

Chapter NR 422

**CONTROL OF ORGANIC COMPOUND EMISSIONS
FROM SURFACE COATING, PRINTING AND ASPHALT
SURFACING OPERATIONS**

NR 422.01	Applicability; purpose (p. 137)	NR 422.11	Surface coating of large appliances (p. 151)
NR 422.02	Definitions (p. 137)	NR 422.12	Magnet wire coating (p. 151)
NR 422.03	Exemptions (p. 142)	NR 422.13	Flat wood panel coating (p. 152)
NR 422.04	Methods of compliance (p. 144)	NR 422.14	Graphic arts (p. 152)
NR 422.05	Can coating (p. 146)	NR 422.145	Screen printing (p. 153)
NR 422.06	Coil coating (p. 147)	NR 422.15	Miscellaneous metal parts and products (p. 154)
NR 422.07	Paper coating (p. 147)	NR 422.155	Fire truck and emergency response vehicle manufacturing (p. 154-2)
NR 422.08	Fabric and vinyl coating (p. 148)	NR 422.16	Use of asphalt surfacing materials (p. 154-3)
NR 422.085	Leather coating (p. 148)		
NR 422.09	Automobile and light-duty truck manufacturing (p. 149)		
NR 422.10	Furniture metal coating (p. 151)		

NR 422.01 Applicability; purpose. (1) **APPLICABILITY.** This chapter applies to all surface coating and printing process air contaminant sources and to their owners and operators. This chapter also applies to the handling and use of cutback asphalts for application to surfaces traversed by motor vehicles, bicycles or pedestrians and to all persons responsible for such handling and use.

(2) **PURPOSE.** This chapter is adopted under ss. 144.31 and 144.38, Stats., to categorize organic compound emissions from surface coating, printing and asphalt surfacing operations into separate organic compound air contaminant source categories and to establish emission limitations or other requirements for these categories of sources in order to protect air quality.

History: Cr. Register, September, 1986, No. 369, eff. 10-1-86; am. Register, February, 1990, No. 410, eff. 3-1-90.

NR 422.02 Definitions. In addition to the definitions in this section, the definitions contained in chs. NR 400, 419, 420 and 421 apply to the terms used in this chapter.

(1) "Air dried coating" means coatings which are dried by the use of air or forced warm air. Forced warm air includes processes whereby the coated object is heated above ambient temperature up to a maximum of 90°C (194°F) to decrease drying time.

(2) "Application area" means the area where a coating is applied by spraying, dipping or flow coating techniques.

(3) "Asphalt" means a dark-brown to black cementitious material (solid, semisolid, or liquid in consistency) in which the predominating constituents are bitumens which occur in nature as such or which are obtained as residue in refining petroleum.

(4) "Baseline transfer efficiency" means the typical transfer efficiency, as defined by the department, for a specific operation in an industry.

(5) "Blade coating" means the application of a coating material to a substrate by means of drawing the substrate beneath a straight-edged blade that spreads the coating evenly over the full width of the substrate.

(7) "Class II hardboard paneling finish" means finishes which meet the specifications of Voluntary Product Standard PS-59-73 as approved by the American National Standards Institute. This standard is incorporated by reference in ch. NR 484.

(8) "Clear coat" means a coating which lacks color and opacity or is transparent and uses the undercoat as a reflectant base or undertone color.

(9) "Coating applicator" means a device or devices used at a single location in a coating line to apply a surface coating of a particular material.

(10) "Coating line" means one or more apparatus or operations, which may include a coating applicator, flashoff area, and oven, wherein a surface coating is applied, dried, or cured.

(11) "Coil coating" means the coating of any flat metal sheet or strip that comes in rolls or coils.

(11m) "Conductive ink" means an ink used in screen printing which contains material that permits electric current to flow through printed lines or patterns.

(12) "Cutback asphalt" means asphalt cement which has been liquefied by blending with petroleum solvents (diluent) other than residual oils. Upon exposure to atmospheric conditions the diluents evaporate, leaving the asphalt cement to perform its function. Asphalt which contains less than 5% by weight petroleum solvents (disregarding any residual oils added) is not included in this definition.

(12m) "Emergency response vehicle" means any motor vehicle specifically designed to carry equipment and personnel involved in providing emergency medical or rescue services.

