard	B1	4%	Sulphur dioxide	Note 10, URT - Note 8, Table 4	v3
Sulphur dioxide	7446-09-5	1.34E+01	AERMOD	1.56E+01	1	100	Health & Vegetative	Sch. 3	Standard	B1	16%	Sulphur dioxide	Note 10, URT - Note 8, Table 4	v3
SPM	N/A	2.44E+01	AERMOD	4.64E+01	24	120	Visibility	Sch. 3	Standard	B1	39%	SPM		v3
Tin	7440-31-5	6.93E-03	AERMOD	3.86E-03	24	10	Health	Sch. 3	Standard	B1	<1%	Unit Run		v3
Zinc	7440-66-6	1.25E-02	AERMOD	4.63E-03	24	120	Particulate	Sch. 3	Standard	B1	<1%	Unit Run		v3

Notes:
1. AERMOD v.22112 was used for all contaminants
2. v3 = Version 3.0 - April 2023

3. "SL-JSL" = Screening Limit - Jurisdictional Screening Limit, "SL-MD" = Screening Limit - Ministry-derived, "SL-PA" = Screening Limit - Previously Accepted", "URT" = Upper Risk Threshold, "DAV" = Daily Assessment Value, "AAV" = Annual Assessment Value, "Previously Approved MAXGLC" = Previously Approved Limit using the Maximum Ground Level Concentration Assessment submitted with the ECA Amendment.

Transitional Operating Conditions
Emission Summary Table
Operations as of December 31, 2023

Contaminant	CAS No.	Total Facility Emission Rate [g/s]	Air Dispersion Model Used ⁽¹⁾	Maximum POI Concentration [µg/m³]	Averaging Period	MECP POI Limit [µg/m³]	Limiting Effect	Schedule	Source	Benchmark	Percentage of MECP Limit [%]	Model Run Name	Notes	Version of ACB List ⁽²⁾
Carbon Monoxide	630-08-0	5.19E+02	AERMOD	7.54E+02	½	6000	Health	Sch. 3	Standard	B1	13%	Carbon Monoxide	Note 17	v3
Nitrogen Oxides	10102-44-0	2.34E+02	AERMOD	7.24E+01	24	200	Health	Sch. 3	Standard	B1	36%	Nitrogen Oxides	Notes 10, 28	v3
Nitrogen Oxides	10102-44-0	2.34E+02	AERMOD	2.96E+02	1	400	Health	Sch. 3	Standard	B1	74%	Nitrogen Oxides	Notes 10, 28	v3
Sulphur dioxide ⁽³⁾	7446-09-5	7.28E+01	AERMOD	2.68E+00	Annual	10	Health & Vegetation	Sch. 3	Standard	B1	27%	Sulphur dioxide	Note 10, URT - Note 8, Table 4	v3
Sulphur dioxide ⁽³⁾	7446-09-5	7.28E+01	AERMOD	9.62E+01	1	100	Health & Vegetation	Sch. 3	Standard	B1	96%	Sulphur dioxide	Note 10, URT - Note 8, Table 4	v3
SPM	N/A	2.90E+01	AERMOD	4.64E+01	24	120	Visibility	Sch. 3	Standard	B1	39%	SPM		v3

Notes:

1. AERMOD v.22112 was used for all compounds

2. v3 = Version 3.0 - April 2023

3. The Facility continuously monitors for SO2 from the Kiln 4 Main Stack, and the Kiln 4 Bypass Stack. There are several emission rate combinations that can demonstrate compliance. The Scenario presented in the table corresponds to the CEMS alarms at the Facility of 66.7 g/s from the Kiln 4 Main Stack and 5 g/s from the Kiln 4 Bypass Stack. Please refer to the Facility's SO₂ Management Plan for further information.

ATTACHMENT 3

**Acoustic Assessment Summary
Table**

Table 1: Phased Noise Mitigation PORs Daytime

POR ID	Existing Dec 2023 (dBA)	After Fully Implemented NAAP (dBA)	Noise Limit (dBA)	Expected Compliance Achievement Date	Compliance with MECP Noise Limits After Implementation of NAAP Controls
POR003	50	42	45	After NAAP Fully Implemented	Yes
POR003A	47	41	45	After NAAP Fully Implemented	Yes
POR006	49	40	45	After NAAP Fully Implemented	Yes
POR006A	49	41	45	After NAAP Fully Implemented	Yes
POR016	49	40	45	After NAAP Fully Implemented	Yes
POR016A	49	40	45	After NAAP Fully Implemented	Yes
POR020	52	42	45	After NAAP Fully Implemented	Yes
POR020A	48	40	45	After NAAP Fully Implemented	Yes
POR037	50	44	45	After NAAP Fully Implemented	Yes
POR037A	51	45	45	Existing	Yes
POR044	51	42	45	Existing	Yes
POR044A	51	42	45	Existing	Yes
POR061	49	42	45	Existing	Yes
POR061A	48	42	45	Existing	Yes

