EPA United States Environmental Protection Agency

Region 6 - Enforcement & Compliance Assurance Division

INSPECTION REPORT

Inspection Date(s):	03/12/2025	
Media Program:	Water	
Regulatory Program(s)	CWA	
Company Name:	**GCC Rio Grande, Inc.**	
Facility Name:	**Tijeras Plant**	
Facility Physical Location:	11783 State Highway 337 South	
(city, state, zip code)	Tijeras, NM 87059	
Mailing address:	Post Office Box 100	
(city, state, zip code)	Tijeras, NM 87059	
County/Parish:	Bernalillo	
Facility Phone Number	505-286-6081	
Facility Contact:	Samantha Kretz	Environmental Manager- South Region
	skretz@gcc.com	
FRS Number:	110000600831	
Identification/Permit Number:	NM0000116	
Media Identifier Number:	N/A	
NAICS:	327310	
SIC:	3241	
Personnel participating in inspection:		
Samantha Kretz	GCC Rio Grande, Inc.	Environmental Manager-South Region
Miranda Moore	GCC Rio Grande, Inc	Environmental Engineer
David A Esparza, P.E.	USEPA/ECDWM	Environmental Engineer
EPA Lead Inspector Signature/Date	DAVID ESPARZA Digitally signed by DAVID ESPARZA Date: 2025.04.08 16:32:09 -06'00'	
	David Esparza	Date
Supervisor Signature/Date	ROBERTO BERNIER Digitally signed by ROBERTO BERNIER Date: 2025.04.09 07:13:47 -05'00'	
	Roberto Bernier	Date