(12s) "Emulsified asphalt" means an emulsion of asphalt cement and water which contains a small amount of an emulsifying agent; a heterogeneous system containing 2 normally immiscible phases (asphalt and water) in which the water forms the continuous phase of the emulsion, and minute globules of asphalt form the discontinuous phase.

(13) "End sealing compound" means a synthetic rubber compound which is coated onto can ends and which functions as a gasket when the end is assembled on the can.

(14) "Exterior base coating" means a coating applied to the exterior of a can to provide exterior protection to the metal and to provide background for the lithographic or printing operation.

(15) "Extreme performance coatings" means coatings designed for harsh exposure or exposure to one or more of the following: the weather all of the time, temperatures consistently above 95°C, detergents, abrasive and scouring agents, solvents, corrosive atmospheres, or similar environmental conditions.

(16) "Fabric coating" means applying a coating, including a saturation coating, or printing on to a textile substrate with a blade, roll, rotogravure or dip coater, or other coating applicator, to impart properties that are not initially present, such as strength, stability, water or acid repellancy, or appearance.

(16m) "Fire truck" means any motor vehicle specifically designed to be used in fighting fires and to carry equipment and personnel involved in fighting fires.

(17) "Flashoff area" means the space between the application area and the oven.

(18) "Flexographic printing" means the application of words, designs or pictures to a substrate by means of a roll printing technique in which the pattern to be applied is raised above the printing roll and the image carrier is made of rubber or other elastomeric materials.

(19) "Furniture metal coating" means the surface coating of any furniture made of metal or any metal part which will be assembled with other metal, wood, fabric, plastic or glass parts to form a furniture piece.

(20) "Hardboard" means a panel manufactured primarily from interfelted ligno-cellulosic fibers which are consolidated under heat and pressure in a hot press.

(21) "Hardwood plywood" means a plywood whose surface layer is a veneer of hardwood.

(21m) "High performance architectural coatings" means a coating which meets the requirements specified in Architectural Aluminum Manufacturer's Association publication number AAMA 605.2-1985, incorporated by reference in ch. NR 484.

(21s) "Ink transfer" means a decal, printed using screen printing onto a special release carrier, that will be transferred from the carrier to a substrate. Final transfer of the decal to the substrate may or may not occur at the screen printing facility.

(22) "Interior sheet base coating" means a coating applied by roller coater or spray to the interior side of sheets from which cans are formed to provide a protective lining between the can metal and product.

(23) "Interior body spray" means a coating sprayed on the interior of the can body to provide a protective film between the product and the can.

(24) "Large appliances" means doors, cases, lids, panels and interior support parts of residential and commercial washers, dryers, ranges, refrigerators, freezers, water heaters, dishwashers, trash compactors, air conditioners and other similar products. Not included are products of such weight that they are normally lifted only with powered lifting equipment or products which are intended to be permanently fastened in place.

(24m) "Leather coating" means the coating of any raw or processed leather material with a roll coater, spray system, or other coating applicator to impart or enhance properties such as strength, stability, water or acid repellency, color or appearance.

(25) "Low solvent coating or ink" means a coating or ink which contains less organic solvent than the conventional coatings used by the particular industry. Low solvent coatings or inks include water-borne, higher solids, electrodeposition and powder coatings or inks.

(26) "Magnet wire coating" means the process of applying a coating of electrically insulating varnish or enamel to aluminum or copper wire for use in electrical machinery.

(27) "Manufacturing plant" means a facility where parts are manufactured, finished or assembled for eventual inclusion into a finished product ready for sale to retailers. With respect to the manufacture of motor vehicles, customizers, body shops and other repainters are not included in this definition.

(28) "Natural finish hardwood plywood panels" means panels whose original grain pattern is enhanced by essentially transparent finishes which may be supplemented by fillers and toners.

(28m) "Organisol" means a thick coating containing resin, plasticizers and organic solvent used to coat flexible substances such as paper or fabrics.

(29) "Oven" means, for the purpose of surface coating, a chamber within which heat is used to bake, cure, polymerize, or dry a surface coating.

(30) "Overvarnish" means a coating applied directly over ink to reduce the coefficient of friction, to provide gloss and to protect the finish against abrasion and corrosion.

