



ARKANSAS
Department of Environmental Quality

SCANNED

MAR 13 2014

MAR 13 2014

Dave Kaufman
Engineering Manager
Kimberly-Clark Corporation (Maumelle Facility)
500 Murphy Drive
Maumelle, AR 72113

Dear Mr. Kaufman:

The enclosed Permit No. 1306-AR-11 is your authority to construct, operate, and maintain the equipment and/or control apparatus as set forth in your application initially received on 11/6/2013.

After considering the facts and requirements of A.C.A. §8-4-101 et seq., and implementing regulations, I have determined that Permit No. 1306-AR-11 for the construction, operation and maintenance of an air pollution control system for Kimberly-Clark Corporation (Maumelle Facility) to be issued and effective on the date specified in the permit, unless a Commission review has been properly requested under Arkansas Department of Pollution Control & Ecology Commission's Administrative Procedures, Regulation 8, within thirty (30) days after service of this decision.

The applicant or permittee and any other person submitting public comments on the record may request an adjudicatory hearing and Commission review of the final permitting decisions as provided under Chapter Six of Regulation No. 8, Administrative Procedures, Arkansas Pollution Control and Ecology Commission. Such a request shall be in the form and manner required by Regulation 8.603, including filing a written Request for Hearing with the APC&E Commission Secretary at 101 E. Capitol Ave., Suite 205, Little Rock, Arkansas 72201. If you have any questions about filing the request, please call the Commission at 501-682-7890.

Sincerely,

Mike Bates
Chief, Air Division

Enclosure

RESPONSE TO COMMENTS
KIMBERLY-CLARK CORPORATION (MAUMELLE FACILITY)
PERMIT #1306-AR-11

AFIN: 60-00915

Written comments on the draft permitting decision were submitted Patrick Brodsky of the Kimberly-Clark Corporation on behalf of the facility. The Department's response to these issues follows.

Note: The following page numbers and condition numbers refer to the draft permit. These references may have changed in the final permit based on changes made during the comment period.

Comment #1:

Specific Condition 2,
NPS-2 solution emission limits not shown in the table.

Response to Comment #1:

The application did not list any Hazardous Air Pollutants (HAPs) or other non-criteria pollutants that needed to be included in Specific Condition 2.

Comment #5:

Statement of Basis Section #16. Recordkeeping Requirements
The word Product in the first line of the table should be changed to Polymer.

Response to Comment #5:

The SOB was updated.

Comment #3:

Specific Condition 6, second sentence should read:
Compliance with this condition will be demonstrated by compliance with Specific Condition #7.

Response to Comment #3:

The sentence has been deleted. Specific Condition #7 covers the recordkeeping requirement.

Comment #4:

Statement of Basis Section #13. Calculations
The equation for NPS-2 is missing a subscript i after AP. This was a typo in the permit application and follow up email. The equation should read:

$$E_{n-i} = M_i K_i A P_i^{\text{sat}} / RT_L$$

The line in the calculations table with the value for P_i^{sat} should be changed to reflect P_i^{sat} for the 2-phenoxy and the 1,2-Octanediol.

Response to Comment #4:

The SOB was updated.

Comment #5:

Permit Flexibility:

In an effort to provide some flexibility in the permit and reduce the permitting burden for future solution formulation changes I respectfully request the following changes to the permit language:

Remove the limit on VOC concentration for NPS-2 (0.0055 lbs per pound) and use only the VOC emission limit from permit 1306-AR-10 (1.0 lbs/hr and 4.4 tpy).

The need for a permit change would be required if the HAPs material changed AND/OR the calculated VOC emissions exceeded the limits. The concentration of existing VOC materials could change without the need for a new permit as long as the calculated VOC emissions did not exceed the permit limit. The calculated VOC emissions from NPS-2 formulations would be based on application of the volatilization formula (EIIP, Volume II, Chap. 16, Eq. 3-24) used in permit 1306-AR-11.

