



Division Waste Management and Radiation Control

USED OIL PROCESSOR PERMIT



Permittee Name: Rock Canyon Oil, LLC

Permittee Mailing Address: 1669 South 580 East
American Fork, UT 84003

Permittee Phone Number: (801) 756-2000

Permittee Contact: Gary Maxwell
General Manager
(801) 420-1640 (cell)
Email: gary@rockcanyonoil.com

Facility Address: 1669 South 580 East
American Fork, UT 84003

Facility Contact: Gary Maxwell
General Manager
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Type of Permit: Used Oil Processor Permit

Permit #: UOP-0122

Original Issue Date: January 10, 2011

EPA ID #: UTR000010454

Signature: _____ Effective Date: _____

Scott T. Anderson, Director
Division of Waste Management and Radiation Control

Module I

General Permit Conditions

I. General Operation

The Permittee shall operate the used oil processing facility located at the facility address listed above in accordance with all applicable requirements of R315-15 of the Utah Administrative Code (~~UAC~~) and of the Used Oil Management Act (19-6-701 et. seq.); and as outlined in the “General Operations” section of this permit, unless otherwise noted in this permit. Rock Canyon Oil, LLC (hereafter also referred to as “Permittee”) shall be subject to the following conditions:

I.A. Permit Revocation

Any noncompliance with this permit or ~~the R315-15 UAC of the Utah Administrative Code~~ or the Act, other than activities authorized by a variance granted by the Utah Waste Management and Radiation Control Board or an emergency permit issued by the ~~Executive Secretary of the Board~~ Director of the Division of Waste Management and Radiation Control (Director), constitutes a violation and may be grounds for enforcement action or permit revocation.

I.B. Permit Modification

- I.B.1. Modifications to this permit shall only be approved by the Director ~~of the Division of Waste Management and Radiation Control (Director)~~.
- I.B.2. The Director may make modifications as necessary, or as a result of statutory or regulatory changes.
- I.B.3. The Permittee may request modifications to any item or activity covered by this permit ~~by the Permittee shall~~ submitting a written permit modification request to the Director. If the Director determines any modification request is substantive, a public hearing, a 15-day public comment period or both may be required before the modifications are approved.
- I.B.4. Implementing modifications prior to the Director’s approval constitutes a violation of the permit and may be grounds for enforcement action or permit revocation.
- I.B.5. Any expansion of the facility beyond the areas designated and described in this permit will require submittal of an amended permit application in accordance with the requirements outlined in R315-15 ~~UAC~~ of the Utah Administrative Code. The Permittee may not change the type or number of storage or processing equipment at this facility until approval of the amended permit is received from the Director. The amended permit application shall include any other information the Director finds necessary to ensure the safe handling of used oil at the processing facility in accordance with the Utah Management Act, 19-7-710 (3)(b)(xii).

I.C. Used Oil Processor Operations

The Permittee ~~shall~~ is authorized to accept, store, and process used oil via gravity separation, clay filtration, vacuum distillation, and blending of on-specification used oil at its facility located at 1669 South 580 East, American Fork, Utah in the manner and

following the methods and procedures described in Attachment 1, "General Operations," and other attachments to this permit.

I.D. Rebuttable Presumption/Analysis Plan

The Permittee shall follow Attachment 2, "Used Oil Analysis/Rebuttable Presumption Plan", which describes procedures to be used by the Permittee to comply with the analysis requirements of R315-15-5.4, R315-15-5.6 and R315-15-7.3 ~~UAC~~ [of the Utah Administrative Code](#).

I.E. Maintenance, Spill Prevention, and Contingency Plan

As required by R315-15-5.3 ~~UAC~~ [of the Utah Administrative Code](#), the Permittee shall maintain and operate the facility to minimize the possibility of a fire, explosion or any sudden or non-sudden release of used oil to air, soil or surface water, which could threaten human health or the environment. The Permittee shall inspect and maintain used oil equipment, containers and tanks on a regular basis to ensure they comply with R315-15-5.5(b) and (c) ~~UAC~~ [of the Utah Administrative Code](#). Used oil drips and releases shall be identified and cleaned up immediately upon detection, and corrective measures shall be taken to prevent future releases. The Permittee shall follow the procedures outlined in Attachment 3, "Contingency Plan." ~~;~~

I.F. Emergency Controls - Spill Plan

The Permittee shall take all reasonable steps to minimize releases to the environment and shall carry out such measures as are necessary to protect human health and the environment. The Permittee shall comply with all applicable requirements of R315-15-9 ~~UAC~~ [of the Utah Administrative Code](#).

I.F.1. In the event of a release of used oil, the Permittee shall immediately take appropriate action to minimize the threat to human health and the environment. It shall not constitute a defense ~~;~~ for the Permittee in an enforcement action, that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance.

I.F.2. The Permittee shall also prepare and implement an SPCC plan for this facility within 60 days of facility startup. The Permittee shall submit a copy of the SPCC plan to the Director for incorporation into this permit.

I.F.3. The Permittee shall follow the requirements of R315-15-9 ~~UAC~~ [of the Utah Administrative Code](#) and the procedures listed in Attachment 4, "Emergency Controls - Spill Plan." ~~;~~

I.G. Security

A gate shall be installed and kept locked at all hours when the facility is not open for business to prevent access to the site during closed hours. Fencing or other measures shall be adequate and maintained to prevent access of unauthorized persons, vehicles and animals by other routes.

I.H. Roads

All roads used for transporting used oil and product in and out of the facility shall be

improved and maintained as necessary to ensure safe and reliable all-weather access to the facility.

I.I. Spill and Runoff Control

The entire concrete secondary containment system, including walls and floors, shall be ~~sufficiently~~ impervious to used oil. The system shall be constructed and maintained to prevent surface runoff of used oil from containers used to store or process used oil and contaminated water. All such runoff shall be diverted to a sump for immediate clean up.

I.J. Ground and Surface Water Quality Protection

The Permittee shall comply with R315-15-1.3(e) and R317-8 ~~UAC of the Utah~~ [Administrative Code](#), prohibiting the disposal of used oil in ground and surface waters.

I.K. Prohibited Waste

The Permittee shall not mix or commingle used oil with hazardous waste so that the resulting mixture may not be recycled or used for other beneficial purposes.

I.K.1. If used oil is mixed with hazardous waste, as defined by R315-1 and R315-2 ~~UAC of the Utah Administrative Code~~, or PCBs, as defined by R315-301-2(53) ~~UAC of the Utah Administrative Code~~, the resulting mixture shall no longer be managed as used oil but shall be subject to applicable hazardous waste and PCB-contaminated waste rules.

I.K.2. If the processor facility will be handling any used oil from transformers, including dielectric oil and mineral oil, or any equipment that may include PCBs, the oil must be tested to determine the PCB concentration and managed as PCB waste if so dictated by the analysis.

I.K.3. Used oil shall not be stored in tanks, containers, storage units, and transportation vessels previously used to transport or store hazardous waste unless these tanks, containers, storage units and transportation vessels have been appropriately emptied and cleaned in accordance with R315-2-7 ~~of the Utah Administrative Code~~.

I.L. Polychlorinated biphenyls (PCBs)

Used oil with PCB concentrations less than 2 ppm may be managed for energy recovery when qualified as on-specification used oil. Used oil with PCB concentrations equal to or greater than 2 ppm may only be managed for energy recovery at a TSCA-permitted facility as described in 40 CFR Part 761.20(e). No person may avoid any provision specifying a PCB concentration by diluting the PCBs, unless otherwise specifically provided.

I.M. Used Oil Training

The Permittee shall follow the training and documentation procedures listed in Attachment 5, "Training Plan." All personnel handling used oil shall be trained according to the Training Plan ~~in the attachment~~.

I.N. Waste Disposal

All wastes generated during used oil operations shall be managed according to procedures outlined in Attachment 6, "Waste Disposal Plan." The wastes shall be taken to an appropriate facility permitted to handle the type of waste generated.

I.O. Liability/Financial Requirements

The Permittee shall maintain liability coverage for any liability that results from the Permittee's operations or accidental spills or mismanagement of used oil (e.g., bodily injury, property damage, and damage to third parties) arising from operations of the vehicles, facility, or group of facilities as required by R315-15-10 ~~UAC~~ [of the Utah Administrative Code](#) and Attachment 7 (Liability Coverage).

I.P. Cleanup and Closure Plan

In the event ~~this facility is~~ [the Permittee](#) no longer operating as ~~a~~ [his](#) used oil processor facility, procedures described in Attachment 8 "Cleanup and Closure Plan" shall be followed to comply with the requirements of R315-15-11 ~~UAC~~ [of the Utah Administrative Code](#).

I.P.1. Any changes affecting the Cleanup and Closure Plan shall be approved by the Director.

I.P.2. Upon implementation of closure of the facility, the Permittee shall follow the requirements of R315-15-11 ~~UAC~~ [of the Utah Administrative Code](#) and the procedures described in Attachment 8, "Cleanup and Closure Plan."

