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Chapter NR 257

ALUMINUM FORMING

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NR 257.01 Purpose. The purpose of this chapter is to establish effluent limitations, performance standards, and pretreatment standards for the discharge of process wastes from the aluminum forming point source category and its subcategories.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

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NR 257.02 Applicability. (1) This chapter applies to any aluminum forming facility which discharges or may discharge pollutants to waters of the state or which introduces or may introduce pollutants into a publicly owned treatment works.

(2) This chapter applies to chemical or electrochemical treatments applied to the surface of the aluminum when these surface treatments are performed at aluminum forming site. When these surface treatments are not performed at the aluminum forming site, regulations for electroplating, ch. NR 260, or metal finishing, ch. NR 261, apply.

(3) This chapter applies to aluminum casting when the casting is performed as an integral part of aluminum forming and is located at the aluminum forming site. When aluminum forming is performed on the same site as primary aluminum reduction, this chapter applies if the aluminum cools prior to casting. If the aluminum does not cool prior to casting, the regulations for nonferrous metals manufacturing, ch. NR 274, apply.

NR 257.03 General definitions. In addition to the definitions set forth in ss. NR 205.03, 205.04, and 211.03, the following definitions apply to the terms used in this chapter:

(1) "Aluminum forming" means a set of manufacturing operations in which aluminum and aluminum alloys are made into semifinished products by hot or cold working, such as rolling, drawing, extruding, and forging, and related operations such as heat treatment and casting.

(2) "Ancillary operation" means a manufacturing operation that has a large flow, discharges significant amounts of pollutants, and may not be present at every plant in a subcategory but when present is an integral part of the aluminum forming process.

(3) "Cleaning or etching operation" means a chemical solution bath and rinse or series of rinses designed to produce a desired surface finish on the workpiece, including conversion coating and anodizing when performed as an integral part of the aluminum forming operations, and the air pollution scrubbers used to control fumes from the chemical solution baths.

(4) "Contact cooling water" means any wastewater which contacts the aluminum workpiece or the raw materials used in aluminum forming.

(5) "Continuous casting" means the production of sheet, rod, or other long shapes by solidifying the metal while it is being poured through an open ended mold using little or no contact cooling water.

(6) "Degassing" means the removal of dissolved hydrogen from the molten aluminum prior to casting by adding chemicals and bubbling gases through the molten aluminum.

(7) "Direct chill casting" means an operation in which molten aluminum is poured into a water cooled mold, contact cooling water is sprayed onto the aluminum as the aluminum is dropped into the mold, and the aluminum ingot falls into a water bath at the end of the process.

(8) "Drawing" means the process of pulling metal through a die or succession of dies to reduce the metal's diameter or alter its shape, using either neat oils, emulsions, or soap solutions as a lubricant.

(9) "Emulsion" means a stable dispersion of 2 immiscible liquids, usually oil and water.

(10) "Existing source" means any point source from which pollutants may be discharged either directly into the waters of the state or into a POTW, except a new source as defined in sub. (18).

(11) "Extrusion" means the application of pressure to a billet of aluminum to force the aluminum to flow through a die orifice.

(12) "Forging" means the exertion of pressure on dies or rolls surrounding heated aluminum stock to force the stock to change shape and, when dies are used, to take the shape of the die.

(13) "Heat treatment" means the application of heat of specified temperature and duration to change the physical properties of the metal.

(14) "Hot water seal" means a water bath heated to approximately 180° F used to seal the surface coating on formed aluminum which has been anodized and coated.

(15) "lb/million off-lbs" means pounds of pollutant introduced into the wastestream per million pounds of aluminum or aluminum alloy removed from a forming or ancillary operation at the end of a process cycle for transfer to a different machine or process.

(16) "mg/off-kg" means milligrams of pollutant introduced into the wastestream per kilogram of aluminum or aluminum alloy removed from a forming or ancillary operation at the end of a process cycle for transfer to a different machine or process.

(17) "Neat oil" means an oil used as a lubricant with few or no added impurities.

(18) "New source" means any point source for which construction commenced after November 22, 1982 and from which pollutants may be discharged either directly into waters of the state or into a publicly owned treatment works.

(19) "Rolling" means the reduction in thickness or diameter of a workpiece by passing it between rollers lubricated with either neat oils or emulsions.

(20) "Stationary casting" means the pouring of molten aluminum into molds and allowing the metal to air cool.

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(21) "TTO" means the sum of the masses or concentrations of each of the following toxic organic compounds which is found in the discharge at a concentration greater than 0.010 mg/1:

p-chloro-m-cresol 2-chlorophenol 2,4-dinifrotoluene 1,2-diphenylhydrazine ethylbenzene fluoranthene isophorone napthalene N-nitrosodiphenylamine phenol benzo(a)pyrene benzo(ghi)perylene fluorene phenanthrene dibenzo(a,h)anthracene indeno(1,2,3 c,d)pyrene pyrene

tetrachloroethylene toluene trichloroethylene endosulfan sulfate bis(2-ethyl hexyl) phthalate diethylpthalate 3,4-benzofluoranthene benzo(k)fluoranthene chrysene acenaphthylene anthracene di-n-butyl phthalate endrin endrin aldehyde PCB-1242, 1254, 1221, 1232, 1248, 1260, 1016 acenaphthene

(22) "Wet scrubber" means an air pollution control device used to remove particulates and fumes from air by entraining the pollutants in a water spray.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.04 Monitoring and reporting requirements. The following special monitoring and reporting requirements apply to all facilities subject to this chapter:

(1) Analyses for cyanide are not required when both of the following conditions are met:

(a) The first wastewater sample of the calendar year has been analyzed and found to contain less than 0.07 mg/1.

(b) The owner or operator of the aluminum forming facility certifies in writing to the department or control authority that cyanide is not and will not be used in the aluminum forming process.

(2) As an alternative pretreatment monitoring procedure, the POTW user may measure and limit oil and grease to the levels shown in the pretreatment standards in lieu of measuring and regulating TTO.

(3) Compliance with the maximum monthly average effluent limitations and pretreatment standards is required regardless of the number of samples analyzed and averaged. The maximum monthly average effluent limitations and pretreatment standards shall be the basis for monthly average discharge limits in direct discharge permits and for pretreatment standards.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.05 Compliance dates. (1) Any existing source subject to this chapter which discharges to waters of the state shall achieve;

(a) the effluent limitations representing BPT by July 1, 1977; and

(b) the effluent limitations representing BAT by July 1, 1984. Register, November, 1989, No. 407 (2) Any new source subject to this chapter which discharges to waters of the state shall achieve NSPS at the commencement of discharge,

(3) Any existing source subject to this chapter which discharges process wastewater pollutants to a POTW shall achieve PSES by October 24, 1986.

(4) Any new source subject to this chapter which discharges process wastewater pollutants to a POTW shall achieve PSNS at the commencement of discharge.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.06 Removal allowances for pretreatment standards. Removal allowances for pretreatment standards pursuant to s. NR 211.13 may be granted for the toxic metals limited by this chapter when the toxic metals are used as indicator pollutants.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

Subchapter I - Rolling With Neat Oils Subcategory

NR 257.10 Applicability; description of the rolling with neat oils subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary rolling with neat oils operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.11 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the rolling operation, such as continuous rod casting, continuous sheet casting, solution heat treatment, and cleaning or etching.

(2) "Core operation" means rolling using neat oils, roll grinding, sawing, annealing, stationary casting, homogenizing, artificial aging, degreasing, and stamping.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.12 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

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Table 1 Core with an annealing furnace scrubber

	BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0,0360	0.0147
Cyanide	0.0237	0.0098
Zinc	0.119	0.0498
Aluminum	0.525	0.257
Oil and grease	1.634	0.980
Suspended solids	3,348	1,593
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Core without a	Table 2 in annealing furnace : BPT	scrubber
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium Cyanide Zinc Aluminum	0.0244 0.0161 0.0808 0.356	0.010 0.0067 0.0338 0.174
Oil and grease Suspended solids pH	1.11 2.27 (1)	0.664 1,079 (1)

¹ Within the range of 7.0 to 10 at all times.

Table 3 Continuous sheet casting spent lubricant BPT

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Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) t by continuous methods
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.00086 0.00057 0.0029 0.0127 0.0393 0.805	0.00035 0.00024 0.0012 0.0063 0.0236 0.0383

¹ Within the range of 7.0 to 10 at all times.

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Solution heat t	reatment contact cool BPT	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminu	/million off-lbs) im quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zínc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids	315.91	150.25
pH	(1)	(1)

Table 4

¹ Within the range of 7.0 to 10 at all times.

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Clea	Table 5 ning or etching bath BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zinc	0.079 0.052 0.262	0.032 0.022 0.110
Aluminum Oil and grease Suspended solids pH	1.15 3.58 7.34 (1)	0.578 2.15 3.49 (1)

¹ Within the range of 7.0 to 10 at all times.