Response to Comment #5:

See response to comment #10.

Comment #6:

Process Description

Paragraph 1: last sentence should read: Coform 2 consists of four coform banks. (the elastomer banks and the point sources attached to them – SN-16, SN-17 and SN-18 – were removed from service in 2009)

Paragraph 7: The elastomer section on coform 2 ...Remove paragraph entirely

Response to Comment #6:

The permit was updated.

Comment #7:

Specific Conditions:

All paragraphs: Changed the word “will” to “shall” for consistency

Paragraph #2: Remove from table SN16, 17, & 18 and associated info. Reduce the totals for PM/PM10 and VOC in the table under Total Allowable Emissions

Paragraph #8, #10, and #11:

Removed sentence; Compliance with ... redundant with paragraph 9 and 12

Response to Comment #7:

The permit was updated.

Comment #8:

Statement of Basis:

Remove references to SN 16, 17, and 18

Response to Comment #8:

The SOB was updated.

Comment #9:

Fee Calculation:

Update PM/PM10 and VOC values per the edits above

Response to Comment #9:

The fee sheet, permit, and SOB were updated to reflect the changes in emissions.

Comment #10:

Add NPS solution as A-9 insignificant activity and remove the conditions.

Response to Comment #10:

The permit was updated to reflect this change since the solution is 0.6% VOC by weight.

ADEQ MINOR SOURCE AIR PERMIT


Permit No. : 1306-AR-11

IS ISSUED TO:

Kimberly-Clark Corporation (Maumelle Facility)
500 Murphy Drive
Maumelle, AR 72113
Pulaski County
AFIN: 60-00915

THIS PERMIT IS THE ABOVE REFERENCED PERMITTEE'S AUTHORITY TO CONSTRUCT, MODIFY, OPERATE, AND/OR MAINTAIN THE EQUIPMENT AND/OR FACILITY IN THE MANNER AS SET FORTH IN THE DEPARTMENT'S MINOR SOURCE AIR PERMIT AND THE APPLICATION. THIS PERMIT IS ISSUED PURSUANT TO THE PROVISIONS OF THE ARKANSAS WATER AND AIR POLLUTION CONTROL ACT (ARK. CODE ANN. SEC. 8-4-101 *ET SEQ.*) AND THE REGULATIONS PROMULGATED THEREUNDER, AND IS SUBJECT TO ALL LIMITS AND CONDITIONS CONTAINED HEREIN.

Signed:


Mike Bates
Chief, Air Division

MAR 13 2014

Date

Kimberly-Clark Corporation (Maumelle Facility)
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Kimberly-Clark Corporation (Maumelle Facility)
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List of Acronyms and Abbreviations

A.C.A.	Arkansas Code Annotated
AFIN	ADEQ Facility Identification Number
CFR	Code of Federal Regulations
CO	Carbon Monoxide
HAP	Hazardous Air Pollutant
lb/hr	Pound Per Hour
No.	Number
NO _x	Nitrogen Oxide
PM	Particulate Matter
PM ₁₀	Particulate Matter Smaller Than Ten Microns
SO ₂	Sulfur Dioxide
Tpy	Tons Per Year
UTM	Universal Transverse Mercator
VOC	Volatile Organic Compound

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Section I: FACILITY INFORMATION

PERMITTEE: Kimberly-Clark Corporation (Maumelle Facility)
AFIN: 60-00915
PERMIT NUMBER: 1306-AR-11
FACILITY ADDRESS: 500 Murphy Drive
Maumelle, AR 72113
MAILING ADDRESS: 500 Murphy Drive
Maumelle, AR 72113
COUNTY: Pulaski County
CONTACT NAME: Dave Kaufman
CONTACT POSITION: Engineering Manager
TELEPHONE NUMBER: 501-212-2241
REVIEWING ENGINEER: Adam McDaniel
UTM North South (Y): Zone 15: 3858201.89 m
UTM East West (X): Zone 15: 555291.89 m