I.Q. Financial Assurance for Cleanup and Closure

The Permittee shall obtain and maintain financial assurance as required to cover costs outlined in Attachment 8, "Cleanup and Closure Plan" and comply with all applicable requirements of R315-15-12 ~~UAC~~ [of the Utah Administrative Code](#).

~~Documentation of the financial assurance mechanism is presented in Attachment 9, "Financial Assurance for Cleanup and Closure".~~

I.Q.1. The minimum required financial assurance amount shall be re-calculated annually, at the beginning of each new calendar year, for inflation. If the Permittee's financial assurance amount falls below the newly adjusted minimum coverage, an increase in coverage shall be required to ~~at least~~ meet the new minimum amount. Documentation verifying that the financial assurance amount has been increased to meet the minimum amount shall be submitted to the Director by March 1 of each calendar year.

I.Q.2. The financial assurance amount in Attachment ~~9~~ [8](#), "Financial Assurance for Cleanup and Closure" shall be increased if modification of the Cleanup and Closure Plan increases the closure cost estimate above the current financial assurance amount.

I.R. Used Oil Handler Certificate

The Permittee shall pay an annual used oil handler fee by December 31 of each year to obtain a Used Oil Handler Certificate from the Director for the subsequent calendar year.

I.R.1. In accordance with R315-15-5.1 ~~UAC~~ of the Utah Administrative Code, the Permittee shall not operate as a used oil processor without obtaining and maintaining a current used oil handler certificate.

I.S. Record Retention

The Permittee shall maintain all applicable used oil processor associated records required by R315-15 ~~UAC~~ of the Utah Administrative Code and all records required by this permit at ~~the its permitted used oil processor~~ facility in American Fork, Utah for a minimum of three years. Records may be in hard copy or electronic format and shall be readily accessible for inspection.

I.T. Annual Reporting Submittal

As required by R315-15-13.5 ~~UAC of the Utah Administrative Code~~, the Permittee shall prepare and submit an ~~A~~annual ~~R~~report to the Director by March 1 of the following year, which shall include the information required ~~by the Annual Report~~ for Used Oil Processors (UO Form 004). Annual ~~R~~reports shall include the operational status of the business until such time the ~~Permittee company~~ has ceased doing business and closure has been completed.

I.U. Inspection and Inspection Access

Upon reasonable notice from the Director, the Permittee shall provide, in Utah, all applicable records of its Utah used oil operations for inspection. Any duly authorized officer, employee or representative of the ~~Utah Solid and Hazardous Waste Control Board~~ Director may have access to and the right to copy any records relating to used oil ~~to determine for the purpose of ascertaining~~ compliance with the applicable provisions of R315-15 ~~of the Utah Administrative Code~~ and the Used Oil Management Act (19-6-701, et. seq.).

I.U.1. Upon presentation of appropriate credentials, any duly authorized ~~officer, employee, or~~ representative of the ~~Utah Solid and Hazardous Waste Control Board~~ Director may, at any reasonable time, enter upon and inspect the Permittee's facility, including equipment, vehicle and documents to assess compliance with the applicable provisions of R315-15 ~~of the Utah Administrative Code~~ and the Used Oil Management Act (19-6-701, et. seq.).

I.U.2. A record of the inspection may be made by photographic, videotape, electronic or other reasonable means.

I.U.3. Where such an inspection involves entry to the Permittee's property, the duly authorized ~~officer, employee or~~ representative ~~of the Utah Solid and Hazardous Waste Control Board~~ shall provide the opportunity to have a representative of the ~~owner, operator or agent in charge of the~~ Permittee's facility to be present.

I.V. Other Laws

Nothing in this permit shall be construed to relieve the Permittee from ~~his~~the ~~Permittee's~~ obligation to comply with any federal, state or local law.

I.W. Transfer of Permit

This permit may not be transferred to another party or parties without prior written approval from the Director.

I.X. Effective Date

This permit shall become effective on the date the permit is signed by the Director.

Attachment 1 General Operations

1.0. General Operations

The Permittee accepts, stores, and processes used oil via gravity separation, clay filtration, vacuum distillation and blending at the Permittee's business address of 1669 South 580 East, American Fork, Utah. This facility also produces and markets custom blended industrial base lubricants not regulated under R315-15 of the Utah Administration Code.

- 1.0.1. The Permittee is authorized to process 15,000,000 gallons of used oil per year.
- 1.0.2. The Permittee shall store incoming and processed used oil in above-ground steel tanks, with concrete secondary containment sufficient to hold 110% of the contents of the largest tank's volume (accounting for the displacement value factor of the tanks), and comply with R315-15-5.5 of the UAC Utah Administrative Code. The Permittee is authorized to store a maximum of up to 494,152-2490,250 gallons of used oil in the vertical steel storage tanks, the used oil processing tanks, and associated piping. An additional 2,000 gallons may be stored in portable drums and totes, and approximately 1,500 gallons in associated piping.
- 1.0.3. Prior to placing used oil in tanks, the Permittee shall conduct tank integrity testing on all tanks in accordance with the tank integrity and testing requirements outlined in 40 CFR 112 (Spill Prevention, Control, and Countermeasure regulations). Testing shall include shall include a testing technique such as hydrostatic testing, radiographic testing, ultrasonic testing, acoustic emissions testing, or another system of non-destructive shell testing. All tanks will be visually inspected prior to and after erection/construction.
- 1.0.4. Collected used oil filters shall be stored in appropriately labeled, compatible containers within the primary secondary contaminant area.
 - 1.0.4.1. Used oil filters collected by the Permittee that have not been properly drained of used oil shall be managed as containers of used oil in accordance with R315-15 of the Utah Administrative Code.
~~Used oil filters containing used oil shall be processed (crushed) on site to remove the used oil. The recovered used oil from the filters shall be transferred to incoming tanks 101, 102, and 104 only.~~
- 1.0.5. The Permittee shall manage residues generated from storing, ~~processing~~, processing or re-refining of used oil per R315-15-5.10.
- 1.0.6. Used oil storage drums and containers shall be labeled as "used oil" and closed except when removing or depositing used oil.
- ~~1.0.7. The Permittee may also store and blend lube oil from oil refineries according to [the rules affecting such activity]. The Permittee shall obtain all the necessary permits and licenses from the State and local authorities.~~

~~1.0.7.1. The Permittee may store and blend lube oil from oil refineries in tanks 121 and 122.~~

~~1.0.7.2. The Permittee shall not blend material regulated as used oil with these lube oils.~~

Comment [MAW1]: Tanks not regulated by used oil. Will only have to update Permit drawing when any changes because of safety. Another corporate entity is leasing the tanks for their use.

Also, tank 109 is bottoms that drop out of used oil regulations. Is part of processing, but should the tanks be under closure plan as the bottoms are no longer regulated as used oil.

1.1. Incoming Used Oil Description & Storage

In order to characterize the used oil feedstock it will be processing, and to ensure that it is not handling hazardous waste or off-specification used oil, the Permittee shall test or ensure testing of used oil on the front end of its process. The Permittee is authorized to accept, manage, and store (Table 1.1) incoming used oil that is defined by the following three categories: 1) untested used oil, 2) untested used oil with PCB contamination (< 2 ppm) and 3) on-specification used oil.

1.1.1. Untested Used Oil

Untested used oil is defined as oil that Rock Canyon Oil has field screened using a Dexsil Clor-D-Tect/Hydroclor-Q test kits or the Permittee will obtain appropriate Utah-certified laboratory results to screen for total halogen concentrations prior to acceptance. The Permittee will place this incoming used oil into tanks 101, 102, or 104. Prior to transferring, processing, or blending the used oil in these incoming tanks (Tanks 101, 102 and 104 in Table 1.1), the Permittee will lock down the tanks, and take a representative sample from each locked-down tank for analytical testing to determine if the material is on-specification. Once the used oil is determined to be on-specification, it will be transferred to tank 107, where it will subsequently be processed.

- 1.1.1.1. Off-specification used oil is oil that exceeds levels of constituents and properties specified in R315-15-1.2. Off-specification used oil will be quarantined and shipped off-site as off-specification used oil.

1.1.2. Untested Used Oil with PCB Contamination (< 2 mg/kg (ppm) PCB)

The Permittee is also authorized to accept and store used oil contaminated with Polychlorinated Biphenyls (PCBs) at concentrations below 2 parts per million (ppm), provided each shipment of this used oil is appropriately characterized according to the Permittee's analysis plan indicating the PCB concentration is less than 2 mg/kg (ppm). The Permittee's analysis plan (found in Attachment 2, "Used Oil Analysis/Rebuttable Presumption Plan" of this permit) contains specific procedures for making this PCB concentration determination. Used oil containing less than 2 ppm PCBs may be processed with other used oil at the Permittee's facility for the purposes of producing on-specification used oil. The Permittee shall not accept, store, or process used oil containing Polychlorinated Biphenyls (PCBs) at concentrations greater than or equal to 2 ppm.

1.1.3. Unprocessed On-Specification Used Oil

Used oil, already determined to be on-specification by a Utah-registered marketer, may be directly transferred into tank 107. Only used oil tested to be on-specification will be processed at the Permittee's facility.

