

Spill Prevention, Control & Countermeasure (SPCC) Plan

Rock Canyon Oil, LLC
Used Oil Processing Facility
American Fork, Utah

July 2012

Revision 1

July 2016

Revision 2 - Pages 1, 14, 15, 16, 17

Prepared by
Rock Canyon Oil

Table 1: Fixed Petroleum Above Ground Storage Containers (ASTs)

Containers at the Facility (See Figure 3)	Contents	Storage capacity (gallons)	Date Installed
109	Bottoms	14,000	Feb. 2011
110	Bottoms	9,500	Aug. 2011
111	Bottoms	9,500	Aug. 2011
112	Bottoms	11,500	Aug. 2011
113	Bottoms	11,500	Aug. 2011
101	Used oil – quarantine	22,500	Feb. 2011
102	Used oil – quarantine	30,000	Aug. 2011
103	Used oil – quarantine	30,000	Future
104	Used oil – quarantine	22,500	Feb. 2011
105	Used oil – reserve	21,500	Future
106	Used oil – Base Oil	16,000	Aug. 2011
107	Feedstock – on spec	110,000	Feb. 2011
108	Feedstock – on spec	110,000	Future
115	Rerefined base oil	110,000	Feb. 2011
116	Rerefined base oil	40,000	Dec. 2011
117	Rerefined base oil	28,000	Dec. 2011
120	Rerefined base oil	30,000	Feb. 2011
119	Water	20,000	Feb. 2011
R201 *	Used oil – on spec	6,000	Feb. 2011
R202 *	Used oil – on spec	6,000	Feb. 2011
R203 *	Used oil – on spec	6,000	Dec. 2012
TK202 *	Rerefined base oil	3,000	Feb. 2011
TK 203 *	Rerefined base oil	3,000	Future
Coalescing Unit	Water, Light ends	250	Mar. 2011
Combuster Knock-out Drum		500	Mar. 2011

* Process tanks only. No permanent petroleum storage.

All tanks and containers owned by Rock Canyon Oil, LLC.

~~Note: All Storage Containers listed in Table 1 are located within the concrete containment or within the plant building as shown on Figures 2 and 3.~~

~~Total above ground permanent petroleum storage capacity:~~

<u>Product (Container)</u>	<u>Current</u>	<u>Future</u>
Bottoms (Tanks 109-114)	56,000	0
Used oil quarantine (Tanks 101-104)	75,000	30,000
Used Oil reserve (Tanks 105-106)	16,000	16,000
Feedstock on spec (Tanks 107,108)	110,000	110,000
Rerefined base oil (Tanks 115-117, 120)	208,000	0
TOTAL	465,000	156,000

~~Other liquid storage in containment areas or on asphalt surfaces (not covered by SPCC rule):~~

<u>Product (Container)</u>	<u>Current</u>	<u>Future</u>
Water (Tank 119)	20,000	0
Processing Tanks (R201-R203, TK202, TK203)	16,000	10,000
Coalescing unit	250	0
Combustor	500	0
TOTAL	36,750	10,000

~~3.1 BULK STORAGE TANKS - 40 CFR 112.7(e)~~

~~This section identifies and describes each "bulk storage container" that is regulated by 40 CFR 112 and is necessary to be included in this SPCC Plan. Facilities with tanks or containers above 1,320 gallons are regulated. Once a facility is required to prepare a SPCC Plan, then all~~

~~containers 55 gallons and above in capacity are to be included in the SPCC Plan, with minor exceptions. For example, a tank or container that is permanently closed is not included.~~

~~A “bulk storage container” may be a container or a tank. This container or tank may be located above ground, underground or partially underground. Spill, overflow and overfill prevention methods for each tank is described in Section 4.2.~~

~~Above Ground Storage: Used Oil Tanks/Product Tanks; Loading & Dispensing~~

~~**Bottoms Tanks 109 through 114** are vertical tanks ranging in size from 9,500 to 110,000 gallons each and are used to store the heavy “bottoms” that are produced in the rerefining process. The tanks are of single wall construction, rest on concrete and are located in the concrete walled containment area, as shown on **Figures 2 and 3**. Tank filling from the plant is through a heat exchanging piping and valve pumping system. It is loaded onto trucks through a 3-inch hose with Cam-Loc fittings from a manifold on the side of the tank near the bottom.~~

~~**Used Oil Tanks 101 through 104** are vertical tanks ranging in size from 21,500 to 30,000 gallons each and are used to quarantine untested used oil. When a tank has sufficient quantity it is “locked down” while a sample is being tested by an independent laboratory. Once it is determined to meet “on-specification” requirements it is transferred into one of the feedstock tanks by a piping and valve pumping system. The tanks are of single wall construction, rest on concrete and are located in the concrete walled containment area, as shown on **Figures 2 and 3**. Tank filling from the tanker truck is through a 3-inch hose with Cam-Loc fittings into a manifold on the side of the tank near the bottom.~~

