



UNITED STATES ENVIRONMENTAL PROTECTION AGENCY
REGION 5
77 WEST JACKSON BOULEVARD
CHICAGO, ILLINOIS 60604

DATE: JUN 28 2019

SUBJECT: CLEAN AIR ACT INSPECTION REPORT
Winpak Heat Seal Corporation (Winpak), Pekin, Illinois

FROM: Victoria Nelson, Environmental Engineer
AECAB (MI/WT)

THRU: Sarah Marshall, Section Chief
AECAB (MI/WT)

TO: File

BASIC INFORMATION

Facility Name: Winpak Heat Seal Corporation (Winpak)

Facility Location: 1821 Riverway Drive, Pekin, Illinois

Date of Inspection: May 7, 2019

EPA Inspectors:

1. Victoria Nelson, Environmental Engineer
2. Eleanor Kane, Environmental Engineer

Other Attendees:

1. Robert Brott, Winpak, Plant Manager
2. Julia Stover, Winpak, Process Engineer

Contact Email Address: Robert.Brott@winpak.com; Julia.Stover@winpak.com

Purpose of Inspection: To assess compliance with the Clean Air Act and the facility's operating permit

Facility Type: Foil and film printing

Arrival Time: 1:30 PM Central Time

Departure Time: 4:00 PM Central Time

Inspection Type:

- ☒ Unannounced Inspection
- ☐ Announced Inspection

OPENING CONFERENCE

- ☒ Credentials Presented
- ☒ CBI warning to facility provided

The following information was obtained verbally from the attendees unless otherwise noted.

Process Description:

Winpak receives inks, solvents, and aluminum foil with a heat seal as raw materials. Winpak operates three flexographic presses that print designs on foil lids for plastic containers. Printing is done by coating etched plates with ink and pressing onto foil. Plates are photosensitive sleeves with the desired design imprinted in the plating room. The plating room is equipped with a solvent still to aid plate imaging. Custom color inks are mixed in the ink room. Once printed, lids are cured in curing ovens and then punched out of foil rolls on die cutters and shipped to customers. Each of the three presses are housed in a permanent total enclosure (PTE) that is continuously monitored for differential pressure. The PTE and the plating room are exhausted to a regenerative thermal oxidizer (RTO).

Staff Interview: The facility operates 24 hours a day for six or seven days out of each week and has 193 employees. The three presses are interlocked with the RTO. In 2018, Winpak resolved an enforcement action with the Illinois Environmental Protection Agency (IEPA), requiring them to obtain and operate pursuant to a new construction permit applying Best Available Control Technology (BACT).

TOUR INFORMATION

EPA toured the facility: Yes

Data Collected and Observations:

EPA inspectors toured the press room, ink room, plating room, and cutting operations. In the ink room, EPA observed ink mixing and found an open inactive drum containing ethyl acetate. The ink room is not exhausted to the RTO.

Photos and/or Videos: were taken during the inspection.

EPA collected three recordings with the FLIR optical gas imaging camera to observe potential uncontrolled emissions of VOCs.

Field Measurements: were not taken during this inspection.

RECORDS REVIEW

- Process flow diagram

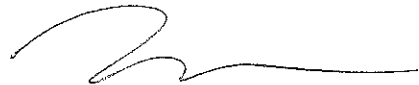
CLOSING CONFERENCE

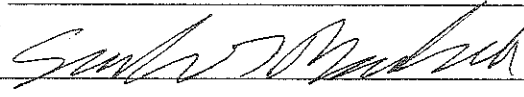
Requested documents:

- Most recent RTO stack test report
- Emissions inventory for previous 12 months
- Most recent PTE test report
- PTE pressure drop readings averaged over three hours for first two weeks of May 2019
- Safety Data Sheets for most commonly used solvents, inks, and chemicals containing hazardous air pollutants

Compliance Assistance: EPA recommended that Winpak keep solvent drums closed when not actively in use.

SIGNATURES

Report Author:  Date: 6/28/19

Section Chief:  Date: 6/28/19

Facility Name: Winkpak Heat Seal Corporation (Winkpak)
Facility Location: 1821 Riverway Drive, Pekin, Illinois
Date of Inspection: May 7, 2019

APPENDICES AND ATTACHMENTS

- Appendix A: Digital Video Log

Facility Name: Winpak Heat Seal Corporation (Winpak)
Facility Location: 1821 Riverway Drive, Pekin, Illinois
Date of Inspection: May 7, 2019

APPENDIX A: DIGITAL VIDEO LOG

1. Photographer Name: Victoria Nelson	2. Dates of Inspection: May 7, 2019
3. Company Name: Winpak Heat Seal Corporation (Winpak)	4. Street Address, City, State: 1821 Riverway Drive, Pekin, Illinois
5. Number of Videos: 3	6. Archival Record Location: C:\Users\Vnelson\OneDrive - Environmental Protection Agency (EPA)\Targeting and Inspections\FLIR Videos

Video Number	File Name	Date	Description of Image
1	MOV_2424.mp4	6/28/2019	Open drum of ink in the PTE for the presses
2	MOV_2425.mp4	6/28/2019	Open ethyl acetate drum in ink room
3	MOV_2426.mp4	6/28/2019	RTO stack