**Section 214.382 Petroleum and Petrochemical Processes**

a) Section 214.301 shall not apply to existing processes designed to remove sulfur compounds from the flue gases of petroleum and petrochemical processes.

b) No person shall cause or allow the emission of more than 1,000 ppm of sulfur dioxide into the atmosphere from any new process emission source in the St. Louis (Illinois) major metropolitan area designed to remove sulfur compounds from the flue gases of petroleum and petrochemical processes.

c) The following limitations apply to any petroleum refinery in the Village of Roxana:

1) No person shall cause or allow the combustion of refinery flasher pitch containing more than 3.0% (three percent) sulfur by weight. This shall be demonstrated by daily sampling of refinery flasher pitch.

2) No person shall burn petroleum refinery fuel gas in any fuel gas combustion device if that refinery fuel gas contains more than 39 grains hydrogen sulfide per 100 dry standard cubic feet (893 mg/scm). This shall be demonstrated by sampling the refinery fuel gas once every eight hours, pursuant to the Tutwiler Procedure (Section 214.104(c)).

3) No person shall cause or allow the total emission of sulfur dioxide into the atmosphere from the following source groupings to exceed the following amounts:

A) All process heaters at distilling unit No. 1 – 459 lbs/hr (208 kg/hr).

B) All process heaters at distilling unit No. 2 – 1260 lbs/hr (571 kg/hr).

C) All gas plant process heaters – 159 lbs/hr (72.1 kg/hr).

D) All vacuum flasher unit heaters – 378 lbs/hr (171 kg/hr).

E) All process heaters at the alkylation, benzene extraction unit and catalytic feed hydrotreating units – 346 lbs/hr (157 kg/hr).

F) All boilers generating steam for general plant use – 2,400 lbs/hr (1,090 kg/hr).

G) All heaters serving the hydrocracker unit catalytic reformer No. 1, and the saturates gas plant – 1,660 lbs/hr (753 kg/hr).

H) All process heaters at the aromatics east process – 768 lbs/hr (348 kg/hr).

I) All catalytic cracking units – 3,430 lbs/hr (1,560 kg/hr).

J) All asphalt converters, distilling unit No. 1, the aromatics east process, all boilers generating steam for general plant use, and all gas plant process heaters – 2,710 lbs/hr (1,230 kg/hr).

d) Compliance with the emission limitations of subsections (b) and (c)(3) of this Section shall be demonstrated on a three-hour block average basis. Such demonstrations shall require, as a permit condition, that data as required by the Illinois Environmental Protection Agency (Section 201.161) be maintained in order to adequately determine the sulfur dioxide emission rate from each source operations group.

e) Sources in the Village of Roxana are not subject to the emission limitations of Section 214.162 when burning refinery flasher pitch or refinery fuel gas.

f) Individual process emission sources in the Village of Roxana are still subject to the emission limitation of Section 214.301 notwithstanding their inclusion in a source operations group.

g) Notwithstanding the provisions of 35 Ill. Adm. Code 201.102 of this Chapter, any physical change in any emission source subject to subsection (b), (c), (d), or (e) of this Section which alters the height of release, temperature or volumetric flow rate of the effluent gases of such source, or alters the diameter of the exit stack, shall be deemed a modification for the purposes of 35 Ill. Adm. Code 201.142 of this Chapter.

(Source: Amended at 12 Ill. Reg. 20778, effective December 5, 1988)