1.2. Facility On-Specification Used Oil Processed

Processed used oil may be marketed as recycled fuel, or as a feedstock to oil blending facilities, which produce recycled lubricants (not fuel). Used oil processed by the facility shall be stored in tanks specified in Table 1.2 in accordance with the following criteria:

1.2.1. Low Viscosity Grade Used Oil (<90 vis)

Tank 120 shall store the low viscosity grade oil generated during vacuum distillation processing. Used oil is fed directly from TK202 into Tank 120. The processed used oil stored in Tank 120 is marketed without additional processing through the clay filtration systems.

Table 1.1 Incoming Used Oil Bulk Storage Tanks

Incoming Used Oil Bulk Storage Tanks		
Tank	Capacity (gal)	Tank Use
101	22,500	Untested used oil bulk storage
102	30,000	Untested used oil bulk storage
104	22,500	Untested used oil bulk storage
107	110,000	On-Specification used oil bulk storage
<u>110</u>	<u>9,500</u>	<u>Untested used oil bulk storage</u>
<u>111</u>	<u>9,500</u>	<u>Untested used oil bulk storage</u>
<u>112</u>	<u>11,500</u>	<u>Untested used oil bulk storage and oil generated from the oil/water separator</u>
<u>113</u>	<u>11,500</u>	<u>Untested used oil bulk storage and oil generated from the oil/water separator</u>

Table 1.2: Processed On-Specification Used Oil Storage Tanks

Outgoing Processed On-Specification Used Oil Bulk Storage Tanks		
Tank	Capacity (gal)	Tank Use
106	16,000	On-Specification Used Oil Storage
109	14,000	Used Oil Bottoms Storage Heavy viscosity used oil generated during processing in R202
110	9,500	Used Oil Bottoms Storage Heavy viscosity Used oil generated during processing in R202
111	9,500	Used Oil Bottoms Storage Heavy viscosity Used oil generated during processing in R202
112	11,500	Used Oil Bottoms Storage Heavy viscosity used oil generated during processing in R202
113	11,500	Used Oil Bottoms Storage Heavy viscosity UO generated during processing in R202
115	110,000	Processed On-Specification Used Oil storage
116	40,000	Processed On-Specification Used Oil storage

117	28,000	Processed On-Specification Used Oil storage
120	30,000	Processed On-Specification Used Oil storage

1.2.2. Medium Viscosity Grade Used Oil (90-120 vis)

The vacuum distillation process generates medium viscosity grade used oil that undergoes additional processing through the facility's clay filtration systems. After the used oil is processed through the clay filtration systems, it is pumped back into tank 115, 116, or 117 for storage. The facility may filter the used oil stored in these tanks multiple times through the clay filtration systems.

1.2.3. Heavy Viscosity Grade Used Oil (Bottoms) (Number 5-Number 6 Oil)

The vacuum distillation process generates heavier viscosity grade used oil that accumulates in the bottom of processing tank R202. This bottom oil is pumped from R202 into tank 109, ~~110, 111, 112 or 113~~ for storage and is marketed as an asphalt extender product, not a fuel. Bottoms marketed as a fuel, must be tested for on-specification parameters every 50,000 gallons.

1.2.4. Used Oil from Oil/Water Separator

In addition to incoming oil tanks 106, 112 and 113 may store used oil recovered from the facilities oil/water separator located in the secondary containment area just north of Tank 120. The oil/water separator receives oily water condensate from the Vapor Combustor Knock-Out tank. The oily condensate produced from the knockout tank is generated from reactor tank R201 and the purge cycle of the Granular Clay Filtration System. The water recovered from the oil/water separator is then placed into tank 118. This water is sprayed into the combustor to modulate the temperature of the combustor.

1.3. Facility Used Oil Process Description

The Permittee accepts, stores, and processes used oil via gravity separation, clay filtration, vacuum distillation and blending. Table 1.3 lists all used oil-processing tanks currently permitted at the facility.

Table 1.3: Facility Used Oil Processing Tanks

Tank	Capacity (gal)	Tank Use
<u>118</u>	<u>2,000</u>	<u>Water Storage Tank for combustor cooling water</u>
119	20,000	Water Storage Tank for process cooling
TK-202	4,000	Used oil storage tank (located inside processing building)
TK-203	4,000	Used oil storage tank (located inside processing building)
R201	125,000*	Used oil Reactor tank (located inside processing building)

R202	125,000 *	Reactor tank (located inside processing building)
Combustor Knock-Out Tank	500	Used oil storage tank (associated with the Vapor Combustor unit)
Rotary Clay Filtration Mixing Tank	900	Mixing tank for Rotary Clay Filtration process (plastic)
Oil/Water Separator Oil Tank	250	Temporary stores process oil
<u>*Reactor Tank Maximum Volume Operating Capacity</u>		

1.3.1. Vacuum Distillation Process

The vacuum distillation process equipment is comprised of two horizontal steel distillation reactor tanks (R201 and R202), a series of heat exchangers, vapor condensers, and two vertical storage tanks that are housed inside of the processing building with exception of two of the heat exchangers which are located outside on the east side of the process building.

1.3.2. Reactor Tanks

There are two reactor tanks, R201 and R202. Tank 107 supplies on-specification used oil feedstock to reactor tank R201 to start the distillation process. The used oil flows through a series of eight heat exchangers to increase the temperature of the oil. The reactor tanks have internal heating systems and mechanical mixers that help evenly heat the used oil in the reactors. Each reactor is designed to have approximately 6,000 gallons of feedstock in the tank while processing. Operating specifics for each tank are listed below:

1.3.2.1. Reactor Tank R201

There are three burner ducts in R201. The burner ducts are 12 inches in diameter and each have three straight sections which transverse the length of the reactor. The operator sets and controls the gallons of used oil entering reactor tank R201 from the process control computer. The feedstock in R201 may be heated to a maximum temperature of 450°F under negative pressure. Water and light ends, such as small concentrations of gasoline and antifreeze are vaporized and then vented to the Combustor Knock-Out tank where any condensed oil/water is collected. The remaining vapors are burned in the Vapor Combustion unit while the Vapor Combustor system is operating at a minimum temperature of 1000° F. The remaining used oil in tank R201 is then pumped through an oil preheater into reactor R202. The preheater will raise the temperature to approximately 600° F, but no higher than 650° F.

1.3.2.2. Reactor Tank R202

There is one internal 24-inch diameter burner duct in R202, which has two straight sections which transverse the length of the reactor. The used oil in reactor R202 may be heated to a maximum temperature of 695° F under negative pressure. The heated used oil releases hydrocarbon vapors that are then fractionated and distilled through a vapor condenser. The fractionation column is located on the floor next to R202. The fractionation column is 34 feet 11 inches tall, 48 inches in diameter, and is filled with

random packing (Pall rings). The low viscosity used oil grade (90 vis) is transferred from the condenser under vacuum into TK202 and from there to storage tank 120. The low viscosity used oil is pumped from storage tank 120 through the clay filtration system into storage tank 117. The medium viscosity used oil grade (90-120 vis) is transferred to the clay filtration system, as described in section 1.2.2., and stored in storage tanks 115 and 116.. Vapor condensers are cooled with production water from cooling tower Tank 119. The heavier used oil (bottoms) shall be transferred directly from R202 into bottoms tanks 109, ~~110, 111, 112, or 113.~~

1.3.3. Reactor Tank Design, Operation and Maintenance Requirements

All reactors shall be operated in a safe manner with the following specific design, operating and maintenance requirements:

- 1.3.3.1. Reactor tanks R201 and R202 shall have pressure and temperature sensors/gauges connected to the main Plant Processing Computer (PPC) system located in the control room for monitoring.
- 1.3.3.2. The up-stream section of the burner ducts shall be constructed of stainless steel at least twice the length of the maximum burner flame.
- 1.3.3.3. Two thermocouples shall be positioned on the outer wall of the burner tube in R202 to detect overheating of the burner tubes, approximately three and five feet from the burner, respectively. Both thermocouples shall be wired into the plant-processing computer (PPC) control system. The PPC will automatically alarm, causing an interlock to shut-down the gas burner if either thermocouple exceeds the high-level temperature limit.
- 1.3.3.4. The thickness of coke build up on the reactor burner ducts in R201 and R202 shall be monitored as follows:
 - 1.3.3.4.1. Reactor R201 burner ducts shall be inspected for coke buildup annually and whenever a burner duct or burner is modified or replaced.
 - 1.3.3.4.2. Coke buildup on burner ducts in reactor tank R202 shall be physically inspected every month or sooner when burner system components are modified or replaced in this reactor.
- 1.3.3.5. The facility shall have a written burner duct inspection and coking removal procedure. Thickness of coke deposits observed on the burner ducts shall be documented in the facility's operations record.

1.3.4. Clay Filtration Systems Description

Used oil generated from the distillation process and stored in tanks 115, 116, or 117 may be processed multiple times through the Rotary Drum Clay Filtration system and the Granular Clay Filtration system. The Permittee shall have written procedures for the operation, waste management, and emergency shut down for both clay filtrations systems.