(31) "Packaging rotogravure printing" means rotogravure printing upon paper, paper board, metal foil, plastic film, or other substrates, which in subsequent operations are formed into packaging products or labels for articles to be sold.

(32) "Paper coating" means application of the uniform coatings, including saturation coatings, put on paper and pressure sensitive tape in a web process. Related web coating processes on plastic films and on metal foil are included in this definition but processes such as printing where the coating is not uniform across the web are not included.

(33) "Penetrating prime coat" means an application of low-viscosity liquid asphalt to an absorbent surface to prepare it for an asphalt surface.

(33g) "Plastisol" means a composition of finely divided resin and plasticizer used to coat flexible substances such as paper or fabrics which is applied as a thick gel which solidifies when heated.

(33m) "Pretreatment coat" means a coating applied directly to metal substrates and which contains at least ½% acid, by weight, and is used to provide surface etching, corrosion resistance and enhanced adhesion of subsequent coatings.

(34) "Prime coat" means a coating applied directly to a substrate or on top of a pretreatment coat or other coating for purposes of providing corrosion resistance or enhancing adhesion or blister resistance of subsequent coatings.

(35) "Printed interior panels" means panels whose grain or natural surface is obscured by fillers and basecoats upon which a simulated grain or decorative pattern is printed.

(36) "Publication rotogravure printing" means rotogravure printing upon paper which is subsequently formed into books, magazines, catalogues, brochures, directories, newspaper supplements, and other types of printed materials.

(37) "Quench area" means a chamber where the hot metal exiting the oven is cooled by either a spray of water or a blast of air followed by water cooling.

(38) "Roll coating" means the application of a coating material to a substrate by means of hard rubber or steel rolls.

(39) "Roll printing" means the application of words, designs or pictures to a substrate, usually by means of a series of hard rubber or steel rolls each with only partial coverage.

(40) "Rotogravure coating" means the application of a coating material to a substrate by means of a roll coating technique in which the pattern to be applied is etched on the coating roll. The coating material is transferred to the substrate from the recessed areas on the coating roll.

(41) "Rotogravure printing" means the application of words, designs or pictures to a substrate by means of a roll printing technique which involves an intaglio or recessed image areas in the form of cells.

(41m) "Saturation coating" means application of a coating which permeates the substrate to which it is applied.

(41p) "Screen printing" means a process in which ink or coating is passed through a taut screen mesh or fabric, to which a refined form of stencil has been applied, onto a substrate. The stencil openings determine the form and dimensions of the imprint made on the substrate.

(41s) "Screen printing unit" means a printing application station and its associated flash-off area, ovens or dryers, conveyors or other equipment operating as part of the screen printing process. Screen reclamation is considered to be part of the screen printing process.

(41v) "Screen reclamation" means the removal of the stencil or of residual ink or coating from the screen mesh or fabric after excess ink or coating has been removed from the screen or fabric.

(42) "Single coat" means a single film of coating applied directly to a metal substrate, omitting the primer application.

(42m) "Special purpose screen printing inks and coatings" means inks and coatings used in screen printing which are conductive inks, are used to print ink transfers, or are designed to resist or withstand any of the following:

(a) More than 2 years of outdoor exposure.

(b) Exposure to chemicals, solvents, acids, detergents, oil products or cosmetics.

(c) Temperatures in excess of 170° F.

- (d) Vacuum forming.
- (e) Embossing.
- (f) Molding.

(43) "Surface coating" means the application of a coating to a product in a coating line.

(44) "Thin particleboard" means a manufactured board 0.64 centimeters ($\frac{1}{4}$ inch) or less in thickness made of individual wood particles which have been coated with a binder and formed into flat sheets by pressure.

(45) "Three-piece can side-seam spray" means a coating sprayed on the exterior and interior of a welded, cemented or soldered seam to protect the exposed metal.

(46) "Tileboard" means paneling that has a colored waterproof surface coating.

(47) "Topcoat" means a coating applied over a prime coat for purposes of appearance, identification or protection of the substrate.

(48) "Transfer efficiency" means the portion of coating solids which adheres to the surface being coated during the application process, expressed as a percentage of the total volume of coating solids delivered to the applicator.

(49) "Two-piece can exterior end coating" means a coating applied by roller coating or spraying to the exterior end of a can to provide protection to the metal.