 Table 6

 Cleaning or etching rinse and hot water seal

 BPT

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Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	6.12	2.51
Cyanide	4.04	1.67
Zinc	20.31	8.49
Aluminum	89.46	44.52
Oil and grease	278.24	166.95
Suspended solids	570,39	271,29
pH	(1)	(-)

¹ Within the range of 7.0 to 10 at all times.

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Cleaning o	Table 7 or etching scrubber lie BPT	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) cleaned or etched
Chromium	7.00	2.86
Cyanide	4.61	1.91
Zíne	23.22	9.70
Aluminum	102.24	50.88
Oil and grease 318.00 190.80		190.80
Suspended solids pH	651.90 (1)	310,05 (1)

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.13 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

Core with an	Table 8 annealing furnace sc BAT	rubber
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium Cyanide Zinc Aluminum	0.036 0.024 0.119 0.525	0.015 0.0098 0.050 0.257

Table 9 Core without an annealing furnace scrubber BAT

	DAI	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) lled with neat oils
Chromium Cyanide Zinc Aluminum	0.025 0.016 0.081 0.356	0.010 0.0067 0.034 0.174

Table 10 Continuous sheet casting spent lubricant BAT

Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) Im sheet cast
0.00086 0.00057 0.00287	0.00035 0.00024 0.0012 0.0062
	any 1 day mg/off-kg (lb of aluminy 0.00086 0.00057

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	Table 11	
Solution heat t	reatment contact cool	ing water
	BAT	
Pollutant or pollutant property	Maximum for	Maximum for
-	any 1 day	monthly average
	of aluminu	million off-lbs) m quenched
- Chromium	0.897	0.367
Cyanide	0.591	0.245
Zine	2.974	1,243
Aluminum	13.10	6.518
	Table 12	
Clea	ning or etching bath	
	BAT	
Pollutant or pollutant property	Maximum for	Maximum for
-	any 1 day	monthly average
	mg/off-kg (lb,	(million off-lbs) leaned or etched
- Chromium	0.079	0,032
	0.052	0.022
Cvanida		
	0.262	0.109
Aluminum	0.262 1.151 Table 13	0.578
Zine Atuminum Cleaning or et	0.262 1.151 Table 13 ching rinse and hot w BAT	0.573 ater seal
Zine Atuminum Cleaning or et	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for	0.573 ater seal Maximum for
Zine Atuminum Cleaning or et	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day	0.573 ater seal
Zine Atuminum Cleaning or et	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb of aluminum c	0.573 ater seal Maximum for monthly average /million off-lbs) leaned or etched
Zinc Aluminum Cleaning or et Pollutant or pollutant property - Chromium	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612	0.573 ater seal Maximum for monthly average /million off-lbs) leaned or etched 0.251
Zinc Atuminum Cleaning or eff Pollutant or pollutant property - Chromium Cyanide	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404	0.573 ater seal Maximum for monthly average (million off-ibs) leaned or etched 0.251 0.167
Zinc Aluminum Cleaning or eff Pollutant or pollutant property Chromium Cyanide Zinc	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031	0.573 ater seal Maximum for monthly average /million off-ibs) leaned or etched 0.251 0.167 0.849
Zinc Aluminum Cleaning or et Pollutant or pollutant property - Chromium	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404	0.573 ater seal Maximum for monthly average (million off-ibs) leaned or etched 0.251 0.167
Zinc Atuminum Cleaning or et Pollutant or pollutant property Chromium Cyanide Zinc Atuminum	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14	0.573 ater seal Maximum for monthly average /million off-ibs) leaned or etched 0.251 0.167 0.849 4.450
Zinc Aluminum Cleaning or eff Pollutant or pollutant property Chromium Cyanide Zinc Aluminum	0.262 1.151 Table 13 ching rinse and hof w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber lie	0.573 ater seal Maximum for monthly average /million off-ibs) leaned or etched 0.251 0.167 0.849 4.450
Zinc Atuminum Cleaning or et Pollutant or pollutant property Chromium Cyanide Zinc Atuminum	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14	0.573 ater seal Maximum for monthly average /million off-ibs) leaned or etched 0.251 0.167 0.849 4.450
Zinc Aluminum Cleaning or eff Pollutant or pollutant property Chromium Cyanide Zinc Aluminum Cleaning of	0.262 1.151 Table 13 ching rinse and hof w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber lie BAT Maximum for	0.573 ater seal Maximum for monthly average (million off-lbs) leaned or etched 0.251 0.167 0.849 4.450 guor Maximum for
Zinc Aluminum Cleaning or et Pollutant or pollutant property Chromium Cyanide Zinc Aluminum Cleaning of	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber liv BAT Maximum for any 1 day	0.573 ater seal Maximum for monthly average (million off-ibs) leaned or etched 0.251 0.167 0.849 4.450 quor Maximum for monthly average
Zinc Aluminum Cleaning or eff Pollutant or pollutant property Chromium Cyanide Zinc Aluminum Cleaning of	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber liv BAT Maximum for any 1 day mg/off-kg (lb,	0.573 ater seal Maximum for monthly average (million off-lbs) leaned or etched 0.251 0.167 0.167 0.849 4.460 Quor Maximum for monthly average (million off-lbs)
Zinc Atuminum Cleaning or eff Pollutant or pollutant property Chromium Cyanide Zinc Atuminum Cleaning Pollutant or pollutant property	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber lie BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c	0.573 ater seal Maximum for monthly average (million off-lbs) leaned or etched 0.251 0.167 0.849 4.460 Quor Maximum for monthly average (million off-lbs) leaned or etched
Zinc Atuminum Cleaning or et Pollutant or pollutant property Chromium Cyanide Zinc Atuminum	0.262 1.151 Table 13 ching rinse and hot w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber liv BAT Maximum for any 1 day mg/off-kg (lb,	0.573 ater seal Maximum for monthly average (million off-lbs) leaned or etched 0.251 0.167 0.167 0.849 4.460 Quor Maximum for monthly average (million off-lbs)
Zinc Atuminum Cleaning or eff Pollutant or pollutant property Chromium Cyanide Zinc Atuminum Cleaning Pollutant or pollutant property Chromium	0.262 1.151 Table 13 ching rinse and hof w BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.612 0.404 2.031 8.944 Table 14 or etching scrubber lie BAT Maximum for any 1 day mg/off-kg (lb, of aluminum c 0.851	0.573 ater seal Maximum for monthly average (million off-lbs) leaned or etched 0.251 0.167 0.849 4.450 quor Maximum for monthly average (million off-lbs) leaned or etched 0.348

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.14 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

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Core with an annealing furnace scrubber NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.030	0.0123 0.0065
Cyanide Zinc	0.016 0.084	0.0343
Aluminum	0.499	0.221 0.817
Oll and grease Suspended solids pH	0.817 1.225 (1)	0.980 (1)

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Table 15

¹ Within the range of 7.0 to 10 at all times.

Table 16 Core without an annealing furnace scrubber NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.021	0.0083
Cyanide	0.011	0.0044
Zinc	0.057	0.023
Aluminum	0.338	0.150
Oil and grease	0.553	0.553
Suspended solids	0.830	0.664
nH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 17 Continuous sheet casting spent lubricant NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) linum cast
Chromium Cyanide	0.00078 0.00039	0.00029 0.00016
Zinc Aluminum	0.0020 0.012	0.00082 0.0053
Oil and grease Suspended solids	0.0197 0.0295 (1)	0.019 0.022
ъH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

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Solution heat t	Table 18 reatment contact cool NSPS	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminu	/million off-lbs} Im quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
Aluminum	12.45	5.52
Oit and grease	20.37	20.37
Suspended solids	30,56	24,45
pH	(1)	(1)

¹Within the range of 7.0 to 10 at all times.

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Clea	Table 19 ning or etching bath NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb, of aluminum c	/million off-lbs) leaned or etched
Chromium	0.066	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0.485
Oil and grease	1.79	1.79
Suspended solids pH	2,69 (1)	2,15 (1)

¹ Within the range of 7.0 to 10 at all times.