Section II: INTRODUCTION

Summary of Permit Activity

Kimberly-Clark Corporation owns and operates an infant care product manufacturing facility (NAICS 313230) located at 500 Murphy Drive in Maumelle, AR. Kimberly-Clark requested a de minimis modification to use a new solution for Wet Wipes Converting (NPS-1 and NPS-2) with a VOC concentration of 0.6% by weight as an Insignificant Activity A-9. Also, SN-16, SN-17, and SN-18 were removed from service in 2009 and were removed from the permit. The total annual permitted emission rate limit changes associated with this modification includes: -6.2 tpy PM/PM₁₀, -22.3 tpy VOC, and the removal of any permitted HAPs.

Process Description

There are two non-woven manufacturing processes formulating baby wet wipes at the Kimberly-Clark facility: Coform 1 and Coform 2. Coform 1 consists of three coform banks. Coform 2 consists of four coform banks.

In each of the seven coform banks on Coform 1 and Coform 2, two air streams are mixed in each bank. One air stream contains polymer pellets that are melted and extruded into microfiber-sized filaments through two dies and met with a hot air stream, heated by Process Air Heaters (SN-05, SN-12, and SN-19). Approximately once per week, the dies are removed and cleaned through the Equipment Cleaning Processes (SN-20), an Insignificant Activity. The other air stream contains fiberized wood pulp fiber. The mixed air streams are rapidly cooled with ambient air and a wetting agent (primarily water) causing re-solidification of the polymer filaments to form a composite web of intermixed polymer and wood pulp traveling on a moving screen (forming wire). On Coform 1, the finished web is then slit to size and wound on rolls for processing into the finished disposable products.

The air emissions that result from the nonwovens process consist of particulate matter and volatile organic compounds (VOCs). The particulate matter consists of polymer particles and wood pulp fiber particles that are entrained within the exhaust airflow, and hydrocarbon waxes that are condensed byproducts of the volatilization of polymer.

The VOC portion of the gas stream consists of volatilized polymer and its breakdown products produced from electrically heating the polymer pellets. Previous analysis at existing Kimberly-Clark operations has shown that the VOCs consist of saturated unreactive alkanes (C_nH_{2n+2}) which are volatile only because they are subjected to elevated process temperatures. To reduce VOC emissions, polymer use and melting temperature are minimized to ensure good product quality and limit the amount of polymer volatilized.

An exhaust unit located below the forming wire of each coform bank captures the bulk of the air emissions from each of the seven banks. Each of the three bank exhausts on Coform 1 are drawn through two drum filters operated in parallel. The two drum filters from each bank discharge through the existing stacks SN-06, SN-02, and SN-03, respectively. On Coform 1, an exhaust unit located above the forming wire captures the balance of the air emissions of the three banks and draws them through two drum filters operated in parallel. The two drum filters from the above-wire exhaust discharge through the existing stack SN-09.

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Each of the two existing coform banks on Coform 2 have one drum filter per bank and discharge the emissions through the stacks SN-10 and SN-11. The two additional coform banks on Coform 2 will have one drum filter per bank and discharge through the stacks SN-14 and SN-15.

Dust that builds up on the dirty side of the filter fabric of the twelve drum filters is vacuumed off by drum stripper fans and is sent to a final collector Mikro-pulsaire reverse pulse system baghouse for dust consolidation and disposal. Filtered air from the baghouse is discharged through stacks SN-07 and SN-13.

Dust collected on the outside of the bags of the baghouse is collected into a dust baler through a rotary airlock. The dust emissions from the dust baler will be reticulated into the below-wire exhausts.

Two housekeeping systems are used for general cleanup of polymer and wood pulp fiber. Each of the Vacuum Blowers has one baghouse per blower and filtered air from the baghouse is discharged through stacks SN-21 and SN-22. Building ambient air is provided by steam produced in the natural gas fired boiler (SN-08).

