Enclosure D

Inspection Observations
5/28-29/2024

Emission Unit	Control Device	Parameter Monitor	Permit Limit	Observations
Amodel Process (Down During the Inspection)				
Hot Oil Heater KB-901 (0A17)	None	Visible Emissions (%)	<20%	Process Down
Boiler UB-1210 (0A21)	None	Visible Emissions (%) Steam Flowrate (lb/hr) Steam Pressure (psig)	<20%	Process Down
Flare KB-807 (0A15)	None	Visible Emissions (%) Pilot Flame Indicator	<40%	Process Down
Extruder KM-601 (0A6D)	None	Visible Emissions (%)	<40%	Process Down
	Scrubber KD-633 (0A6B)	Pressure Drop (in H_2O) Flowrate	<5 in H_2O >1 gpm	Process Down
	Seal Drum (KF613)	Exit Temperature (°F)	<220°F	Process Down
	Vacuum Pump (C603)	Exit Temperature (°F)	<220°F	Process Down
Mix Tank KD-260 (0A2B)	None	Visible Emissions (%)	<40%	Process Down
Mix Tank KD-260 (0A2B) Surge Tank KD-266 (0A2C) Concentrator KD-301 (CONC)	Scrubber KT-1001 (A10A)	Pressure Drop (in H_2O) Flowrate	<6 in H_2O >20,000 lb/hr	Process Down
Distillation Still KD-806 (0A9A)	Condenser C-803 (0A8C)	Exit Temperature (°F)	<350°F	Process Down
Sulfone Process				
Hot Oil Heater #1 (00H1)	None	Visible Emissions (%)	<20%	0
Hot Oil Heater #2 (00H2)	None	Visible Emissions (%)	<20%	0

Waste Heat Boiler LM-731 (00B8)	None	Visible Emissions (%) Temperature	<20% >1500°F	Process Down
Railcar Unloading Station (RCU)	None	Visible Emissions (%)	<20%	0
Tank LD-101 (0C1E)	None	Visible Emissions (%)	<40%	0
Reactor LR-201 (0C4D)	None	Visible Emissions (%)	<40%	0
Waste Heat Boiler LM-731 (00B8)	Mist Eliminator (0C7L)	Pressure Drop (in H_2O)	>9 in H_2O	Process Down
Storage Tank LF-111 (0C2B) Storage Tank LF-115 (0C2X)	Condenser (0C2A)	Exit Temperature (°C)	<12.8°C	3.45
Reactor LR-201 (0C4D)	Condenser (0C2G)	Exit Temperature (°C)	<12.8°C	0.62
Reactor Cooler LE-202 (0C2E)	Condenser (0C2L)	Exit Temperature (°C)	<12.8°C	0.98
Tower LT-302 (0C3C) Reactor LR-380 (R380)	Condenser (0C5A)	Exit Temperature (°C)	<12.8°C	3.01
Feed Tank LD-458 (0C4I) Feed Tank LD-401 (0C6F)	Condenser (0C6A)	Exit Temperature (°C)	<12.8°C	1.97
Tower LT-460 (0C6G)	Condenser (0C6C)	Exit Temperature (°C)	<12.8°C	2.40
Feed Tank LD-501 (0C5F) Tank LD-325 (0C5G) Tank LD-601 (0C6J) Feed Tank LD-621 (0C6K) Tank LD-651 (0C6L) Tank LD-701 (0C7D) Storage Drum LD-751 (0C7E) Tank LD-814 (0C8C) Tank LD-852 (0C8F) Drum LD-1201 (C10H) Drum LD-712 (0C7F) Tank LD-645 (0C64)	Condenser (0C7A)	Exit Temperature (°C)	<12.8°C	2.88
Storage Tank LD-310 (0C5D) Storage Tank LD-314 (0C5E)	Condenser (0C5B)	Exit Temperature (°C)	<12.8°C	1.91