Section I – INTRODUCTION

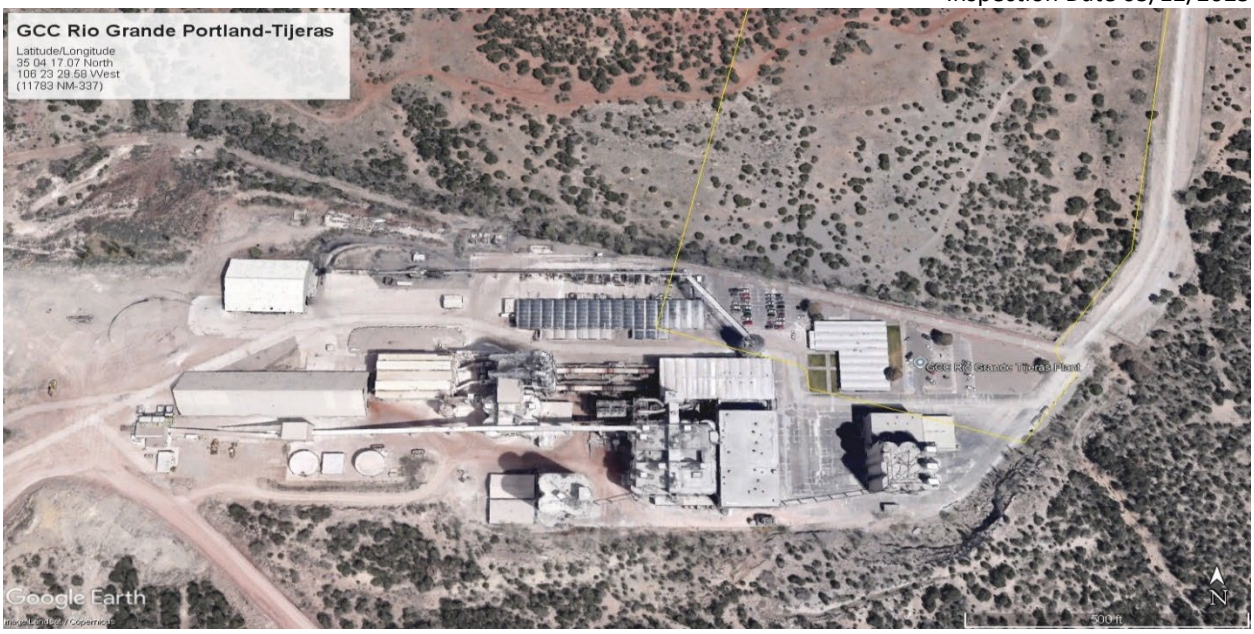
PURPOSE OF THE INSPECTION

United States Environmental Protection Agency (EPA) Region 6 inspector David Esparza, PE, arrived at the Grupo Cementos de Chihuahua (GCC)-Rio Grande Portland-Tijeras Plant (Rio Grande Portland) at approximately 0930 AM on March 12, 2025, for an unannounced inspection. I presented my credentials to Ms. Samantha Kretz, Environmental Manager-South Region and Ms. Miranda Moore, Environmental Engineer and informed them that this was an EPA inspection to determine the facility's compliance under the Clean Water Act (CWA) and the requirements of the National Pollutant Discharge Elimination System (NPDES) permit program, in accordance with the CWA. The generation of this report is based on information supplied by Rio Grande Portland representatives, observations made by the EPA inspector, NMED and records and reports maintained by the permittee (Rio Grande Portland), and the EPA. Before leaving the facility on March 12, 2025, an exit briefing was held with Ms. Kretz and Ms. Moore to explain areas of concern noted at the time of the inspection.

FACILITY DESCRIPTION

Rio Grande Portland owns and operates the Tijeras Mine and Mill consisting of a Portland cement plant and multiple open pit limestone quarries. The facility operations are in Bernalillo County in the East Mountain area approximately fifteen miles east of Albuquerque, New Mexico, near the Village of Tijeras. at 11783 State Highway 337 on approximately 2,100-acres (depicted in Aerial Image #1 below). The site is bordered on the west and east by U.S. Forest Service land within the Cibola National Forest. The U.S. Department of Energy also owns land adjacent to the southern boundary. The site is bordered by private land on the north and east. The mine and mill have been in operation since 1959. Ideal Basic Industries began construction and development of the site in 1958. Holnam, Inc. acquired the property and its operations in 1990. In 1995, GCC-Rio Grande purchased the site and the facility.

Currently Outfall 001 is the only permitted discharge utilized for stormwater runoffs from quarry, storage and production areas, cooling and/or cleaning water, and well water. In the event of a discharge occuring, the surface flows would traverse into unclassified reaches of Corral Canyon, thence to Tijeras Canyon, thence to a classified reach of the Rio Grande.



Aerial Image #1- Overall view of the GCC Rio Grande Portland- Tijeras Plant. Aerial from Google Earth

Treatment Scheme/Process

The predominant raw material used in the process is limestone, which is extracted from a quarry adjacent to the plant. Other raw materials, including silica, alumina, and iron are transported to the site via truck. Raw milling involves mixing and grinding the raw materials to provide the kiln feed with the correct chemical and physical properties. The milling ensures optimal fuel efficiency in the cement kiln and strength in the final concrete product. The plant uses a dry milling process to prepare the kiln feed. This means that the materials are dried before or during the grinding process and no water is added. In Pyroprocessing (kilns), the raw materials are heated to produce Portland cement clinker. The kiln system consists of preheating, calcining (a process in which calcium oxide is formed), and burning (reaction of the oxides to form clinker). The clinker cooling operation recovers approximately 30% of kiln system heat, preserves product quality, and enables the cooled clinker to be handled by belt conveyors. The facility uses reciprocating grate coolers. Air sent through the clinker to cool it is directed to the rotary kiln where it nourishes fuel combustion. Conveyors then transfer the clinker to a covered storage pile until the product is moved to the finish mill.

Section II – OBSERVATIONS

I observed the following and the following information was provided and/or stated

- The facility maintains two (2) above-ground storage tanks (ASTs). These ASTs are double walled and situated within a containment vault.
- The earthen sediment pond capacity equates to an approximate 4M-gallons.
- Open flows/controlled discharges are to permitted Outfall 001. It was stated the last controlled discharge was circa August 2022.
- The facility does not perform analytical analysis on-site, but uses Eurofins Environment Testing to perform applicable analysis, in conjunction with Bio Aquatics Services.

- The facility had secure perimeter fencing; thus, limiting access. The overall operations and maintenance (O&M), and general facility housekeeping appeared to be in good order in the portions that were observed.

Section III – AREAS OF CONCERN

I observed no areas of concern at the time of the inspection

EPA Region 6 inspector David Esparza conducted a closing conference at Rio Grande Portland/Tijeras Plant at approximately 12:30 PM on March 12, 2025, for the inspection.

Section IV – FOLLOW UP

The following information was received by EPA on March 21, 2025, after exiting the Facility on March 12, 2025:

- Analytical results
- Facility site layout and maps with descriptions.

Section V – LIST OF APPENDICES

Appendix 1 – Photo Log – 3 photos taken 3/12/25
Appendix 2 – Tijeras Plant Building General Layout
Appendix 3 – Overall Tijeras Facility Site Map

Appendix 1

Photograph Log

UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 1

Location: GCC-Rio Grande Portland- Tijeras Plant		
City: Tijeras	County/Parish: Bernalillo	State: New Mexico

View of 4M-gallon earthen sediment pond looking approximately Southeast. (IMG_0276). (Photographed 03/12/2025: 10:48 AM) Photographed by D. Esparza.

UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 2

Location: GCC-Rio Grande Portland- Tijeras Plant		
City: Tijeras	County/Parish: Bernalillo	State: New Mexico

Another view of the 4m-gallon earthen sediment pond looking approximately Northeast towards Interstate-40 (I-40). (IMG_0277). (Photographed 03/12/2025: 10:48 AM) Photographed by D. Esparza

UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 3

Location: GCC-Rio Grande Portland- Tijeras Plant		
City: Tijeras	County/Parish: Bernalillo	State: New Mexico

View of the 4M-gallon earthen sediment pond looking approximately Southwest. (IMG_0278). (Photographed 03/12/2025: 10:52 AM) Photographed by D. Esparza

UNITED STATES ENVIRONMENTAL PROTECTION AGENCY

Photograph Log

Photo No. 4

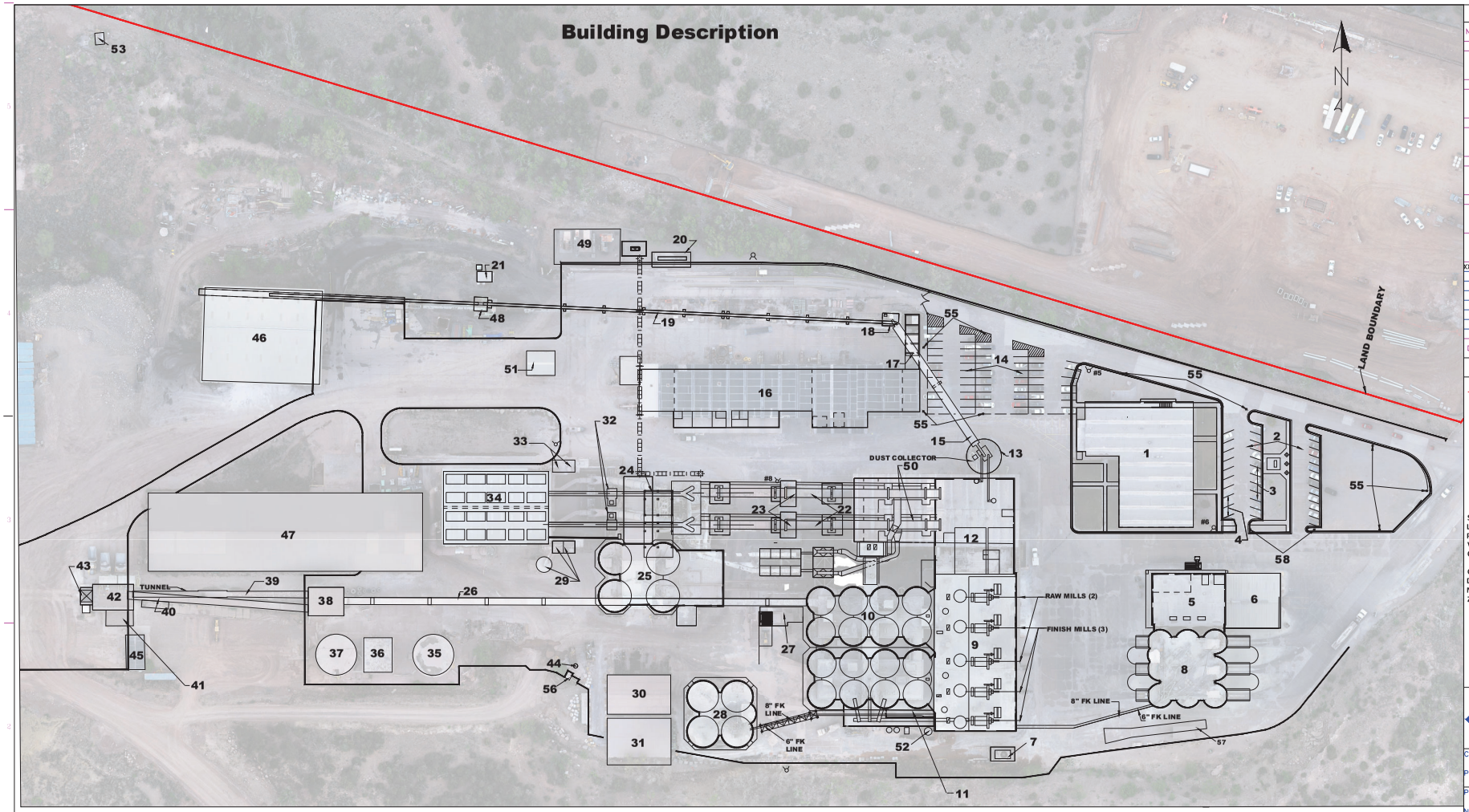
Location: GCC-Rio Grande Portland- Tijeras Plant		
City: Tijeras	County/Parish: Bernalillo	State: New Mexico

