

**CONSTRUCTION PERMIT
OFFICE OF AIR MANAGEMENT**

**Kokomo Grain Company
East Pennsylvania
Amboy, Indiana 46911**

is hereby authorized to construct

a modification to the existing Amboy, Indiana grain processing plant, consisting of the addition of the following equipment:

- (a) four (4) concrete storage silos, each with a storage capacity of 210,000 bushels, each exhausting through air vents located at the top of the silos;
- (b) one (1) 26.2 million (MM) British thermal units per hour (Btu/hr), natural gas fired column grain dryer, processing a maximum of 5,000 bushels per hour;
- (c) six (6) enclosed belt conveyors, each with a capacity of 25,000 bushels per hour; and
- (d) one (1) enclosed drag conveyor, with a capacity of 7,500 bushels per hour.

This permit is issued to the above mentioned company (herein known as the Permittee) under the provisions of 326 IAC 2-1 and 40 CFR 52.780, with conditions listed on the attached pages.

Construction Permit No.: CP-103-8706-00005	
Issued by: Paul Dubenetzky, Branch Chief Office of Air Management	Issuance Date:

Construction Conditions

General Construction Conditions

1. That the data and information supplied with the application shall be considered part of this permit. Prior to any proposed change in construction which may affect allowable emissions, the change must be approved by the Office of Air Management (OAM).
2. That this permit to construct does not relieve the permittee of the responsibility to comply with the provisions of the Indiana Environmental Management Law (IC 13-11 through 13-20; 13-22 through 13-25; and 13-30), the Air Pollution Control Law (IC 13-17) and the rules promulgated thereunder, as well as other applicable local, state, and federal requirements.

Effective Date of the Permit

3. That pursuant to IC 13-15-5-3, this permit becomes effective upon its issuance.
4. That pursuant to 326 IAC 2-1-9(b)(Revocation of Permits), the Commissioner may revoke this permit if construction is not commenced within eighteen (18) months after receipt of this approval or if construction is suspended for a continuous period of one (1) year or more.
5. That notwithstanding Construction Condition No. 6, all requirements and conditions of this construction permit shall remain in effect unless modified in a manner consistent with procedures established for modifications of construction permits pursuant to 326 IAC 2 (Permit Review Rules).

First Time Operation Permit

6. That this document shall also become a first-time operation permit pursuant to 326 IAC 2-1-4 (Operating Permits) when, prior to start of operation, the following requirements are met:
 - (a) The attached affidavit of construction shall be submitted to the Office of Air Management (OAM), Permit Administration & Development Section, verifying that the facilities were constructed as proposed in the application. The facilities covered in the Construction Permit may begin operating on the date the Affidavit of Construction is postmarked or hand delivered to IDEM.
 - (b) If construction is completed in phases; i.e., the entire construction is not done continuously, a separate affidavit must be submitted for each phase of construction. Any permit conditions associated with operation start up dates such as stack testing for New Source Performance Standards (NSPS) shall be applicable to each individual phase.
 - (c) Permittee shall receive an Operation Permit Validation Letter from the Chief of the Permit Administration & Development Section and attach it to this document.
 - (d) The operation permit will be subject to annual operating permit fees pursuant to 326 IAC 2-1-7.1(Fees).
 - (e) Pursuant to 326 IAC 2-1-4, the Permittee shall apply for an operation permit renewal at least ninety (90) days prior to the expiration date established in the validation letter. The operation permit issued shall contain as a minimum the conditions in the Operation Conditions section of this permit.

NSPS Reporting Requirement

7. That pursuant to the New Source Performance Standards (NSPS), Part 60.300, Subpart DD, the source owner/operator is hereby advised of the requirement to report the following at the appropriate times:
- (a) Commencement of construction date (no later than 30 days after such date);
 - (b) Anticipated start-up date (not more than 60 days or less than 30 days prior to such date);
 - (c) Actual start-up date (within 15 days after such date); and
 - (d) Date of performance testing (at least 30 days prior to such date), when required by a condition elsewhere in this permit.

Reports are to be sent to:

Indiana Department of Environmental Management
Compliance Data Section, Office of Air Management
100 North Senate Avenue, P. O. Box 6015
Indianapolis, IN 46206-6015

The application and enforcement of these standards have been delegated to the IDEM-OAM. The requirements of 40 CFR Part 60 are also federally enforceable.

