



File: PA-01578

REGISTERED MAIL RT 558 067 662

February 28, 2005

West Fraser Mills Ltd. and
Daishowa Marubeni International Ltd.
operating in the firm name and style of
Cariboo Pulp and Paper Company
600 North Star Road
P.O. Box 7500
Quesnel, British Columbia V2J 3J6

Dear Permittee:

Enclosed is Amended Permit PA-01578 issued under the provisions of the *Environmental Management Act*. Your attention is respectfully directed to the terms and conditions outlined in the permit. An annual fee will be determined according to the Permit Fees Regulation.

This permit does not authorize entry upon, crossing over, or use for any purpose of private or Crown lands or works, unless and except as authorized by the owner of such lands or works. The responsibility for obtaining such authority rests with the permittee. This permit is issued pursuant to the provisions of the *Environmental Management Act* to ensure compliance with Section 120(3) of that statute, which makes it an offence to discharge waste, from a prescribed industry or activity, without proper authorization. It is also the responsibility of the permittee to ensure that all activities conducted under this authorization are carried out with regard to the rights of third parties, and comply with other applicable legislation that may be in force.

This decision may be appealed to the Environmental Appeal Board in accordance with Part 8 of the *Environmental Management Act*. An appeal must be delivered within 30 days from the date that notice of this decision is given. For further information, please contact the Environmental Appeal Board at (250) 387-3464.

Administration of this permit will be carried out by staff from the Cariboo Region. Plans, data and reports pertinent to the permit are to be submitted to the Regional Manager, Environmental Protection, at Ministry of Water, Land and Air Protection, Regional Operations, Cariboo Region, Suite 400 - 640 Borland St, Williams Lake, BC V2G 4T1.

Yours truly,



Douglas Hill, P.Eng.
for Director, *Environmental Management Act*
Cariboo Region

Enclosure

cc: Environment Canada

**PERMIT
PA-1578**

Under the Provisions of the Environmental Management Act

**West Fraser Mills Ltd.
and
Daishowa Marubeni International Ltd.**

**operating in the firm name and style of
Cariboo Pulp and Paper Company
600 North Star Road
P.O. Box 7500
Quesnel, British Columbia
V2J 3J6**

is authorized to discharge air contaminants to the air from a Kraft pulp mill located in Quesnel, British Columbia, subject to the conditions listed below. Contravention of any of these conditions is a violation of the *Environmental Management Act* and may result in prosecution.

This permit supersedes and amends all previous versions of Permit PA-01578, issued under Part 2, Section 14 of the *Environmental Management Act*.

1. AUTHORIZED DISCHARGES


1.1. This section applies to the discharge of air contaminants from a **RECOVERY STACK**. The site reference number for this discharge is E103060.

1.1.1 The maximum authorized rate of discharge is 6,400 cubic metres per minute. The maximum authorized loading rate for particulate matter is 80.3 kg/hr, and for total reduced sulphur is 2.9 kg/hr.

1.1.2 The authorized discharge period is continuous, 24 hours/day.

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1.1.3 The characteristics of the discharge shall not exceed:

<u>Contaminant</u>	<u>Maximum Concentration</u>
Particulate Matter	230 mg/m ³ at 6% O ₂
Total Reduced Sulphur (as H ₂ S)	8.3 mg/m ³ (hourly)

1.1.4 The authorized works are a low odour Kraft recovery boiler, two electrostatic precipitators, fans, ducting, stack, and related appurtenances approximately located as shown on Site Plan A as location 1.

1.1.5 The location of the facilities from which the discharge originates and the location of the point of discharge is Lot B, District Lot 78, Plan 18650, Cariboo District.

1.2. This section applies to the discharge of air contaminants from a **DISSOLVING TANK VENT STACK**. The site reference number for this discharge is E217893.

1.2.1 The maximum authorized rate of discharge is 300 cubic metres per minute.

1.2.2 The authorized discharge period is continuous, 24 hours/day.

1.2.3 The characteristics of the discharge shall not exceed:

<u>Contaminant</u>	<u>Maximum Loading</u>
Particulate Matter	183 kg/d

1.2.4 The authorized works are a smelt dissolving tank, wet scrubber, ducting, stack, and related appurtenances approximately located as shown on Site Plan A as location 5.