Table 2: Phased Noise Mitigation PORs Nighttime

POR ID	Existing Dec 2023 (dBA)	After Fully Implemented NAAP (dBA)	Noise Limit (dBA)	Expected Compliance Achievement Date	Compliance with MECP Noise Limits After Implementation of NAAP Controls
POR003	50	36	40	After NAAP Fully Implemented	Yes
POR003A	46	33	-	After NAAP Fully Implemented	Yes
POR006	48	35	40	After NAAP Fully Implemented	Yes
POR006A	48	35	-	After NAAP Fully Implemented	Yes
POR016	49	39	40	After NAAP Fully Implemented	Yes
POR016A	49	39	-	After NAAP Fully Implemented	Yes
POR020	51	38	40	After NAAP Fully Implemented	Yes
POR020A	47	37	-	After NAAP Fully Implemented	Yes
POR037	50	40	40	After NAAP Fully Implemented	Yes
POR037A	50	40	-	Existing	Yes
POR044	51	40	40	Existing	Yes
POR044A	50	39	-	Existing	Yes
POR061	48	40	40	Existing	Yes
POR061A	48	40	-	Existing	Yes

ATTACHMENT 4

Summary of Operational Events that May Have
Negatively Impacted the Environment

Start Date	Event	SAC Reference #	Reason For Incident	Corrective Action
April 1, 2023	Elevated Opacity	1-346QES	A PLC power supply failed. Lost communication on PLC network	Replaced power supply which allowed PLC to communicate on PLC network again and able to control
April 1, 2023	Elevated Opacity	1-347P2Q	power surge shutdown mill building and kiln as well s dust collectors	power breakers turned back on
April 5, 2023	Elevated Opacity	1-34R35X	Power Interruption outside of plant	restarted equipment
April 12, 2023	Elevated Opacity	1-3DK87R	lime flow backed up, 6A precip tripped during 9 mill start up	reset 6A precip, cleared line
April 12, 2023	Elevated Opacity	1-3DKTCU	problem with 6 precip	Electrician corrected.
April 12, 2023	Elevated Opacity	1-3DXF2F	8 and 9 mill feed failure. Shutdown	restarted once feed reestablished
April 21, 2023	Elevated Opacity	1-3F9EQE	Combustion Control Problem. Lost flame on our back end burner of kiln due to low pressure (Valve Position)	operator reset setpoint to 0% and manually, then adjusted setpoint to a commanded valve and allowed program to takeover control again
April 25, 2023	Elevated Opacity	1-3FGF80	8&9 mills down(LM bin empty 2460 belt down).	restart mills
May 23, 2023	Elevated Opacity	1-3H1SEP	power interruption	restart equipment
May 29, 2023	Elevated Opacity	1-3HHRJI	Plant wide power outage	Power restored, system restarted
June 18, 2023	Elevated Opacity	1-3JVT8W	power blimp - hydro	took out a card, oxygen sensors unable to restart precipis
June 18, 2023	Elevated Opacity	1-3JX112	cyclone plugged on 6 precip line	cleared cyclone plug
June 29, 2023	Elevated Opacity	1-3L973X	fuel spike shut down precipitators	reduce fuel restart precipis
July 16, 2023	Elevated Opacity	1-3OPPX4	9 precip tripped due to low oxygen at top of tower	restored oxygen, restarted precip, relight gas
July 24, 2023	Elevated Opacity	1-3OO19H	lost gas on kiln	restarted gas and lit flame
August 3, 2023	Elevated Opacity	1-3TC4SS	Power Interruption	restart

Start Date	Event	SAC Reference #	Reason For Incident	Corrective Action
August 16, 2023	Elevated SO2	1-3QFZYK	mill shut down	increased lime feed from 1.5 to 2.5 TPH
September 21, 2023	Elevated Opacity	1-3V1NPA	Main gas flame fault. Due to stack exit analyzer calibration issue	stack exit analyzer inspect and recalibration
September 22, 2023	Elevated Opacity	1-3VAJ5Y	abnormal opacity due to shutdown. Adjust dampers	aborted closing of 4,5,6 bypass dampers
October 10, 2023	Elevated SO2	1-3X2457	lime dosing system malfunction	lime dosing system cleaned and restarted
November 7, 2023	Elevated Opacity	1-4CJ86O	Plant Lost Air due to glycol cooling pump trip. Which caused loss of cooling to compressors	restarted glycol system pump and compressors
November 8, 2023	Elevated SO2	1-4D604X	Feed Failure due to elevator caused Loesche mills to stop. Lime delivery system plugged	Unplug Lime system and restart
November 27, 2023	Elevated SO2	1-4G8VUZ	Feed Failure	Unplug Lime system and restart
December 1, 2023	Elevated Opacity	1-4GR39Z	Lost kiln gas flame, caused destabilized system	Relit gas flame and stabilized system
December 2, 2023	Elevated SO2	1-40VYWL	Blown hose on west lime silo, East lime silo plugged	Replaced hose on west and unplugged east
December 12, 2023	Elevated Opacity	1-4HJ3GG	Network Communication Error	Repaired and corrected, Back on line
December 18, 2023	Elevated Opacity	1-4J72GR	Power Failure: Type 2-2350 TPD at the time, lost power to LM and BS area, kiln and ID fans stayed running, no precipitates or fans at LM, shut kiln down as quickly as could, it was close to 2:15am when this occurred but screens were frozen until 306 off line was cleared	Restored Power to Loesche, blend silo and ID fans
December 19, 2023	Elevated Opacity	1-4IQ8XA	Startup 4 fan	4 fan shorted on start up. shut loesch down and kiln
December 25, 2023	Elevated SO2	1-4K5TVU	Mill down and lime flow issue	Mill restored and flow of lime corrected
December 28, 2023	Elevated Opacity	1-4KETWG	loss of row mill combined with lime flow issue	Mill restored and flow of lime corrected