This permit includes two non-point sources of emissions, designated NPS-1 and NPS-2. These aqueous solutions are used to impregnate the wiping products to aid in cleansing. Most of the solvents incorporated in the solution are actually trapped in the sealed containers and not emitted from the facility. This is an A-9 insignificant activity.

Regulations

The following table contains the regulations applicable to this permit.

Regulations
Arkansas Air Pollution Control Code, Regulation 18, effective June 18, 2010
Regulations of the Arkansas Plan of Implementation for Air Pollution Control, Regulation 19, effective July 27, 2013

Total Allowable Emissions

The following table is a summary of emissions from the facility. This table, in itself, is not an enforceable condition of the permit.

TOTAL ALLOWABLE EMISSIONS		
Pollutant	Emission Rates	
	lb/hr	tpy
PM	4.9	19.8
PM ₁₀	4.9	19.8
SO ₂	0.4	0.4
VOC	22.8	98.2
CO	0.9	3.4
NO _x	1.6	6.9

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Section III: PERMIT HISTORY

Permit #1306-A, the initial permit for the facility, was issued on April 13, 1992.

Permit #1306-AR-1, issued on August 27, 1993, covered the addition of a new manufacturing line.

Permit #1306-AR-2 was issued on August 10, 1995. This permit covered the addition of a new process bank to the facility.

Permit #1306-AR-3 was issued on August 26, 1997. This permit allowed for the installation of a new source, SN-09, the usage of a new raw material and an increase in natural gas usage.

Permit #1306-AR-4 was issued on August 3, 1998. This permit allowed Kimberly-Clark flexibility in their permit limits and added a new nonwoven manufacturing process.

Permit #1306-AR-5 was issued on October 31, 2000. This permit was issued to add to the existing equipment an elastomer extrusion process and two additional polymer extrusion banks. The new sources were SN-14 and 15, the nonwoven process, both controlled by drum filters. Also, sources SN-16, 17, and 18 which account for emissions from the elastomer process were added. Sources SN-19 and SN-20, a process air heater and an equipment cleaning process, respectively were also added. Sources SN-21 and 22, vacuum blowers, were new equipment added in the modification. In addition to the new sources, the facility also modified the emissions for existing sources SN-04, 10, 11, and 13.

Permit #1306-AR-6 was issued on June 14, 2002. Kimberly-Clark requested modification of their permit to update VOC emission factors for source numbers SN-10, SN-11, SN-16, SN-17, and SN-18, reflecting VOC stack testing performed at the Maumelle facility the previous year. The facility reduced VOC emissions to 78.0 tpy. An administrative change to the permit language associated with Specific Condition #1 and Specific Condition #2 was made. The facility requested the inclusion of the phrase "Compliance with these limits shall be demonstrated by compliance with Specific Conditions 3-10."

Permit #1306-AR-7 was issued on April 13, 2004. This permit modification increased estimated stack emissions of VOCs, including trace amounts of HAPs, from identified point sources, bringing permitted VOC emissions up to 95.6 tpy from 78.9 tpy. These emissions are from waste material that is not shipped out as finished product. Total facility emissions were permitted at: 23.0 tpy of PM/PM₁₀, 0.4 tpy SO₂, 95.7 tpy VOC, 3.4 tpy CO, 6.9 NO_x, and 0.16 tpy Formaldehyde.

Permit #1306-AR-8 was issued on December 14, 2006. This permit modification changed the throughput rates of raw material and solution formulations and updated VOC emission data for the wet wipes manufacturing processes, NPS-1 and NPS-2. SN-04 was removed. Permitted emissions increases were: 1.0 tpy VOC, 0.12 tpy Formaldehyde, and 0.04 tpy Ethylene Oxide.

