



HOT MIX ASPHALT PLANTS

EMISSION ASSESSMENT REPORT

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PREFACE

This report was produced by the Source Measurement Technology Group of EPA's Emissions Measurement Center located in Research Triangle Park, NC. It is one of a series of twelve reports prepared to document an EPA program to characterize emissions to the air from hot mix asphalt plants. These twelve reports and their associated EPA document numbers and publication dates are:

Document Title	EPA Document Number	Publication Date
Hot Mix Asphalt Plants Emission Assessment Report	EPA 454/R-00-019	December 2000
Hot Mix Asphalt Plants Kiln Dryer Stack Instrumental Methods Testing Asphalt Plant A, Cary, North Carolina	EPA 454/R-00-020	April 2000
Hot Mix Asphalt Plants Kiln Dryer Stack Manual Methods Testing Asphalt Plant A, Cary, North Carolina Volume 1 of 2	EPA 454/R-00-021a	April 2000
Volume 2 of 2	EPA 454/R-00-021b	April 2000
Hot Mix Asphalt Plants Kiln Dryer Stack Instrumental Methods Testing Asphalt Plant B, Clayton, North Carolina	EPA 454/R-00-022	April 2000
Hot Mix Asphalt Plants Kiln Dryer Stack Manual Methods Testing Asphalt Plant B, Clayton, North Carolina Volume 1 of 2	EPA 454/R-00-023a	April 2000
Volume 2 of 2	EPA 454/R-00-023b	April 2000
Hot Mix Asphalt Plants Truck Loading and Silo Filling Instrumental Methods Testing Asphalt Plant C, Los Angeles, California	EPA 454/R-00-024	May 2000
Hot Mix Asphalt Plants Truck Loading and Silo Filling Manual Methods Testing Asphalt Plant C, Los Angeles, California Volume 1 of 8	EPA 454/R-00-025a	May 2000
Volume 2 of 8	EPA 454/R-00-025b	May 2000
Volume 3 of 8	EPA 454/R-00-025c	May 2000
Volume 4 of 8	EPA 454/R-00-025d	May 2000
Volume 5 of 8	EPA 454/R-00-025e	May 2000
Volume 6 of 8	EPA 454/R-00-025f	May 2000
Volume 7 of 8	EPA 454/R-00-025g	May 2000
Volume 8 of 8	EPA 454/R-00-025h	May 2000
Hot Mix Asphalt Plants Technical Systems Audit of Testing at Asphalt Plant C Asphalt Plant C, Los Angeles, California	EPA 454/R-00-026	May 2000

Document Title	EPA Document Number	Publication Date
Hot Mix Asphalt Plants Truck Loading Instrumental Methods Testing Asphalt Plant D, Barre, Massachusetts	EPA 454/R-00-027	May 2000
Hot Mix Asphalt Plants Truck Loading Manual Methods Testing Asphalt Plant D, Barre, Massachusetts	EPA 454/R-00-028	May 2000
Hot Mix Asphalt Plants Response to Comments on Testing Program for Asphalt Plants C and D	EPA 454/R-00-029	May 2000
Hot Mix Asphalt Plants Stakeholders Opinions Report	EPA 454/R-00-030	

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LIST OF ACRONYMS

ASTM	American Society of Testing and Materials
Btu	British thermal unit
CH ₄	methane
CO	carbon monoxide (as measured by EPA Method 10)
CO ₂	carbon dioxide (as measured by EPA Method 3)
EPA	Environmental Protection Agency
HAP	hazardous air pollutant (listed in or pursuant to section 112(b) of the 1990 Clean Air Act Amendments)
HMA	hot mix asphalt
NO _x	nitrogen oxides (as measured by EPA Method 7)
PAH	polycyclic aromatic hydrocarbon (a class of HAPs)
PM	particulate matter (as measured by EPA Methods 5 or 17)
PM-10	particulate matter less than 10 microns in diameter
PM-2.5	particulate matter less than 2.5 microns in diameter
RAP	reclaimed asphalt pavement
RTFOT	rolling thin film oven test (ASTM Method D2872-88)
SCC	source classification code
SO ₂	sulfur dioxide (as measured by EPA Methods 6 or 8)
SO _x	sulfur oxides
TOC	total organic compounds (as measured by EPA Method 25A)
VOC	volatile organic compound (refer to 40 CFR 51.100); VOC is TOC plus formaldehyde, less methane, ethane, acetone, and other chemicals listed as negligibly photochemically reactive.

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1. EXECUTIVE SUMMARY

1.1 INTRODUCTION

This report presents an assessment of emissions from hot mix asphalt (HMA) manufacturing facilities. Included in the report is a description of the manufacturing process and the emissions associated with HMA production; the procedures for developing emission factors and emission inventories for the HMA industry; and estimated annual emissions for typical HMA facilities.