View from the berm of the 4M-gallon earthen sediment pond looking approximately Northeast towards Outfall 001 and I-40. (IMG_0279). (Photographed 03/12/2025: 10:53 AM) Photographed by D. Esparza

Appendix 2

Tijeras Plant
Building
General Layout

Building Description



1 Laboratory and Offices, **18,620.74 ft²**
2 Employee Parking, **26 spaces, 9.74' each space.**
3 Visitor Parking, **4 spaces.**
4 Handicap Parking, **2 spaces.**
5 Packhouse Substation, **7,011.58** ft²
6 Sack Cement Storage, **4,959.40 ft²**
7 Cement Storage Silos, **8,853.29 ft²**
8 Pump House and Cooling Tower, **551.59 ft²**
9 Mill Building, **20,821.64 ft²**
10 Raw and Clinker Silos, **23,751.63 ft²**
11 Electrical Room, **2,366.07 ft²**
12 Control Room, **20,807.14 ft²**
13 Coal Silo, **1,560.68 ft²**
14 Employee Parking, **55 spaces, 9.22' each space.**
15 Belt Conveyor "C", **1,938.36 ft²**
16 Maintance Building, **23,440.00 ft²**
17 Scrap Metal Bins, **866.12 ft²**
18 Transfer Tower, **315.77 ft²**
19 Belt Conveyor "B", **2,586.58 ft²**
20 Gas Meter
21 Electrical Sub Estation, **303.85 ft²**
22 Kilns
23 Dual Drives, **660 ft² each one**
24 Kiln Feed Building
25 Blending Silos, **12,472.23 ft²**
26 Limestone Transport Belt Conveyor, **5,297.80 ft²**
27 Additive System, **1,231.08 ft²**
28 Cements Storage Silos, **6,238.47 ft²**
29 Dust Bins, **753.74 ft²**
30 Storage Building, **4,063.18 ft²**
31 Warehouse Building, **4,841.86 ft²**
32 Kilin ID Fan, **259.02 ft² each one**
33 Dust Bins, **440.26 ft²**
34 Kiln Dust Bag Houses, **12,372.06 ft²**
35 Tank (Empty), **2,153.02 ft²**
36 Water Pump House, **1,597.09 ft²**
37 Water Tank, **2,153.02 ft²**
38 Screen Building, **1,647.01 ft²**
39 Primary Belt, **1,780.22 ft²**
40 Secondary Belt, **2,152.63 ft²**
41 Crusher Substation, **702.21 ft²**
42 Crusher Building, **1,714.14 ft²**
43 Dump Hopper, **342.88 ft²**
44 Well No.2
45 Quarry Office, **1,055.40 ft²**
46 Coal Storage Building, **17,793.03 ft²**
47 Covered storage Area, **34,923.83 ft²**
48 Crusher, **302.12 ft²**
49 Public Service Substation
50 Clinker Coolers.
51 Diesel #2, **1,140.66 ft²**
52 Cooling Water Sump.
53 Well No.1
54 Well No.3
55 Lighting
56 Pump House, **71.71 ft²**
57 Truck Scale, **1632.92 ft²**

SCALE
0 120 240 Feet

REVISIONS

No.	DATE	DESCRIPTION	BY
1	1/27/25	PLACEMENT OF AREAS	MTH

XXX-XX-XXX --------

DWG. No. TITLE

DRAWING SYMBOLOGY

— — — LAND BOUNDARY

NOTE:

SATELITE IMAGE IS REPRESENTATIVE, LAYOUT IS FOR REFERANCE AND PROPERTY SURVAY DATED ON 1994 BY VLADIMIR JIRIK SHOULD BE USED FOR OFFICIAL PROPERTY BOUNDARIES.

GNSS TOPOGRAPHIC SURVEY AND DRONE IMAGES ARE REFERENCED TO A NAD83 (2011) NEW MEXICO CENTRAL ZONE US FOOT COORDINATE SYSTEM.