Permit #1306-AR-9 was issued on April 14, 2008. Kimberly-Clark was authorized to make changes to the throughput rates of raw material and solution formulations and to update VOC emission data for the wet wipes manufacturing processes, NPS-1 and NPS-2. Emissions associated with the changes to the NPS-1 and NPS-2 wet wipes processes were: 2.8 tpy VOC, 0.05 tpy Formaldehyde, and 0.01 tpy Ethylene Oxide. Additionally, VOC content for NPS-2

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solution in the Specific Condition 11 has been corrected from 0.018 lbs per pound of solution to 0.006 lbs per pound of solution.

Permit #1306-AR-10 was issued on May 2, 2011. Kimberly-Clark requested authorization to install a new nozzle on CM1. The emission increases were 3.0 ton per year (tpy) of PM/PM₁₀, and 0.1 tpy of VOC.

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Section IV: EMISSION UNIT INFORMATION

Specific Conditions

- The permittee shall not exceed the emission rates set forth in the following table.
 [Regulation 19 §19.501 et seq. and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN	Description	Pollutant	lb/hr	tpy
02	Nonwovens Process	PM ₁₀	0.4	1.6
		VOC	2.5	11.0
03	Nonwovens Process	PM ₁₀	0.2	1.1
		VOC	2.0	8.8
05	Process Air Heater	PM ₁₀	0.1	0.2
		SO ₂	0.1	0.1
		VOC	0.1	0.1
		CO	0.1	0.4
		NO _x	0.4	1.8
06	Nonwovens Process	PM ₁₀	0.4	1.6
		VOC	2.5	11.0
07	Stripper Fans	PM ₁₀	0.8	3.5
		VOC	0.1	0.3
08	Boiler	PM ₁₀	0.1	0.1
		SO ₂	0.1	0.1
		VOC	0.1	0.1
		CO	0.1	0.2
		NO _x	0.2	0.9
09	Nonwovens Process	PM ₁₀	0.7	3.1
		VOC	3.5	15.3
10	Nonwovens Process	PM ₁₀	0.4	1.7
		VOC	2.4	10.5
11	Nonwovens Process	PM ₁₀	0.4	1.7
		VOC	2.4	10.5
12	Process Air Heater	PM ₁₀	0.1	0.1
		SO ₂	0.1	0.1
		VOC	0.1	0.1
		CO	0.1	0.2
		NO _x	0.3	1.1
13	Stripper Fans	PM ₁₀	0.2	1.0
		VOC	0.2	0.6
14	Nonwovens Process	PM ₁₀	0.4	1.7
		VOC	1.0	4.4
15	Nonwovens Process	PM ₁₀	0.4	1.7
		VOC	1.0	4.4

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SN	Description	Pollutant	lb/hr	tpy
19	Process Air Heater	PM ₁₀	0.1	0.3
		SO ₂	0.1	0.1
		VOC	0.1	0.2
		CO	0.6	2.6
		NO _x	0.7	3.1
21	Vacuum Blower	PM ₁₀	0.1	0.2
22	Vacuum Blower	PM ₁₀	0.1	0.2

2. The permittee shall not exceed the emission rates set forth in the following table. [Regulation 18 §18.801 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN	Description	Pollutant	lb/hr	tpy
02	Nonwovens Process	PM	0.4	1.6
03	Nonwovens Process	PM	0.2	1.1
05	Process Air Heater	PM	0.1	0.2
06	Nonwovens Process	PM	0.4	1.6
07	Stripper Fans	PM	0.8	3.5
08	Boiler	PM	0.1	0.1
09	Nonwovens Process	PM	0.7	3.1
10	Nonwovens Process	PM	0.4	1.7
11	Nonwovens Process	PM	0.4	1.7
12	Process Air Heater	PM	0.1	0.1
13	Stripper Fans	PM	0.2	1.0
14	Nonwovens Process	PM	0.4	1.7
15	Nonwovens Process	PM	0.4	1.7
19	Process Air Heater	PM	0.1	0.3
21	Vacuum Blower	PM	0.1	0.2
22	Vacuum Blower	PM	0.1	0.2

3. Visible emissions may not exceed the limits specified in the following table of this permit as measured by EPA Reference Method 9. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