Table 20
Cleaning or etching rinse and hot water seal
NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) leaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zine	1.42	0.59
Aluminum	8.50	8.70
Oil and grease	13.91	13.91
Suspended solids	20,87	16.69
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

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Cleaning or etching scrubber liquor NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.715	0.29
Cyanide	0.387	0.16
Zíne	1.97	0.81
Aluminum	11.81	5.24
Oil and grease	19.33	19.33
Suspended solids pH	29.00 (i)	23.20 (1)

Table 21 - - 1-

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.15 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

Core with an annealing furnace scrubber PSES		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.036	0.015
Cyanide	0.024	0.010
Zinc	0.119	0.050
TTO	0.057	
Oil and grease (alternate monitoring parameter)	4.30	2.10

Table 22 o.,

Tab	ole 23
Core without an anne	aling furnace scrubber
50	272

	PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.025	0.010
Cyanide	0.016	0.007
Zine	0.081	0.034
TTO	0.038	
Oil and grease (alternate monitoring parameter)	2.90	1.50

Continuo	Table 24 us sheet casting lubric PSES	cant
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alum	/million off-lbs) inum cast
Chromium Cyanide Zinc	0.00086 0.00057 0.0029	0.00035 0.00024 0.0012
TTO Oil and grease (alternate monitoring parameter)	0.0014 0.100	0.052

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Table 25
Solution heat treatment contact cooling water

	PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminu	/million off-lbs) um quenched
Chromium Cyanlde Zinc	0.90 0,69 2,98	0.37 0.25 1.25
TTO Oil and grease (alternate monitoring parameter)	1.41 110.0	53.0

Clea	Table 26 ning or etching bath PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
· · ·	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.079	0.0032
Cyanide	0.052	0.022 0.109
Zine TTO	0.262 0.124	0.109
Oil and grease (alternate monitoring parameter)	9.30	4,70

Cleaning or etc	Table 27 ching rinse and hot w PSES	ater scal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.61	0.25
Cyanide Zinc	0.41 2.03	0.17 0.85
TTO Oil and grease (alternate monitoring parameter)	0.96 73.0	36.0

Cleaning	Table 28 or etching scrubber lie PSES	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide	0.85 0.56	0.35 0.23 1.18
Zinc TTO Oil and grease (alternate monitoring parameter)	2,82 1.34 100,0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.16 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

Core with an	Table 29 annealing furnace so PSNS	crubber
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum rolled with neat oils	
Chromium Cyanide Zinc	0.030 0.017 0.084	0.013 0.007 0.035
TTO Oil and grease (alternate monitoring parameter)	0.057 0.817	0.817

Core without a	Table 30 an annealing furnace : PSNS	scrubber
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum	/million off-lbs) h with neat oils
Chromium Cyanide Zinc	0.021 0.011	0.009 0.005 0.024
Zinc TTO Oil and grease (alternate monitoring parameter)	0.057 0.038 0.54	0.54

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Continuo	Table 31 us sheet casting lubric PSNS	ant
Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	monthly average
	mg/off-kg (lb/ of alum	million off-lbs) inum cast
Chromium	0.00078	0.00029
Cyanide	0.00039 0.0020	0.00016 0.00082
Zínc TTO	0.0020	0.00082
Oil and grease (alternate	0.020	0.020
monitoring parameter)		
	Table 32	
Solution heat t	reatment contact cool PSNS	ing water
Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	monthly average
	of aluminu	/million off-lbs) m quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zíne TTO	2.08 1.41	0.86
Oil and grease (alternate monitoring parameter)	20.37	20.37
	Table 33	
Clea	ning or etching bath PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		million off-lbs)
	of aluminum c	leaned or etched
Chromium	0.067	0.027
Cyanide Zinc	0.036 0.183	0.015 0.075
TTO	0.124	0.010
Oil and grease (alternate monitoring parameter)	1.79	1.79
Cleaning or et	Table 34 ching rinse and hot w	ater seal
· · · · · · · · · · · · · · · · · · ·	PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	of aluminum c	/million off-lbs) leaned or etched
Chromium	0.52	0.21
Cyanide	0.28 1.42	0.11 0.59
Zine TTO	0.96	0.08
Oil and grease (alternate monitoring parameter)	13,91	13.91

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Cleaning o	or etching scrubber lie PSNS	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide	0.72 0.39	0.29 0.16
Zine TTO	1.97 1.34	0.81
Oil and grease (alternate monitoring parameter)	19.33	19.33

Table 35

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

Subchapter II — The Rolling With Emulsions Subcategory

NR 257.20 Applicability; description of the rolling with emulsions subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary rolling with emulsions operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.21 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the rolling operation, such as direct chill casting, solution heat treatment, cleaning or etching, and degassing.

(2) "Core operation" means rolling using emulsions, roll grinding, stationary casting, homogenizing, artificial aging, annealing, and sawing.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.22 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology cur-rently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction at-tainable by the application of BPT:

Table 36
Core operation
BPT

	<i>D</i> 1 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum rol	/million off-lbs) led with emulsions
Chromium Cyanide	0.057 0.038 0.19	0.024 0.016 0.079
Zinc Aluminum Oil and grease	0.84 2.60	0.416 1.56
Suspended solids pH	5,33 (1)	2,53 (1)

¹ Within the range of 7.0 to 10 at all times.

Direct chill cas	Table 37 sting contact cooling water BPT
/ /	

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) inum cast
Chromium	0.59	0.24
Cyanide	0.89	0.16
Zine	1.94	0.81
Aluminum	8.65	4.26
Oil and grease	26.58	15.95
Suspended solids	54,49	25,92
pH	(1)	(1)

¹ The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without commingling with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

Table 38
Solution heat treatment contact cooling water
BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) um quenched
Chromium	3.39	0.89
Cyanide	2,24	0.93
Zíne	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154,10	92.46
Suspended solids	315,91	150,25
nH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

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Table 39 Cleaning or etching bath BPT

Pollutant or pollutant property	Maximum for	Maximum for
-	any 1 day	monthly average
		/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zine	0.262	0.109
Aluminum	1.15	0.573
Oil and grease	3.58	2,15
Suspended solids	7.34	3,49
σH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

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Table	40

Cleaning or etching rinse and hot water seal BPT		
Maximum for any 1 day	Maximum for monthly average	
mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched		
6.12	2.51	
	1.67	
20.31	8.49	
89.46	44.52	
278.24	166.95	
670.39 (1)	271.29	
	ching rinse and hot w BPT Maximum for any 1 day mg/off-kg (lb of aluminum c 6.12 4.04 20.31 89.46 278.24	

¹ Within the range of 7.0 to 10 at all times.

Table 41 Cleaning or etching scrubber liquor BPT		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs)
Chromium	7.00	2.86
Cyanide	4.61	1,91
Zine	23.22	9.70
Aluminum	102.24	50.88
Oil and grease	318.00	190.80
Suspended solids	651.90 (1)	810.05 (1)

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.23 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

	Table 42 Core operation BAT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum rol	(million off-lbs) led with emulsions
Chromium Cyanide Zinc Aluminum	0.057 0.038 0.19 0.84	0.024 0.016 0.079 0.42

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	Table 43	
Direct chill c	asting contact cooling	water
	BAT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		million off-lbs)
_		num cast
Chromium	0.59	0.24
Cyanide Zinc	0.39 1.94	0.16 0.81
Aluminum	8.55	4.26
	Table 44	
Solution heat t	reatment contact cooli	ing water
	BAT	0
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/	/million off-lbs) m quenched
Chromium	0.90	0.37
Cyanide	0.59	0.25 1.25
Zinc Aluminum	2.98 13.10	6.52
	Table 45	
Clea	ning or etching bath	
*****	BAT	
Pollutant or pollutant property	Maximum for	Maximum for monthly average
-	any 1 day mg/off.kg (lb)	million off-lbs)
		leaned or etched
Chromium	0.079	0.032
Cyanide Zine	0.052 0.26	0.022 0.109
Aluminum	1.15	0.573
2 minutes (* 1998). 1990 - Maria Marian, 1990 - Maria Marian, 1990 - Maria Marian, 1990 - Maria Maria, 1990 - Maria Maria, 1990 - M 1990 - Maria Maria, 1990 - Maria	Table 46	
Cleaning or et	ching rinse and hot w BAT	ater seal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs)
Chromium	01 aluminum c 0.61	leaned or etched 0.25
Cyanide	0.61	0.25
Zinc	2.03	0.85
Aluminum	8.95	4.45

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Table 47 Cleaning or etching scrubber liquor BAT			
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched		
Chromium	0.85	0.35	
Cyanide Zinc	0.56 2.82	0.23 1.18	
Aluminum	12.43	6,19	

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.24 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

	Table 48 Core operation NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum rol	/million off-lbs) led with emulsions
Chromium	0.048	0.020
Cyanide Zinc	0.026	0.011
	0.133	0.055
Aluminum	0.80	0.35
Oll and grease	1.30	1.30
Suspended solids pH	1.95 (1)	1.56 (1)

¹ Within the range of 7.0 to 10 at all times.

Table 49	
Direct chill casting contact cooling water	
ŇSPS	

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum cast b	/million off-lbs) y continuous methods
Chromium Cyanide Zinc Aluminum Oli and grease Suspended solids pH	0.49 0.27 1.36 8.12 13.29 19.94 (1)	0.20 0.11 0.56 3.60 13.29 15.95 (1)

¹ The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without comminging with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

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Solution heat t	Table 50 reatment contact cool NSPS	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium Cyanide	0.76 0.41	0.31 0.17
Zinc	2.08	0.86
Aluminum Oil and grease	12.45 20.37	5.52 20,37
Suspended solids pH	30.56 (1)	24,45 (1)

pH¹ ¹ Within the range of 7.0 to 10 at all times.

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Clea	Table 51 ning or etching bath NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium Cyanide Zinc Aluminum	0.067 0.036 0.183 1.094	0.027 0.015 0.075 0.485
Oil and grease Suspended solids pH	1.79 1.79 2.69 (1)	0.485 1.79 2.15 (1)

¹ Within the range of 7.0 to 10 at all times.