(50) "Vinyl coating" means printing on or applying a decorative or protective topcoat, other than vinyl plastisols or organisols, to vinyl or urethane coated fabric or vinyl or urethane sheets.

History: Renum. from NR 154.01, Register, September, 1986, No. 369, eff. 10-1-86; cr. (24m), Register, January, 1987, No. 373, eff. 2-1-87; cr. (21m), Register, July, 1988, No. 391, eff. 8-1-88; cr. (12m), (16m) and (33m), am. (34) and (47), Register, August, 1989, No. 404, eff. 9-1-89; renum. (6) to be NR 400.02 (21m), am. (16), (32) (33m) and (50), cr. (28m), (33g) and (41m), (12s) renum. from NR 400.02 (36), Register, February, 1990, No. 410, eff. 3-1-90; am. (7), Register, May, 1992, No. 437, eff. 6-1-92; am. (50), Register, December, 1993, No. 456, eff. 1-1-94; cr. (11m), (21s), (41p), (41s), (41v) and (42m), am. (32), Register, June, 1994, No. 462, eff. 7-1-94.

NR 422.03 Exemptions. Sections NR 422.04 to 422.155 apply to any facility which contains one or more of the surface coating or printing process lines described in ss. NR 422.05 to 422.155, except as specified in this section. If VOC emissions exceed an exemption level given in this section, the exemption will no longer apply to the source. Exempt facilities include:

(1) Any surface coating process line which meets the specific applicability requirements of ss. NR 422.04 to 422.155 within a facility when actual emissions of VOCs from all surface coating process lines meeting the same applicability requirements within the facility are never greater than 6.8 kilograms (15 pounds) in any one day with all emission control equipment inoperative.

(2) Surface coating facilities as described under s. NR 422.15 or 422.155 which have maximum theoretical emissions of VOCs from all surface coating process lines meeting the applicability requirements of s.

NR 422.15 or 422.155 within the facility of less than or equal to 10 tons per year.

(3) Surface coating facilities as described under ss. NR 422.05 to 422.08, 422.09 to 422.13, 422.15 and 422.155 which are located outside the counties of Brown, Calumet, Dane, Dodge, Door, Fond du Lac, Jefferson, Kenosha, Kewaunee, Manitowoc, Milwaukee, Outagamie, Ozaukee, Racine, Rock, Sheboygan, Walworth, Washington, Waukesha, and Winnebago and which have total emissions of VOCs from the facility, with all emission control equipment inoperative, of less than or equal to 100 tons per year.

(4) Printing facilities as described under s. NR 422.14 which are located in the counties of Kenosha, Milwaukee, Ozaukee, Racine, Washington or Waukesha and have maximum theoretical emissions of VOCs from the facility of less than or equal to 25 tons per year, or are located outside the counties of Kenosha, Milwaukee, Ozaukee, Racine, Washington and Waukesha and have maximum theoretical emissions of VOCs from the facility of less than or equal to 100 tons per year.

(4m) Screen printing facilities as described under s. NR 422.145 which are:

(a) Located outside the counties of Kenosha, Kewaunee, Manitowoc, Milwaukee, Ozaukee, Racine, Sheboygan, Washington and Waukesha; or

(b) Located in the county of Kenosha, Milwaukee, Ozaukee, Racine, Washington or Waukesha and which have maximum theoretical emissions of VOCs from all screen printing units at the facility of less than or equal to 25 tons per year; or

(c) Located in the county of Kewaunee, Manitowoc or Sheboygan and which have maximum theoretical emissions of VOCs from all screen printing units at the facility of less than or equal to 100 tons per year.

(5) Surface coating process sources used exclusively for chemical or physical analysis or determination of product quality and commercial acceptance where:

(a) The operation of the source is not an integral part of the production process; and

(b) The emissions from the source do not exceed 363 kilograms (800 pounds) in any calendar month; and

(c) The exemption is approved in writing by the department.

(6) Leather surface coating facilities as described under s. NR 422.085 which are:

(a) Located outside the counties of Door, Kenosha, Kewaunee, Manitowoc, Milwaukee, Ozaukee, Racine, Sheboygan, Walworth, Washington and Waukesha; or

(b) Located in the counties of Kenosha, Milwaukee, Ozaukee, Racine, Washington, or Waukesha, and which have maximum theoretical emissions of VOCs from the facility of less than 25 tons per year; or

(c) Located in the counties of Door, Kewaunee, Manitowoc, Sheboygan or Walworth, and which have maximum theoretical emissions of VOCs from the facility of less than 100 tons per year.