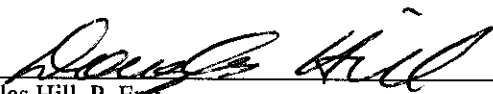
1.2.5 The location of the facilities from which the discharge originates and the location of the point of discharge is the same location as set out in Section 1.1.

1.3. This section applies to the discharge of air contaminants from a **POWER BOILER** that burns wood, natural gas, turpentine, non-condensable gases, tall oil and #2 fuel oil. The site reference number for this discharge is E103063.

1.3.1 The maximum authorized rate of discharge is 6,180 cubic metres per minute.

1.3.2 The authorized discharge period is continuous, 24 hours/day.

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1.3.3 The characteristics of the discharge shall not exceed:

<u>Contaminant</u>	<u>Maximum Concentration</u>
Particulate Matter	230 mg/m ³ at 12% CO ₂

1.3.4 The authorized works are a wood burning power boiler, wet scrubber, fans, ducting, stack, and related appurtenances approximately located as shown on Site Plan A as location 23.

1.3.5 The location of the facilities from which the discharge originates and the location of the point of discharge is the same location as set out in Section 1.1.

1.4. This section applies to the discharge of air contaminants from a **KILN STACK**. The site reference number for this discharge is E217895.

1.4.1 The maximum authorized rate of discharge is 660 cubic metres per minute.

1.4.2 The authorized discharge period is continuous, 24 hours/day.

1.4.3 The characteristics of the discharge shall not exceed:

<u>Contaminant</u>	<u>Maximum Concentration</u>
Particulate Matter	230 mg/m ³

1.4.4 The authorized works are a lime kiln, cyclone separator, venturi scrubber, fans, ducting, stack, and related appurtenances approximately located as shown on Site Plan A as location 4.

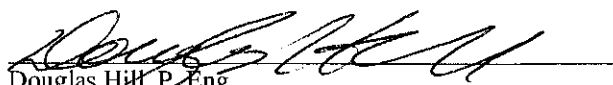
1.4.5 The location of the facilities from which the discharge originates and the location of the point of discharge is the same location as set out in Section 1.1.

1.5. This section applies to the combined discharge of total reduced sulphur compounds from the **DISSOLVING TANK VENT STACK, POWER BOILER STACK, KILN STACK and BROWNSTOCK SCRUBBER STACK**. The site reference number for the Brownstock Scrubber is E217896.

1.5.1 The maximum combined authorized rate of discharge is 9,000 cubic metres per minute.

1.5.2 The authorized discharge period is continuous, 24 hours/day.

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1.5.3 The characteristics of the discharge shall not exceed:

<u>Contaminant</u>	<u>Maximum Loading</u>
Total Reduced Sulphur (as H ₂ S)	205 kg/d (total combined)

1.5.4 The authorized works are noted above in 1.2, 1.3 and 1.4 and a brownstock washer, wet scrubber, fans, ducting, stack, and related appurtenances approximately located as shown on Site Plan A as locations 5. 23. 4 and 2 respectively.

1.5.5 The location of the facilities from which the discharge originates and the location of the point of discharge is the same location as set out in Section 1.1.

1.6. This section applies to the discharge of air contaminants from a **BLEACH PLANT SCRUBBER STACK**. The site reference number for this discharge is E103061.

1.6.1 The maximum authorized rate of discharge is 2,000 cubic metres per minute.

1.6.2 The authorized discharge period is continuous, 24 hours/day.

1.6.3 The characteristics of the discharge shall be typical of a pulp bleach plant operation.

1.6.4 Should chlorine dioxide emission levels become excessive, the Regional Manager, Environmental Protection, may require the permittee to undertake monitoring or install additional works.


1.6.5 The authorized works are wet scrubbers, fans, ducting, stack, and related appurtenances approximately located as shown on Site Plan A as location 3.

1.6.6 The location of the facilities from which the discharge originates and the location of the point of discharge is the same location as set out in Section 1.1.

1.7. This section applies to the discharge of air contaminants from **MISCELLANEOUS MILL SOURCES**. The site reference number for this discharge is E103064.