Table 52		
 Cleaning or etching rinse and hot water seal 		
NSPS		

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zine	1.42	0.59
Aluminum	8.50	3.77
Oil and grease	18.91	13.91
Suspended solids pH	20.87 (1)	16.70 (1)

¹ Within the range of 7.0 to 10 at all times.

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Cleaning	Table 53 or etching scrubber li NSPS	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.72	0.29
Cyanide Zinc	0.39 1.97	0.16 0.81
Aluminum	11,81	5.24
Oil and grease	19.33	19.33 23,20
Suspended solids pH	29,00 (1)	20,20

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.25 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

	Table 54 Core operation PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum rol	/million off-lbs) led with emulsions
Chromium Cyanide Zinc	0.057 0.038 0.190	0.024 0.016 0.079
TTO Oil and grease (alternate monitoring parameter)	0.090 6.80	3.40

Direct chill	Table 55 casting contact cooling PSES	g water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum cast by :	/million off-lbs) semicontinuous methods
Chromium Cvanide	0.59 0.39	0.24 0.16
Cyanide Zinc TTO	1.94 0.92	0.81
Oil and grease (alternate monitoring parameter)	69.0	35.0

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Solution heat t	Table 56 reatment contact cool PSES	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluming	/million off-lbs) Im quenched
Chromium	0.90	0.37
Cyanide Zinc	0.59	0.25
Zinc TTO	2.98 1.41	1.25
Oil and grease (alternate monitoring parameter)	110.0	53.0

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Clea	ning or etching bath PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zine TTO	0.262 0,124	0.109
Oil and grease (alternate monitoring parameter)	9.30	4.70

Cleaning or et	Table 58 ching rinse and hot w PSES	ater scal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.61	0.25
Cyanide Zinc	0.41	0.17
	2.03	0.85
TTO	0.96	
Oil and grease (alternate monitoring parameter)	73.0	86.0

Cleaning	Table 59 or etching scrubber lie PSES	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb) of aluminum c	/million off-lbs) leaned or etched
Chromium	0.85	0.35
Cyanide	0.56	0.23
Zinc	2.83	1.18
TTO Oil and grease (alternate monitoring parameter)	1.34 100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.26 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which in-

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troduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

	Table 60 Core operation PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum rol	/million off-lbs) led with emulsions
Chromium Cyanide Zinc TTO	0.048 0.026 0.133 0.090	0.020 0.011 0.055
Oil and grease (alternate monitoring parameter)	1.30	1.30

Direct chill	Table 61 casting contact cooling PSNS	(water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb, of aluminum cast by s	/million off-lbs) emicontinuous methods
Chromium Cyanide	0.49 0.27	0.20 0.11
Zine TTO	$\begin{array}{c} 1.36\\ 0.92\end{array}$	0.56
Oil and grease (alternate monitoring parameter)	13.29	13.29

Solution heat t	Table 62 catment contact cool PSNS	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
**	mg/off-kg (lb of aluminu	/million off-lbs) am quenched
Chromium	0.76	0.31

	Table 63	
Oil and grease (alternate monitoring parameter)	20.37	20.37
TTO	1.41	
Cyanide Zinc	0.41 2.08	0.17 0.86
0.4 014-414		

Clea	ning or etching bath PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/ of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide	0.067 0.036	0.027 0.015
Zine TTO	0.183 0.124	0.075
Oil and grease (alternate monitoring parameter)	1.79	1,79

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Cleaning or etching rinse and not water seal PSNS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1,42	0.59
TTO	0.96	
Oil and grease (alternate monitoring parameter)	13.91	13.91

 Table 64

 Cleaning or etching rinse and hot water seal

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Table 65 Cleaning or etching scrubber liquor PSNS

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Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium Cyanide Zinc	0.72 0.39 1.97	0.29 0.16 0.81
TTO Oil and grease (alternate monitoring parameter)	1.34 19.33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

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Subchapter III — The Extrusion Subcategory

NR 257.30 Applicability; description of the extrusion subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary extrusion operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.31 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the extrusion operation, such as direct chill casting, press or solution heat treatment, cleaning or etching, degassing, and extrusion press hydraulic fluid leakage.

(2) "Core operation" means extrusion die cleaning, any wet scrubber associated with the die cleaning, dummy block cooling, stationary casting, artificial aging, annealing, degreasing, and sawing.

(3) "Extrusion die cleaning" means an operation in which the steel dies used for aluminum extrusion are cleaned by dipping the dies into a concentrated caustic bath to dissolve the aluminum and then rinsing the dies with water.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.32 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology cur-

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rently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

Table 66 Core operation BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) um extruded
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.16 0.11 0.53 2.34 7.32 15.00 15	0.066 0.044 0.22 1.16 4.39 7.13 (1)

Within the range of 7.0 to 10 at all times.

Table 67 Extrusion press leakage BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) um extruded
Chromium Cyanide Zinc	0.65 0.43 2.16	0.27 0,18 0.90
Aluminum Oil and grease	9.51 29.56	4.73 17.74 28,82
Suspended solids pH	60,60 (1)	20.02 (1)

¹ Within the range of 7.0 to 10 at all times.

Table 68 Direct chill casting contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alum	/million off-lbs) inum cast
Chromium Cyanide	0.59 0.39	0.24 0.16
Zinc Aluminum	1.94 8.55	0.81 4.26
Oil and grease Suspended solids	26.58 54.49	15.95 25,92
pH	(1)	(1)

¹ The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without comminging with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

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Tress neut ne	BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_)/million off-lbs) um quenched
Chromium	3.39	1,39
Cyanide	2,24	0.93
Zíne	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154,10	92.46
Suspended solids pH	315.91 (1)	150.25 (1)

Table 69 Press heat treatment contact cooling water PPT

¹ Within the range of 7.0 to 10 at all times.

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Table 70 Solution heat treatment contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluming	/million off-lbs} um quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zine	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids	315.91	150.25
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 71 Cleaning or etching bath BPT

	<i>D</i> 1 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zine	0.26	0.109
Aluminum	1.15	0.573
Oil and grease	3.58	2,15
Suspended solids pH	7.34 (1)	3.49 ⁽¹⁾

¹ Within the range of 7.0 to 10 at all times.

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Table 72 Cleaning or etching rinse and hot water seal RPT

	<i>D</i> 1 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	6.12	2.51
Cyanide Zinc	4.04 20.31	1.67 8.49
Aluminum Oil and museus	89.46 278.24	44.52 166.95
Oil and grease Suspended solids	570,39	271,29
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 73 Cleaning or etching scrubber liquor BPT

	<i>D</i> L 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	7.00	2.86
Cyanide	4.61	1.91
Zinc Aluminum	23.22 102.24	9.70 50.88
Oil and grease	318.00	190.80
Suspended solids	651,90	310,05
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 74	
Degassing scrubber	liquor
ТВРТ	

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) um degassed
Chromium	1.15	0.47
Cyanide	0.76	0.32
Zinc	3.81	1.59
Aluminum	16.78	8.35
Oil and grease	52.18	31.31
Suspended solids	106,97	50,88
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.33 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except a provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT. Degassing operations may not discharge wastewater pollutants.

	Table 75 Core operation BAT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/n of aluminur	nillion off-lbs)
Chromium	1.7	0.7
Cyanide	1.2	0.5
Zínc	5.7	2.4
Aluminum	25.0	13.0
EXT	rusion press leakage BAT	
Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	monthly average
	mg/off-kg (lb/r of aluminur	nillion off-lbs) n extruded
Chromium	0.65	0.27
Cyanide	0.43	0.18
Zine	2.16	0.90
Aluminum	9.51	4.73
	Table 77	

Direct chill o	asting contact cooling BAT	g water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alum	/million off-lbs) inum cast
Chromium	0.59	0.24
Cyanide	0.39	0.16
Zine	1.94	0.81
Aluminum	8,55	4.26

Table 78 Press heat treatment contact cooling water BAT

Poliutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) 1m quenched
Chromium Cyanide	0.90 0.59	0.37 0.25
Zinc Aluminum	2.98 13.10	$1.25 \\ 6.52$

Table 79 Solution heat treatment contact cooling water BAT

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Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um quenched
Chromium	0.90	0.87
Cyanide	0.59	0.25
Zine	2.98	1.25
Aluminum	13.10	6.52

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Clea	Table 80 ning or etching bath BAT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb, of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zinc Aluminum	0.079 0.052 0.262 1.15	0.032 0.022 0.109 0.58

Table 81
Cleaning or etching rinse and hot water seal
BAT

Diff		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium Cyanide	1.7 1.2	0.7 0.5
Zinc Aluminum	5.7 25.0	2.4 13.0

Cleaning	Table 82 or etching scrubber lie BAT	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zine Aluminum	0.85 0.56 2.82 12.43	0.35 0.23 1.18 6.19

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.34 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards. Degassing operations may not discharge wastewater pollutants.