1.3.4.1. Rotary Drum Clay Filtration (RDCF) System

The rotary clay filtration system processes used oil directly from tanks 115, 116 or 117 to filter contaminants from the used oil. Clay is mixed with used oil in the RDCF tank and piped into the RDCF system. Contaminates are removed by the clay which then adheres to the exterior wall of the rotary drum. The contaminated clay is scraped off the exterior wall during processing and the resulting material is collected for used oil recycling or offsite disposal. The Permittee shall determine if the waste generated from this process is a hazardous waste before management of the waste in accordance with Attachment 2, "Used Oil Analysis/Rebuttable Presumption Plan".

1.3.4.2. Granular Clay Filtration (GCF) System

The GCF system processes used oil directly from tanks 115, 116, or 117 to filter contaminants from the used oil. This system is comprised of up to 150 vertical clay filled columns aligned in a series. The filtered used oil is then circulated back into tanks 115, 116 or 117. The clay in the columns is purged as necessary to remove buildup of used oil contaminants. The purging process is described below:

- 1.3.4.2.1. The GCF system purge is initiated with approximately 1.5 gallons of used oil remaining in each filter column. The clay is heated and the oil adhered to the clay is burned off. All vapors generated from the burning of the oil are vented to the Vapor Combustor system for processing while the Vapor Combustor system is operating at a minimum temperature of 1000° F.
- 1.3.4.2.2. The clay purge cycle for the GCF system takes eight to ten hours. To control the burn rate of the used oil in the column, there is an orifice installed on the air intake of each column. The columns maximum operating temperature is 1000 °F with an external column temperature of 325° F. Temperatures in excess of 1200 °F inside the columns will damage the ability of the clay to filter oil. The GCF system does not have internal thermocouples to monitor temperature of the column during the purge. The Permittee shall periodically monitor the exterior temperatures readings for each column, using a calibrated heat-sensing gun. The operator shall adjust the air intake to each column so the internal temperature does not exceed 1000° F.
- 1.3.4.2.3. The Permittee shall characterize spent clay to determine if the spent clay is hazardous in accordance with Attachment 2, "Used Oil Analysis/Rebuttable Presumption Plan" if sold as fuel or used in a manner-constituting disposal.

1.3.5. Plant Processing Computer (PPC) System Requirements

Table 1 lists the "high-high" and "low-low" alarms settings, which trigger automatic shutdown of specific processing equipment. All parameters monitored by the PPC will be recorded in the facility data archiving system. The parameters in the table must be monitored by the facility control system without interruption, with the value of each parameter evaluated at least every minute and the average value of each parameter calculated and recorded at least every 10 minutes.

- 1.3.5.1. The facility shall have a written PPC System procedure, which documents all of the connected instrumentation, and their associated alarm levels or operating limits. The procedure shall specify at what alarm levels the PPC will automatically shut down any processing equipment and any required actions by the control room operator for manual

shutdown of the facility.

- 1.3.5.2. Control room operators shall record all process alarms, which trigger automatic shutdown of processing equipment in the operation logbook.
- 1.3.5.3. The operating record shall be maintained until closure of the facility.

Table 1.4 – Automatic Shutdown PPC Alarms

Alarms	Action Value	Equipment Shutdown
Combustor Temperature	>2200°F	Combustor turns off
Combustor Feed Elbow Temperature Sensor	> 600°F	Combustor turns off
R201 and R202 Low Oil Level	< 4” on stick	Reactor Burner Shutdown
Mixer Shuts Down on R201 and R202	Mixer Off	Reactor Burner Shutdown
R202 Low Air Pressure Burners	Preset Factory	Reactor Burner Shutdown
R202 Low Gas Pressure Burners	Preset Factory	Reactor Burner Shutdown
R202 High Gas Pressure Burners	Preset Factory	Reactor Burner Shutdown
R202 Burner Tube Sensors 1 or 2	>1400 °F	Reactor Burner Shutdown
Stack Temperature	>1200°F	R202 Burner Shutdown

- 1.3.6. The following facility diagram (Figure 1.1) represents an accurate layout of the facility. The Permittee shall submit an updated diagram to the Director upon approval of modifications, which alter the layout of the facility.
- 1.3.7. The Permittee may install and use a filter or centrifuge to enhance the quality of the products in tanks 115, 116, 117 and 120.

1.4. Secondary Containment

The Rock Canyon Oil, LLC facility shall construct secondary containment that is impervious to used oil to prevent any used oil releases from storage or processing areas from migrating out of the system to the soil, groundwater or surface water in accordance with R315-15-5.5.

- 1.4.1. The concrete floor, tank pads and walls shall be sealed with a petroleum resistant epoxy. The seal may be temporarily removed for periods of up to 2 weeks, if necessary, during floor maintenance.
- 1.4.2. The joint between the concrete floor and the tank pads shall be caulked to prevent migration of oil to the soil and groundwater.
- 1.4.3. The truck loading /unloading area shall be constructed of concrete and graded to drain all spills and runoff into the above-ground storage tank containment.

- 1.4.4. Any alterations or additions to the secondary containment system must be approval by the Director before changes are implemented.

1.5. Other Facility Storage Tanks

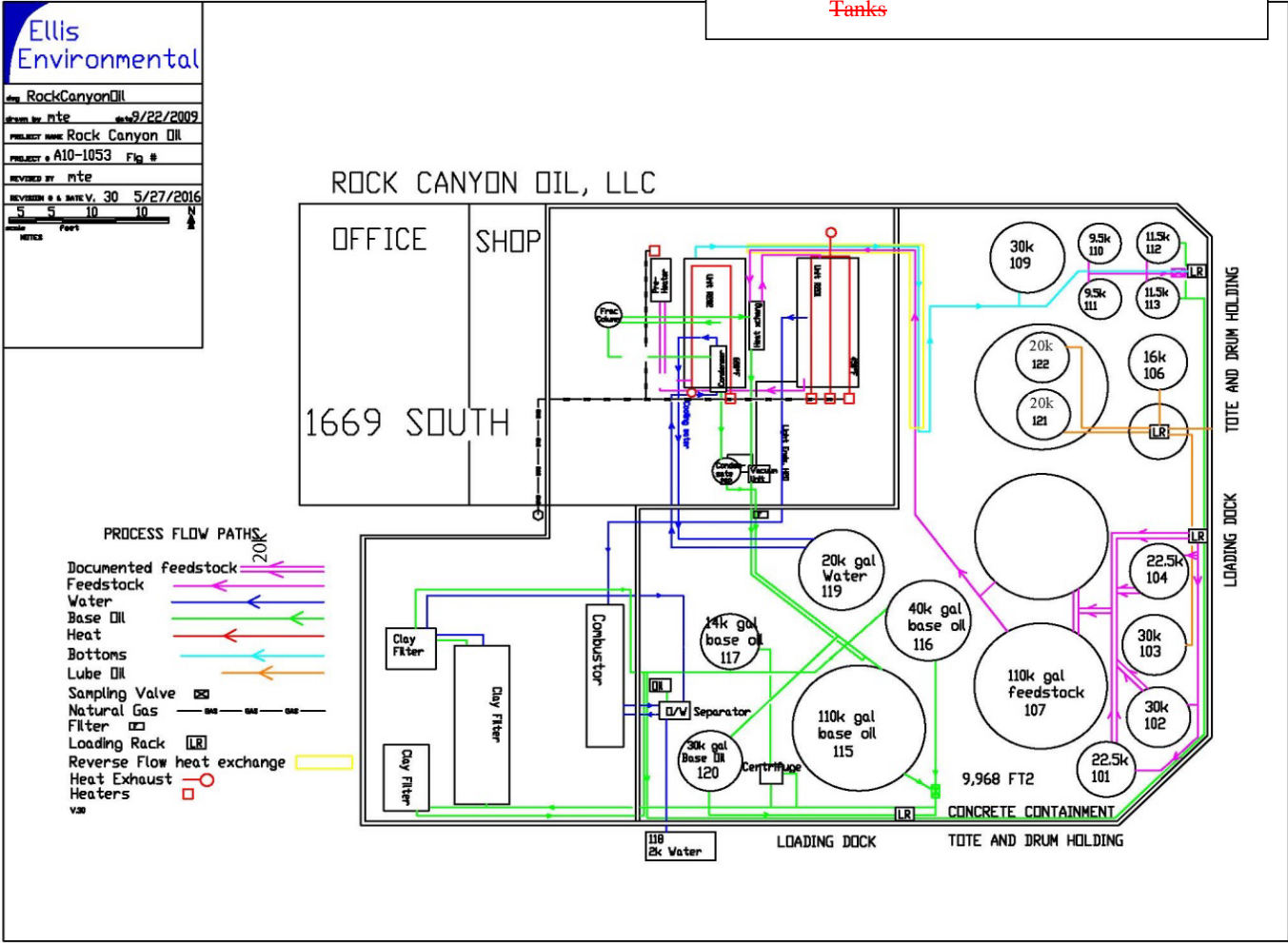
The Permittee shall adhere to the following conditions to protect the human health and the environment in case of an emergency at the facility for the storage tanks identified in Table 1.5 that are not regulated under R315-15. These facility tanks may be operated by the Permittee or leased to another company to store custom base lubricant oils.