SN	Limit	Regulatory Citation
Facility	5%	§19.503

4. The permittee shall not cause or permit the emission of air contaminants, including odors or water vapor and including an air contaminant whose emission is not otherwise prohibited by Regulation #18, if the emission of the air contaminant constitutes air pollution within the meaning of A.C.A. §8-4-303. [Regulation 18 §18.801 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Kimberly-Clark Corporation (Maumelle Facility)

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5. The permittee shall not conduct operations in such a manner as to unnecessarily cause air contaminants and other pollutants to become airborne. [Regulation 18 §18.901 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
6. The permittee shall not process more than 17,800 tons of polymers at the facility per consecutive 12-month period. [Regulation 19, §19.705 and A.C.A. §8-4-203 as referenced by A.C.A. §8-4-304 and §8-4-311]
7. The permittee shall maintain monthly records which demonstrate compliance with Specific Condition #6. The permittee will maintain a twelve month rolling total and each individual month's data on-site and made available to Department personnel upon request. The permittee will update the records by the fifteenth day of the month following the month to which the records pertain. [Regulation 19 §19.705 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
8. The polymer throughput at SN-10, SN-11, SN-14, and SN-15 will not exceed 561.4 lb/hr per bank. [§19.705 of Regulation 19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
9. The permittee shall maintain monthly records of the polymer throughput through sources SN-10, 11, 14, and 15 to demonstrate compliance with Specific Condition #8. These records shall include the amount of polymer processed by each source, the time each source was operated, and the monthly average of the hourly rate of the equipment. The permittee shall maintain a twelve month rolling total and each individual month's data on-site and made available to Department personnel upon request. The permittee shall update the records by the fifteenth day of the month following the month to which the records pertain. [§19.705 of Regulation 19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
13. The permittee shall not emit any HAP not listed in Specific Condition #2 except in De Minimis amounts as defined by the Department (lb/hr HAPs * 4.4 < relative toxicity). [§18.801 of Regulation 18, and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
14. The permittee shall use only pipeline quality natural gas as fuel. [§19.705 of Regulation 19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

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Section V: INSIGNIFICANT ACTIVITIES

The Department deems the following types of activities or emissions as insignificant on the basis of size, emission rate, production rate, or activity in accordance with Group A of the Insignificant Activities list found in Regulation 18 and 19 Appendix A. Insignificant activity emission determinations rely upon the information submitted by the permittee in an application dated August 23, 2006 and February 26, 2013.

Description	Category
Equipment Cleaning Process (SN-20)	A-13
NPS Solution	A-9

Section VI: GENERAL CONDITIONS

1. Any terms or conditions included in this permit that specify and reference Arkansas Pollution Control & Ecology Commission Regulation 18 or the Arkansas Water and Air Pollution Control Act (A.C.A. §8-4-101 et seq.) as the sole origin of and authority for the terms or conditions are not required under the Clean Air Act or any of its applicable requirements, and are not federally enforceable under the Clean Air Act. Arkansas Pollution Control & Ecology Commission Regulation 18 was adopted pursuant to the Arkansas Water and Air Pollution Control Act (A.C.A. §8-4-101 et seq.). Any terms or conditions included in this permit that specify and reference Arkansas Pollution Control & Ecology Commission Regulation 18 or the Arkansas Water and Air Pollution Control Act (A.C.A. §8-4-101 et seq.) as the origin of and authority for the terms or conditions are enforceable under this Arkansas statute.
2. This permit does not relieve the owner or operator of the equipment and/or the facility from compliance with all applicable provisions of the Arkansas Water and Air Pollution Control Act and the regulations promulgated under the Act. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
3. The permittee shall notify the Department in writing within thirty (30) days after commencement of construction, completion of construction, first operation of equipment and/or facility, and first attainment of the equipment and/or facility target production rate. [Regulation 19 §19.704 and/or A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
4. Construction or modification must commence within eighteen (18) months from the date of permit issuance. [Regulation 19 §19.410(B) and/or Regulation 18 §18.309(B) and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
5. The permittee must keep records for five years to enable the Department to determine compliance with the terms of this permit such as hours of operation, throughput, upset conditions, and continuous monitoring data. The Department may use the records, at the discretion of the Department, to determine compliance with the conditions of the permit. [Regulation 19 §19.705 and/or Regulation 18 §18.1004 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
6. A responsible official must certify any reports required by any condition contained in this permit and submit any reports to the Department at the address below. [Regulation 19 §19.705 and/or Regulation 18 §18.1004 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