	Table 83 Core operation NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) 1m extruded
Chromium	0.13	0,051
Cyanide	0.068	0.027
Zinc	0.35	0.14
Aluminum	2.07	0.92
Oil and grease	3.39	3.39
Suspended solids pH	5.10 (1)	4.07

¹ Within the range of 7.0 to 10 at all times.

Register, November, 1989, No. 407

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Extr	Table 84 usion press leakage NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/ of aluminu	(million off-lbs) Im extruded
Chromium Cyanide	0.11 0.060	0.045 0.024
Zínc	0.31	0.126
Aluminum Oil and grease	1.82 2.98	0.81 2.98
Suspended solids pH	$4_{\{1\}}^{47}$	3.58 (1)

¹ Within the range of 7.0 to 10 at all times.

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Table 85 Direct chill casting contact cooling water NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cast by semicontinuous methods	
Chromium	0.49	0.20
Cyanide	0.27	0.11
Zinc	1.36	0.56
Aluminum	8.12	3.60
Oil and grease	13.29	13.29
Suspended solids	19,94	15,95
pH	(1)	(1)

¹ The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without commingling with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

	Tabl	le 86	
Press heat	treatment	contact	cooling water
	NS	PS	•

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
Aluminum	12,45	5.52
Oil and grease	20.87	20.37
Suspended solids	30,56	24,45
Ha	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 87 Solution heat treatment contact cooling water NSPS r pollutant property Maximum for Maximum for

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) ım quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
Aluminum	12.45	5.52
Oil and grease	20.37	20.37
Suspended solids pH	30,56 (1)	24.45 (1)

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¹ Within the range of 7.0 to 10 at all times.

Table 88Cleaning or etching bathNSPS			
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
-	mg/off-kg (lb	/million off-lbs) leaned or etched	
Chromium	0.067	0.027	
Cyanide	0.036	0.015	
Zinc	0.183	0.075	
Aluminum	1.094	0.485	
Oil and grease	1.79	1.79	
Suspended solids pH	2,69	2.15 (1)	

Within the range of 7.0 to 10 at all times.

Table 89 Cleaning or etching rinse and hot water seal NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zine	1,42	0.59
Aluminum	8.50	8.77
Oil and grease	13.91	13.91
Suspended solids	20.87	16,70
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Register, November, 1989, No. 407

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	NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.72	0.29
Cyanide	0.39	0.16
Zine	1.97	0.81
Aluminum	11.81	5.24
Oil and grease	19.33	19.33
Suspended solids	29,00	23,20
pH	(1)	(1)

 Table 90

 Cleaning or etching scrubber liquor

 NSPS

¹ Within the range of 7.0 to 10 at all times.

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History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.35 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources. Degassing operations may not discharge wastewater pollutants.

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	Core operation PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluming	/million off-lbs) um extruded
Chromium Cyanide Zinc	0.15 0.098 0.49	0.061 0.041 0.21
TTO Oil and grease (alternate monitoring parameter)	0.23 18.0	8.8

Table 92
Extrusion press leakage
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluming	/million off-lbs) am extruded
Chromium	0.65	0.27
Cyanide	0.43	0,18
Zine TTO	2.16 1.02	0.90
Oil and grease (alternate monitoring parameter)	77.0	39.0

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PSES		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) inum cast
Chromium	0.59	0.24
Cyanide	0.39	0.16
Zíne	1.94	0.81
TTO	0.92	
Oil and grease (alternate monitoring parameter)	69.0	35.0

Table 93 Direct chill casting contact cooling water PSFS

Table 94 Press heat treatment contact cooling water PSES

Pollutant or pollutant property	Maximum for any 1 day 🚲	Maximum for monthly average
	mg/off-kg (lk of alumin)/million off-lbs) um quenched
Chromium	0.90	0.37
Cyanide	0.59	0.25
Zíne	2.98	1.25
тто	1.41	
Oil and grease (alternate monitoring parameter)	110.0	53.0

Table 95 Solution heat treatment contact cooling water PSES

	I OHO	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) 1m quenched
Chromium Cyanide	0.90	0.37
Zíne	0.59 2.98	$0.25 \\ 1.25$
TTO Oil and grease (alternate	1.41 110.0	53.0
monitoring parameter)		

Table 96 Cleaning or etching bath PSES

	PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium Cyanide	0.079 0.052	0.032 0.022
Zinc TTO	0.26 0.124	0.109
Oil and grease (alternate monitoring parameter)	9,30	4.70

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Cleaning or et-	Table 97 ching rinse and hot w PSES	ater seal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zinc	1.7 1.2 5.7	0.7 0.5 2.4
TTO Oil and grease (alternate monitoring parameter)	2.7 200.0	100.0

Cleaning	Table 98 or etching scrubber lie PSES	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.85	0.35
Cyanide	0.56	0.23
Zinc TTO	2.82 1.34	1.18
Oil and grease (alternate monitoring parameter)	100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.36 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources. Degassing operations may not discharge wastewater pollutants.

Table 99
Core operation

	PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um extruded
Chromium	0.13	0.05
Cyanide	0.07	0.03
Zinc TTO	0.35 0.24	0.15
Oil and grease (alternate monitoring parameter)	3,40	3.40

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Ext	Table 100 usion press leakage PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) 1m extruded
Chromium	0.11	0.05
Cyanide	0,06	0.03
Zíne	0.81	0.13
ТТО	0.21	
Oil and grease (alternate monitoring parameter)	2.98	2.98

Direct chill o	Table 101 casting contact cooling PSNS	g water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alum	/million off-lbs) inum cast
Chromium Cyanide Zinc	0.49 0.27 1.36	0.20 0.11 0.56
TTO Oil and grease (alternate	0.92 18.29	13.29

monitoring parameter)				
Table 102Press heat treatment contact cooling waterPSNS				
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average		
	mg/off-kg (lb/million off-lbs) of aluminum quenched			
Chromium	0.76	0.31		
Cyanide	0.41	0.17		
Zíne	2.08	0.86		
TTO	1,41			
Oil and grease (alternate monitoring parameter)	20.37	20.87		

Table 103 Solution heat treatment contact cooling water PSNS

	I DIND	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zine TTO	2.08 1.41	0.86
Oil and grease (alternate monitoring parameter)	20.37	20.37

Table 104 **Cleaning or etching bath** PSNS

	10110	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•**	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium Cyanide	0.067 0.036	0.027 0.015
Zinc TTO	0.183 0.124	0.075
Oil and grease (alternate monitoring parameter)	1.79	1,79

Table 105	
etching rinse and	ho

Cleaning or etching rinse and hot water seal PSNS

Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) leaned or etched
0.52	0,21
0.28	0.11
1.42	0.59
0.96	
13.91	13.91
	Maximum for any 1 day mg/off-kg (ib of aluminum o 0.52 0.28 1.42 0.96

Cleaning	Table 106 or etching scrubber li PSNS	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.72	0.29
Cyanide	0.39	0.16
Zine	1.97	0.81
TTO Oil and grease (alternate monitoring parameter)	1,34 19,33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

Subchapter IV — The Forging Subcategory

NR 257.40 Applicability; description of the forging subcategory. This sub-chapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary forging operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

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NR 257.41 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core op-eration but which is performed on-site following or preceding the forging operation, such as forging air pollution scrubbers, solution heat treatment, cleaning or etching.

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 $\left(2\right)$ "Core operation" means forging, artificial aging, annealing, degreasing, and sawing.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.44 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

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Table 107 Core operation NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		(million off-lbs) num forged
Chromium	0.019	0.008
Cyanide	0.010	0.004
Zine	0,051	0.021
Aluminum	0.305	0.135
Oil and grease	0.50	0.50
Suspended solids pH	0.75 (1)	0.60 (1)

Within the range of 7.0 to 10 at all times.

Table 108 Forging scrubber liquor NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumit	/million off-lbs) num forged
Chromium	0.035	0.014
Cyanide	0.019	0.008
Zíne	0.096	0.04
Aluminum	0.576	0.256
Oil and grease	0.943	0.95
Suspended solids pH	1.42 (1)	1.18 (1)

¹Within the range of 7.0 to 10 at all times.

Table 109 Solution heat treatment contact cooling water NSPS

	Noro	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminu	/million off-lbs) 1m quenched
Chromium	0.76	0.31
Cyanide	0.41	0.163
Zine	2.08	0.86
Aluminum	12.45	5.52
Oil and grease	20.37	20.37
Suspended solids pH	30.56 (1)	24.45 (1)

¹ Within the range of 7.0 to 10 at all times.

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Table 110 Cleaning or etching bath NSPS

	Noro	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) cleaned or etched
Chromium	0.066	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0,485
Oil and grease	1.79	1.79
Suspended solids	2.69	2.15
nH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 111 Cleaning or etching rinse and hot water scal NSPS Table 111 NSPS Table 111 NSPS Table 111 Navigue for

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide Zinc	0.28 1.42	0.11 0.59
Aluminum	8.50	3.77
Oil and grease Suspended solids	13.91 20.87	13.91 16.69
Suspended solids	20.0((i)	(1)

¹ Within the range of 7.0 to 10 at all times.