- 1.5.1. These tanks shall not be connected via piping to the used oil tanks regulated under R315-15 as identified in Table 1.1 (Incoming Used Oil Bulk Storage Tanks) or Table 1.2 (Processed On-Specification Used Oil Storage Tanks).
- 1.5.2. The Permittee shall submit to the Director, within 20 days of the changes, a request to modify this Permit to update any information listed in Table 1.5 and the facility diagram in figure 1.1.
- 1.5.3. Prior to use, new tanks shall be inspected in accordance with the requirements of Permit condition 3.2 (Attachment 1).

Table 1.5 Onsite- Facility Tanks not regulated under R315-15

<u>Tank #</u>	<u>Maximum Capacity (gal)</u>	<u>Tank Use</u>
<u>103</u>	<u>30,000</u>	<u>Base lubricate oil not subject to regulation under R315-15.</u>
<u>106</u>	<u>16,000</u>	<u>Base lubricate oil not subject to regulation under R315-15.</u>
<u>109</u>	<u>30,000</u>	<u>Used oil re-refining distillation bottoms marketed as feedstock to manufacture asphalt products not subject to regulation under R315-15.</u>
<u>121</u>	<u>20,000</u>	<u>Base lubricate oil not subject to regulation under R315-15.</u>
<u>122</u>	<u>20,000</u>	<u>Base lubricate oil not subject to regulation under R315-15.</u>

Figure 1.1: Facility ~~Diagram~~ **Diagram**



Comment [MAW2]: Rock Canyon has to submit and updated drawing before this goes out to public comment.

Comment [DN3]: Is this the correct diagram

NO Rock Canyon will need to update this drawing. The one they sent with the Modification was not accurate. I want to get the language approved through you and Scott, but I will not put out for public comment until he pays the modification fee and updates this drawing.

Attachment 2

Used Oil Analysis/Rebuttable Presumption Plan

2.0. General Testing Requirements

The Permittee shall characterize waste generated from used oil operations and incoming and outgoing processed used oil in accordance with requirements listed below and R315-15-.5.4.

- 2.0.1. All analytical testing, required by this Permit, shall be conducted by a laboratory that holds a current Utah Laboratory Certification issued by the Utah Department of Health. The laboratory shall be certified for the method(s) and analytes used to generate the data.
- 2.0.2. Table 2.1 lists the analytical and preparatory laboratory methods required for specific for the types of sample analysis.

Table 2.1: Testing Parameter Analytical and Preparatory Method Requirements

Parameter	Analytical (A) & Preparation (p) Methods
Metals	P -3050B or 3051A A – 6010C or 6020A
Volatile Organic Carbons (VOCs)	P – 5035A & 3585 A - 8260B or C or 8021B
Semi-Volatiles	P – 3546 or 3580A A – 8270D
PCBS	P – 3580A and 3665A A – 8082A or EPA 1668
Oil & Grease	A - 1664A
GRO & DRO	P – 5035A A – 8260B or 8021B and 8270D
Flash Point	1010A or 1020B
Total Halogens	9076 (or methods specified for compounds listed in 40 CFR 261 Appendix VIII)
TPRH	EPA 1664A

- 2.0.3. Sample request forms or chain of custody forms shall be generated for all sampling events and accompany all samples to the receiving laboratory.

2.1. Testing of Incoming Used Oil

In order to characterize the used oil feedstock it will be processing, and to ensure that it is not handling hazardous waste or off-specification used oil, and to satisfy the rebuttable presumption requirements outlined in R315-15-5.4 ~~UAC~~ [of the Utah Administrative Code](#), the Permittee will test or ensure testing of used oil on the front end of its process. The Permittee will employ one of the following applicable procedures prior to accepting used oil at its processor facility in Utah.

2.1.1. Untested Used Oil

Each load collected directly from generators, shall be tested using a new, unexpired Dextsil *CLOR-D-TECT* 1000 or Q4000 kit if the water content is less than 20%. If the water content is 20% or greater, a Dextsil HydroClor-Q test kit or analysis must be performed by a Utah certified laboratory for total halogens. The Permittee may obtain results from a Utah-certified laboratory to screen for total halogen concentrations prior to acceptance. Test results will be documented in the used oil processor facility operating record, as required by R315-15-5.8.

- 2.1.1.1. Prior to transferring, processing, or blending the used oil from tanks 101, 102, and 104, the Permittee will lock down each of the tanks, take a representative sample from each locked-down tank, and submit these samples for analytical testing to determine if the material is on-specification. Only after Utah-certified laboratory results show that the used oil from a particular tank is on-specification, may the material from that particular tank be transferred to tank 107, where it will subsequently be processed.
- 2.1.1.2. Used oil will not be accepted for processing if test results indicate a halogen reading of 1000 mg/kg (ppm) or greater, unless the rebuttable presumption requirements have been satisfied and approved by the Director.

2.1.2. On-Specification Used Oil

Used oil determined to be on-specification by a Utah-registered marketer can be directly placed into tank 101, 102, 104 or 107. This material may then be processed without further testing, unless it is mixed with untested used oil, in which case the entire mixture shall be handled as untested used oil.

2.1.3. Used Transformer Oil

When accepting used transformer (mineral or dielectric) oil or used oil, which may contain PCBs at its facility, the Permittee shall ensure the following:

- 2.1.3.1. Prior to accepting used transformer oil with PCB concentrations below 2 parts per million (ppm), the Permittee shall:
 - 2.1.3.1.1. provide or obtain appropriate and representative test results from a Utah-certified laboratory for each container of the used oil certifying that the used oil contains PCB concentrations below 2 mg/kg (ppm); or
 - 2.1.3.1.2. require the generator to provide appropriate and representative lab testing results from a Utah-certified laboratory for each container of the used oil certifying that the used oil contains PCB concentrations below 2 mg/kg (ppm); or
 - 2.1.3.1.3. ensure that the generator or provider of each container of the used oil certifies that it has not been mixed/blended/combined with other material, or used oil for the purpose of dilution to avoid any provision specifying a PCB concentration in any federal or state environmental regulation or rule. The used oil shall only have PCB concentrations below 2 ppm. If this used oil is destined for energy recovery, then the Permittee will take a representative sample and provide or obtain an appropriate and representative test result from a Utah-certified laboratory confirming that it contains

less than 2 ppm PCBs prior to mixing/blending/combining it with other used oil or material.

- 2.1.3.2. The Permittee is not authorized to accept used transformer oil with PCB concentrations equal to or greater than 2 ppm.
- 2.1.3.2.1. For purposes of this section of the analysis plan, the following conditions shall apply:
- 2.1.3.2.2. Records of any laboratory test results or certifications used to demonstrate PCB concentrations, or any certification used to show that any material was not mixed/blended/combined for the purposes of dilution to avoid any provision specifying a PCB concentration in any federal or state environmental regulation or rule, shall accompany the material;
- 2.1.3.2.3. PCB concentrations mean a record of information that describes the PCB concentration in mg/kg, for seven of the Aroclors in the list below (Table 2.2 -must include Aroclor® 1016, Aroclor® 1260, Aroclor® 1254, and Aroclor® 1242), or total PCBs as sum of all congeners;

Table 2.2: Aroclors® Required for Analysis

CAS RN	Aroclor®	CAS RN	Aroclor®
12674-11-2	1016	12672-29-6	1248
147601-87-4	1210	165245-51-2	1250
151820-27-8	1216	89577-78-6	1252
11104-28-2	1221	11097-69-1	1254
37234-40-5	1231	11096-82-5	1260
11141-16-5	1232	37324-23-5	1262
71328-89-7	1240	11100-14-4	1268
53469-21-9	1242		

- 2.1.3.2.4. A Utah-certified laboratory means a laboratory that holds a current Utah Laboratory Certification issued by the Utah Department of Health for the methods used to determine the PCB concentration.

2.2. Testing of Outgoing Used Oil

The Permittee shall deliver used oil from its processor facility under the following scenarios:

2.2.1. Untested Used Oil

Used oil, which has not been tested, shall be transported by a permitted used oil transporter from the facility. The material shall be tracked as used oil on bills-of-lading.

2.2.2. On-Specification Used Oil

Used oil determined to be on-specification in accordance with this analysis plan, shall be transported by a permitted used oil transporter from the facility if sold as fuel. Product sold meeting the definition of recycled lubricants (not burned) do

not have to be transported by a permitted used oil transporter. The material must be tracked as “on-specification used oil” (or similar designation consistent with R315-15-5.7) and accompanied with an appropriate cross-reference to the applicable test results on bills-of-lading.

2.2.3. Off-Specification Used Oil

Used oil determined to be off-specification shall be transported by a permitted used oil transporter from the facility. The material must be tracked as “off-specification used oil” on bills-of-lading.

2.2.4. Use Oil Infused Clay for Disposal

Used oil infused clay generated from the Clay Filtration systems shall be characterized by the Permittee for any hazardous components (e.g. RCRA characterization) to determine if the material is a hazardous waste when sent for disposal.

Attachment 3 Contingency Plan

3.0. General Requirements

As required by R315-15-5.3, the Permittee shall follow the contingency plan procedures outlined below. The Permittee shall update these procedures as appropriate.

