

## AMENDMENT TO AIR QUALITY PERMIT

**Permit Amendment No.**  
**2631-051-0010-E-03-1**

**Effective Date of Amendment**  
**Nov 26, 2001**

In accordance with The Georgia Air Quality Act, O.C.G.A. Section 12-9-1, et seq and the Rules, Chapter 391-3-1, adopted pursuant to or in effect under that Act, Permit No. 2631-051-0010-E-03-0 issued on October 18, 2000 to:

**Willamette Industries, Inc. Port Wentworth Mill**  
P.O. Box 668  
Savannah, GA 31402

**Facility Location:** 1 Bonnybridge Road  
Port Wentworth, Georgia (Chatham County)

for the following: The operation of a Kraft Pulp Mill that produces 1200 ADTP Bleached Market Pulp, including the No. 4 Power Boiler, the No. 3 Recovery Boiler, the No. 3 Smelt Tank, the No. 2 Lime Kiln, a Bleach Plant, a Chlorine Dioxide Plant, and a Kamyr Continuous Digester. The construction and operation of low solids digester cooking, various pump upgrades and piping modifications, an oxygen delignification system, additional D2 bleaching stage, replacement washer for the Ep bleaching stage, ClO2 plant upgrades (reboiler and condenser replacement, additional salt cake filter and chiller), additional pulp drying capacity, and additional handling capacity.

is hereby amended as follows: Modification to the No. 3 Evaporator line through the addition of a new concentrator, permanent shutdown of the No. 2 Evaporator line. Replacement of Lime Kiln Scrubber with an ESP. Conditions 21(b), 29b & d are modified. Conditions 52 through 54 are added.

Reason for Amendment: Pollution Control Project Application 13080 dated May 2001, modeling analysis dated July 2001 and SIP Application 13153, dated July 2001.

This Permit is further subject to and conditioned upon the terms, conditions, limitations, standards, or schedules contained in or specified on the attached 1 page(s), which page is part of this Amendment.

This Permit Amendment is effective from the date first above written and is hereby made a part of Permit No. 2631-051-0010-E-03-0 and compliance herewith is hereby ordered. Except as amended hereby, the above referenced Permit remains in full force and effect.

---

Director  
Environmental protection Division

**State of Georgia  
Department of Natural Resources  
Environmental Protection Division**

**Permit Amendment No.  
2631-051-0010-E-03-1**

**Page 1 of 1**

**Monitoring Requirements (modified)**

21. The Permittee shall install calibrate, maintain and operate the following continuous emissions monitoring systems or monitoring devices:
- (b) The No. 2 Lime Kiln – continuous emission monitoring systems to measure and record the TRS concentration and oxygen concentration of the flue gas; and monitoring devices to measure and record the secondary current and secondary voltage for each electrical isolatable section (bus section) of the electrostatic precipitator for the No. 2 Lime Kiln. Data shall be recorded once per shift of operation. The total power for each precipitator shall be determined and recorded from the secondary parameters no less than once per shift of operation.

**Process and Control Equipment (modified)**

29. The following air pollution control equipment shall be operational and maintained within normal operating parameters at all times:
- b. Lime Kiln ESP – for the No. 2 Lime Kiln
  - d. Noncondensable Gas System – for the Continuous Digesters, Blow Tanks A and B and the #3 Evaporator Set and associated concentrator.

**Special Conditions (new)**

52. The Permittee shall collect the HVLC gases from the pulp washing system (KD03), the knoter and screening units (KD04), the decker (KD05), the weak liquor storage tanks (WS01), the intermediate liquor storage tank (ILST), the 70% (strong) liquor storage tank (SLST), the salt cake mix tank (SCMT), the unscreened stock tanks (USST) and the blow tank (BLOW) and route the gases to the Recovery Furnace for incineration.
53. The Permittee may route the gases from condition 52 to the #4 Power Boiler (also known as #4 Combination Boiler) as a back-up incineration device when the recovery boiler is not operating or during a malfunction event.
54. The Permittee shall notify the Division in writing within 15 days of completion of each individual project (HVLC Project, Lime Kiln Project & # 3 Evaporator).