~~**Used Oil Tanks 105 and 106** are vertical tanks ranging in size from 16,500 to 21,500 gallons capacity each and are used to store incoming or outgoing used oil products. The tanks are single wall construction, rest on concrete and are located in the concrete walled containment area, as shown on **Figures 2 and 3**. The used oil is transferred into or out of the adjacent processing facility by a piping and valve pumping system. Loading and unloading from the tanks to the tanker truck is through a 3-inch hose with Cam-Loc fittings into a manifold on the side of the tank near the bottom.~~

~~**Feedstock Tanks 107 and 108** are vertical tanks with 110,000 gallons capacity each and are used to temporarily store “on-specification” used oil prior to being processed into a light or medium viscosity base oil product. The tanks are of single wall construction, rest on concrete and are located in the concrete walled containment area, as shown on **Figures 2 and 3**. Tank filling from the tanker truck is through a 3-inch hose with Cam-Loc fittings into a manifold on the side of the tank near the bottom. The used oil is transferred into the adjacent processing facility by a piping and valve pumping system.~~

~~**Rerefined VGO and Base Oil Tanks 115, 116, 117 and 120** are used for storing our rerefined products VGO and base oil. The tanks are single-walled having storage capacities between 28,000 and 110,000 gallons. The tanks are located in the concrete lined and walled containment area, as shown on **Figures 2 and 3**. Tank filling and product removal is by piping from the processing facility and pumping into a tanker truck or trailer using a 3-inch hose with Cam-Loc~~

~~fittings. Overtopping is prevented by constant visual inspection of the tank filling operation.~~

~~Processing Tanks R201 through R203 and TK202 through TK203 are used to process used oil and have a capacity of 1,500 and 6,000 gallons. The tanks are single walled, rest on concrete within the concrete lined and walled containment area, as shown on Figure 3.~~

~~Out of service tanks are stored on the gravel yard area as shown on Figure 2.~~

~~Tanker Trucks (1-3) can have a capacity between 4,000 and 11,000 gallons and are used to transport used oil to the processing plant, and product to various customers. The tankers are temporarily parked as shown on Figure 2 on the concrete loading docks that slope into the containment. The oil is pumped from the tankers by a 3-inch hose with Cam-Loc fittings. Constant visual inspection is done to prevent overtopping. Tanker filling of product is by hose connections into the bottom of the tanker truck. All unloading and filling is done with the truck parked within the concrete pad loading/unloading area, as shown on Figure 2.~~

~~Drums existing on the site are identified as follows and are located in the containment area as shown on Figure 2:~~

~~55 Gallon Drums — Drums located in Figure 2 are used to store used motor oil and other petroleum products.~~

~~Fire extinguishers are located by the loading dock shown on Figure 3.~~

~~Underground Storage Tanks (USTs)~~

~~As reported, there are no underground storage tanks located at the facility.~~

Table 1: Petroleum Above Ground Fixed Storage (ASTs) and Processing Tanks, and Wastewater Storage Tanks.

Total Facility Petroleum Storage Capacity: 582,900 Gallons			
Containers at the Facility (See Figure 3)	Contents	Maximum Storage	Year Installed
Petroleum (used oil) Storage & Processing Tanks/Containers Regulated under R315-15)			
101	Used oil-quarantine	22,500	2011
102	Used oil-quarantine	30,000	2011
104	Used oil-quarantine	22,500	2011
107	Used Oil (on-spec feedstock)	110,000	2011
110	Used oil-quarantine	9,500	2011
111	Used oil-quarantine	9,500	2011
112	Used oil-quarantine	11,500	2011
113	Used oil-quarantine	11,500	2011
115	Re-refined Used Oil	110,000	2011
116	Re-refined Used Oil	40,000	2011
117	Re-refined Used Oil	28,000	2011
120	Re-refined Used Oil	30,000	2011
R201*	Used oil (On-Spec)	5,000	2011
R202*	Used oil (On-Spec)	5,000	2011
TK202*	Rerefined Used Oil	4,000	2011
Oil/Water Separator	Used Oil	250	2011
Combustor Knock out Drum	Used Oil	500	2011
Rotary Clay Filtration Mixing Tank	Used Oil	900	2013
Drums (55 gal) Totes (<300 gal)	Used Oil-quarantine	2,000	NA
Petroleum Tanks not Regulated under R315-15)			
103**	Base Oil	30,000	2016
106**	Base Oil	30,000	2011
109**	Asphalt Extender Bottoms	30,000	2016
121**	Base Oil	20,000	2015
122**	Base Oil	20,000	2015
Wastewater Tanks			
118	Process Cooling Water	2,000	2015
119	Process Cooling Water	20,000	2011

* Used Oil Processing tanks have a 5,000-gallon maximum operating capacity

** These tanks are owned and maintained by Rock Canyon Oil LLC and are subject to this SPCC Plan even if these tanks are leased out to another operator.

