



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

SUBJECT: CLEAN AIR ACT INSPECTION REPORT
Olin Winchester, East Alton, Illinois

FROM: Ethan Chatfield, Environmental Engineer
AECAB (IL/IN)

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

TO: File

BASIC INFORMATION

Facility Name: Olin Winchester

Facility Location: 427 North Shamrock, East Alton, Illinois

Date of Inspection: July 21, 2022

EPA Inspector(s):

1. Ethan Chatfield, Environmental Engineer
2. Brittany Cobb, Environmental Engineer

Other Attendees:

1. Gretchen Joehl, Manager of Safety, Health & Environment - Winchester Ammunition
2. Troy Lively, Associate Environmental Specialist – Winchester Ammunition

Contact Email Address: gajoehl@olin.com and tjlively@olin.com

Purpose of Inspection: Clean Air Act Inspection

Facility Type: Ammunition manufacturer.

Regulations Central to Inspection: The Illinois State Implementation Plan (SIP).

Arrival Time: 2:07 pm

Departure Time: ~3:30 pm

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 Troy Lively unless otherwise noted.

Process Description:

The company primarily manufactures lead shot at its Shot Tower Operation and manufactures other components of small ammunition and explosives in the rest of the facility.

TOUR INFORMATION

EPA Tour of the Facility: Yes

Data Collected and Observations:

EPA inspectors met with plant environmental managers, Lively and Joehl at the plant entrance gate and primarily focused on inspecting the Shot Tower Operation. The Shot Tower has three lead melt kettles (LK-1, LK-2 and LK-3). All three kettles are controlled by a common baghouse with 3 separate hoods. The lower billet melt kettle (LK-4) and buckshot hot tumbling system has only been operated a couple times this year and was not operating during the inspection. Emissions from LK-4 are controlled by a baghouse with a HEPA filter. Winchester's "Centerfire" operation moved from the Alton, Illinois facility to Oxford, Mississippi in or around 2010 and hence the LK-4 kettle is now only rarely operated. The shot dryer is controlled by a rotoclone, a baghouse is not feasible due to moisture in the process, the outside structure of the rotoclone appeared to be in poor condition but operational. The shots are comprised of lead with antimony and arsenic added. The kettles are the only metal, melt furnaces at this facility. Other operations at the facility involve the shaping of brass shell casings (cupping), primer assembly, ammunition testing, and some on-site package boilers for steam generation.

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

Field Measurements: were not taken during this inspection.

CLOSING CONFERENCE

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

Requested documents:

- Current copy of the Facility's Title V operating permit.

DIGITAL SIGNATURES

Report Author: ETHAN CHATFIELD Digitally signed by
ETHAN CHATFIELD
Date: 2022.08.03
16:37:41 -05'00'

Section Supervisor: Frank,
Nathan Digitally signed by Frank,
Nathan
Date: 2022.08.03
16:44:39 -05'00'

Facility Name: Olin Winchester

Facility Location: 427 North Shamrock Street, East Alton, Illinois

Date of Inspection: July 21, 2022

APPENDIX A: DIGITAL IMAGE LOG

1. Inspector Name: Ethan Chatfield	2. Archival Record Location: <i>See the ERC file</i>
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Image Number	File Name	Date and Time (incl. Time zone and DST)	Description of Image
1	IMG-0116.jpg	07/21/2022 14:41	LK-1, LK-2, LK-3, and LK-4 baghouse magnehelic and photohelic display. STBH-1