GCC Rio Grande — TIJERAS PLANT — GCC of America

COMPANY: GCC RIO GRANDE
PLANT: TIJERAS
PROJECT No.:
NAME:
TITLE:

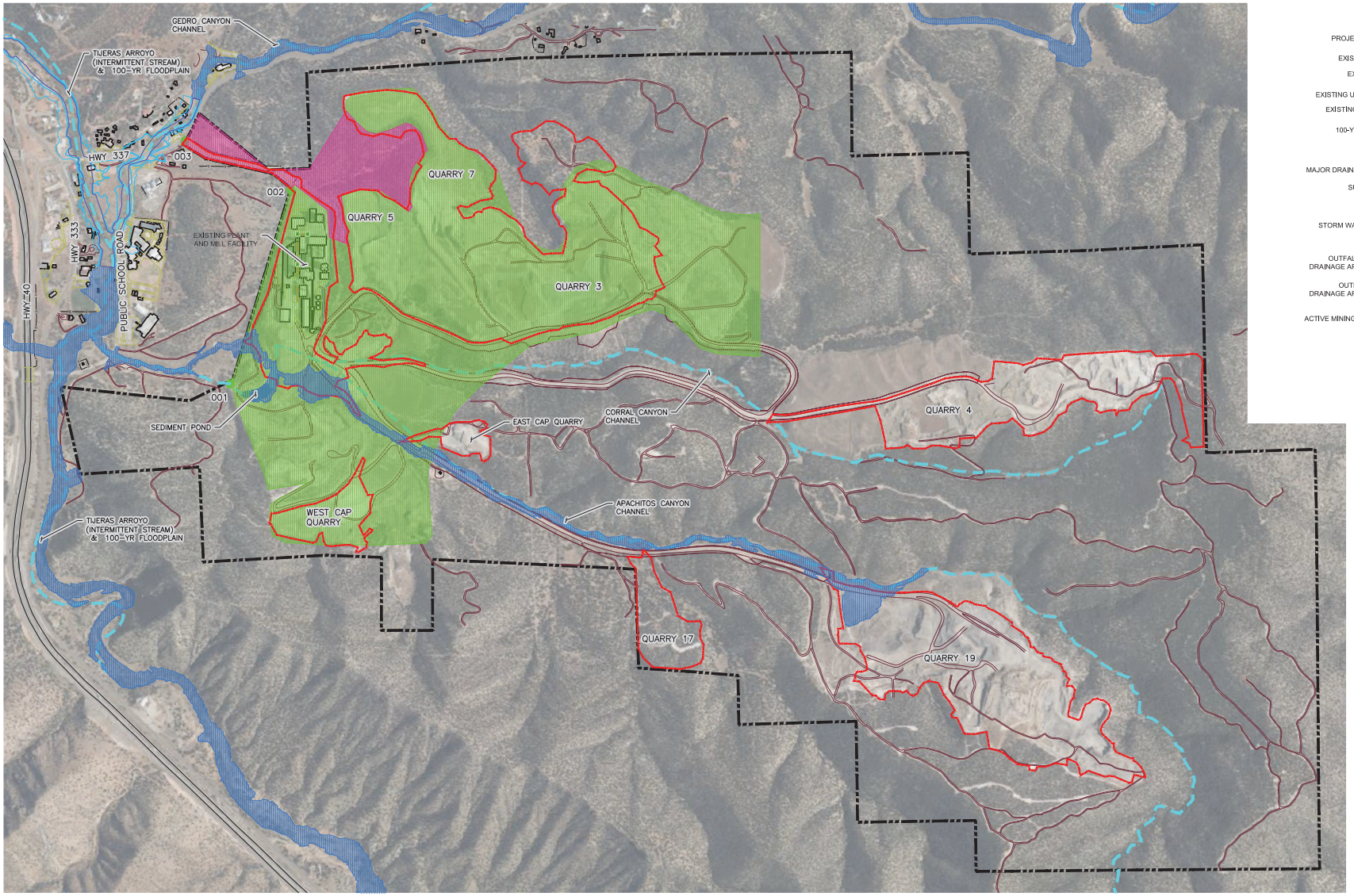
GCC RIO GRANDE
TIJERAS PLANT
GENERAL LAYOUT

DRAWN: M.A.T.H	DATE: FEB/25/2025
CHECKED: M.P.L.	DATE: FEB/25/2025
APPROVED: R.O.R.	DATE: FEB/25/2025
UNIT: FT	SHEET 2 OF 5