Emission Unit	Control Device	Parameter Monitor	Permit Limit	Observations

Extraction Tower LT-445 (0C7G) Acid Extraction Column II LT485 (T485) Acid Extraction Column II Bottoms Cleaner LH-487 (H487) Sulfone Neutralization and Wash Column II LT-495 (T495) Sulfone Neutralization and Wash Column II Bottoms Coalescer LH-497 (H497)	Condenser (0C7B)	Exit Temperature (°C)	<12.8°C	0.74
LD505 Crude Crystallizer Feed Drum (D505) LD531 Crude Crystallizer (D531) LM542 Crude Centrifuge (M542) LD551 Crude Reslurry Tank (D551)	Condenser (D576)	Exit Temperature (°C)	<12.8°C	3.90
Tank LD-101 (0C1E)	Scrubber (0C1A)	Pressure Drop (in H_2O)	<20 in H_2O	0.2
Waste Heat Boiler LM-731 (00B8)	Scrubber (0C8A)	Pressure Drop (in H_2O)	<10 in H_2O	Process Down
	Scrubber (0C8B)	Pressure Drop (in H_2O) Flowrate pH	<10 in H_2O >27,850 lb/hr >7	Process Down

Xydar Process (Down During Inspection)

Hot Oil Heater H-601 (00P1)	None	Visible Emissions (%)	<20%	Process Down
Hot Oil Heater H-603 (00P2)	None	Visible Emissions (%)	<20%	Process Down
Boiler H-602 (00P3)	None	Visible Emissions (%)	<20%	Removed
Boiler H-604 (00P4)	None	Visible Emissions (%)	<20%	Removed
Emission Unit	**Control Device**	**Parameter Monitor**	**Permit Limit**	**Observations**
Reactors R-201 A/B/C (RX01)	None	Visible Emissions (%)	<40%	Process Down
Mixer R-202A (0X2G)	None	Visible Emissions (%)	<40%	Process Down
Mixer R-202B (0X2H)	None	Visible Emissions (%)	<40%	Process Down
Mixer R-202C (0X2I)	None	Visible Emissions (%)	<40%	Process Down

Reactors R-201 A/B/C (RX01) Mixer R-202A (0X2G) Mixer R-202B (0X2H) Mixer R-202C (0X2I)	Scrubber (0X2T)	Pressure Drop (in H_2O) Flowrate pH	<15 in H_2O >120 gpm >9	Process Down

Udel Process

Udel Thermal Oxidizer (00C2)	None	Visible Emissions (%) Temperature (°F)	<40% >1600°F	Not Built
Reactor PR-401 (0U4D)	None	Visible Emissions (%)	<40%	Not Built-
Tank PD-411 (0U4A) Tank PD-412 (0U4B) Tank PD-603 (0U6A) Tank PD-604 (0U6B) Udel Thermal Oxidizer (00C2) Reactor PR-401 (0U4D) Column PT-715 (0U7I) Drum PD-425 (0U4E) Tank PD-202 (0U2A) Tank PD-503 (0U5C) Tank PD-730 (0U7G)	Scrubber (00C3)	Pressure Drop (in H_2O) Flowrate pH	>5 in H_2O >10 gpm >7	Not Built-

KetaSpire/NovaSpire (also known as Jupiter (PEEK) Process)

Hot Oil Heater (BE-01)	None	Visible Emissions (%)	<20%	
Boiler (BE-02)	None	Visible Emissions (%) Steam Flowrate (lb/hr) Steam Pressure (psig)	<20%	
Emission Unit Group HE-2 Process Reactor (PR-200)	Scrubber (SC1)	Pressure Drop (in H_2O)	<15 in H_2O	0.1
Emission Unit Group HE-1 HCL Storage Tank (PF-800)	Scrubber (SC2)	Pressure Drop (in H_2O)	<15 in H_2O	0.8

Push Process (Not Built)

Unit FD-1210: 2,5-DCBP Mix Tank (FD02)	Scrubber (FT01)	Pressure Drop (in H_2O) pH	<15 in H_2O >7	Not Built
Unit FR-200: Digestion Tank(FD08)	Scrubber (FT02)	Pressure Drop (in H_2O) pH	<15 in H_2O >7	Not Built
	Carbon Drum Membrane (FA03)	Pressure Drop (in H_2O)	<90 psia	Not Built
Unit FR-400 through Unit FR-805 and Unit FF-705 through Unit FF-800	Scrubber (FT03)	Pressure Drop (in H_2O)	<15 in H_2O	Not Built