1.2 OVERVIEW OF HMA INDUSTRY

Hot mix asphalt is used primarily as paving material and consists of a mixture of aggregate and liquid asphalt cement, which are heated and mixed in measured quantities. Hot mix asphalt facilities can be broadly classified as either drum mix plants or batch mix plants, according to the process by which the raw materials are mixed. In a batch mix plant, the aggregate is dried first, then transferred to a mixer where it is mixed with the liquid asphalt. In a drum mix plant, a rotary dryer serves to dry the aggregate and mix it with the liquid asphalt cement. After mixing, the HMA generally is transferred to a storage bin or silo, where it is stored temporarily. From the silo, the HMA is emptied into haul trucks, which transport the material to the job site. Figure 1 presents a diagram of a typical batch mix HMA plant; a typical drum mix HMA plant is depicted in Figure 2.

In 1996, approximately 500 million tons of HMA were produced at the 3,600 (estimated) active asphalt plants in the United States. Of these 3,600 plants, approximately 2,300 are batch plants, and 1,300 are drum mix plants. The total 1996 HMA production from batch and drum mix plants is estimated at about 240 million tons and 260 million tons, respectively. Based on these figures, an average batch mix plant produces approximately 100,000 tons of HMA annually, and an average drum mix plant produces about 200,000 tons of HMA per year. Natural gas fuel is used to produce 70 to 90 percent of the HMA. The remainder of the HMA is produced using oil, propane, waste oil, or other fuels.

The primary emission sources associated with HMA production are the dryers, hot bins, and mixers, which emit particulate matter (PM) and a variety of gaseous pollutants. Other emission sources found at HMA plants include storage silos, which temporarily hold the HMA; truck load-out operations, in which the HMA is loaded into trucks for hauling to the job site; liquid asphalt storage tanks; hot oil heaters, which are used to heat the asphalt storage tanks; and yard emissions, which consist of fugitive emissions from the HMA in truck beds. Emissions also result from vehicular traffic on paved and unpaved roads, aggregate storage and handling operations, and vehicle exhaust.

The PM emissions associated with HMA production include the criteria pollutants PM-10 (PM less than 10 micrometers in aerodynamic diameter) and PM-2.5, hazardous air pollutant (HAP) metals, and HAP organic compounds. The gaseous emissions associated with HMA production include the criteria pollutants sulfur dioxide (SO₂), nitrogen oxides (NO_x), carbon monoxide (CO), and volatile organic compounds (VOC), as well as volatile HAP organic compounds.

1.3 DEVELOPMENT AND USE OF EMISSION FACTORS FOR HMA FACILITIES

An emission factor relates the quantity (weight) of pollutants emitted to a unit of activity of the source. Emission factors for the HMA industry are generally determined in units of pounds of pollutant emitted per ton of HMA produced. These emission factors typically are used to estimate area-wide

emissions for a large number of facilities and emissions for specific facilities where source-specific emissions data are not available or where source testing is cost prohibitive.

To develop emission factors for the HMA industry, data from more than 390 emission test reports and other documents on the industry were compiled and reviewed. Through a careful screening process, the documents that were determined to be unusable for emission factor development were excluded from further evaluation. The remaining reports were compiled by plant type, emission source, pollutant, and emission control. For each emission test, emission factors were calculated by dividing the measured emission rates by the HMA production rate measured at the time of the emission test. These emission factors were then grouped by source, pollutant, and control device, and an average emission factor was calculated for each group.

Emission factors can be used to estimate emissions from one or more HMA facilities by multiplying the emission factor by the HMA production rate. For example, the emission factor for CO emissions from a natural gas-fired drum mix dryer is 0.13 pounds per ton (lb/ton). If the dryer produces 200,000 tons per year (ton/yr), the estimated CO emissions during that period would be: $200,000 \text{ ton/yr} \times 0.13 \text{ lb/ton} = 26,000 \text{ lb/yr}$ or 13 tons/yr.