History: Renum. from NR 154.13 (4) (a) and am. Register, September, 1986, No. 369, eff. 10-1-86; am. (3) and cr. (6), Register, January, 1987, No. 373, eff. 2-1-87; am. (intro.), (2) and (3), Register, August, 1989, No. 404, eff. 9-1-89; am. (intro.), (1) to (4) and (6) (b), Register, February, 1990, No. 410, eff. 3-1-90; am. (intro.) and (2), Register, May, 1992, No. 437, eff. 6-1-92; am. (1) to (4), (6) (a) and (b), Register, December, 1993, No. 456, eff. 1-1-94; cr. (4m), Register, June, 1994, No. 462, eff. 7-1-94.

NR 422.04 Methods of compliance. (1) IN-LINE AVERAGING. Compliance with the emission limitations of this chapter may be achieved through a daily volume-weighted average of all coatings or inks applied by emission units in a process line subject to the same numerical emission limitation. Any owner or operator achieving compliance by means of this subsection shall comply with the reporting requirements of s. NR 439.03 (7) and the recordkeeping requirements of s. NR 439.04 (5) (g).

(a) No owner or operator of a coating line subject to an emission limitation contained in ss. NR 422.05 to 422.08, 422.09 to 422.12, 422.15 or 422.155 and complying with the emission limitation by means of this subsection may cause, allow or permit the daily volume-weighted average VOC content to exceed the emission limitation to which the coatings are subject. For purposes of this paragraph, daily volume-weighted average VOC content shall be calculated by using the following equation:

$$\text{VOC}_A = \left[\sum_{i=1}^n C_i V_i \right] / V_T$$

where:

VOC_A is the volume-weighted average VOC content of two or more coatings applied on a coating line during any day in kilograms per liter (pounds per gallon) of coating, excluding water

i is the subscript denoting an individual coating

n is the number of different coatings subject to the same numerical emission limitation applied during any day on a coating line

C_i is the VOC content of each coating (i) as applied during any day on the coating line in kilograms per liter (pounds per gallon) of coating, excluding water

V_i is the volume of each coating (i), excluding water, as applied during any day on the coating line in liters (gallons)

V_T is the total volume of all n coatings subject to the same emission limitation, excluding water, applied during any day on the coating line in liters (gallons)

(b) No owner or operator of a printing line subject to an emission limitation contained in s. NR 422.14 (2) (a) or (b) and complying with the emission limitation by means of this subsection may cause, allow or permit the daily volume-weighted average VOC content to exceed the emission limitation to which the inks are subject.

1. When s. NR 422.14 (2) (a) applies, the daily volume-weighted average VOC content shall be calculated by using the following equation:

$$\text{VOC}_B = \frac{\sum_{i=1}^n C_i L_i V_{VFi}}{\sum_{i=1}^n L_i V_{VFi}}$$

where:

VOC_B is the volume-weighted average VOC content of 2 or more inks applied on a printing line during any day in percent VOC by volume of the volatile fraction

i is the subscript denoting an individual ink

n is the number of different inks subject to the same emission limitation applied during any day on a printing line

C_i is the VOC content in percent VOC by volume of the volatile fraction in each ink (i) as applied

L_i is the volume of each ink (i) as applied in liters (gallons)

V_{VFi} is the volume fraction volatile content in each ink (i) as applied

2. When s. NR 422.14 (2) (b) applies, the daily volume-weighted average VOC content shall be calculated by using the following equation:

$$\text{VOC}_C = \left[\sum_{i=1}^n C_i V_i \right] / V_T$$

where:

VOC_C is the volume-weighted average VOC content of 2 or more inks applied on a printing line during any day in percent VOC by volume, excluding water

i is the subscript denoting an individual ink

n is the number of different inks subject to the same emission limitation applied during any day on a printing line

C_i is the VOC content of each ink (i) applied during any day on the printing line in percent VOC by volume, excluding water

V_i is the volume of each ink (i), excluding water, applied during any day on the printing line in liters (gallons)

V_T is the total volume of all n inks subject to the same emission limitation, excluding water, applied during any day on the printing line in liters (gallons)

(c) An owner or operator of a coating or printing line subject to an emission limitation in this chapter not specified in par. (a) or (b) may comply by means of this subsection only by obtaining prior department approval through an order issued under s. 144.31 (2) (b), Stats., or through a permit. Any approval granted by the department under this paragraph shall be submitted to, and will not become effective for federal purposes until approved by, the administrator of the U.S. environmental protection agency or designee as a source-specific revision to the department's state implementation plan for ozone.