3.1. SPCC Plan

The Permittee shall implement an SPCC (Spill Prevention, Control and Countermeasures) plan for this facility. The Permittee shall submit a copy of the SPCC plan to the Director for incorporation into this permit.

3.2. Storage Tank Testing Requirements

Prior to storing used oil in its tanks, the Permittee shall conduct tank integrity testing on all of the tanks in accordance with the tank integrity and testing requirements outlined in 40 CFR 112 (Spill Prevention, Control, and Countermeasure regulations). All tanks will be visually inspected prior to and after erection/construction. In addition to visual inspection, the Permittee will also perform integrity testing in accordance with SPCC guidelines, which shall include a testing technique such as hydrostatic testing, radiographic testing, ultrasonic testing, acoustic emissions testing or another system on non-destructive shell testing. In addition, the inspector shall have the option to test welds or material thickness or any other non-destructive test deemed necessary for determination of tank soundness. Tests will be consistent with the certification of the testing company and the need to verify the condition of the tank or tanks.

- 3.2.1. Tank integrity testing shall be done prior to facility start up or tank usage. Regular tank integrity testing, in accordance with SPCC requirements, will be done on a five-year inspection interval. Only tanks passing integrity testing protocol shall be used at the facility.

3.3. Releases of Used Oil

In the event of a release of used oil, the person responsible for the material at the time of the release shall immediately take the following response actions, and then follow the facilities Emergency Spill Response Plan to completion.

3.4. Immediate Release Response

The Plant Manager is the key responder for this plan. The Plant Manager is responsible for executing this plan and providing the follow-up documentation in the event of a spill.

- 3.4.1. Shut off the source of the spill or isolate the plume.
- 3.4.2. Remove non-essential personnel from the property.
- 3.4.3. Essential, spill-trained personnel will assist the Plant Manager as assigned.
- 3.4.4. Notify the Utah State Department of Environmental Quality, 24-hour Answering Service, (801) 536-4123 for used oil releases exceeding 25 gallons, or smaller releases that pose a potential threat to human health or the environment. Small leaks and drips

from vehicles are considered de minimis and are not subject to the release clean-up provisions of R315-9 [of the](#) Utah Administrative Code. Notify the local emergency response coordinator through dialing “911” or by calling the LEPC identified in Section 2.9.

- 3.4.5. Notify the Utah State Department of Environmental Quality, 24-hour Answering Service, (801) 536-4123, and the American Fork Fire Department, (435) 241-1028, of upset conditions that result in the release of malodorous process gasses from the reactor vessels or the combustor, detectable beyond the facility boundaries.

3.5. Spill Reporting Requirements

Provide the following information when reporting the release:

- 3.5.1. Name, phone number and address of person responsible for the release.
- 3.5.2. Name, title and phone number of individual reporting.
- 3.5.3. Time and date of release.
- 3.5.4. Location of release--as specific as possible including nearest town, city, highway or waterway.
- 3.5.5. Description contained on the manifest and the amount of material released.
- 3.5.6. Cause of release.
- 3.5.7. Possible hazards to human health or the environment and emergency action taken to minimize that threat.
- 3.5.8. The extent of injuries, if any.
- 3.5.9. The above Immediate Action procedures should be implemented along with those procedures described in this section.

3.6. Additional Spill Response and Countermeasures

The following steps, if they can be safely conducted, should be taken immediately when responding to an oil spill.

3.6.1. Stop the Product Flow

- 3.6.1.1. Shut off pumps feeding leaking equipment.
- 3.6.1.2. Isolate leaking equipment by closing appropriate valves.
- 3.6.1.3. If possible, pump contents of leaking equipment to another tank.
- 3.6.1.4. If possible, repair leak.
- 3.6.1.5. Instigate other procedures that can be safely carried out to stop the flow of oil.

3.6.2. Warn Personnel

- 3.6.2.1. Warn all onsite personnel about the emergency.

3.6.2.2. Contact facility management.

3.6.2.3. Contact Local Emergency Response agencies by dialing “911”.

3.6.3. Shut Off Ignition Sources

3.6.3.1. Shut down, de-energize or remove ignition sources such as running engines, open flames, etc.

3.6.3.2. Remove chemically incompatible material from spill’s pathway.

3.6.3.3. Instigate other procedures that can safely eliminate ignition sources.

3.6.4. Initiate Containment

Restrict and contain the flow in as small an area as possible with the use of sand, absorbents, booms, sandbags, shovels, and/or earth-moving equipment.

3.6.5. Notify Appropriate Agencies and Personnel

Spills of greater than 25 gallons per event, or smaller releases that pose a potential threat to human health and the environment require notification to regulatory agencies.

3.6.6. Spill Reporting Procedures and Emergency Contacts

3.6.6.1. Emergency contacts and telephone numbers are provided to all Rock Canyon Oil, LLC employees upon employment and are posted in driver lounge areas, dispatch areas, and an offsite location for access in an emergency. It is the responsibility of the Plant Manager to determine the need for spill response support in addition to Rock Canyon Oil, LLC personnel and equipment. Dispatchers are directed by a manager for appropriate reporting action.

3.6.6.2. Spills of oil into or upon the navigable waters (including wetlands and municipal storm water systems) of the United States or adjoining shorelines will be reported Immediately by the person responsible for spill prevention or the alternate qualified individual (see Section V of this plan) to the following:

3.6.6.3. National Response Center, 24-hr. 800-424-8802 or 202-267-2675

3.6.6.4. Utah Department of Environmental Quality
Division of Waste Management and Radiation Control
P.O. Box 144880
195 North 1950 West
Salt Lake City, Utah 84114-4880 801-536-0200
24-hour emergency phone number: 801-536-4123

3.6.6.5. The verbal spill report follows the format of the Spill Report form in the SPCC plan. Using the form allows the spill reporter to have access to the emergency numbers and document all the information relevant to the release.

3.6.6.6. As required by the SPCC plan, should the facility release in excess of 1,000 gallons in a single event or have two reportable spill events within any twelve month period, the facility shall submit to its U.S. EPA Regional Administrator within 60 days from the

time the facility became aware of the spill, the following:

- 3.6.6.6.1. Name of the facility
- 3.6.6.6.2. Name of the owner or operator of the facility
- 3.6.6.6.3. Location of the facility
- 3.6.6.6.4. Maximum storage or handling capacity of the facility and normal daily throughput
- 3.6.6.6.5. The corrective actions and/or countermeasures taken, including an adequate description of equipment repairs and/or replacements
- 3.6.6.6.6. Adequate description of the facility, including maps, flow diagrams, and topographical maps
- 3.6.6.6.7. The cause(s) of such spills, including a failure analysis of the system or subsystem in which the failure occurred
- 3.6.6.6.8. Additional preventative measures taken or contemplated to minimize the possibility of recurrence
- 3.6.6.6.9. Such other information as the Regional Administrator may reasonably require pertinent to the SPCC plan or spill event.

- 3.6.6.7. This information will be submitted in writing to:

EPA Region 8 Administrator
8OC-EISC
1595 Wynkoop St.
Denver, CO 80202-1129

- 3.6.6.8. This information will also be provided to the Utah Department of Environmental Quality, Division of Waste Management and Radiation Control at the contact address above.

3.7. Safety Equipment

An intercom system will be installed in the office, shop and outside the building to notify and instruct plan personnel in the event of a release at the facility. Cellular telephones will be used by plant employees to communicate with the Plant Manager and with emergency response personnel. A portable foam extinguisher will be located outside the shop, near the tank farm for exterior fire suppression.

- 3.7.1. Installation of the fire suppression system shall be certified by a registered P.E.

3.8. Response Contacts

Rock Canyon Oil: General Manager, Gary Maxwell, Cell: 801-420-1640
Rock Canyon Oil: Plant Manager, Jay Kirchhoff, Cell: 801-616-6274

3.8.1. Other Emergency Contacts

- 3.8.1.1. EPA Region 8 303-293-1788

- 3.8.1.2. National Response Center (NRC) 800-424-8802
- 3.8.1.3. National Response Center, 24-hr 202-267-2675
- 3.8.1.4. State of Utah Department of Environmental Quality
 Division of Waste Management and Radiation Control
 P.O. Box 144880
 195 North 1950 West
 Salt Lake City, Utah 84114-4880
 Telephone during the day: 801-536-0248
 24-hour emergency phone number: 801-536-4123
- 3.8.1.5. Local Emergency Planning Committee:
 Tom Augustus, office 801-852-6315; cell, 801-404-6374; pager 801-432-3118
 Don Rigtrip, office 801-767-7233; pager 801-276-3615; home 801-756-2110
 Dennis Barker, office 801-852-6315; cell, 801-404-0659
 Dave Bennett, office 801-851-4132; cell 801-404-1911; pager 801-851-3030
- 3.8.1.6. Fire Department 911
- 3.8.1.7. Police/Sheriff 911
- 3.8.1.8. Ambulance 911
- 3.8.1.9. American Fork Hospital
 170 North 1100 East
 American Fork, UT 801-855-3300

3.9. Cleanup and Disposal of Oil-Contaminated Materials

Whenever it becomes necessary to cleanup and dispose of oil-contaminated soil or materials all applicable environmental regulations must be followed. Management should be contacted to plan and coordinate cleanup and disposal operations. Process follows:

- 3.9.1. Waste material will be placed into non leaking containers
- 3.9.2. Each container will be placarded with a Non Hazardous placard if the contents are known to be not characteristic of hazardous waste.
- 3.9.3. The non-hazardous waste will be contracted for transport and disposal at a regulated landfill.
- 3.9.4. There are hazardous substances on this site including benzene, arsenic, cadmium, chromium, lead and traces of gasoline. If these hazardous substances qualify the spilled material as hazardous waste, the waste will be containerized and placarded with the appropriate sticker, waste code, and accumulation date.
- 3.9.5. If the spill material is known, such as used oil, refer to the MSDS at the end of this document for characterization documentation.