1.4 ESTIMATED ANNUAL EMISSIONS FROM TYPICAL HMA FACILITIES

Annual emissions for a facility can be estimated by summing up the emissions from each emission source over the course of a year. Annual emissions for a specific source can be estimated by multiplying the annual throughput or production rate for that source by its corresponding emission factors. For an HMA facility, annual emissions can be estimated by multiplying the annual HMA production rate by the emission factors for each type of source at the facility. Table 1 summarizes annual emissions for a typical HMA batch mix plant, and Table 2 summarizes annual emissions for a typical drum mix HMA plant. The estimates presented in these tables account for all of the identified emission sources at each type of facility. For both batch mix plants (Table 1) and drum mix plants (Table 2), the estimate includes emissions from the dryer/mixer, load-out operations, asphalt storage, yard (fugitive emissions from loaded trucks), diesel exhaust, paved and unpaved road dust, and aggregate processing (screening, conveyor transfer, and reclaimed asphalt pavement [RAP] crushing). Additionally, for the drum mix plant (Table 2), the estimate includes emissions from silo filling operations. Estimates are presented for criteria pollutants (pollutants for which national ambient air quality standards have been developed) and hazardous air pollutants (HAPs, as defined in section 112(b) of the 1990 Clean Air Act Amendments). Criteria pollutants include PM-10, VOC, CO, SO₂, and NO_x. Emissions for three classes of HAPs are presented in Tables 1 and 2: polycyclic aromatic hydrocarbons (PAHs), volatile organic HAPs, and metal HAPs. The emissions were estimated using the emission factors developed for the HMA industry and the following assumptions:

- Dryers are fueled with natural gas or No. 2 fuel oil (estimates are presented for both types). It is estimated that between 70 and 90 percent of HMA plants use natural gas, although some HMA plants use fuel oil as an alternative to natural gas.
- Dryer emissions are controlled with fabric filters.
- PM emissions from load-out and silo filling are entirely PM-10.
- Annual HMA production rate for a typical batch mix plant is 100,000 ton/yr.
- Annual HMA production rate for a typical drum mix plant is 200,000 ton/yr.
- The typical HMA plant has two 18,000-gallon asphalt storage tanks.

As indicated in Table 1, a typical batch mix plant using a No. 2 fuel oil-fired dryer emits over 74,000 lb/yr of criteria pollutants, and a typical batch mix plant using a natural gas-fired dryer emits over

56,000 lb/yr of criteria pollutants, of which approximately 41,000 lb/yr are CO and approximately 10,700 lb/yr are PM-10; emissions of other criteria pollutants range from about 500 to about 12,000 lb/yr. The same plant would emit about 770 lb/yr of HAPs. A typical drum mix plant using a No. 2 fuel oil-fired dryer emits about 83,000 lb/yr of criteria pollutants, and a typical drum mix plant using a natural gas-fired dryer emits around 75,000 lb/yr of criteria pollutants, of which approximately 28,000 lb/yr are CO, about 10,000 lb/yr are VOC, and around 31,000 lb/yr are PM-10. A typical drum mix plant emits from 1,300 to 2,000 lb/yr of HAPs, depending on the fuel used in the dryer.