1.7.1 The maximum authorized rate of discharge is 7,000 cubic metres per minute.

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- 1.7.2 The authorized discharge period is continuous, 24 hours/day.
- 1.7.3 The sources authorized are listed in Table 1.
- 1.7.4 The authorized works are exhaust fans, separators, scrubbers, fans, ducting, stacks, effluent ponds and related appurtenances approximately located as shown on Site Plans A, B and C.
- 1.7.5 The location of the facilities from which the discharge originates and the location of the point of discharge is the same location as set out in Section 1.1.

Table 1

Source	Site Plan Reference #
RECAUST TANK FARM VENT STACK	6
SLAKER STACK	7
PULP MACHINE HEADBOX EXHAUST	8
MACHINE ROOM EXHAUSTS (5)	9, 10, 11, 12, 13
ROSS DRYER EXHAUSTS (3)	14, 15, 50
LIME MUD FILTER HOOD EXHAUSTS (2)	16, 17
VACUUM FILTER PUMP EXHAUST	18
BLEACH PLANT EXHAUSTS (3)	19, 20, 21
DREGS FILTER HOOD EXHAUST	22
CHIP FINES CYCLONE	24
CHIP BLOWERS (2)	25, 26
MCO2 REACTOR BLOW TANK VENT	27
MCO2 WASHER FILTRATE VENTS (2)	28, 29
PULP MACHINE DRY END EXHAUSTS (2)	30, 31
CHIP BIN EXHAUSTS (2)	32, 33
VACUUM PUMP EXHAUST	34
MAIN NCG VENT TO ATMOSPHERE	35
DIGESTER NCG RELIEF VENT	36
MCO2 ROOM EXHAUSTS (2)	37, 38
SODA ASH UNLOADING TANK VENT	39
WET END ROOM EXHAUSTS (2)	40, 41
PARTS WASHER VENT	42
MACHINE SHOP EXHAUST	43
PACKAGE BOILER STACK	44
OXYGEN PLANT	45
SUPERHEATER VENT	46
BLOWDOWN	47
#1 LAGOON	48
SPILL BASIN	49
EFFLUENT FOAM BREAKER TANK VENT	51
LIME KILN BAGHOUSE	52

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2. **GENERAL REQUIREMENTS**

2.1. **Maintenance of Works**

The permittee shall inspect the authorized works regularly and maintain them in good working order. Notify the Regional Manager, Environmental Protection, of any malfunction of these works.

2.2. **Bypasses**

The discharge of air contaminants which has bypassed the authorized treatment works is prohibited unless the approval of the Director is obtained and confirmed in writing.

2.3. **Emergency Procedures**

In the event of an emergency which prevents continuing operation of the approved method of pollution control, the permittee shall immediately take appropriate remedial action and shall immediately notify:

(a) The Regional Manager, Environmental Protection, by phone, (250) 398-4530, between the hours of 08:00 and 16:30, Monday to Friday;

(b) The Regional Manager, Environmental Protection, by facsimile, (250) 398-4214, when the incident occurs at any other time; and

(c) The Provincial Emergency Program, by phone (800) 663-3456, 24-hours/day, for emergencies involving major emissions of air contaminants to the atmosphere that could affect public health.

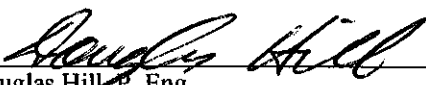
2.4. **Process Modifications**

The Regional Manager, Environmental Protection, shall be notified prior to implementing changes to any process that may adversely affect the quality and/or quantity of the discharge.

2.5. **Future Upgrading of Works**

The permit authorizes the continued use of the existing treatment and disposal works for the time being. Upgrading of the treatment works and disposal facilities may be required at any time based on monitoring results, and/or any other pertinent information.

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2.6. **Standard Conditions**

For the administration of this permit all gaseous volumes shall be converted to standard conditions of 293.15 K and 101.325 kPa with zero percent moisture.

2.7. **Sampling Facilities**

Sampling ports shall be provided with nearby electrical outlets and, where required, approved access ladders and adequately sized platforms, for the discharges covered by Section(s) 1.1 to 1.6 to enable Environmental Protection personnel to monitor these emissions.