8. That when the facility is constructed and placed into operation the following operation conditions shall be met:

Operation Conditions

General Operation Conditions

1. That the data and information supplied in the application shall be considered part of this permit. Prior to any change in the operation which may result in an increase in allowable emissions exceeding those specified in 326 IAC 2-1-1 (Construction and Operating Permit Requirements), the change must be approved by the Office of Air Management (OAM).
2. That the permittee shall comply with the provisions of the Indiana Environmental Management Law (IC 13-11 through 13-20; 13-22 through 13-25; and 13-30), the Air Pollution Control Law (IC 13-17) and the rules promulgated thereunder.

Preventive Maintenance Plan

3. That pursuant to 326 IAC 1-6-3 (Preventive Maintenance Plans), the Permittee shall prepare and maintain a preventive maintenance plan, including the following information:
- (a) Identification of the individual(s) responsible for inspecting, maintaining, and repairing emission control devices.
 - (b) A description of the items or conditions that will be inspected and the inspection schedule for said items or conditions.

- (c) Identification of the replacement parts which will be maintained in inventory for quick replacement.

The preventive maintenance plan shall be submitted to IDEM, OAM upon request and shall be subject to review and approval.

Transfer of Permit

4. That pursuant to 326 IAC 2-1-6 (Transfer of Permits):

- (a) In the event that ownership of the four (4) storage silos, one (1) column grain dryer, and seven (7) enclosed conveyors is changed, the Permittee shall notify OAM, Permit Branch, within thirty (30) days of the change. Notification shall include the date or proposed date of said change.
- (b) The written notification shall be sufficient to transfer the permit from the current owner to the new owner.
- (c) The OAM shall reserve the right to issue a new permit.

Permit Revocation

5. That pursuant to 326 IAC 2-1-9(a)(Revocation of Permits), this permit to construct and operate may be revoked for any of the following causes:

- (a) Violation of any conditions of this permit.
- (b) Failure to disclose all the relevant facts, or misrepresentation in obtaining this permit.
- (c) Changes in regulatory requirements that mandate either a temporary or permanent reduction of discharge of contaminants. However, the amendment of appropriate sections of this permit shall not require revocation of this permit.
- (d) Noncompliance with orders issued pursuant to 326 IAC 1-5 (Episode Alert Levels) to reduce emissions during an air pollution episode.
- (e) For any cause which establishes in the judgment of IDEM, the fact that continuance of this permit is not consistent with purposes of 326 IAC 2-1 (Permit Review Rules).

Availability of Permit

6. That pursuant to 326 IAC 2-1-3(l), the Permittee shall maintain the applicable permit on the premises of this source and shall make this permit available for inspection by the IDEM, or other public official having jurisdiction.

Opacity Limitations

7. (a) That pursuant to 40 CFR 60.302(c), the following shall apply to the four (4) storage silos and seven (7) conveyors:
- (i) On and after the 60th day of achieving the maximum production rate at which the four (4) storage silos and seven (7) conveyors will be operated, but no later than 180 days after initial startup, this source shall not cause to be discharged into the atmosphere any fugitive emission from:

- (1) Any individual truck unloading station, railcar unloading station, or railcar loading station, which exhibits greater than 5 percent opacity.
 - (2) Any grain handling operation which exhibits greater than 0 percent opacity.
 - (3) Any truck loading station which exhibits greater than 10 percent opacity.
 - (4) Any barge or ship loading station which exhibits greater than 20 percent opacity.
- (b) Pursuant to 40 CFR 60.303(b), the source will determine compliance with the opacity standards listed above using Method 9 in 40 CFR 60, Appendix A.
- (c) These tests shall be performed according to 326 IAC 3-2.1 (Source Sampling Procedures) using the methods specified in the rule or as approved by the Commissioner.
- (i) A test protocol shall be submitted to the OAM, Compliance Data Section, 35 days in advance of the test.
 - (ii) The Compliance Data Section shall be notified of the actual test date at least two (2) weeks prior to the date.
 - (iii) All test reports must be received by the Compliance Data Section within 45 days of completion of the testing.
- (d) These opacity limits will also satisfy the requirements of 326 IAC 5-1-2 for the four (4) storage silos and seven (7) conveyors.
- (e) That pursuant to 326 IAC 5-1-2 (Visible Emission Limitations) except as provided in 326 IAC 5-1-3 (Temporary Exemptions), the visible emissions from the source shall meet the following:
- (i) visible emissions shall not exceed an average of 40% opacity in 24 consecutive readings.
 - (ii) visible emissions shall not exceed 60% opacity for more than a cumulative total of 15 minutes (60 readings) in a 6-hour period.