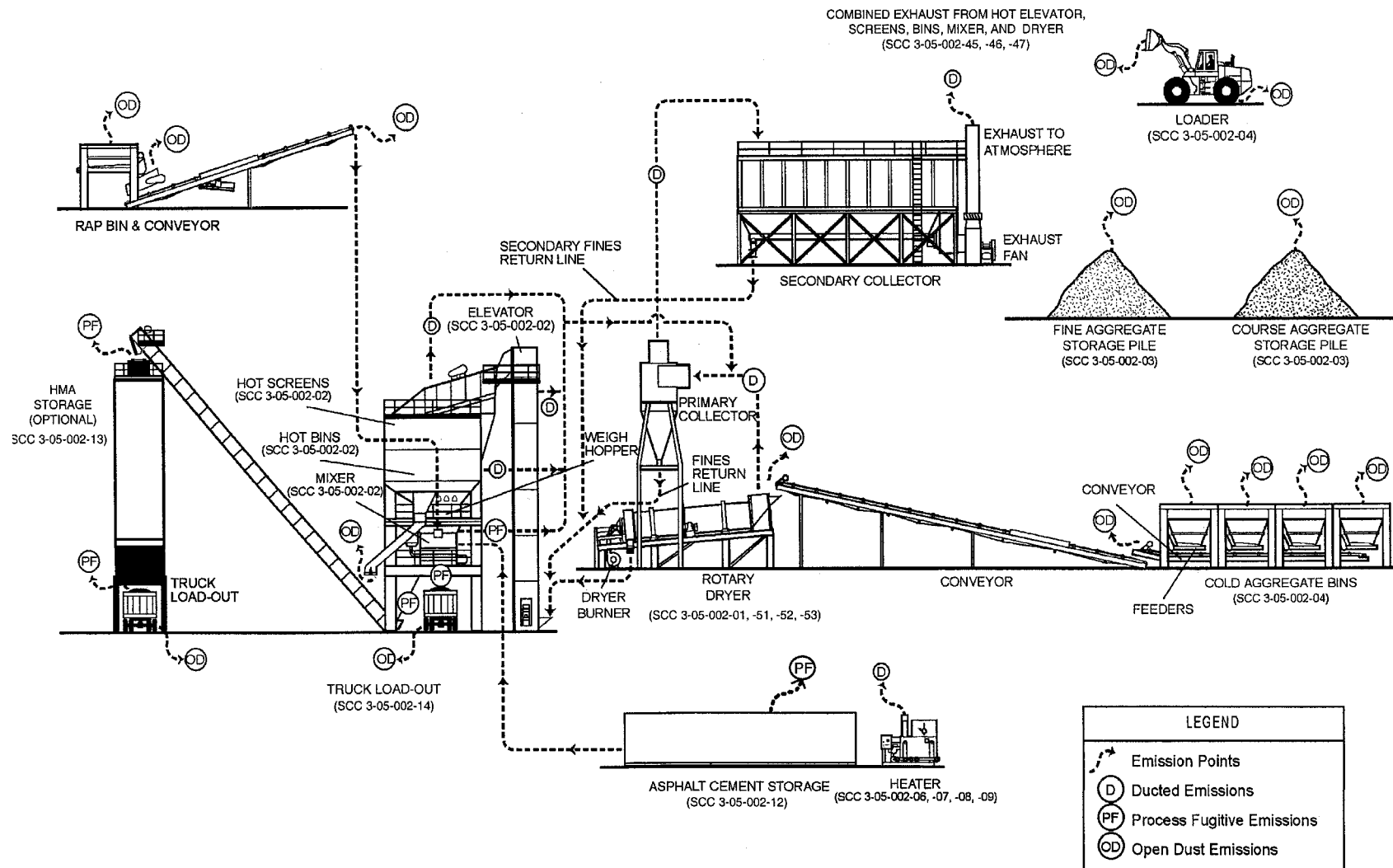


Figure 1. General process flow diagram for batch mix asphalt plants (source classification codes in parentheses).