2.8. **Fugitive Particulate Emission**


The permittee shall control fugitive particulate emissions generated from the property. Should the Director have reasonable grounds to believe that fugitive particulate emissions cause pollution outside the property boundary, the permittee shall undertake additional measures and/or curtail operations to control the emissions.

3. **MONITORING AND REPORTING REQUIREMENTS**

3.1. **Discharge Monitoring**

<u>Source</u>	<u>Reference #</u>	<u>Parameter</u>	<u>Frequency</u>
Recovery Boiler (section 1.1)	E103060	Discharge Rate	Quarterly
		Particulate Matter	Quarterly
		Total Reduced Sulphur (as H2S)	Continuously
Smelt Dissolving Tank (section 1.2)	E217893	Discharge Rate	Quarterly
		Particulate Matter	Quarterly
		Total Reduced Sulphur (as H2S)	Monthly ⁽¹⁾
Power Boiler (section 1.3)	E103063	Discharge Rate	Quarterly
		Particulate Matter	Quarterly
		Total Reduced Sulphur (as H2S)	Monthly ⁽¹⁾
Lime Kiln (section 1.4)	E217895	Discharge Rate	Quarterly
		Particulate Matter	Quarterly
		Total Reduced Sulphur (as H2S)	Monthly ⁽¹⁾
Brown Stock Scrubber (section 1.5)	E217896	Total Reduced Sulphur (as H2S)	Monthly ⁽¹⁾

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- (1) For monthly monitoring of Total Reduced Sulphur compounds, the permittee shall obtain Grab Samples every 60 minutes, over four consecutive hours, and carry out analysis using a method approved by the Regional Manager, Environmental Protection. The arithmetic average of the results shall be reported.

3.2. **Continuous Emission Monitor**

The permittee shall operate and maintain a continuous emission monitor for Total Reduced Sulphur compounds on the Recovery Boiler stack. The results shall be reported as hourly averages, hourly concentration maximum recordings, and monthly average.

3.3. **Operating Conditions - Power Boilers**

Sampling is to be done under "normal" operating conditions. The operating conditions of the power boiler(s) shall be reported in terms of steam load (kg/h) and hog fuel content fired (expressed as the ratio of steam produced by hog fuel to the total steam) for both the sampling period and for the ninety day period prior to the sampling event.

3.4. **Plant Operating Conditions**

For the purpose of validating the sampling and monitoring data, the "specified operating conditions" of the plant are listed below. These conditions should be created when sampling is done unless "actual operating conditions" can be determined. Sampling may be done under "actual operating conditions" when, in the opinion of the Director, the permittee is able to properly document that these conditions represent an operational level equal to or greater than the 90th percentile for the ninety (90) days prior to the date the sample is to be taken.


For determining "actual operating conditions", the following parameters are to be considered:

- (a) Total mill production of unbleached Kraft pulp in terms of ADUt/d;
- (b) Recovery boiler black liquor solids burnt in terms of kg/d;
- (c) Power boiler total and wood waste derived steam production in terms of kg/h.

Specified Operating Conditions of the Mill's Main Areas

Production rating	unbleached Kraft	1038 ADUt/d
Recovery boiler	black liquor solids burnt	1,900,00 kg/d

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Wood burning power boiler	steam production steam characteristics wood waste derived steam load	115,000 kg/h 4,480 kPa, 400 °C 70% minimum
Lime kiln	100% lime mud	245 t/d (CaO)

3.5. **Venting of Non-Condensable Gases**

Non-condensable gases may only be diverted to the RSH reactor on an emergency basis, when the lime kiln or power boiler incineration systems are not available. Following two hours of diversion, and every two hours thereafter, the permittee shall sample these sources for Total Reduced Sulphur (as H₂S). A single grab sample shall be analyzed as defined in section 3.1. The permittee shall provide the times and durations in which these diversions occur, and include this information in the monthly report.