Next page is numbered 145

which enter the incinerator or oxidation unit are oxidized to nonorganic compounds; or

3. An alternative VOC emission reduction system demonstrated to have at least a 90% reduction efficiency, as measured across the control system, and approved by the department. Any approval granted by the department under this subdivision shall be submitted to, and will not become effective for federal purposes until approved by, the administrator of the U.S. environmental protection agency or designee as a source-specific revision to the department's state implementation plan for ozone.

(3) CONTROL SYSTEM. The overall emission reduction efficiency of any capture system and control device used in conjunction with sub. (2) (c) shall be at least:

- (a) 75% where a publication rotogravure process is employed;
- (b) 65% where a packaging rotogravure process is employed; or
- (c) 60% where a flexographic printing process is employed.

History: Renum. from NR 154.13 (2) (1) and am. Register, September, 1986, No. 369, eff. 10-1-86; am. (2) (intro.), Register, February, 1990, No. 410, eff. 3-1-90; am. (2) (a), (c) 2. and 3., (3) (intro.), (b) and (c), Register, December, 1993, No. 456, eff. 1-1-94.

NR 422.145 Screen printing (1) APPLICABILITY. This section applies to all screen printing units at screen printing facilities which are not exempt facilities under s. NR 422.03 (4m).

(2) EMISSION LIMITATIONS. (a) *General*. No owner or operator of a screen printing unit may cause, allow or permit the emission of any VOCs in excess of 0.40 kilograms per liter (3.3 pounds per gallon) of ink or coating, excluding water, delivered to an applicator, except as provided in pars. (b) and (c).

(b) *Special purpose inks and coatings*. No owner or operator of a screen printing unit using a special purpose ink or coating may cause, allow or permit the emission of any VOCs in excess of 0.80 kilograms per liter (6.7 pounds per gallon) of special purpose ink or coating, excluding water, delivered to an applicator.

(c) *Roll coating*. No owner or operator of a screen printing unit may cause, allow or permit the emission of any VOCs in excess of 0.80 kilograms per liter (6.7 pounds per gallon), excluding water, delivered to a roll coating applicator associated with screen printing.

(d) *Screen reclamation*. No owner or operator of a screen printing unit may cause, allow or permit the emission of any VOCs in excess of 0.24 kilograms per square meter (0.050 pounds per square foot) of screen reclaimed, calculated on a daily average basis for each day of operation using the following equation:

$$C = A/B$$

where:

C is the daily average VOC emission rate, in kilograms per square meter (pounds per square foot), from all screen reclamation at a screen printing facility

A is the amount of VOCs used in all screen reclamation at a screen printing facility during a day, in kilograms (pounds), except that any VOCs directed into containers that prevent evaporation may be subtracted

B is the surface area of all screens reclaimed during a day, in square meters (square feet)

(3) **COMPLIANCE DEADLINE.** The owner or operator of a screen printing unit subject to this section on which construction or modification commenced before July 1, 1994 shall achieve final compliance with the emission limitations of sub. (2) not later than May 31, 1995. Any source which is subject to this section and on which construction or modification commenced on or after July 1, 1994 shall meet the emission limitations of sub. (2) upon startup.

(4) **RECORDKEEPING.** The owner or operator of a screen printing unit subject to this section shall collect and record the information required in s. NR 439.04 (5) (a). In addition, the owner or operator shall collect and record all of the following information for screen reclamation at the facility for each day of operation:

(a) The daily average VOC emission rate from screen reclamation in kilograms per square meter (pounds per square foot) of screen reclaimed as calculated using the equation in sub. (2) (d).

(b) The amount of VOCs emitted during the day from screen reclamation in kilograms (pounds).

(c) The total surface area of screens reclaimed during the day in square meters (square feet).

History: Cr. Register, June, 1994, No. 462, eff. 7-1-94.