DWG. No. FILE: C101S1852-100-01-01.dwg REV.
C101S1852-100-01-02 D

Appendix 3

Overall
Tijeras
Facility Site Map



LEGEND

- PROJECT BOUNDARY
- EXISTING BUILDING
- EXISTING FENCE
- EXISTING UNPAVED ROAD
- EXISTING PAVED ROAD
- 100-YR FLOODPLAIN
- WATER
- MAJOR DRAINAGE CHANNEL
- SURFACE FLOW
- STORM DRAIN
- STORM WATER OUTFALL
- CULVERT
- OUTFALL 001 (NPDES) DRAINAGE AREA (APPROX.)
- OUTFALL 002 & 003 DRAINAGE AREA (APPROX.)
- ACTIVE MINING OPERATIONS

GENERAL NOTES:

1. THIS PLAN SHEET IS INTENDED TO SHOW THE APPROXIMATE DRAINAGE BASIN AREAS FOR EACH OUTFALL LOCATION, AS DEFINED IN THE APPROVED STORMWATER POLLUTION PREVENTION PLAN (SWPPP) FOR THE SITE, DATED JULY, 2024.
2. STORMWATER RUNOFF IN THE SOUTH QUARRY AREAS REMAIN WITHIN THE QUARRY FOR EVAPORATION / INFILTRATION VIA STORMWATER CONTROL MEASURES (PERIMETER BERMING AND TOPOGRAPHY GRADING/SLOPING).
3. STORMWATER RUNOFF IN THE NORTH QUARRY AREA TYPICALLY REMAINS WITHIN THE QUARRY FOR EVAPORATION / INFILTRATION VIA STORMWATER CONTROL MEASURES (PERIMETER BERMING AND TOPOGRAPHY GRADING/SLOPING). ANY STORMWATER RUNOFF FROM THE NORTH QUARRY ACCESS ROADS FLOWING NORTH INTO THE PLANT AREA IS DIRECTED TOWARDS NPDES OUTFALL 001 VIA STORMWATER CONTROL MEASURES (BERMING, GRADING, EARTHEN SWALES AND/OR ESTABLISHED VEGETATION)
4. OUTFALL 002 DRAINAGE AREA = 33 ACRES (APPROX.)
5. OUTFALL 003 DRAINAGE AREA = 8.3 ACRES (APPROX.)
6. THE TIJERAS ARROYO FLOODPLAIN HAS BEEN SHOWN FOR REFERENCE. THE TIJERAS ARROYO IS AN INTERMITTENT STREAM AND THE FLOODPLAIN IMPACTS TO THIS SITE ARE MINIMAL DUE TO BACKFLOW CONDITIONS.
7. NO SITE RUNOFF DIRECTLY FLOWS INTO THE ARROYO OR MAJOR CHANNELS FLOWING THROUGH THE PROJECT SITE. ANY RUNOFF THAT IS NOT INFILTRATED WITHIN THE QUARRIES THEMSELVES IS ROUTED TOWARDS THE SEDIMENT POND AND DRAINAGE OUTFALL 001 THROUGH THE USE OF ROADSIDE DIVERSION BERMS.

JEREMY J. GANNT — NEW MEXICO — 30090 — PROFESSIONAL ENGINEER — 2/21/25

1 - PLAN: OVERALL SITE PLAN

0 600 1200

SCALE IN FEET

PRELIMINARY DRAFT
NOT FOR CONSTRUCTION

NO.	BY	CHK	APP.	DATE	REVISION DESCRIPTION

REVIEW	11/22/24	2/7/25	2/21/25					
30% DESIGN								
90% DESIGN								
CONSTRUCTION								
RECORD								
RELEASED TO/FOR	A	B	C	D	0	1	2	
DATE RELEASED								

BARR

Project Office:
BARR ENGINEERING CO.
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Fax: (952) 832-2601
www.barr.com

Corporate Headquarters:
Minneapolis, Minnesota
Ph: 1-800-632-2277

Scale	AS SHOWN
Date	11/20/2024
Drawn	AAB
Checked	JJG
Designed	BARR
Approved	-

GCC RIO GRANDE, INC.
GLENDALE, CO

TIJERAS MINE MILL
BERNALILLO COUNTY, NEW MEXICO

DRAINAGE AND GRADING PLAN SUBMITTAL
DRAINAGE BASIN MAP

BARR PROJECT No. 31/01-1007.02
CLIENT PROJECT No. -
DWG. No. C3
REV. No.