3.6. **Sampling Procedures**

Sampling is to be carried out in accordance with the procedures described in the "British Columbia Field Sampling Manual for Continuous Monitoring and the Collection of Air, Air-Emission, Water, Wastewater, Soil, Sediment, and Biological Samples, 2003 Edition (Permittee)", or most recent edition, or by suitable alternative procedures as authorized by the Director.

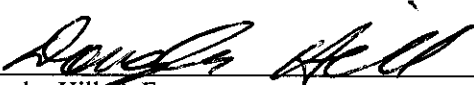
A copy of the above manual may be purchased from the Queen's Printer Publications Centre, P. O. Box 9452, Stn. Prov. Gov't. Victoria, British Columbia, V8W 9V7 (1-800-663-6105 or (250) 387-6409). A copy of the manual is also available for inspection at all Environmental Protection offices.

3.7. **Chemical Analysis - Air**

Analyses are to be carried out in accordance with procedures described in the "British Columbia Laboratory Methods Manual for the Analysis of Water, Wastewater, Sediment, Biological Materials and Discrete Ambient Air Samples (2003 Permittee Edition)", or the most recent edition, or by suitable alternative procedures as authorized by the Director.

A copy of the above manual may be purchased from the Queen's Printer Publications Centre, P. O. Box 9452, Stn. Prov. Gov't. Victoria, British Columbia, V8W 9V7 (1-800-663-6105 or (250) 387-6409). A copy of the manual is also available for inspection at all Environmental Protection offices.

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3.8. **Ambient Air**

The permittee shall maintain and operate continuous Total Reduced Sulphur monitors located in Quesnel and owned by the Ministry, to the satisfaction of the Regional Manager, Environmental Protection. The permittee shall ensure that operating times for the continuous emission monitors exceed 85% each month, and immediately report deviations to the Regional Manager, Environmental Protection.

The need for changes in the ambient monitoring program shall be determined by the Director and any modifications shall be communicated by written notice to the permittee.

3.9. **Complaints**

The permittee shall include in the monthly report the details of all complaints received (location, date, time, nature of complaint, suspected cause, and resolution).


3.10. **Reporting**

The permittee shall maintain data of analyses, monitoring results, and reports, as defined in sections 2.2, 2.3, 3.1, 3.2, 3.5 and 3.9 for inspection and submit the data, suitably tabulated, to the Regional Manager, Environmental Protection, within 30 days of the end of each month. Any reports of permit non-compliances shall include reasons for the incident, and corrective action taken to minimize immediate impact and to prevent future similar incidents.

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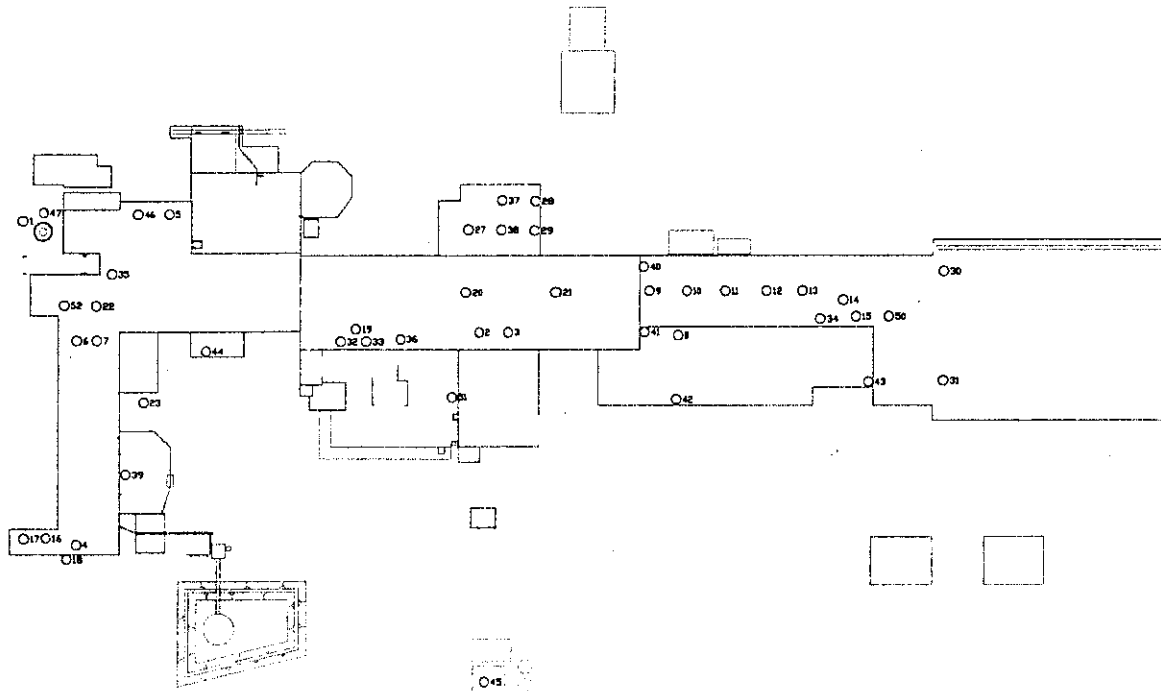