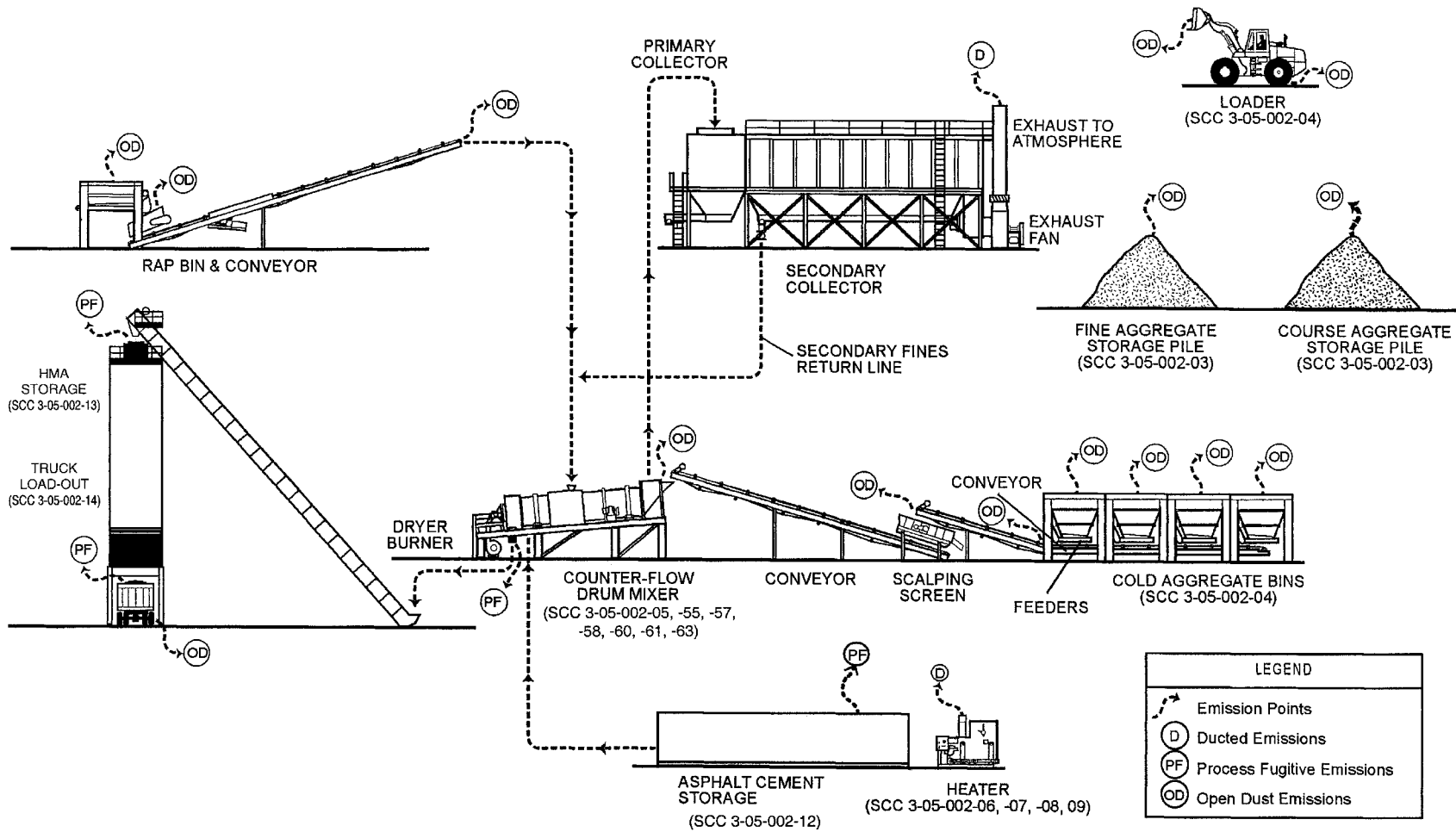


Figure 2. General process flow diagram for counter-flow drum mix asphalt plants (source classification codes in parentheses).

TABLE 1. ESTIMATED ANNUAL EMISSIONS FOR A TYPICAL BATCH MIX HMA FACILITY^a

Pollutant	Annual emissions by source, pounds per year								
	Mobile sources (diesel exhaust)	Material handling and road dust	No. 2 fuel oil-fired dryer, hot screens, and mixer ^b	Natural gas-fired dryer, hot screens, and mixer ^c	Load-out ^d	Asphalt Storage ^e	Yard ^f	Total ^g (oil-fired)	Total ^g (gas-fired)
Criteria air pollutants									
Particulate matter less than 10 micrometers (PM-10)	46	7,900	2,700	2,700	52			10,700	10,700
Volatile organic compounds (VOC)	100		820	820	391	32	110	1,500	1,500
Carbon monoxide (CO)	700		40,000	40,000	135	3	35	41,000	41,000
Sulfur dioxide (SO ₂)	22		8,800	460				8,800	480
Nitrogen oxides (NO _x)	380		12,000	2,500				12,400	2,900
Hazardous air pollutants (HAPs)									
Polycyclic aromatic hydrocarbons (PAHs)	0.035		11	11	2.0	0.12		13	13
Phenol					0.40			0.40	0.40
Volatile HAPs	1.9		751	751	6.2	140	1.6	760	760
Metal HAPs			1.4	1.4				1.4	1.4
Total HAPs ^g	1.9		760	760	8.6	140	1.6	770	770

^a Based on an annual HMA production rate of 100,000 tons per year.

^b Between 10 and 30 percent of the HMA is produced using fuel oil.

^c Between 70 and 90 percent of the HMA is produced using natural gas.

^d Loading of HMA into haul trucks.

^e Includes emissions from oil-fired hot oil heaters.

^f Fugitive emissions from loaded trucks prior to departure to the job site.

^g Total expressed using two significant figures.

TABLE 2. ESTIMATED ANNUAL EMISSIONS FOR A TYPICAL DRUM MIX HMA FACILITY^a

Pollutant	Annual emissions by source, pounds per year									
	Mobile sources (diesel exhaust)	Material handling and road dust	No. 2 fuel oil-fired dryer ^b	Natural gas-fired dryer ^c	Load-out ^d	Silo filling ^e	Asphalt storage ^f	Yard ^g	Total ^h (oil-fired)	Total ^h (gas-fired)
Criteria air pollutants										
Particulate matter less than 10 micrometers (PM-10)	220	26,000	4,600	4,600	104	117			31,000	31,000
Volatile organic compounds (VOC)	190		6,400	6,400	782	2,440	64	220	10,000	10,000
Carbon monoxide (CO)	1,200		26,000	26,000	270	236	6	72	28,000	28,000
Sulfur dioxide (SO ₂)	26		2,200	680					2,200	710
Nitrogen oxides (NO _x)	560		11,000	5,200					12,000	5,800
Hazardous air pollutants (HAPs)										
Polycyclic aromatic hydrocarbons (PAHs)	0.13		176	37	4.0	5.8	0.12		190	50
Phenol					0.80				0.80	0.80
Volatile HAPs	6.6		1,560	1,020	12.4	31	140	3.3	1,800	1,200
Metal HAPs			19	16					19	16
Total HAPs ^h	6.7		1,800	1,100	17	37	140	3.3	2,000	1,300

^a Based on an annual HMA production rate of 200,000 tons per year.

^b Between 10 and 30 percent of the HMA is produced using fuel oil.

^c Between 70 and 90 percent of the HMA is produced using natural gas.

^d Loading of HMA into haul trucks

^e Filling of temporary storage silo prior to load-out.