Particulate Matter Limitation

8. (a) That pursuant to 326 IAC 6-3 (Process Operations), mineral oil shall be applied at all times when the four (4) storage silos, one (1) grain dryer, and seven (7) conveyors are in operation, and particulate matter (PM) emissions from the grain dryer shall not exceed the allowable PM emission rate of 54.7 pounds per hour.
- (b) PM and PM10 emissions from the four (4) storage silos, one (1) grain dryer, and seven (7) conveyors shall not exceed 250 tons per year. Therefore, the Prevention of Significant Deterioration (PSD) rules, 326 IAC 2-2 and 40 CFR 52.21, will not apply.

Fugitive Dust Emissions

9. That pursuant to 326 IAC 6-4 (Fugitive Dust Emissions), the permittee shall be in violation of 326 IAC 6-4 (Fugitive Dust Emissions) if any of the criteria specified in 326 IAC 6-4-2(1) through (4) are violated. Observations of visible emissions crossing the property line of the source at or near ground level must be made by a qualified representative of IDEM. [326 IAC 6-4-5(c)].

Work Practices

10. That particulate matter (PM) emissions shall be considered in compliance provided that:
- (a) good housekeeping and equipment maintenance procedures are implemented.
 - (b) emissions are minimized in receiving, handling, and shipping operations by appropriate methods. These may include but need not be limited to, dust collection systems, windscreens, baffles, restricted hopper openings, enclosed transfer points, flexible drop spouts and/or sleeves,
 - (c) no visible accumulation of particulate matter beyond the plant property line, and
 - (d) emissions do not violate 326 IAC 6-4 (Fugitive Dust Emissions).

Open Burning

11. That the permittee shall not open burn any material except as provided in 326 IAC 4-1-3, 326 IAC 4-1-4 or 326 IAC 4-1-6.

Emergency Reduction Plans

12. Pursuant to 326 IAC 1-5-2 (Emergency Reduction Plans; Submission):
- (a) The Permittee shall prepare written emergency reduction plans (ERPs) consistent with safe operating procedures.
 - (b) These ERPs shall be submitted for approval to:

Indiana Department of Environmental Management
Compliance Branch, Office of Air Management
100 North Senate Avenue, P.O. Box 6015
Indianapolis, Indiana 46206-6015

within 180 calendar days from the issuance date of this permit.
 - (c) If the ERP is disapproved by IDEM, OAM, the Permittee shall have an additional thirty (30) days to resolve the differences and submit an approvable ERP. If after this time, the Permittee does not submit an approvable ERP, IDEM, OAM, shall supply such a plan.
 - (d) These ERPs shall state those actions that will be taken, when each episode level is declared, to reduce or eliminate emissions of the appropriate air pollutants.
 - (e) Said ERPs shall also identify the sources of air pollutants, the approximate amount of reduction of the pollutants, and a brief description of the manner in which the reduction will be achieved.

- (f) Upon direct notification by IDEM, OAM, that a specific air pollution episode level is in effect, the Permittee shall immediately put into effect the actions stipulated in the approved ERP for the appropriate level. [326 IAC 1-5-3]

Indiana Department of Environmental Management Office of Air Management

Technical Support Document (TSD) for New Construction and Operation

Source Background and Description

Source Name:	Kokomo Grain Company
Source Location:	East Pennsylvania, Amboy, Indiana 46911
County:	Miami
Construction Permit No.:	CP-103-8706-00005
SIC Code:	5153
Permit Reviewer:	Trish Earls/EVP

The Office of Air Management (OAM) has reviewed an application from Kokomo Grain Company relating to the construction and operation of a modification to the existing Amboy, Indiana grain processing plant, consisting of the addition of the following equipment:

- (a) four (4) concrete storage silos, each with a storage capacity of 210,000 bushels, each exhausting through air vents located at the top of the silos;
- (b) one (1) 26.2 million (MM) British thermal units per hour (Btu/hr), natural gas fired column grain dryer, processing a maximum of 5,000 bushels per hour;
- (c) six (6) enclosed belt conveyors, each with a capacity of 25,000 bushels per hour; and
- (d) one (1) enclosed drag conveyor, with a capacity of 7,500 bushels per hour.