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Site Plan A



- | | | |
|---------------------------------------|-----------------------------------|------------------------------------|
| 1 RECOVERY STACK | 18 VACUUM FILTER PUMP EXHAUST | 35 MAIN NCG VENT TO ATMOSPHERE |
| 2 BROWNSTOCK SCRUBBER STACK | 19 BLEACH PLANT EXHAUST 1 | 36 DIGESTER NCG RELIEF VENT |
| 3 BLEACH PLANT SCRUBBER STACK | 20 BLEACH PLANT EXHAUST 2 | 37 MCO2 ROOM EXHAUST 1 |
| 4 KILN STACK | 21 BLEACH PLANT EXHAUST 3 | 38 MCO2 ROOM EXHAUST 2 |
| 5 DISSOLVING TANK VENT STACK | 22 DREGS FILTER HOOD EXHAUST | 39 SODA ASH UNLOADING TANK VENT |
| 6 RECAUST TANK FARM VENT STACK | 23 POWER BOILER STACK | 40 WET END ROOM EXHAUST 1 |
| 7 SLAKER STACK | 24 CHIP FINES CYCLONE | 41 WET END ROOM EXHAUST 2 |
| 8 PULP MACHINE HEADBOX EXHAUST | 25 CHIP BLOWER 1 | 42 PARTS WASHER VENT |
| 9 MACHINE ROOM EXHAUST 1 | 26 CHIP BLOWER 2 | 43 MACHINE SHOP EXHAUST |
| 10 MACHINE ROOM EXHAUST 2 | 27 MCO2 REACTOR BLOW TANK VENT | 44 PACKAGE BOILER STACK |
| 11 MACHINE ROOM EXHAUST 3 | 28 MCO2 WASHER FILTRATE VENT EAST | 45 OXYGEN PLANT |
| 12 MACHINE ROOM EXHAUST 4 | 29 MCO2 WASHER FILTRATE VENT WEST | 46 SUPERHEATER VENT |
| 13 MACHINE ROOM EXHAUST 5 | 30 PULP MACHINE DRY END EXHAUST 1 | 47 BLOWDOWN |
| 14 ROSS DRYER EXHAUST A | 31 PULP MACHINE DRY END EXHAUST 2 | 48 #1 LAGOON |
| 15 ROSS DRYER EXHAUST B | 32 CHIP BIN EXHAUST NORTH | 49 SPILL BASIN |
| 16 LIME MUD FILTER HOOD EXHAUST SOUTH | 33 CHIP BIN EXHAUST SOUTH | 50 ROSS DRYER EXHAUST C |
| 17 LIME MUD FILTER HOOD EXHAUST NORTH | 34 VACUUM PUMP EXHAUST | 51 EFFLUENT FOAM BREAKER TANK VENT |
| | | 52 LIME KILN BAG HOUSE |