Arkansas Department of Environmental Quality
Air Division
ATTN: Compliance Inspector Supervisor
5301 Northshore Drive
North Little Rock, AR 72118-5317
7. The permittee shall test any equipment scheduled for testing, unless stated in the Specific Conditions of this permit or by any federally regulated requirements, within the following time frames: (1) newly constructed or modified equipment within sixty (60) days of

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achieving the maximum production rate, but no later than 180 days after initial start up of the permitted source or (2) existing equipment already operating according to the time frames set forth by the Department. The permittee must notify the Department of the scheduled date of compliance testing at least fifteen (15) business days in advance of such test. The permittee must submit compliance test results to the Department within thirty (30) calendar days after the completion of testing. [Regulation 19 §19.702 and/or Regulation 18 §18.1002 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

8. The permittee shall provide: [Regulation 19 §19.702 and/or Regulation 18 §18.1002 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 - a. Sampling ports adequate for applicable test methods;
 - b. Safe sampling platforms;
 - c. Safe access to sampling platforms; and
 - d. Utilities for sampling and testing equipment
9. The permittee shall operate equipment, control apparatus and emission monitoring equipment within their design limitations. The permittee shall maintain in good condition at all times equipment, control apparatus and emission monitoring equipment. [Regulation 19 §19.303 and/or Regulation 18 §18.1104 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
10. If the permittee exceeds an emission limit established by this permit, the permittee will be deemed in violation of said permit and will be subject to enforcement action. The Department may forego enforcement action for emissions exceeding any limits established by this permit provided the following requirements are met: [Regulation 19 §19.601 and/or Regulation 18 §18.1101 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 - a. The permittee demonstrates to the satisfaction of the Department that the emissions resulted from an equipment malfunction or upset and are not the result of negligence or improper maintenance, and the permittee took all reasonable measures to immediately minimize or eliminate the excess emissions.
 - b. The permittee reports the occurrence or upset or breakdown of equipment (by telephone, facsimile, or overnight delivery) to the Department by the end of the next business day after the occurrence or the discovery of the occurrence.
 - c. The permittee must submit to the Department, within five business days after the occurrence or the discovery of the occurrence, a full, written report of such occurrence, including a statement of all known causes and of the scheduling and nature of the actions to be taken to minimize or eliminate future occurrences, including, but not limited to, action to reduce the frequency of occurrence of such conditions, to minimize the amount by which said limits are exceeded, and to reduce the length of time for which said limits are exceeded. If the information is included in the initial report, the information need not be submitted again.
11. The permittee shall allow representatives of the Department upon the presentation of credentials: [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]