NR 422.15 Miscellaneous metal parts and products. (1) **APPLICABILITY.** This section applies, subject to the provisions of s. NR 425.03, to all coating line application areas, conveyors, flashoff areas, drying areas, forced air driers, and ovens of any industry categorized under the 2-digit major groups of 33 to 39 as described in the Standard Industrial Classification Manual, 1987, incorporated by reference in ch. NR 484, which are involved in the surface coating of miscellaneous metal parts and products with the following exceptions:

(a) Coating of airplane exteriors;

(b) Coating of marine vessels;

(c) Automobile refinishing;

(d) Customized topcoating of automobiles and trucks if production is less than 35 vehicles per day;

(e) Adhesives and materials used to prepare a surface for adhesives at facilities located outside the counties of Door, Kenosha, Kewaunee, Manitowoc, Milwaukee, Ozaukee, Racine, Sheboygan, Walworth, Washington and Waukesha;

(g) Sealants or fillers whose purpose is to seal or fill seams, joints, holes and minor imperfections of surfaces, and which are applied at facilities located outside the counties of Door, Kenosha, Kewaunee, Manitowoc,

Register, June, 1994, No. 462

Milwaukee, Ozaukee, Racine, Sheboygan, Walworth, Washington and Waukesha;

(h) Coating lines covered under ss. NR 422.05 to 422.12;

(i) Sources exempted under s. NR 422.03;

(j) Silk screening of metal parts and products at facilities located outside the counties of Door, Kenosha, Kewaunee, Manitowoc, Milwaukee, Ozaukee, Racine, Sheboygan, Walworth, Washington and Waukesha; or

(k) Coating operations subject to s. NR 422.155.

(2) EMISSION LIMITATIONS — CURED COATINGS. No owner or operator of a miscellaneous metal parts or products coating line using a baked or specially cured coating technology may cause, allow, or permit the emission of any VOCs in excess of:

(a) 0.52 kilograms per liter (4.3 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies clear coatings;

(b) 0.42 kilograms per liter (3.5 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies extreme performance coatings; and

(c) 0.36 kilograms per liter (3.0 pounds per gallon) of coating, excluding water, delivered to a coating applicator for all other coatings.

(3) EMISSION LIMITATIONS — AIR DRIED COATINGS. No owner or operator of a miscellaneous metal parts or products coating line using an air dried coating technology may cause, allow, or permit the emission of any VOCs in excess of:

(a) After December 31, 1982, 0.58 kilograms per liter (4.8 pounds per gallon) of any coating, excluding water, delivered to a coating applicator;

(b) After December 31, 1985, 0.52 kilograms per liter (4.3 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies clear coatings;

(c) After December 31, 1985, 0.42 kilograms per liter (3.5 pounds per gallon) of coating, excluding water, delivered to a coating applicator for all other coatings.

(4) EMISSION LIMITATIONS — PRETREATMENT COATS. This subsection applies to miscellaneous metal parts and products coating lines which are located outside the counties of Door, Kenosha, Kewaunee, Manitowoc, Milwaukee, Ozaukee, Racine, Sheboygan, Walworth, Washington and Waukesha. No owner or operator of a miscellaneous metal parts or products coating line may cause, allow, or permit the emission of any VOCs in excess of 0.78 kilograms per liter (6.50 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies pretreatment coats. Coatings subject to this subsection may not participate in an internal offset under s. NR 425.05 or generate emission reduction credits in an emission reduction option.

(5) EMISSION LIMITATIONS AND REQUIREMENTS — HIGH PERFORMANCE ARCHITECTURAL COATINGS. This subsection applies to miscellaneous metal parts and products coating lines which were involved in the appli-

cation of high performance architectural coatings, prior to July 1, 1983, and are located outside the counties of Brown, Calumet, Dane, Dodge, Door, Fond du Lac, Jefferson, Kenosha, Kewaunee, Manitowoc, Milwaukee, Outagamie, Ozaukee, Racine, Rock, Sheboygan, Walworth, Washington, Waukesha and Winnebago.

(a) No owner or operator of a miscellaneous metal parts or products coating line which applies a high performance architectural coating may cause, allow or permit the emission of any VOCs from the coating in excess of:

1. 0.65 kilograms per liter (5.4 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies prime coatings;

2. 0.70 kilograms per liter (5.8 pounds per gallon) of coating, excluding water, delivered to a coating applicator for all other coatings.