CADD USER: Jeremy J. Gannt // FILE: M:\DESIGN\31\01007.02\GCC TIJERAS MINE - C3 - DRAINAGE.DWG PLOT SCALE: 1:1 PLOT DATE: 2/22/2025 3:44 PM
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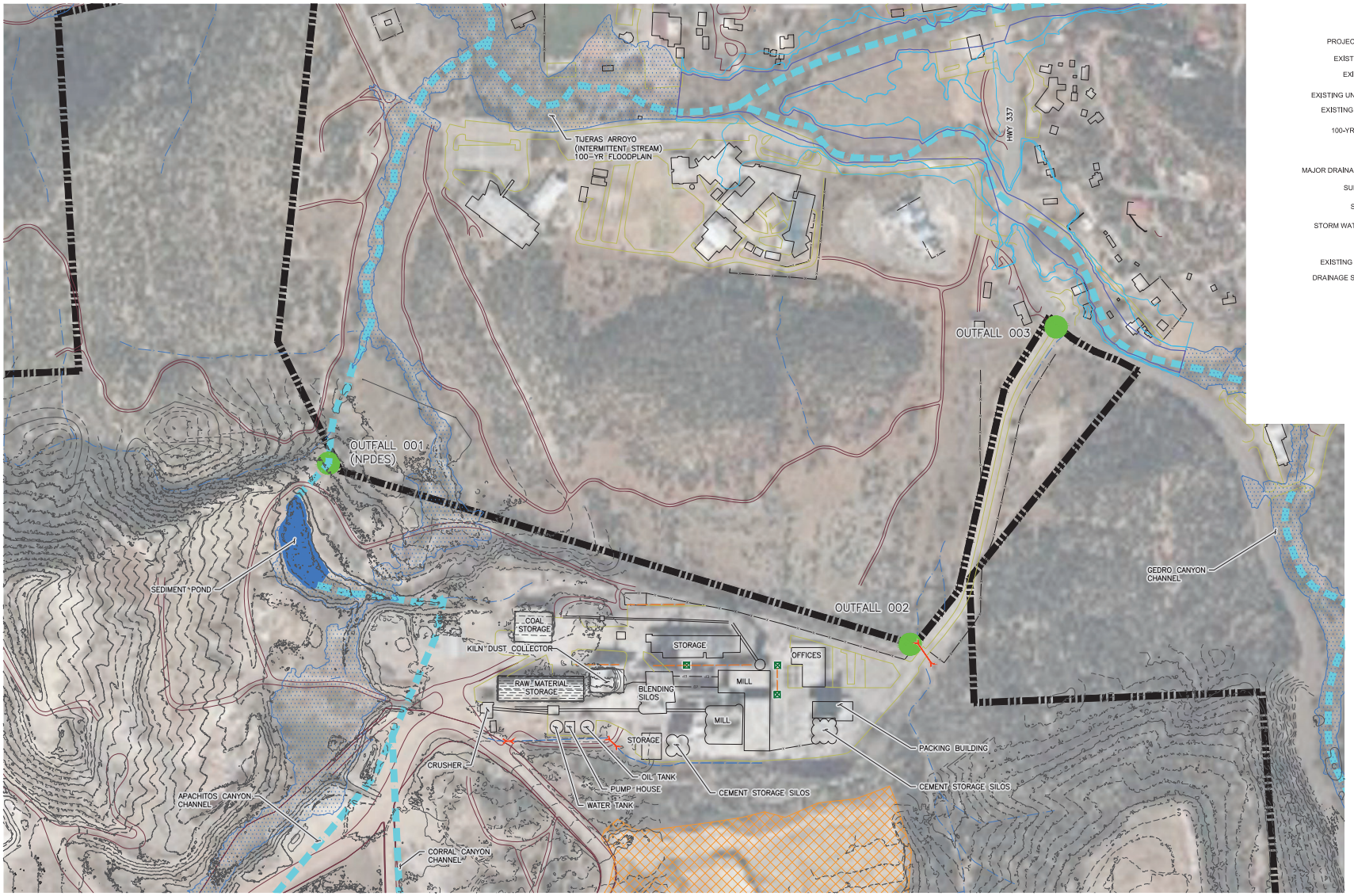

LEGEND

- PROJECT BOUNDARY
- EXISTING BUILDING
- EXISTING FENCE
- EXISTING UNPAVED ROAD
- EXISTING PAVED ROAD
- 100-YR FLOODPLAIN
- WATER
- MAJOR DRAINAGE CHANNEL
- SURFACE FLOW
- STORM DRAIN
- STORM WATER OUTFALL
- CULVERT
- EXISTING 10' CONTOUR
- DRAINAGE SWALE/CREEK

