



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

SUBJECT: CLEAN AIR ACT INSPECTION REPORT
Exxon Mobile Hammond Terminal, Hammond, Indiana

FROM: Jason Schenandoah, Environmental Engineer
AECAB (IL/IN)

THRU: Nathan Frank, Section Supervisor
AECAB (IL/IN)

TO: File

BASIC INFORMATION

Facility Name: Exxon Mobil Hammond Terminal

Facility Location: 1527 141st St, Hammond, IN 46327

Date of Inspection: August 2, 2022

EPA Inspector(s):

1. Jason Schenandoah, Environmental Engineer
2. Meghan Pashen, Environmental Engineer

Other Attendees:

1. Peter Rock, Working Foreman, Exxon Mobil
2. Sasa Dunovic, Air Compliance Inspector, Indiana Department of Environmental Management

Contact Email Address: Pete.J.Rock@exxonmobil.com

Purpose of Inspection: Tanks inspection

Facility Type: Terminal

Regulations Central to Inspection: NESHAP BBBB

Arrival Time: 9:15 am

Departure Time: 11:30 am

Inspection Type:

- ☒ Unannounced Inspection
- ☐ Announced Inspection

OPENING CONFERENCE

- ☒ Presented Credentials
- ☒ Stated authority and purpose of inspection
- ☐ Provided Small Business Resource Information Sheet
- ☒ Small Business Resource Information Sheet not provided. Reason: Not a small business
- ☒ Provided CBI warning to facility

The following information was obtained verbally from Peter Rock unless otherwise noted.

Process Description:

Exxon Mobil's Hammond terminal (the Facility) operates three gasoline storage tanks with internal floating roofs (IFR), three diesel fixed roof storage tanks, one ethanol storage tank with an IFR, one biodiesel storage tank with a fixed roof, and one blend stock storage tank with a fixed roof. Petroleum and diesel products are brought into the Facility via pipeline. Outgoing material is loaded into tanker trucks via a five bay loading rack. While loading, ethanol and biodiesel are blended into the gasoline and diesel, respectively, depending on the required specifications for the product. Vapors from the loading operations are vented to a common header that routes to a vapor recovery unit (VRU). The VRU consists of two carbon beds and a collection tower. Vapors are routed alternatively between the two carbon beds every 15 minutes. A vacuum is drawn on the carbon bed that is not currently controlling vapors and the collected vapors are sent to a collection tower. The collection tower sprays gasoline onto the vapors to incorporate the vapors into the liquid phase.

Staff Interview:

Auditory, visual, and olfactory inspections are conducted on storage tanks once per month. IFR seal inspections are conducted quarterly by looking through the manway of the storage tanks. IFR storage tanks have an in-service seal inspection once every 10 years. American Petroleum Institute (API) 653 inspections are conducted on storage tanks every 20 years. The pipeline can create a co-mingled diesel and gasoline product called transmix; transmix is taken by another company to be re-refined. A continuous emissions monitoring system (CEMS) is used at the outlet of the VRU carbon beds to measure outlet emissions to the atmosphere. The CEMS will alarm at 1.96% organics concentration for a warning and loading operations are ceased if the organics concentration reaches 2.56%.

TOUR INFORMATION

EPA Tour of the Facility: Yes

Data Collected and Observations:

A Forward Looking Infrared (FLIR) camera was utilized to perform optical gas imaging (OGI) throughout the Facility. Emissions were visualized exiting the VRU stack while conducting OGI. OGI was conducted on Tanks 154, 155, and 156 and emissions were visualized exiting the vents on the tanks. Tanks 154, 155, and 156 are each IFR tanks that store gasoline.

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

Photos and videos have been logged in Appendix A: Digital Image Log

Field Measurements: were not taken during this inspection.

CLOSING CONFERENCE

☒ Provided U.S. EPA point of contact to the facility

Requested documents:

- Last in-service inspection report of IFR seals for Tanks 154, 155, and 156
- Last API 653 inspection report for Tanks 154, 155, and 156

DIGITAL SIGNATURES

Report Author: JASON
SCHENANDOAH Digitally signed by JASON
SCHENANDOAH
Date: 2022.09.23
15:15:19 -05'00'

Section Supervisor: Frank,
Nathan Digitally signed by Frank,
Nathan
Date: 2022.09.26
16:48:02 -05'00'

Facility Name: Exxon Mobil Hammond Terminal
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APPENDICES AND ATTACHMENTS

- 1.* Appendix A: Digital Image Log

Facility Name: Exxon Mobil Hammond Terminal
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APPENDIX A: DIGITAL IMAGE LOG

1. Inspector Name: Jason Schenandoah	2. Archival Record Location: Electronics Record Center: Enf_ExxonMobileHammond_IL_22
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Image Number	File Name	Date and Time (incl. Time zone and DST)	Latitude and Longitude	Description of Image
1	SEQ_0445	*		Emissions from VRU stack
2	DC_0446	8/2/2022 10:21 am**		Photo of VRU CEMS system
3	SEQ_0447	*		Emissions from Tank 156
4	MOV_0448	8/2/2022 10:29 am***		Emissions from Tank 156
5	MOV_0449	8/2/2022 10:36 am***		Emissions from south side of Tank 154
6	MOV_0450	8/2/2022 10:47 am***		Emissions from Tank 155
7	MOV_0451	8/2/2022 10:51 am ***		Emissions from north side of Tank 154

* Metadata from SEQ file did not preserve in ERC

** Metadata from this file is 1 hour off from actual capture time, it is corrected in the table above

*** Metadata from these files are 4 hours off from actual capture time, it is corrected in the table above