(b) The owner or operator of a miscellaneous metal parts and products coating line may demonstrate compliance with the emission limits of this subsection by demonstrating, on a daily basis, that the combined emission rate from all high performance architectural coatings is less than or equal to the allowable emission rate as determined by the equation in s. NR 425.05 (2) (b) 2.

(6) CHANGE IN TECHNOLOGY. Miscellaneous metal parts or products coating lines which, prior to January 1, 1980, used a baked or specially cured coating technology shall meet the emission limitations of sub. (2) notwithstanding the coating technology presently in use.

(7) MULTIPLE LIMITATIONS. If more than one emission limitation in sub. (2) applies to a specific coating, then the least stringent emission limitation shall be applied.

(8) SOLVENT WASHINGS. All VOC emissions from solvent washings shall be considered in the emission limitations in subs. (2) and (3), unless the used wash solvent is directed into containers that prevent evaporation into the atmosphere.

History: Renum. from NR 154.13 (4) (m) and am. Register, September, 1986, No. 369, eff. 10-1-86; renum. (4) to (6) to be (5) to (7), cr. (4), Register, July, 1988, No. 391, eff. 8-1-88; am. (1) (h) and (i), cr. (1) (j), Register, April, 1989, No. 400 eff. 5-1-89; am. (1) (i) and (j), cr. (1) (k), Register, August, 1989, No. 404, eff. 9-1-89; am. (1) (b), (2) (intro.) and (3) (intro.), r. (1) (f), renum. (4) to (7) to be (5) to (8) and am. (5) (b), cr. (4), Register, February, 1990, No. 410, eff. 3-1-90; am. (1) (intro.), (e), (g) and (j), (4), (5) (intro.) and (b), Register, December, 1993, No. 456, eff. 1-1-94.

NR 422.155 Fire truck and emergency response vehicle manufacturing. (1) APPLICABILITY. This section applies to coating operations of fire truck and emergency response vehicle manufacturing where meeting applicable emission limits in s. NR 422.15 is not technologically or economically feasible and where total facility production of fire trucks and emergency response vehicles is less than 35 vehicles per day.

(2) EMISSION LIMITATIONS. No owner or operator of a fire truck or emergency response vehicle coating operation may cause, allow or permit the emission of any VOCs in excess of:

(a) 0.80 kilograms per liter (6.68 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies pretreatment coats.

(b) 0.53 kilograms per liter (4.44 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies prime coats.

(c) 0.72 kilograms per liter (6.00 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies topcoats.

(d) 0.42 kilograms per liter (3.50 pounds per gallon) of coating, excluding water, delivered to a coating applicator that applies clear coats.

(3) **SOLVENT WASHINGS.** All VOC emissions from solvent washings shall be considered in the emission limitations in sub. (2), unless the used wash solvent is directed into containers that prevent evaporation into the atmosphere.

(4) **INTERNAL OFFSETS.** Coating operations subject to this section may not be involved in an internal offset under s. NR 425.05.

History: Cr. Register, August, 1989, No. 404, eff. 9-1-89; am. (2) (a) to (d) and (4), Register, February, 1990, No. 410, eff. 3-1-90.

NR 422.16 Use of asphalt surfacing materials. (1) **APPLICABILITY.** This section applies to the mixing, storage, use and application of cutback asphalts in Wisconsin. This section does not apply to cutback asphalts intended for uses other than application to surfaces traversed by motor vehicles, bicycles or pedestrians.

(2) **RESTRICTED MATERIALS.** The following restrictions apply to the mixing, open storage, use or application of cutback asphalts during the ozone season:

(a) The use of rapid curing cutback asphalts containing gasoline or naphtha as the diluent is prohibited.

(b) The use of cutback asphalts not prohibited under par. (a) is prohibited except for:

1. Application of a single coat of liquid asphalt to an aggregate base to control dust; and

2. Use as a penetrating prime coat during the first and last months of the ozone season.

History: Renum. from NR 154.13 (5) (a) and am. Register, September, 1986, No. 369, eff. 10-1-86; am. (2) (a) and (b), r. (2) (c), Register, February, 1990, No. 410, eff. 3-1-90.