Table 112 Cleaning or etching scrubber liquor NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.72	0.29
Cyanide	0.39	0.155
Zine	1,97	0.812
Aluminum	11.81	5.24
Oil and grease	19.33	19.33
Suspended solids pH	29,00 (1)	23.20 (1)

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.45 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. 211 and achieve the following pretreatment standards for existing sources:

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	Table 113 Core operation PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) turn forged
Chromium	0.022	0.009
Cyanide	0.015	0.006
Zine TTO	0.078 0.035	0.031
Oil and grease (alternate monitoring parameter)	2.6	1.8

For	Table 114 ging scrubber liquor PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumi	/million off-lbs) num forged
Chromium Cyanide Zinc	0.042 0.028 0.140	0.017 0.011 0.058
Oil and grease (alternate monitoring parameter)	0.065 4.9	2.5

Table 115
Solution heat treatment contact cooling water
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (ib/million off-lbs) of aluminum quenched	
Chromium Cyanide	0.897 0.591	0.37 0.25
Zinc TTO	2.98 1.41	1,24
Oil and grease (alternate monitoring parameter)	110.0	53.0

Clea	Table 116 ning or etching bath PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/ of aluminum c	/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zine	0.26	0,11
TTO	0.123	
Oil and grease (alternate monitoring parameter)	9.30	4.70

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 Table 117

 Cleaning or etching rinse and hot water scal PSES

 or pollutant property

 Maximum for

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	1.7	0.7
Cyanide	1.2	0.5
Zíne	5.7	2.4
тто	2.7	
Oil and grease (alternate monitoring parameter)	200.0	100.0

Cleaning	Table 118 or etching scrubber li PSES	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.851	0.35
Cyanide Zinc	0.561 2.82	0.23 1,18
TTO Oil and grease (alternate monitoring parameter)	1.34 100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.46 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

Table 119
Core operation
PSNG

	IDNU	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) num forged
Chromium Cyanide Zinc TTO	0.019 0.010 0.051 0.035	0.008 0.004 0.021
Oil and grease (alternate monitoring parameter)	0.50	0.50

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Table 120 Forging scrubber liquor PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumi	/million off-lbs) num forged
Chromium	0.035	0.014
Cyanide	0.019	0.008
Zinc TTO	0.096 0.065	0.040
Oil and grease (alternate monitoring parameter)	0.95	0,95

Solution heat to	Table 121 ceatment contact cool PSNS	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb, of aluminu	/million off-lbs) m quenched
Chromium	0.76	0.31
Cyanide Zinc	0.41 2.08	0.16 0.86
TTO	1,41	0.00
Oil and grease (alternate	20.37	20.37

Oil and grease (alternate monitoring parameter)

Table 122 Cleaning or etching bath PSNS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb, of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide	0.067 0.036	0.027 0.015
Zíne TTO	0.183 0.124	0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

Table 123
Cleaning or etching rinse and hot water seal
PSNS

D. Nutrat Nutrat		37 3
Pollutant or pollutant property	Maximum for	Maximum for
_	any 1 day	monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zíne	1.42	0.59
ТТО	0.96	
Oil and grease (alternate monitoring parameter)	13.91	13.91

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Table 124 Cleaning or etching scrubber liquor PSNS			
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched	
Chromium Cyanide	0,72 0.39	0.29 0.16	
Zine TTO Oil and more fallements	1.97 1.34 19.33	0.812 19.33	
Oil and grease (alternate monitoring parameter)	12.00	19,55	

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

Subchapter V — The Drawing With Neat Oils Subcategory

NR 257.50 Applicability; description of the drawing with neat oils subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary drawing with neat oils operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.51 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the drawing operation, such as continuous rod casting, solution heat treatment, and cleaning or etching.

(2) "Core operation" means drawing with neat oils, stationary casting, artificial aging, annealing, degreasing, sawing, and swaging.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.52 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

	Table 125 Core operation BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum dr	/million off-lbs) awn with neat oils
Chromium Cyanide Zinc	0.022 0.015 0.073	0.0090 0.0050 0.031
Aluminum Oil and grease Suspended solids DH	0.97 2.04 (1)	$0.598 \\ 0.972 \\ (1)$

¹ Within the range of 7.0 to 10 at all times.

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Continuous	Table 126 rod casting spent lub BPT	ricant
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc Aluminum	0.00086 0.00057 0.00287 0.0127	0.00035 0.00024 0.0012 0.0063
Oil and grease Suspended solids pR	0.0393 0.0805 (T)	0.0236 0.0383 (1)

pH ¹ Within the range of 7.0 to 10 at all times.

Continuous roo	Table 127 I casting contact cool BPT	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide	0,684 0,451	0.28 0.187
Zine Aluminum	2.271 10.00	0.949 4.976
Oil and grease Suspended solids pH	31.10 63.76	18.66 30,322

¹ Within the range of 7.0 to 10 at all times.

Table 128 Solution heat treatment contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) Im quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zinc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids pH	315,91	150.25

¹ Within the range of 7.0 to 10 at all times.

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Table 129	
Cleaning or etching	bath

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Maximum for any 1 day	Maximum for monthly average
mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
0.079	0.032
0.052	0.022
0.26	0,11
1.150	0.57
3.58	2.15
7,34	8,49
(1)	(1)
	any 1 day mg/off-kg (lb of aluminum of 0.079 0.052 0.26 1.150

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¹ Within the range of 7.0 to 10 at all times.

Table 130 Cleaning or etching rinse and hot water seal BPT			
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched	
Chromium Cyanide	6.12 4.40	2.51 1.67	
Zíne	20.31	8.49	
Aluminum Oil and grease	89.46 278.24	44.52 166.95	
Suspended solids pH	570.39 (1)	271.29 (1)	

¹ Within the range of 7.0 to 10 at all times.

Cleaning o	Table 131 or etching scrubber lie BPT	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide	7.00 4.61	2.86 1.91
Zinc Aluminum	23.22 102.24	9.70 50.88
Oil and grease	318.00	190.80
Suspended solids pH	651.90 (1)	310,05 (1)

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.53 Effluent limitations representing the degree of effluent reduc-tion attainable by the application of the best available technology economi-cally achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the fol-lowing effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

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	Table 132 Core operation BAT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum dr	/million off-lbs) awn with neat oils
Chromium	0.022	0.009
Cyanide	0.015	0.006
Zine	0.073	0.031
Aluminum	0.321	0.16

Table 133 rod casting spent lub BAT	ricant
Maximum for	Maximum for monthly average
mg/off-kg (lb)	/million off-lbs) um rod cast
0.00086	0.0004
	0.0002
	0.0012 0.0063
BÅT Maximum for	ng water Maximum for monthly average
mg/off-kg (lb,	/million off-lbs) um rod cast
0.086	0.035
	0.024
	0.118
1,247	0.621
Table 135	
reatment contact cool	ing water
BAT	
	rod casting spent lub BAT Maximum for any 1 day mg/off-kg (lb, of alumin 0.00086 0.0029 0.0127 Table 134 d casting contact cooli BAT Maximum for any 1 day mg/off-kg (lb, of alumin 0.086 0.056 0.283 1.247

0.896	0.367
0.591	0.245
2.974	1.243
13.10	6.519
	0.591 2.974

Cle	Table 136 aning or etcing bath BAT	
Pollutant or pollutant property	Maximum for any 1 day mg/off-kg (lb, of aluminum c	Maximum for monthly average /million off-lbs) leaned or etched
Chromium Cyanide Zinc Aluminum	0.079 0.052 0.262 1.151	0.032 0.022 0.109 0.563

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Cleaning or et	Table 137 ching rinse and hot w BAT	ater seal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
·	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium Cyanide Zinc Aluminum	0.512 0.404 2.031 8.944	0.251 0.167 0.849 4.451

Cleaning	Table 138 or etching scrubber lie BAT	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zinc Aluminum	0.851 0.561 2.82 12.43	0.348 0.232 1.179 6.19

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.54 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

	Table 139 Core operation NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum dr.	/million off-lbs) awn with neat oils
Chromium	0.019	0.008
Cyanide	0.010	0,004
Zine	0.051	0.021
Aluminum	0.304	0.135
Oil and grease	0.498	0.498
Suspended solids pH	0.747 (1)	0.598 (1)

¹ Within the range of 7.0 to 10 at all times.

Continuous	Table 140 rod casting spent lub NSPS	ricant
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium	0.0008	0.0003
Cyanide Zinc	0.0004 0.002	0.0002 0.0008
Aluminum	0.012	0.006
Oil and grease	0.02	0.02
Suspended solids pH	0.03	0.024 (1)

¹ Within the range of 7.0 to 10 at all times.