Stack Summary

There are no stacks associated with this modification. Each silo has air vents at the top.

Enforcement Issue

IDEM is aware that two (2) 210,000 bushel storage silos, one (1) 26.2 MMBtu per hour natural gas fired column dryer, three (3) enclosed belt conveyors, and one (1) enclosed drag conveyor have been constructed and operated prior to receipt of the proper permit. IDEM is reviewing this matter and will take appropriate action. This proposed permit is intended to satisfy the requirements of the construction permit rules.

Recommendation

The staff recommends to the Commissioner that the construction and operation be approved. This recommendation is based on the following facts and conditions:

Information, unless otherwise stated, used in this review was derived from the application and additional information submitted by the applicant.

A complete application for the purposes of this review was received on June 18, 1997, with additional information received September 23, 1997.

Emissions Calculations

See Appendix A (Emissions Calculation Spreadsheets) for detailed calculations (6 pages).

Total Potential and Allowable Emissions

Indiana Permit Allowable Emissions Definition (after compliance with applicable rules, based on 8,760 hours of operation per year at rated capacity):

Pollutant	Allowable Emissions (tons/year)	Potential Emissions (tons/year)
Particulate Matter (PM)	239.7	106.8
Particulate Matter (PM10)	239.7	27.9
Sulfur Dioxide (SO ₂)	--	0.1
Volatile Organic Compounds (VOC)	--	0.3
Carbon Monoxide (CO)	--	4.0
Nitrogen Oxides (NO _x)	--	16.1
Single Hazardous Air Pollutant (HAP)	--	0.0
Combination of HAPs	--	0.0

- (a) Allowable emissions of PM and PM10 are determined from the applicability of rule 326 IAC 6-3-2. See discussion of 326 IAC 6-3-2, under the State Rules Applicability Section, page 4 of this TSD.
- (b) The potential emissions before control are less than the allowable emissions, therefore, the potential emissions before control are used for the permitting determination.
- (c) Allowable emissions (as defined in the Indiana Rule) of PM and PM10 are greater than 25 tons per year. Therefore, pursuant to 326 IAC 2-1, Sections 1 and 3, a construction permit is required.

County Attainment Status

- (a) Volatile organic compounds (VOC) and oxides of nitrogen are precursors for the formation of ozone. Therefore, VOC and NO_x emissions are considered when evaluating the rule applicability relating to the ozone standards. Miami County has been designated as attainment or unclassifiable for ozone. Therefore, VOC and NO_x emissions were reviewed pursuant to the requirements for Prevention of Significant Deterioration (PSD), 326 IAC 2-2 and 40 CFR 52.21.
- (b) Miami County has been classified as attainment or unclassifiable for all other criteria pollutants. Therefore, these emissions were reviewed pursuant to the requirements for Prevention of Significant Deterioration (PSD), 326 IAC 2-2 and 40 CFR 52.21.

Source Status

Existing Source PSD Definition (emissions after controls, based on 8,760 hours of operation per year at rated capacity):

Pollutant	Emissions (ton/yr)
PM	89.2
PM10	23.5
SO ₂	0.1
VOC	0.3
CO	4.0
NO _x	16.1

- (a) This existing source is **not** a major stationary source because no attainment regulated pollutant is emitted at a rate of 250 tons per year or more, and it is not in one of the 28 listed source categories.
- (b) Due to insufficient information in the existing permits for the existing equipment, these emissions were calculated (see TSD Appendix A, pages 4-6) based on the existing permitted grain throughput for the source and information provided by the applicant regarding the capacities of the existing permitted equipment.

Proposed Modification

PTE from the proposed modification (based on 8,760 hours of operation per year at rated capacity including enforceable emission control and production limit, where applicable):

Pollutant	PM (ton/yr)	PM10 (ton/yr)	SO ₂ (ton/yr)	VOC (ton/yr)	CO (ton/yr)	NO _x (ton/yr)
Proposed Modification	106.8	27.9	0.1	0.3	4.0	16.1
PSD Threshold Level	250	250	250	250	250	250

This modification to an existing minor stationary source is not major because the emission increase is less than the PSD significant levels. Therefore, pursuant to 326 IAC 2-2, and 40 CFR 52.21, the PSD requirements do not apply.