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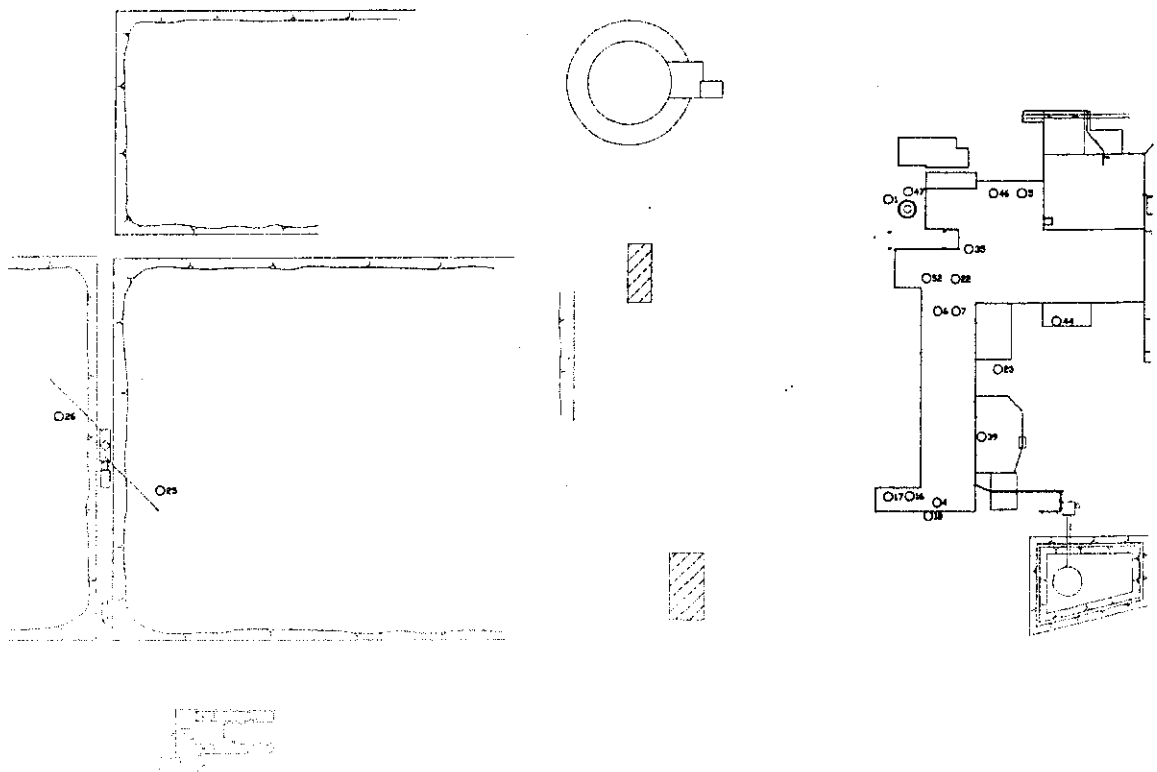
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Site Plan B




- 18 VACUUM FILTER PUMP EXHAUST
- 19 BLEACH PLANT EXHAUST 1
- 20 BLEACH PLANT EXHAUST 2
- 21 BLEACH PLANT EXHAUST 3
- 22 DREGS FILTER HOOD EXHAUST
- 23 POWER BOILER STACK
- 24 CHIP FINES CYCLONE
- 25 CHIP BLOWER 1
- 26 CHIP BLOWER 2
- 27 MCDE REACTOR BLOW TANK VENT
- 28 MCDE WASHER FILTRATE VENT EAST
- 29 MCDE WASHER FILTRATE VENT WEST
- 30 PULP MACHINE DRY END EXHAUST 1
- 31 PULP MACHINE DRY END EXHAUST 2
- 32 CHIP BIN EXHAUST NORTH
- 33 CHIP BIN EXHAUST SOUTH
- 34 VACUUM PUMP EXHAUST