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#### Table 141 Continuous rod casting contact cooling water NSPS Pollutant or pollutant property Maximum for any 1 day monthly average

mg/off-kg (lb/million off-lbs)
of aluminum rod cast
Chromium 0.072 0.029
Cyanide 0.039 0.016
Zinc 0.198 0.082
Aluminum 1.185 0.526
Oil and grease 1.939 1.939
Suspended solids 2.909 2.327 pH (1) (1)

¹ Within the range of 7.0 to 10 at all times.

### Table 142 Solution heat treatment contact cooling water NSPS Pollutant or pollutant property Maximum for any 1 day Maximum for monthly average mg/off-kg (ib/million off-lbs) of aluminum quenched 0.754 0.306 Chromium Cyanide 0.754 0.306 Zinc 2.08 0.856 Aluminum 12.45 5.52 Oil and grease 20.37 20.37 Suspended solids 30.56 24.45 pH (1) (1)

¹ Within the range of 7.0 to 10 at all times.

#### Table 143 Cleaning or etching bath NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb	/million off-lbs) leaned or etched
Chromium	0.066	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0.485
Oil and grease	1.79	1.79
Suspended solids pH	2,69 (1)	2,15 (1)

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¹ Within the range of 7.0 to 10 at all times.

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Cleaning or et	Table 144 ching rinse and hot w NSPS	ater seal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium Cyanide	0.515 0.278	0.209 0.111
Zine Aluminum	1.42 8.50	0.584 3.77 12.01
Oil and grease Suspended solids pH	13.91 20.87 (1)	13.91 16.70 (1)

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¹ Within the range of 7.0 to 10 at all times.

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Cleaning o	Table 145 or etching scrubber lie NSPS	Juor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.715	0.290
Cyanide	0.387	0.155
Zinc	1.97	0.812
Aluminum	11.81	5.24
Oil and grease	19.33	19.33
Suspended solids	29,00 (1)	23.20 (1)

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¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.55 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

Table 146 Core operation PSES

	1000	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum dr	/million off-lbs) awn with neat oils
Chromium Cyanide Zinc	0.022 0.015 0.073	0.009 0.006 0.031
TTO Oil and grease (alternate monitoring parameter)	0.035 2.6	1.3

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0.052

Continue	Table 147 ous rod casting lubric: PSES	ant
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc mmo	0.0009 0.0006 0.0029	0.0004 0.0003 0.0012

	or anumum roc	i cast
Chromium	0.0009	
Cyanide	0.0006	
Zinc	0.0029	
TTO	0.0014	
Oil and grease (alternate monitoring parameter)	0.10	
Continuous ro	Table 148 d casting contact cooling wa PSES	ater
Pollutant or pollutant property	Maximum for	Ma

Maximum for any 1 day			
mg/off-kg (lb/million off-lbs) of aluminum rod cast			
0.086	0.035		
0.057	0.023		
0.283	0.118		
0.133			
10.00	5,10		
	any 1 day mg/off-kg (lb 0.086 0.057 0.283 0.133		

Table 149			
Solution heat treatment contact cooling water			
PSES			

	I OLIO	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium Cyanide Zinc	0.896 0.591 2.98	0.367 0.245 1.24
TTO Oil and grease (alternate monitoring parameter)	1.41 110.0	53.0

Clea	Table 150 ning or etching bath PSES		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
-	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched		
Chromium	0.079	0.033	
Cyanide	0.052	0.022	
Zíne	0.262	0.109	
TTO	0.124		
Oil and grease (alternate monitoring parameter)	9.30	4.70	

Cleaning or et	Table 151 ching rinse and hot w PSES	ater seal	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
-	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched		
Chromium	0.612	0.251	
Cyanide	0.404	0.17	
Zine	2.03	0.85	
TTO	0.96		
Oil and grease (alternate monitoring parameter)	73.0	36.0	

#### Table 152 Cleaning or etching scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zine TTO	0.851 0.561 2.82 1.34	0.348 0.232 1.18
Oil and grease (alternate monitoring parameter)	100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.56 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

Table 153
Core operation

	PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum drawn with neat oils	
Chromium	0.019	0.008
Cyanide	0.010	0.004
Zinc TTO	0.051 0.035	0.021
Oil and grease (alternate monitoring parameter)	0.50	0.50

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	PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium	0.0007	0.0003
Cyanide	0.0004	0.0002
Zinc TTO	0.0020 0.0014	0.0008
Oil and grease (alternate monitoring parameter)	0.020	0.020

#### Table 154 Continuous rod casting lubricant PSNS

	Table	155		
<b>Continuous rod</b>	casting	contact	cooling	water
PSNS				

	I MIND	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium	0.072	0.029
Cyanide	0.039	0.016
Zinc	0.198	0.082
TTO	0.134	
Oil and grease (alternate	1.94	1.94
monitoring parameter)		

## Table 156 Solution heat treatment contact cooling water PSNS

	rono	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluming	/million off-lbs) m quenched
Chromium Cyanide	0.76 0.41	0.306 0.163
Zinc TTO Oil and grease (alternate	2.08 1.41 20.37	0.856
monitoring parameter)		

#### Table 157 Cleaning or etching bath PSNS

1 61 16	
Maximum for any 1 day	Maximum for monthly average
mg/off-kg (lb of aluminum of	/million off-lbs) leaned or etched
0.067	0.027
0.036	0.015
0.183	0.075
0.124	
1.79	1.79
	any 1 day mg/off-kg (lb of aluminum of 0.067 0.036 0.183 0.124

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Table 158 Cleaning or etching rinse and hot water seal

	PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) leaned or etched
Chromium	0.52	0,21
Cyanide	0.28	0,11
Zine TTO	1.42 0.96	0.59
Oil and grease (alternate monitoring parameter)	13.91	13.91

Cleaning	Table 159 or etching scrubber lic PSNS	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb, of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zinc	0.72 0.39 1.97	0.29 0.16 0.812
TTO Oil and grease (alternate monitoring parameter)	1,34 19.33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

#### Subchapter VI — The Drawing With Emulsions or Soaps Subcategory

NR 257.60 Applicability; description of the drawing with emulsions or soaps subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary drawing with emulsions or soaps operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.61 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the drawing operation, such as continuous rod casting, solution heat treatment, and cleaning or etching.

(2) "Core operation" means drawing with emulsions or soaps, stationary casting, artificial aging, annealing, degreasing, sawing, and swaging.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.62 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

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	Table 160 Core operation BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium	0.205	0.084
Cyanide	0.135	0.056
Zinc	0.680	0.285
Aluminum	3.00	1.50
Oil and grease	9.33	5,60
Suspended solids	19.12	9.10
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

## Table 161 Continuous rod casting spent lubricant BPT

	BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) inum cast
Chromium	0.0009	0.0004
Cyanide	0.0006	0.0003
Zinc	0.0029	0.001
Aluminum	0.013	0.007
Oil and grease	0.040	0.024
Suspended solids	0.081	0,039
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

#### Table 162 Continuous rod casting contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) inum cast
Chromium	0.684	0.28
Cyanide	0.450	0.187
Zínc Aluminum	2.27	0.949
Oil and grease	10.00 31.10	4.976 18.66
Suspended solids	63.76	30,323
pH	(1)	(1)

¹ Within the range of 7.0 to 10 at all times.

 Table 163
 Solution heat treatment contact cooling water

 RPT
 RPT

	RLL	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (ll	o/million off-lbs) um quenched
Chromium Cyanide	3.39 2.24 11.25	1.39 0.93 4.70
Zinc Aluminum Oil and grease	49.55 154.10	24,66 92,46
Suspended solids pH	815.91 (1)	150,25 (1)

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¹ Within the range of 7.0 to 10 at all times.

Clea	Table 164 ning or etching bath BPT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide	0.079 0.052	0.032 0.022
Zinc Aluminum Oil and grease	0.262 1.15 3.58	0.109 0.573 2.15
Suspended solids	7.34 (1)	3.49 (1)

pH ¹ Within the range of 7.0 to 10 at all times.

Cleaning or et	Table 165 ching rinse and hot w BPT	ater seal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium	6.12	2.51
Cyanide	4.04	1.67
Zinc	20.31	8.49
Aluminum	89.46	44,519
Oil and grease	278.24	166.95
Suspended solids	570.89	271.29
nH	(1)	(1)

pH ¹ Within the range of 7.0 to 10 at all times.