Part 70 Permit Determination

326 IAC 2-7 (Part 70 Permit Program)

This existing source, including this modification, is not subject to the Part 70 Permit requirements because the potential to emit (PTE) of:

- (a) each criteria pollutant, except PM, is less than 100 tons per year,
- (b) a single hazardous air pollutant (HAP) is less than 10 tons per year, and
- (c) any combination of HAPs is less than 25 tons/year.

This status is based on all the air approvals issued to the source. This status has been verified by the OAM inspector assigned to the source. For the purpose of determining Title V applicability for particulates, PM-10, not PM, is the regulated pollutant in consideration.

Federal Rule Applicability

40 CFR Part 60.300 through 60.304, Subpart DD

- (a) The four (4) storage silos and seven (7) conveyors are subject to the New Source Performance Standard, 326 IAC 12, (40 CFR Part 60.300, Subpart DD), because they are affected facilities (grain handling operations) at a grain terminal elevator that has a permanent storage capacity greater than 2.5 million bushels and was constructed after August 3, 1978. Pursuant to 40 CFR 60.302(c), the following shall apply:
 - (i) On and after the 60th day of achieving the maximum production rate at which the four (4) storage silos and seven (7) conveyors will be operated, but no later than 180 days after initial startup, this source shall not cause to be discharged into the atmosphere any fugitive emission from:
 - (1) Any individual truck unloading station, railcar unloading station, or railcar loading station, which exhibits greater than 5 percent opacity.
 - (2) Any grain handling operation which exhibits greater than 0 percent opacity.
 - (3) Any truck loading station which exhibits greater than 10 percent opacity.
 - (4) Any barge or ship loading station which exhibits greater than 20 percent opacity.
 - (b) Pursuant to 40 CFR 60.303(b), the source will determine compliance with the opacity standards listed above using Method 9 in 40 CFR 60, Appendix A. The requirements of 40 CFR 60.302(a) do not apply to the column grain dryer because the grain dryer does not have a column plate perforation exceeding 0.094 inches. The requirements of 40 CFR 60.302(b) and (d) do not apply to this modification because the modification does not include any process emissions (particulate matter collected by a capture system) or barge or ship unloading stations.

State Rule Applicability

326 IAC 2-6 (Emission Reporting)

This source is not subject to 326 IAC 2-6 (Emission Reporting), because the source is located in Miami County and emits less than 100 tons per year of CO, VOC, NO_x, PM10 and SO₂.

326 IAC 5-1 (Visible Emissions Limitations)

- (a) Pursuant to 326 IAC 5-1-2 (Visible Emissions Limitations), except as provided in 326 IAC 5-1-3 (Temporary Exemptions), visible emissions shall meet the following, unless otherwise stated in this permit:
 - (i) Visible emissions shall not exceed an average of forty percent (40%) opacity in twenty-four (24) consecutive readings as determined by 326 IAC 5-1-4,

- (ii) Visible emissions shall not exceed sixty percent (60%) opacity for more than a cumulative total of fifteen (15) minutes (sixty (60) readings) in a six (6) hour period.

- (b) If specific visible emission limitations have been established in 326 IAC 11, 326 IAC 12, or 326 IAC 6, those limitations shall apply. The four (4) storage silos and seven (7) conveyors are subject to 326 IAC 12 (40 CFR 60.300 through 60.304, Subpart DD), "Standards of Performance for Grain Elevators", which establishes specific visible emission limitations that satisfy the opacity limits of 326 IAC 5-1-2.

326 IAC 6-3-2 (Particulate Emission Limitations)

The 5,000 bushel per hour column grain dryer is subject to particulate matter limitations under 326 IAC 6-3-2. Pursuant to this rule, particulate emissions from the dryer shall be limited by the following equation:

$$E = 55.0P^{0.11} - 40 \text{ (for process weights in excess of 60,000 lbs/hr)}$$

where E = maximum allowable PM emission rate (lbs/hr)
P = process weight (tons/hr): 140.0 tons/hr

$$E = 55.0(140.0^{0.11}) - 40 = 54.7 \text{ lbs/hr (239.7 tons/yr)}$$

Potential uncontrolled emissions from the grain dryer (106.8 tons/yr) are less than the allowable emissions (239.7 tons/yr), therefore, the grain dryer will comply with the requirements of 326 IAC 6-3-2.