Note: All Storage Containers listed in Table 1 are located within the concrete containment or within the plant building as shown on Figures 2 and 3.

3.1 BULK STORAGE TANKS- 40 CFR 112.7(e)

This section identifies and describes each "bulk storage container" that is regulated by 40 CFR 112.7(e) and is necessary to be included in this SPCC Plan. Facilities with tanks or containers above 1,320 gallons are regulated. Once a facility is required to prepare a SPCC Plan, then all containers 55-gallons and above in capacity are to be included in the SPCC Plan, with minor exceptions. For example, a tank or container that is permanently closed is not included. A "bulk storage container" may be a container or a tank. This container or tank may be located above ground, underground or partially underground. Spill, overflow and overfill prevention methods for each tank is described in Section 4.2.

USED OIL TANKS

Incoming Used Oil Storage Tanks

Used Oil Tanks 101, 102, 104, and 110 through 113 are vertical steel tanks (above ground) ranging in size from 9,500 to 30,000 gallons each and are used to quarantine untested used oil delivered to the facility. When a tank has sufficient quantity it is "locked down" while a sample is being tested by an independent laboratory. Once it is determined to meet "on-specification" requirements it is transferred into feedstock tank 107 by a piping and valve pumping system. The tanks are of single-wall construction, rest on concrete and are located in the concrete walled containment area, as shown on Figures 2 and 3.

Feedstock Tanks 107 is a vertical tank with 110,000-gallon capacity is used to temporarily store "on-specification" used oil prior to being processed into a light or medium viscosity base oil products. The tanks are of single-wall construction, rest on concrete and are located in the concrete walled containment area, as shown on Figures 2 and 3. The used oil is transferred into the adjacent processing facility by a piping and valve pumping system.

Processing Tanks and Outgoing Used Oil Storage Tanks

Processing Tanks R201, R202, and TK202 are used to process used oil and have a capacity of 1,500 and 6,000 gallons. The tanks are single-walled, rest on concrete within the concrete lined and walled containment area, as shown on Figure 3.

Bottoms Tanks 109 is a 30,000-gallon vertical steel tank used to store the heavy "bottoms" that are produced in the re-refining process. This tank is of single-wall construction, rest on concrete and is located in the concrete walled containment area, as shown on Figures 2 and 3. Tank filling from the plant is through a heat-exchanging piping and valve pumping system. It is loaded onto trucks through a 3-inch hose with Cam-Loc fittings from a manifold on the side of the tank near the bottom.

Used Oil Tanks 115, 116, 117 and 120 are vertical tanks ranging in size from 28,000 to 110,000 gallons capacity each and are used to store incoming or outgoing used oil products. The tanks are single-wall construction, rest on concrete and are located in the concrete walled containment area, as shown on Figures 2 and 3. The used oil is transferred into or out of the adjacent Processing Tanks.

BASE OIL TANKS

Tanks 103, 106, 109, 121, and 122 are vertical tanks ranging in size from 20,000 to 30,000 gallons capacity each and are used to store base oils not derived from used oil processed at the facility. The tanks are single-walled, rest on concrete within the concrete lined and walled containment area, as shown on Figure 3.

Out of service, tanks are stored on the gravel yard area as shown on Figure 2.

Tanker Trucks (1-3) can have a capacity between 4,000 and 11,000 gallons and are used to transport used oil to the processing plant, and product to various customers. The tankers are temporarily parked as shown on Figure 2 on the concrete loading docks that slope into the containment. The oil is pumped from the tankers by a 3-inch hose with Cam-Loc fittings. Constant visual inspection is done to prevent overtopping. Tanker filling of product is by hose connections into the bottom of the tanker truck. All unloading and filling is done with the truck parked within the concrete pad loading/unloading area, as shown on Figure 2.

Drums existing on the site are identified as follows and are located in the containment area as shown on Figure 2:

55 Gallon Drums- Drums located in Figure 2 are used to store used motor oil and other petroleum products.

Fire extinguishers are located by the loading dock shown on Figure 3 Underground Storage Tanks (USTs)

As reported, there are no underground storage tanks located at the facility.

RESERVED