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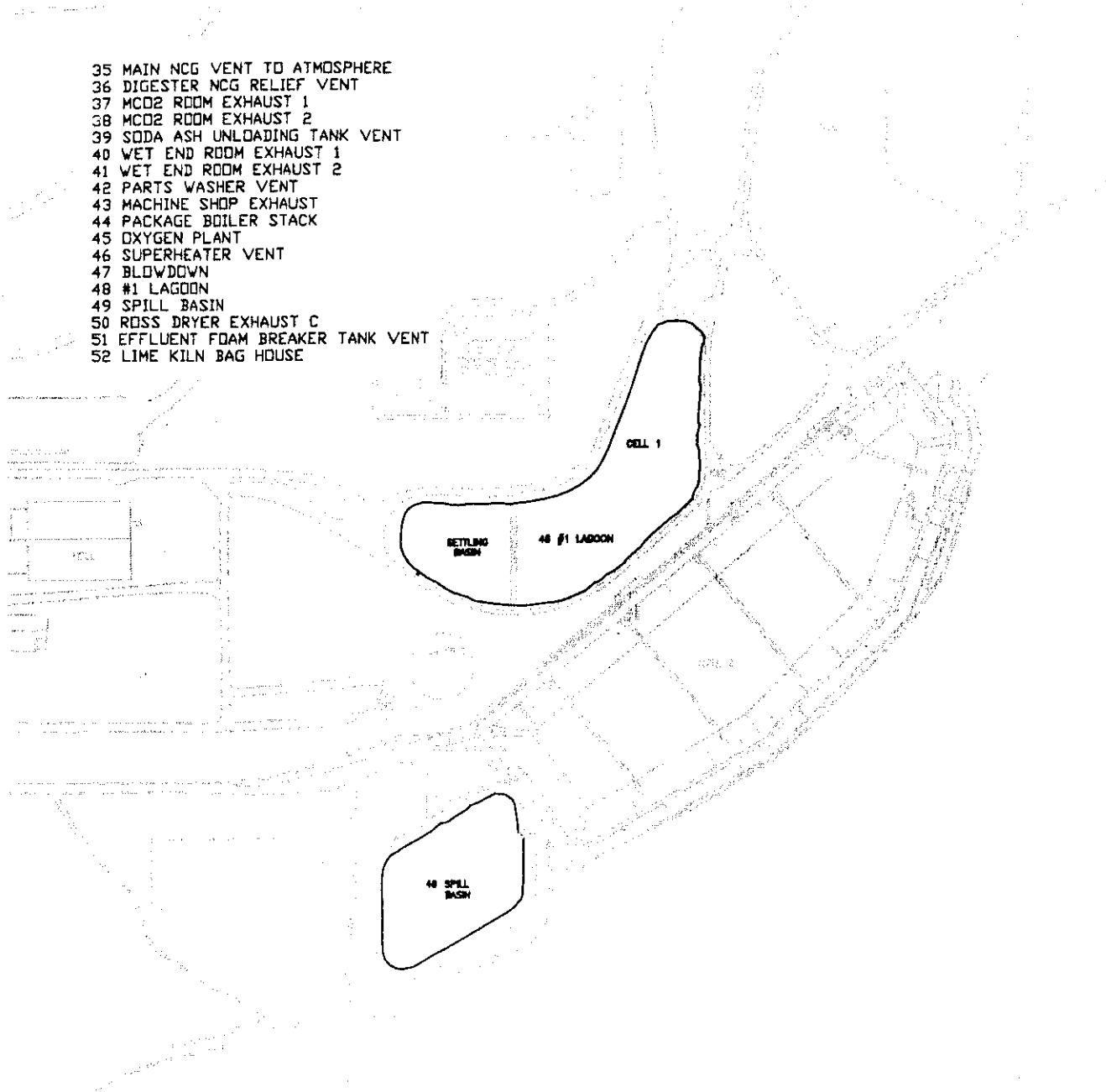
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Site Plan C



- 35 MAIN NCG VENT TO ATMOSPHERE
- 36 DIGESTER NCG RELIEF VENT
- 37 MCD2 ROOM EXHAUST 1
- 38 MCD2 ROOM EXHAUST 2
- 39 SODA ASH UNLOADING TANK VENT
- 40 WET END ROOM EXHAUST 1
- 41 WET END ROOM EXHAUST 2
- 42 PARTS WASHER VENT
- 43 MACHINE SHDP EXHAUST
- 44 PACKAGE BOILER STACK
- 45 OXYGEN PLANT
- 46 SUPERHEATER VENT
- 47 BLOWDOWN
- 48 #1 LAGOON
- 49 SPILL BASIN
- 50 ROSS DRYER EXHAUST C
- 51 EFFLUENT FOAM BREAKER TANK VENT
- 52 LIME KILN BAG HOUSE




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Location Map



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