- 3.9.6. If the contents of the container are unknown for waste characteristics, one sample per container will be collected and submitted to a Utah-certified laboratory for analysis.
- 3.9.7. The analysis, unless other information is available, will include flash point, the eight RCRA metals and chlorinated volatile organics (F & D listed wastes).
- 3.9.8. Waste codes for the appropriate hazardous waste chemicals will be filled in on the hazardous waste container placards.
- 3.9.9. A licensed waste transporter will be contracted to remove the hazardous waste to a licensed Treatment, Storage, and Disposal Facility (TSDF).
- 3.9.10. Rock Canyon Oil, LLC will keep the returned manifests from the TSDF indefinitely.

3.10. Distribution List

This plan will be distributed to the following agencies:

- 3.10.1. City of American Fork, Fire Chief
- 3.10.2. Utah County Health Department, Provo, UT
- 3.10.3. Utah Division of Waste Management and Radiation Control, Hazardous Waste Section, Salt Lake City, UT

Figure 3.1: Rock Canyon Oil Emergency Spill Report Form

Spill Emergency Reporting Form - Report must be made immediately upon discovery of a reportable release			
Facility Name <u>Rock Canyon Oil, LLC</u> , Location 1669 South 580 East, American Fork, UT 84003			
Telephone <u>801-420-1640</u> EPA ID # <u>UTR000010454</u>			
Name/title of person making the report			
Local Safety Responder	911	Date	Time
Utah DEQ	801-536-4123	Date	Time
National Response Center	800-424-8802	Date	Time
LEPC Contact	Date	Time	
Tom Augustus, office 801-852-6315; cell, 801-404-6374; pager 801-432-3118			
Don Rigtrip, office 801-767-7233; pager 801-276-3615; home 801-756-2110			
Dennis Barker, office 801-852-6315; cell, 801-404-0659			
Dave Bennett, office 801-851-4132; cell 801-404-1911; pager 801-851-3030			
Date/Time of the spill			
Date/Time of this report			
Source of the spill			
Type of material spilled			
Quantity of the spill			
Cause of the spill			
Affected media	<input type="checkbox"/> Pavement <input type="checkbox"/> Soil <input type="checkbox"/> Surface water <input type="checkbox"/> Groundwater <input type="checkbox"/> Air		
Describe potential hazards			
Evacuation Recommended	<input type="checkbox"/> YES <input type="checkbox"/> NO		
Injuries/casualties			
Remedial Actions Taken			
Spill Contained by When			
Spill Controlled by When			
Spill Remediated by When			
Who Discovered the Spill			
On Site Manager			
Unique circumstances			

Attachment 4

Emergency Controls – Spill Plan

4.0. General Policies

A copy of this spill plan will be kept at the American Fork, Utah used oil processor main office.

- 4.0.1. Employees will be given spill plan training before handling used oil.
- 4.0.2. The facility and storage tank farm will have the following: A 5-gallon bucket of absorbent material, rubber gloves, three, 5- foot long “oil socks,” several rags, plastic bags, and a shovel and broom for collecting used absorbent materials.
- 4.0.3. All spills will be reported to the supervisor after the spill has been stabilized or cleaned up.
- 4.0.4. Supervisors will review procedures with employees to recap, and to prevent further occurrences.

4.1. Immediate Action Steps in the Event of Used Oil Spills:

In the event of a spill or a release, Rock Canyon Oil, LLC will implement the following protocol:

- 4.0.1. R315-15-9.1(a): Take appropriate action to minimize the threat to human health and the environment. Attempt to stop further spilling/leaking if safe.
- 4.1.2. Take action to prevent spill from spreading (use rags, “socks,” absorbent material). Use sand, dirt or other material, or dig a trench to contain the spill.
- 4.1.3. Notify law enforcement, fire, medical officials, if necessary.
- 4.1.4. Safeguard yourself and others, but remain at or near the scene until officials arrive. You should not leave until authorized by these officials.
- 4.1.5. Notify supervisor if cleanup will require a significant amount of time or if assistance is needed to contain spill or clean up area.
- 4.1.6. If necessary, the supervisor will notify appropriate waste cleanup company to assist with cleanup.
- 4.1.7. If spill meets reporting criteria, the supervisor will report spills to appropriate agencies (see “Notification for: Used Oil Spills” below).
- 4.1.8. Clean up the area after spills are collected. Collect materials in plastic bags, and check with supervisor to determine if this material can be disposed in a dumpster.

4.2. R315-15-9.3 Release Clean Up

The person responsible for the material at the time of the release shall clean up all the released material and any residue or contaminated soil, water or other material resulting from the release. Take action as may be required by the Director so that the released material, residue, or contaminated soil, water or other material no longer presents a

hazard to human health or the environment. The cleanup or other required actions shall be at the expense of the person responsible for the release.

- 4.2.1. Complete a spill report form and give it to your supervisor at end of shift.
- 4.2.2. The supervisor will be responsible to follow up with requirements of **R315-15-9.4 REPORTING** (see below) if the spill meets this requirement.
- 4.3. Notification for: "Used Oil Spills exceeding 25 gals, or smaller releases that pose a potential threat to human health or the environment." - R315-15-9.1(b) & (c)**
 - 4.3.1. Notify the Utah State Department of Environmental Quality, 24-hour Answering Service, 801-536- 4123 for used oil releases exceeding 25 gallons, or smaller releases that pose a potential threat to human health or the environment. Small leaks and drips from vehicles are considered de minimis and are not subject to the release clean-up provisions of R315-15-9.
 - 4.3.2. Provide the following information when reporting the release:
 - 4.3.2.1. Name, phone number and address of person responsible for the release.
 - 4.3.2.2. Name, title and phone number of individual reporting.
 - 4.3.2.3. Time and date of release.
 - 4.3.2.4. Location of release--as specific as possible including nearest town, city, highway, or waterway.
 - 4.3.2.5. Description contained on the manifest and the amount of material released.
 - 4.3.2.6. Cause of release.
 - 4.3.2.7. Possible hazards to human health or the environment and emergency action taken to minimize that threat.
 - 4.3.2.8. The extent of injuries, if any.
 - 4.3.3. An air, rail, highway, or water transporter who has discharged used oil shall:
 - 4.3.3.1. Give notice, if required by 49 CFR 171.15 to the National Response Center, 800-424-8802 or 202- 426-2675; and
 - 4.3.3.2. Report in writing as required by 49 CFR 171.16 to the Director, Office of Hazardous Materials Regulations, Materials Transportation Bureau, Department of Transportation, and Washington, D.C. 20590.
- 4.4. R315-15-9.4 Reporting**

Within 15 days after any release of used oil that is reported under R315-15-9.1(b), Rock Canyon Oil, LLC shall submit to the Director a written report which contains the following information:

 - 4.4.1. The person's name, address, and telephone number;

- |
- 4.4.2. Date, time, location, and nature of the incident;
 - 4.4.3. Name and quantity of material(s) involved;
 - 4.4.4. The extent of injuries, if any;
 - 4.4.5. An assessment of actual or potential hazards to human health or the environment, where this is applicable; and
 - 4.4.6. The estimated quantity and disposition of recovered material that resulted from the incident.

Attachment 5
Training Plan

5.0. General Training

All employees will receive used oil training before participating in used oil processing and handling operations.

- 5.0.1. Utah-specific used oil processing and handling training will be conducted on an annual basis to all employees involved in used oil handling in Utah. and these procedures. The training will be provided during scheduled company safety/training meetings, or as appropriate. Refresher training will cover general used oil management procedures, identification of used oil and rebuttable presumption/analysis requirements for used oil transportation in Utah, the “Emergency Controls – Spill Plan,” spill reporting, and personal safety and protection.
- 5.0.2. Records of this training (date, employee name & signature, items covered) will be kept and made available for inspection for three years, and a master copy will be kept in the company training file.

Table 5.1: Used Oil Training Record for Rock Canyon Oil, LLC

Date	Name	Signature	Comments

**Attachment 6
Waste Disposal Plan**

6.0. General Requirements

All used oil contaminated solid waste generated at the facility shall be collected and stored in covered and labeled drums in the facilities secondary containment areas. Oily-liquids will be properly managed, and applicable characterization testing will be performed prior to treatment or disposal.