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- a. To enter upon the permittee's premises, or other premises under the control of the permittee, where an air pollutant source is located or in which any records are required to be kept under the terms and conditions of this permit;
 - b. To have access to and copy any records required to be kept under the terms and conditions of this permit, or the Act;
 - c. To inspect any monitoring equipment or monitoring method required in this permit;
 - d. To sample any emission of pollutants; and
 - e. To perform an operation and maintenance inspection of the permitted source.
12. The Department issued this permit in reliance upon the statements and presentations made in the permit application. The Department has no responsibility for the adequacy or proper functioning of the equipment or control apparatus. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 13. The Department may revoke or modify this permit when, in the judgment of the Department, such revocation or modification is necessary to comply with the applicable provisions of the Arkansas Water and Air Pollution Control Act and the regulations promulgated the Arkansas Water and Air Pollution Control Act. [Regulation 19 §19.410(A) and/or Regulation 18 §18.309(A) and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 14. This permit may be transferred. An applicant for a transfer must submit a written request for transfer of the permit on a form provided by the Department and submit the disclosure statement required by Arkansas Code Annotated §8-1-106 at least thirty (30) days in advance of the proposed transfer date. The permit will be automatically transferred to the new permittee unless the Department denies the request to transfer within thirty (30) days of the receipt of the disclosure statement. The Department may deny a transfer on the basis of the information revealed in the disclosure statement or other investigation or, deliberate falsification or omission of relevant information. [Regulation 19 §19.407(B) and/or Regulation 18 §18.307(B) and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 15. This permit shall be available for inspection on the premises where the control apparatus is located. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 16. This permit authorizes only those pollutant emitting activities addressed herein. [A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 17. This permit supersedes and voids all previously issued air permits for this facility. [Regulation 18 and 19 and A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311]
 18. The permittee must pay all permit fees in accordance with the procedures established in Regulation No. 9. [A.C.A §8-1-105(c)]
 19. The permittee may request in writing and at least 15 days in advance of the deadline, an extension to any testing, compliance or other dates in this permit. No such extensions are authorized until the permittee receives written Department approval. The Department may grant such a request, at its discretion in the following circumstances:

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- a. Such an extension does not violate a federal requirement;
- b. The permittee demonstrates the need for the extension; and
- c. The permittee documents that all reasonable measures have been taken to meet the current deadline and documents reasons it cannot be met.

[Regulation 18 §18.314(A), Regulation 19 §19.416(A), A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR Part 52, Subpart E]

20. The permittee may request in writing and at least 30 days in advance, temporary emissions and/or testing that would otherwise exceed an emission rate, throughput requirement, or other limit in this permit. No such activities are authorized until the permittee receives written Department approval. Any such emissions shall be included in the facilities total emissions and reported as such. The Department may grant such a request, at its discretion under the following conditions:

- a. Such a request does not violate a federal requirement;
- b. Such a request is temporary in nature;
- c. Such a request will not result in a condition of air pollution;
- d. The request contains such information necessary for the Department to evaluate the request, including but not limited to, quantification of such emissions and the date/time such emission will occur;
- e. Such a request will result in increased emissions less than five tons of any individual criteria pollutant, one ton of any single HAP and 2.5 tons of total HAPs; and
- f. The permittee maintains records of the dates and results of such temporary emissions/testing.

[Regulation 18 §18.314(B), Regulation 19 §19.416(B), A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR Part 52, Subpart E]

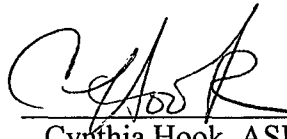
21. The permittee may request in writing and at least 30 days in advance, an alternative to the specified monitoring in this permit. No such alternatives are authorized until the permittee receives written Department approval. The Department may grant such a request, at its discretion under the following conditions:

- a. The request does not violate a federal requirement;
- b. The request provides an equivalent or greater degree of actual monitoring to the current requirements; and
- c. Any such request, if approved, is incorporated in the next permit modification application by the permittee.

[Regulation 18 §18.314(C), Regulation 19 §19.416(C), A.C.A. §8-4-203 as referenced by §8-4-304 and §8-4-311, and 40 CFR Part 52, Subpart E]

CERTIFICATE OF SERVICE

I, Cynthia Hook, hereby certify that a copy of this permit has been mailed by first class mail to Kimberly-Clark Corporation (Maumelle Facility), 500 Murphy Drive, Maumelle, AR, 72113, on this 13th day of March, 2014.

A handwritten signature in black ink, appearing to read 'Cynthia Hook', written over a horizontal line.

Cynthia Hook, ASIII, Air Division