326 IAC 6-4 (Fugitive Dust Emissions)

This source is subject to 326 IAC 6-4 for fugitive dust emissions. Pursuant to 326 IAC 6-4 (Fugitive Dust Emissions), fugitive dust shall not be visible crossing the boundary or property line of a source. Observances of visible emissions crossing property lines may be refuted by factual data expressed in 326 IAC 6-4-2(1), (2) or (3).

Air Toxic Emissions

Indiana presently requests applicants to provide information on emissions of the 187 hazardous air pollutants set out in the Clean Air Act Amendments of 1990. These pollutants are either carcinogenic or otherwise considered toxic and are commonly used by industries. They are listed as air toxics on the Office of Air Management (OAM) Construction Permit Application Form Y.

- (a) None of these listed air toxics will be emitted from this proposed construction.

Conclusion

The construction of these four (4) storage silos, one (1) column grain dryer, and seven (7) enclosed conveyors will be subject to the conditions of the attached proposed **Construction Permit No. CP-103-8706-00005**.

Indiana Department of Environmental Management Office of Air Management

Addendum to the Technical Support Document for New Construction and Operation

Source Name: Kokomo Grain Company
 Source Location: East Pennsylvania, Amboy, Indiana 46911
 County: Miami
 Construction Permit No.: CP-103-8706-00005
 SIC Code: 5153
 Permit Reviewer: Trish Earls/EVP

On January 9, 1998, the Office of Air Management (OAM) had a notice published in The Peru Daily Tribune, Peru, Indiana, stating that Kokomo Grain Company had applied for a construction permit to construct and operate a modification to the existing grain processing plant consisting of the addition of four (4) storage silos, one (1) column grain dryer, and seven (7) enclosed conveyors. The notice also stated that OAM proposed to issue a permit for this installation and provided information on how the public could review the proposed permit and other documentation. Finally, the notice informed interested parties that there was a period of thirty (30) days to provide comments on whether or not this permit should be issued as proposed.

Upon further review, the OAM has decided to make the following change to the Construction Permit:

1. Operation Condition No. 7 of the Construction Permit, now on page 4 of 7, has been revised to include the requirements of 326 IAC 3-2.1 for testing. The condition now reads as follows (changes in bold for emphasis):

Opacity Limitations

- (a) That pursuant to 40 CFR 60.302(c), the following shall apply to the four (4) storage silos and seven (7) conveyors:
 - (i) On and after the 60th day of achieving the maximum production rate at which the four (4) storage silos and seven (7) conveyors will be operated, but no later than 180 days after initial startup, this source shall not cause to be discharged into the atmosphere any fugitive emission from:
 - (1) Any individual truck unloading station, railcar unloading station, or railcar loading station, which exhibits greater than 5 percent opacity.
 - (2) Any grain handling operation which exhibits greater than 0 percent opacity.
 - (3) Any truck loading station which exhibits greater than 10 percent opacity.
 - (4) Any barge or ship loading station which exhibits greater than 20 percent opacity.
- (b) Pursuant to 40 CFR 60.303(b), the source will determine compliance with the opacity standards listed above using Method 9 in 40 CFR 60, Appendix A.
- (c) **These tests shall be performed according to 326 IAC 3-2.1 (Source Sampling**

Procedures) using the methods specified in the rule or as approved by the Commissioner.

- (i) A test protocol shall be submitted to the OAM, Compliance Data Section, 35 days in advance of the test.**
 - (ii) The Compliance Data Section shall be notified of the actual test date at least two (2) weeks prior to the date.**
 - (iii) All test reports must be received by the Compliance Data Section within 45 days of completion of the testing.**
- (d)** These opacity limits will also satisfy the requirements of 326 IAC 5-1-2 for the four (4) storage silos and seven (7) conveyors.
- (e)** That pursuant to 326 IAC 5-1-2 (Visible Emission Limitations) except as provided in 326 IAC 5-1-3 (Temporary Exemptions), the visible emissions from the source shall meet the following:
- (i) visible emissions shall not exceed an average of 40% opacity in 24 consecutive readings.
 - (ii) visible emissions shall not exceed 60% opacity for more than a cumulative total of 15 minutes (60 readings) in a 6-hour period.