- 6.0.1. Rock Canyon Oil, LLC will document and maintain records showing proper handling and disposal for all used oil related waste products, including wastewater. The Permittee, as required by R315-15-5.8, will keep and maintain an operating record detailing the mass balance of wastewater entering and leaving the facility.
- 6.0.2. The Rock Canyon Oil, LLC facility is designed as a no-discharge facility. There will be no sewer line installed other than what services the restroom in the office. Wastewater disposal services are anticipated only in the event of an emergency. Therefore, wastewater will be transported off site to an appropriately permitted facility such as:
 - 6.0.2.1. H2O Environmental, 111 West 43rd Street, Garden City, ID 83714, Tel# 208-343-7867 or Champion Industrial Services, 537 West 800 South, SLC, Utah 84101 Tel# 801-886-2625.
- 6.0.3. The Permittee will properly characterize and dispose oily solids at an appropriately permitted facility such as:
 - 6.0.3.1. ECDC, 10500 South 1300 West, Suite A, South Jordan, Utah 84095 Tel# 801-253-1111 or
 - 6.0.3.2. E.T. Technologies Inc, 6030 West 1300 South, Salt Lake City, Utah 84104 Tel# 801-973-2065
- 6.0.4. The Permittee shall properly characterize and dispose hazardous wastes at appropriately permitted facilities.
- 6.0.5. Rock Canyon Oil, LLC notified as a Conditionally Exempt Small Quantity Generator of hazardous waste, UTR000010454.

Attachment 7
Liability Coverage

7.0. General Requirements

The Permittee shall have shall have non-sudden and sudden used oil pollution liability insurance in accordance with R315-15-10.

7.1. The Permittee shall submit documentation of non-sudden, and sudden used oil pollution liability insurance by March 1 of each reporting year.

7.2. Any changes that impact the liability coverage will require notification and written approval by the Director.

Attachment 8 Cleanup and Closure Plan

8.0. General Closure Plan Requirements

Rock Canyon Oil shall have a written closure plan (partial and final) that is designed to safely dismantle the facility, evaluate potential impact of the surrounding soil and groundwater from used oil and lube oil processing, operations, and storage in accordance with R315-15-11 of the Utah Administrative Code ~~R315-15-11~~. The Permittee shall be responsible for any cleanup of any used oil and lube oil contamination that has migrated beyond the facility property boundaries in accordance with R315-15-11(d). Rock Canyon Oil shall be responsible for any cleanup of contamination resulting from its lube oil operations, both on its property and any contamination that has migrated beyond the facility property boundaries, as if the lube oil contamination were the result of used oil contamination.

- 8.0.1. The Permittee shall establish a financial assurance mechanism in accordance with R315-15-12 to assure clean up and closure of the facility.
- 8.0.2. The Permittee shall conduct an annual review of the Closure Plan. An annual report shall be submitted to the Director, by March 1 of each year that updates closure financial responsibility information, including a yearly cost adjustment for inflation, in accordance with R315-15-12.4 and R315-15-11.2(a)(4).
- 8.0.3. The Permittee shall modify the permit to update the closure plan (Attachment 8) and increase the value of the financial assurance mechanism if the following occurs:
 - 8.03.1. New information is obtained by the facility or the Director that the current closure estimates are inaccurate; or
 - 8.0.3.2. Modification of the facilities design, storage ~~capacity~~, capacity or processing operations will require an increase in closure costs.
- 8.0.4. The Permittee shall initiate this closure plan within 90 days after the Permittee receives the final volume of used oil or when the Director revokes Rock Canyon Oil's Processing Permit ~~(UOP-0122)~~ in accordance with the requirements of R315-15-11.3.
- 8.0.5. The Permittee shall submit, by registered mail, to the Director within 60 days of the completion of closure, a certification that the facility has been cleaned closed in accordance with the approved closure plan. The Permittee and a Utah registered engineer (independent) shall sign the closure certification verifying successful closure of the facility.

8.1. Specific Closure Areas

The following areas will be addressed during closure of the facility:

- 8.1.1. Storage tanks, piping and ancillary equipment (untested and processed used oil storage),
- 8.1.2. processing reactor tanks, piping and ancillary equipment in the processing building,
- 8.1.3. clay filtration systems, piping, processing equipment and tanks,

- 8.1.4. vapor combustion system, tanks and ancillary equipment, and
- 8.1.5. soil and groundwater contamination.

8.2. Estimated Closure Costs

Total closure costs for the facility are estimated costs and specifics requirements are discussed below.

8.2.1. Soil and Groundwater Investigation (Task 1)

The total costs for site investigation is estimated cost with cost estimates identified in Table 8.1. The facility shall submit a written closure sampling and analysis plan to the Director for approval. Additional sampling and remediation costs may be accrued at time of closure. Sample costs were estimated as follows:

8.2.1.1. Soil Samples

Twenty-two soil samples are based on the 95% probability of detecting soil contamination using a 30 ft. by 30 ft. sampling grid over the secondary containment areas, unload/loading areas and 25% of the processing building.

8.2.1.2. Groundwater Samples

Four groundwater samples are based on the 95% probability of detecting groundwater contamination using a 70 ft. by 70 ft. sampling grid over the secondary containment areas, unload/loading areas and 25% of the processing building.

8.2.1.3. Analysis and Methods

All soil and groundwater samples will be tested for Oil and Grease, DRO, GRO and RCRA characterization parameters including metals, semi-volatiles, volatiles, , and PCBs. Testing methods will be outlined in your closure sampling and analyses plan.. The Permittee shall submit a Level 4 analytical data package with the testing results from a Utah certified laboratory, within 30 days of receipt, to the Director for review and approval.

8.2.2. Plant Decommission and Certification (Task 2 & 3)

The total costs for plant decommission and closure certification costs with a cost estimate identified in Table 8.1. The facility shall submit a written Plant Decommission plan to the Director for approval. Specific requirements are listed below:

- 8.2.2.1. All used oil and other media will be removed from all tanks, containers, piping, pumps, filters and other ancillary equipment.
- 8.2.2.2. On- specification, off-specification, untested used oil and other liquids shall be transported to a recycling facility or a waste disposal facility approved by the Director.
- 8.2.2.2. Processing and storage tanks, piping and ancillary equipment shall be dismantled where appropriate, and cleaned to remove used oil residues.

- 8.2.2.3. Rinsate water generated from used oil cleaning operations shall be transported to a recycling facility or a waste disposal facility approved by the Director.
- 8.2.2.4. Containers of drained used oil filters shall be sent for metal recycling.

Table 8.1: Itemized Task Closure Costs for Financial Assurance

Task	TASK DESCRIPTION	COMPANY	UNITS	RATE	COST
1	Site Sampling and Analytical				
	Gather Soil Samples Soil Sample Collection	Third-Party	22	\$112.00	\$2,464.00
	Gather Water Samples Groundwater Sample Collection	Third-Party	4	\$112.00	\$448.00
	Drilling for soil and groundwater sample collection Sampling Rig Mobilization	Third-Party	1	<u>\$1200.00</u>	<u>\$1,200.00</u>
	Water Samples Testing Sample Laboratory Analytical Costs	Third-Party	426	<u>\$1000.00</u>	\$32 <u>\$26,000.00</u>
	Site Sampling and Analytical Sub-Total				\$25,212.00 <u>\$30,112.00</u>
2	Plant Decommission				
	Remove residual oil, <u>& oily</u> water (gal)	Third-Party	474,152 <u>474,900</u> gal	\$0.08/gal	\$37,932 <u>\$37,992.00</u>
	Disposal of possibly contaminated oil (gal)	Third-Party	20,000	\$0.41/gal	\$8,200.00
	Disposal of containers of used oil filters	Third -Party	10	\$107/drum	\$1,070.00
	Clean Equipment and tanks Tank Decontamination and Rinsate Disposal	Third-Party	70 <u>16</u> /tank	\$340/hour <u>\$180/each</u>	\$23,800.00 <u>\$19,200.00</u>
	Disposal of rinsate generated from equipment and tanks (gal) Clean Auxiliary Equipment & Rinsate Disposal	Third-Party	6,666 <u>1</u>	\$0.45/gal <u>\$1.200.00</u>	\$3,000.00 <u>\$1,200.00</u>
	Contaminated soil removal (tons)	Third-Party	174 <u>170</u>	\$22.00_Ton	\$3,828 <u>\$740.00</u>
					\$76,760.00 <u>\$71,402.00</u>
3	Final Closure Verification				
	Independent P.E. Verification	Third-Party	1	\$500.00	\$500.00
	<u>Division of Waste Management & Radiation Review</u>	<u>20 hours</u>	<u>20</u>	<u>\$90.00/hour</u>	<u>\$1,800.00</u>
	Final Closure Verification Sub-Total				\$500 <u>\$2,300.00</u>
Total Closure Costs <u>(Recalculated June 2016):</u>					\$103,542.00 <u>103,814.00</u>

Attachment 9

Financial Assurance for Cleanup and Closure

~~9.0. General Requirements~~

~~The Permittee shall submit closure financial assurance documents to the Director in accordance with R315-15-12.~~

APPENDIX 1

Spill Prevention and Countermeasures Plan