^f Includes emissions from oil-fired hot oil heaters.

^g Fugitive emissions from loaded trucks prior to departure to the job site.

^h Total expressed using two significant figures.

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2. ASSESSMENT OF HOT MIX ASPHALT EMISSIONS

This section presents the results of an assessment of emissions from HMA manufacturing. An overview of the HMA industry and process operations is provided first (Section 2.1). Section 2.2 summarizes the methodology used to develop emission factors for the HMA industry. Section 2.3 identifies other sections of AP-42 that apply to HMA plants. An overview of the process for conducting an emission inventory is presented in Section 2.4, and Section 2.5 presents estimates of annual emissions from typical HMA facilities.

2.1 INDUSTRY OVERVIEW AND PROCESS DESCRIPTION¹

Hot mix asphalt paving materials are a mixture of well-graded, high-quality aggregate and liquid asphalt cement, which is heated and mixed in measured quantities. The aggregate often includes RAP. Aggregate and RAP (if used) constitute over 92 percent by weight of the total mixture. Aside from the amount and grade of asphalt cement used, mix characteristics are determined by the relative amounts and types of aggregate and RAP used. A certain percentage of fine aggregate (less than 74 micrometers [μm] in physical diameter) is required for the production of good quality HMA.

Hot mix asphalt plants can be classified by their mixing operation as one of the following: (1) batch mix plants, (2) continuous mix (mix outside dryer drum) plants, (3) parallel flow drum mix plants, and (4) counterflow drum mix plants. An HMA plant can be constructed as a permanent plant, a skid-mounted (easily relocated) plant, or a portable plant. All plants can have RAP processing capabilities.

In 1996, approximately 500 million tons of HMA were produced at the 3,600 (estimated) active asphalt plants in the United States. Of these 3,600 plants, approximately 2,300 are batch plants, 1,000 are parallel flow drum mix plants, and 300 are counterflow drum mix plants. The total 1996 HMA production from batch and drum mix plants is estimated at about 250 million tons and 260 million tons, respectively. About 85 percent of new plants being constructed today are of the counterflow drum mix design, while batch plants and parallel flow drum mix plants account for 10 percent and 5 percent respectively. Continuous mix plants represent a very small fraction of the plants in use (≤ 0.5 percent) and, therefore, are not discussed further. While most HMA plants have the capability to use both fuel oil and natural gas, it is estimated that between 70 and 90 percent of the HMA in the U. S. is produced using natural gas. The process operations at typical batch mix and drum mix plants are described in the following paragraphs.

2.1.1 Batch Mix Plants²

Processing begins as the aggregate is hauled from onsite storage piles and is placed in the appropriate hoppers of the cold feed unit. The material is metered from the hoppers onto a conveyer belt and is transported into a rotary dryer (typically gas- or oil-fired). As the hot aggregate leaves the dryer, it drops into a bucket elevator, is transferred to a set of vibrating screens, then separated into as many as four different grades (sizes), and dropped into "hot" bins according to size. At newer facilities, RAP may be transferred to a separate heated storage bin. At the same time, liquid asphalt cement is pumped from a heated storage tank to an asphalt bucket, where it is weighed to achieve the desired aggregate-to-asphalt cement ratio in the final mix. To control the aggregate size distribution in the final batch mix, the operator transfers material from various hot bins (and RAP bins, if used) to a weigh hopper until the desired mix

¹ See Appendix A, Section 11.1.1, and Appendix B, Section 2.1, for more detailed information.

² See Appendix A, Section 11.1.1.1, and Appendix B, Section 2.2.1, for more detailed information.

and weight are obtained. The aggregate from the weigh hopper is dropped into the mixer (pug mill) and dry-mixed for 6 to 10 seconds. The liquid asphalt is then dropped into the pug mill where it is mixed for an additional period of time. At older plants, RAP typically is conveyed directly to the pug mill from a storage hopper and combined with the hot aggregate. Total mixing time usually is less than 60 seconds. Then, the hot mix is conveyed to a hot storage silo or is dropped directly into a truck and hauled to the job site. Figure 1 depicts a typical batch mix plant.

2.1.2 Drum Mix Plants³

This process is a continuous mixing type process. The major difference between this process and the batch process is that the dryer is used not only to dry the material but also to mix the heated and dried aggregates with the liquid asphalt cement. In a parallel flow drum mixer, the aggregate is introduced to the drum at the burner end. As the drum rotates, the aggregate, as well as the combustion products from the burner, move toward the other end of the drum in parallel. Liquid asphalt cement is introduced in the mixing zone midway down the drum in a lower temperature zone, along with any RAP and PM from collectors. In a counterflow drum mixer, the material flow in the drum is opposite or counterflow to the direction of exhaust gases. In addition, the liquid asphalt cement mixing zone is located behind the burner flame zone so as to remove the materials from direct contact with hot exhaust gases. After mixing, the mixture is discharged at the end of the drum and is conveyed to either a surge bin or HMA storage silos. Figure 2 illustrates a counterflow drum mix plant.