GENERAL NOTES:

1. THIS PLAN SHEET IS INTENDED TO SHOW DRAINAGE OUTFALL LOCATIONS FROM THE SITE PER THE SITE NPDES PERMIT (NM0000116) AND THE SITE SPECIFIC STORMWATER POLLUTION PREVENTION PLAN (SWPPP) DATED JULY 2024.
2. NO IMPROVEMENTS OR NEW DISTURBED AREAS ARE PROPOSED WITH THIS SUBMITTAL.
3. OUTFALL 001 IS AUTHORIZED TO DISCHARGE STORMWATER RUNOFF COMMINGLED WITH ONCE-THROUGH COOLING WATER AND COOLING TOWER BLOWDOWN VIA NPDES INDIVIDUAL PERMIT NO. NM0000116. THE STORMWATER BMPS ASSOCIATED WITH SURFACE RUNOFF DRAINAGE TO OUTFALL 001 ARE INSPECTED, MAINTAINED, AND MANAGED WITH THE STORMWATER BMPS WITHIN THE SITE SWPPP.
4. OUTFALL 002
   - RECEIVING SURFACE WATER: UNNAMED TRIBUTARY TO TIJERAS CREEK / ARROYO
   - DRAINAGE AREA: 33 ACRES
   - TYPE OF DISCHARGE: CONCENTRATED
   - ASSOCIATED CONTROL MEASURES
     - EARTHEN DRAINAGE SWALE
     - ESTABLISHED VEGETATION
     - ROUTINE INSPECTION
4. OUTFALL 003
   - RECEIVING SURFACE WATER: UNNAMED TRIBUTARY TO TIJERAS CREEK / ARROYO
   - DRAINAGE AREA: 8.3 ACRES
   - TYPE OF DISCHARGE: CONCENTRATED
   - ASSOCIATED CONTROL MEASURES
     - EARTHEN DRAINAGE SWALE
     - ROCK RIP-RAP PRIOR TO ENTRANCE
     - ESTABLISHED VEGETATION
     - ROUTINE INSPECTION
5. THE TIJERAS ARROYO FLOODPLAIN HAS BEEN SHOWN FOR REFERENCE. THE TIJERAS ARROYO IS AN INTERMITTENT STREAM AND THE FLOODPLAIN IMPACTS TO THIS SITE ARE MINIMAL DUE TO BACKFLOW CONDITIONS.
7. NO SITE RUNOFF DIRECTLY FLOWS INTO THE ARROYO OR MAJOR CHANNELS FLOWING THROUGH THE PROJECT SITE. ANY RUNOFF THAT IS NOT INFILTRATED WITHIN THE QUARRIES THEMSELVES IS ROUTED TOWARDS THE SEDIMENT POND AND DRAINAGE OUTFALL 001 THROUGH THE USE OF ROADSIDE DIVERSION BERMS.

JEREMY J. GARCIA — NEW MEXICO — 30090 — PROFESSIONAL ENGINEER — 2/21/25

PRELIMINARY DRAFT
NOT FOR CONSTRUCTION

1 - PLAN: OVERALL SITE PLAN
0 200 400
SCALE IN FEET

N

NO.	BY	CHK	APP.	DATE	REVISION DESCRIPTION

	11/22/24	2/7/25	2/21/25				
REVIEW							
30% DESIGN							
90% DESIGN							
CONSTRUCTION							
RECORD							
RELEASED TO/FOR	A	B	C	D	0	1	2
DATE RELEASED							

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Minneapolis, Minnesota
Ph: 1-800-632-2277

Scale	AS SHOWN
Date	11/20/2024
Drawn	AAB
Checked	JJG
Designed	BARR
Approved	-

GCC RIO GRANDE, INC.
GLENDALE, CO

TIJERAS MINE MILL
BERNALILLO COUNTY, NEW MEXICO

DRAINAGE AND GRADING PLAN SUBMITTAL
DETAILED OUTFALL MAP

BARR PROJECT No.	31/01-1007.02
CLIENT PROJECT No.	-
DWG. No.	C4
REV. No.	

CADD USER: Jeremy J. Garcia // E:\E: M:\DESIGN\31\01007.02\GCC TIJERAS MINE - C4 - OUTFALL MAP.DWG PLOT SCALE: 1:1 PLOT DATE: 2/22/2025 3:54 PM
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