228-1	16	
	NR	257

Cleaning	BPT	4um
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide	7.00 4.61	2.86 1.91
Zine Aluminum	23.22 102.24	9.70 50.88
Oil and grease Suspended solids	318.00 651,90	190.80 310.05
pH	(1)	(i)

Table 166 Cleaning or etching scrubber liquor

¹ Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.63 Effluent limitations representing the degree of effluent reduction attainable by the application of best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.80 to 125.82, any existing point source subject to this subchapter shall achieve the follow-ing effluent limitations representing the degree of effluent reduction at-tainable by the application of BAT:

	Table 167 Core operation BAT	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum drawn y	/million off-lbs) with emulsions or soaps
Chromium Cyanide Zinc Aluminum	0.205 0.135 0.681 3.00	0.084 0.056 0.285 1.49

Continuous	Table 168 rod casting spent lub BAT	ricant
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc Aluminum	0,0009 0.0006 0.0029 0.013	0.0004 0.0003 0.0012 0.0063

### Table 169 Continuous rod casting contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) um rod cast
Chromium Cyanide Zinc	0.086 0.056 0.283	0.035 0.024 0.118
Aluminum	1.25	0.62

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Solution heat t	Table 170 reatment contact cooli	ind wefer
Solution near t	BAT	ing mater
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/	million off-lbs)
Chromium	0.897	m quenched 0.37
Cyanide	0.591	0.25
Zinc	2.98	1.24
Aluminum	13.10	6.52
	Table 171	
Clea	ning or etching bath BAT	
Dell fant og villetant og varder		Maximum for
Pollutant or pollutant property	Maximum for any 1 day	monthly average
	mg/off-kg (lb	/million off-lbs)
		leaned or etched
Chromium Cvanide	0.079 0.052	0.032 0.022
Zine	0.262	0.11
Aluminum	1.15	0.57
	Table 172	
Cleaning or e	tching rinse and hot w	ater seal
	BAT	
Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	monthly average
	mg/off-kg (lb	/million off-lbs) leaned or etched
Chromium	0.612	0.251
Cyanide	0.404	0.167
Zine	2.03	0.849
Aluminum	8.95	4.45
	Table 173	
Cleaning	or etching scrubber li BAT	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.85	0.348
Cyanide	0.561	0,282
Zine	2,82	1.18 6.19
Aluminum	12.43	0,10

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.64 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

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	Table 174 Core operation NSPS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium	0.178	0.070
Cyanide Zinc	0.094 0.476	0.038 0.196
Aluminum	2.85	1.27
Oil and grease Suspended solids	4.67	4.67
pH	7,00 (1)	5.60 (1)

¹ Within the range of 7.0 to 10 at all times,

Table 175 Continuous rod casting spent lubricant NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium	0.0008	0.0003
Cyanide	0.0004	0.0002
Zine	0.0020	0.0008
Aluminum	0.012	0.0053
Oil and grease	0.020	0.020
Suspended solids pH	0.030	0.024 (1)

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¹ Within the range of 7.0 to 10 at all times.

Continuous rod	Table 176   casting contact cooli NSPS	ng water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium	0.072	0.029
Cyanide Zinc	0.039 0.198	0.016 0.081
Aluminum	1,184	0.526
Oil and grease	1,940	1.940
Suspended solids pH	2.91 (1)	2.33 (1)

 $\frac{\text{pH}^2}{1}$  Within the range of 7.0 to 10 at all times.

	228-1	19
NR	257	

Solution heat treatment contact cooling water NSPS		
llutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminu	/million off-lbs) im quenched
-		

Table 177

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lt of alumin	/million off-lbs) um quenched
Chromium Cyanide Zinc Aluminum Oli and grease Suspended solids pH	$\begin{array}{c} 0.754\\ 0.408\\ 2.08\\ 12.450\\ 20.00\\ 20.56\\ (1)\end{array}$	$\begin{array}{c} 0.31 \\ 0.16 \\ 0.86 \\ 5.52 \\ 20.37 \\ 24.45 \\ (1) \end{array}$

¹ Within the range of 7.0 to 10 at all times.

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aximum for hthly average
-lbs) tched
0.027
0.015 0.075
0.49
1.79 2.15

pH ¹ Within the range of 7.0 to 10 at all times.

Cleaning or et	Table 179 ching rinse and hot w NSPS	ater scal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium Cyanide Zinc Abustiana	0,515 0.278 1.42 8.50	0.21 0.11 0.59 3.77
Aluminum Oil and grease Suspended solids pH	13.911 20.87 (1)	13.91 16.70 (1)

pH¹ ¹Within the range of 7.0 to 10 at all times.

228-120 NR 257	
NK 257	

Cleaning or etching scrubber liquor NSPS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	0.72	0.290
Cyanide	0.387	0.155
Zinc	1.97	0.812
Aluminum	1.18	5.24
Oil and grease	19.33	19.88
Suspended solids	29.00	23.20
pH	(1)	(1)

### Table 180

Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.65 Pretreatment standards for existing sources. Except as pro-vided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch, NR 211 and achieve the following pretreatment standards for ex-isting sources:

Table 181 Core operation PSES	
Maximum for	Maximum for
any 1 day	monthly average
mg/off-kg (lb	/million off-lbs)
of aluminum drawn y	with emulsions or soaps
0.205	0.084
0.135	0.056
0,681 0.32 25.0	0.285 12.0
	Core operation PSES Maximum for any 1 day mg/off-kg (lb of aluminum drawn v 0.205 0.135 0.681 0.32

Continue	Table 182 ous rod casting lubrica PSES	ant
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb) of alumin	/million off-lbs) um rod cast
Chromium Cyanide	0.0009 0.0006	0.0004 0.0003
Zine TTO	0.0029 0.0014	0.0012
Oil and grease (alternate monitoring parameter)	0.10	0.052

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228-121 NR 257

 Table 183

 Continuous rod casting contact cooling water

 PSES

	PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium	0.086	0.085
Cyanide	0.056	0.024
Zine	0.283	0.119
TTO	0.134	
Oil and grease (alternate monitoring parameter)	10.0	5.1

Solution heat t	Table 184 reatment contact cool PSES	ing water
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•	mg/off-kg (lb of aluminu	/million off-lbs) im quenched
Chromium Cyanide Zinc	0.896 0.591 2.98	0.867 0.245 1.25
TTO Oil and grease (alternate monitoring parameter)	1.41 110.0	53.0

Clea	Table 185 ning or etching bath PSES	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/ of aluminum cl	million off-ibs) eaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zíne	0.262	0.11
TTO	0.124	
Oil and grease (alternate monitoring parameter)	9.30	4.70

Cleaning or et	Table 186 ching rinse and hot w PSES	ater scal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs) leaned or etched

of aluminum c	of aluminum cleaned or etched	
0.612	0.251	
0.404	0,167	
2.03	0.849	
0,96		
73.0	36.0	
	0.612 0.404 2.03 0.96	

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228-12	22	
	NR	257

Cleaning	or etching scrubber lie PSES	quor
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.851	0.348
Cyanide Zinc	0.561 2.82	0.232 1.18
TTO Oil and grease (alternate monitoring parameter)	1.34 100.0	50.0

Table 187

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.66 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which in-troduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

	Table 188 Core operation PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum drawn y	/million off-lbs) with emulsions or soaps
Chromium Cyanide Zinc	0.173 0.094 0.48	0.070 0.038 0.196
Oll and grease (alternate monitoring parameter)	0.32 4.67	4.67

#### Table 189 Continuous rod casting lubricant PSNS

	I DINO	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium Cyanide Zinc TTO	0.0008 0.0004 0.0020 0.0014	0.0003 0.0002 0.0008
Oil and grease (alternate monitoring parameter)	0.020	0.020

228-123 NR 257

 Table 190

 Continuous rod casting contact cooling water

 DSNS

	PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc	0.072 0.039 0.198	0.029 0.016 0.082
TTO Oil and grease (alternate monitoring parameter)	0.134 1.94	1.94

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Table 191 Solution heat treatment contact cooling water PSNS		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) Im quenched
Chromium Cyanide Zinc	0.76 0.41	0.806 0.163
TTO	$\begin{array}{c} 2.08 \\ 1.41 \\ \end{array}$	0.856
Oil and grease (alternate monitoring parameter)	20.37	20.37

Clea	Table 192 ning or etching bath PSNS	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/ of aluminum cl	million off-lbs) eaned or etched
Chromium Cyanide	0.067 0.036	0.027 0.015
Zinc TTO	0.183 0.124	0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

Cleaning or eff	Table 193 ching rinse and hot w PSNS	ater seal
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs) cleaned or etched
Chromium Cyanide	0.52 0.28	0.21 0.11
Zinc TTO	1.42 0.96	0.59
Oil and grease (alternate monitoring parameter)	13.91	13.91

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Cleani	ng or etching scrubbe PSNS	r
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum c	/million off-lbs) leaned or etched
Chromium	0.715	0.290
Cyanide Zinc	0.387 1.97	0.155 0.812
TTO	1.34	
Oil and grease (alternate monitoring parameter)	19.33	19.33

Table 194

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

Note: The Wisconsin administrative code corresponds to the code of federal regulations according to the following table:

Corresponding Feder	al Regulation
40 C.F.R. s.	401.Ĭ1
40 C.F.R. s.	401.11
40 C.F.R. Part	403
40 C.F.R. s.	403.3
40 C.F.R. s.	403.7
40 C.F.R. s.	403.13
40 C.F.R. Part	467
	40 C.F.R. s. 40 C.F.R. Part 40 C.F.R. s. 40 C.F.R. s.