In a parallel flow mixer, the exhaust gases also exit the end of the drum and pass on to the collection system. Parallel flow drum mixers have an advantage, in that mixing in the discharge end of the drum captures a substantial portion of the aggregate dust, therefore lowering the load on the downstream PM collection equipment. For this reason, most parallel flow drum mixers are followed only by primary collection equipment (usually a baghouse or venturi scrubber). However, because the mixing of aggregate and liquid asphalt cement occurs in the hot combustion product flow, organic emissions (gaseous and liquid aerosol) may be greater than in other processes.

Counterflow drum mix plants likely will have organic stack emissions (gaseous and liquid aerosol) that are lower than parallel flow drum mix plants because the liquid asphalt cement, virgin aggregate, and RAP are mixed in a zone removed from the exhaust gas stream. A counterflow drum mix plant normally can process RAP at ratios up to 50 percent with little or no observed effect upon emissions.

2.1.3 Recycle Processes⁴

Reclaimed asphalt pavement significantly reduces the amount of new aggregate and asphalt cement needed to produce HMA. In the reclamation process, old asphalt pavement is removed from the road base. This material is then transported to the plant, and is crushed and screened to the appropriate size for further processing. The paving material then is heated and mixed with new aggregate (if applicable), and the proper amount of new asphalt cement is added to produce HMA that meets the quality requirements of the customer.

³ See Appendix A, Sections 11.1.1.2 and 11.1.1.3, and Appendix B, Sections 2.2.2 and 2.2.3, for more detailed information.

⁴ See Appendix A, Section 11.1.1.4, and Appendix B, Section 2.2.4, for more detailed information.

2.1.4 Emissions and Controls⁵

Hot mix asphalt plants have two major categories of emissions: ducted sources (those vented to the atmosphere through some type of stack, vent, or pipe), and fugitive sources (those not confined to ducts and vents but emitted directly from the source to the ambient air). Dryers are the most significant ducted sources of emissions from both batch mix and drum mix HMA plants. Emissions from these sources consist of water (as steam evaporated from the aggregate); PM; products of combustion (carbon dioxide [CO₂], NO_x, and sulfur oxides [SO_x]); CO; and small amounts of organic compounds of various species (including VOC, methane [CH₄], and HAPs). The CO and organic compound emissions result from incomplete combustion of the fuel and also are released from the heated asphalt.

At batch mix plants, other potential process sources include the hot-side conveying, classifying, and mixing equipment, which are vented to either the primary dust collector (along with the dryer gas) or to a separate dust collection system. These emissions are mostly aggregate dust, but they also may contain gaseous organic compounds, CO, and a fine aerosol of condensed organic particles. This organic aerosol is created by the condensation of gas into particles during cooling of organic vapors volatilized from the asphalt cement in the mixer. The amount of organic aerosol produced depends to a large extent on the temperature of the asphalt cement and aggregate entering the mixer. Organic vapor and its associated aerosol also are emitted directly to the atmosphere as process fugitives during truck load-out, from the bed of the truck itself during transport to the job site, and from the asphalt storage tank. Both the low molecular weight organic compounds and the higher weight organic aerosol may contain small amounts of HAP. The ducted emissions from the heated asphalt storage tanks may include gaseous and aerosol organic compounds and combustion products from the tank heater.

At most HMA facilities, fabric filters are used to control emissions from dryers. Other controls used include mechanical collectors and scrubbers. Emissions from aggregate handling and transfer typically are controlled with fabric filters or scrubbers. Large diameter cyclones and settling chambers also are used as product recovery devices. The material collected in those devices is recycled back into the process.

There also are a number of fugitive dust sources associated with batch mix HMA plants, including vehicular traffic generating fugitive dust on paved and unpaved roads, aggregate material handling, and other aggregate processing operations.

2.2 EMISSION FACTOR DEVELOPMENT FOR AP-42 SECTION 11.1, HOT MIX ASPHALT PLANTS

A detailed description of how the emission factors were developed for the HMA industry is provided in Section 4 of Appendix B. The following paragraphs summarize the methodology used.

To develop emission factors for the HMA industry, data from about 390 emission test reports and other documents on the industry were compiled and reviewed (a complete list of these references is provided following Section 4 of Appendix B). The majority of these reports documented measurements of emissions from batch plant dryer/mixers and drum plant dryers. Through a careful screening process, 35 of the reports were determined to be unusable for emission factor development and were excluded from further evaluation. About 350 reports remained and were compiled by plant type, emission source, pollutant, and emission control. These emission factors were then grouped by source, pollutant, and

⁵ See Appendix A, Section 11.1.2, and Appendix B, Section 2.3, for more detailed information.

control device, and an average emission factor was calculated for each group. Table 3 presents a matrix of all of the sources and pollutants for which emission factors are presented in AP-42 (Appendix A).

While the particulate, CO₂, CO, and TOC emission factors are based on over 100 tests, most of the remaining criteria pollutant emission factors are based on between 5 and 10 tests. A few HAP emission factors are based on more than 5 tests, although the majority are based on between 2 and 5 tests. Information on the supporting data for specific emission factors and the quality rating assigned to the emission factor is included in the section or table in Appendices A and B as indicated in Table 4. Column four of Table 4 references the tables in Appendix A that present the emission factors and quality ratings. Column five of Table 4 references the paragraphs in Appendix B that discuss the basis for the emission factors developed for all of the sources and pollutants. Column six of Table 4 references the tables in Appendix B that present the emission factors and the individual data used to develop the emission factors. Generally, the amount of supporting data is typical of many AP-42 sections. However, the amount of data supporting the particulate, CO₂, CO, and TOC emission factors is greater than most AP-42 sections. The following paragraphs summarize the procedures followed to develop the emission factors for HMA facilities.

2.2.1 Batch Mix and Drum Mix Dryers

The usable data on batch mix and drum mix plant dryer emissions were compiled according to source type, emission control, and pollutant. Data on fuel types, the percentage of RAP used in the mix, and the process operating rate (e.g., dryer production rate) also were recorded. The quality of the emission data was evaluated with respect to the level of documentation in the report, the test methods used, the number of test runs, and any reported problems with the sampling procedures or the operation of the source during the test period. On the basis of this evaluation, data ratings of A, B, C, or D were assigned to each data set. Specific procedures used to evaluate the data are specified in *Procedures for Preparing Emission Factor Documents* (EPA-454/R-95-015).

For each emission test, an emission factor also was calculated for each pollutant sampled. These test-specific emission factors then were grouped according to source type, emission control device, pollutant, and, in the case of combustion sources, fuel type. At this stage in the process, D-rated data sets were discarded, provided there were higher quality data available for that particular group (i.e., that specific combination of source, control, fuel, and pollutant). In addition, where there were data from multiple tests on the same specific emission source, the test-specific emission factors were averaged to yield a source-specific emission factor. In subsequent calculations, this source-specific emission factor was used.

A statistical analysis of the data for batch and drum mix dryers was performed to determine the effects of RAP content, fuel type, production rate on emissions of several pollutants. The analysis showed no strong correlation between these parameters and emission factors. Details on the statistical analysis can be found in Section 4.3 of Appendix B.

To develop emission factors, the mean of the test-specific emission factors was calculated for each of the emission factor groups discussed above. In some cases, the data for two or more groups were combined and an overall mean emission factor was calculated. For example, if the data indicated that fuel type had no apparent effect on emissions of a specific pollutant, fuel type was ignored and all of the data for that source type and pollutant were combined. The final step in developing emission factors is to assign a quality rating of A, B, C, D, or E. Quality ratings are a function primarily of the number of data points

from which a specific emission factor is calculated. Additional information on the rating system used is discussed in Section 3 of Appendix B.

2.2.2 Hot Oil Heaters

For hot oil heaters, only a single test report for an oil-fired hot oil heater was available. The report was reviewed and the emission factors compiled using the procedures described previously. Appendix B, Section 4.2.4.2, provides a detailed description of how these emission factors were developed. It should be noted that most hot oil heaters are gas-fired, and the emission factors developed from the available data would not necessarily be representative of gas-fired heaters.

2.2.3 Truck Load-Out

Truck load-out emissions were developed from two emission tests sponsored by the U. S. Environmental Protection Agency (EPA) (Appendix B References 355 and 356). In designing, performing and evaluating these two tests, EPA was involved with a number of groups. The groups included citizens, State and local health agencies, State and local air pollution control agencies, and industry associations. These different groups provided input on the selection of facilities for emissions testing, the design of the test program, reviewed the individual site-specific test plans, observed emissions testing, commented on the draft test reports and provided suggestions for analysis of the data to develop emission factors. The procedures used to develop emission factors generally were the same as those described above. However, additional steps were taken to ensure the quality and consistency of the data and the representativeness and universality of the emission factors developed from the data. For example, two quality assurance scientists from Research Triangle Institute were employed to independently audit the test. These additional steps are summarized below. Detailed explanations of the methodology used are provided in Section 4.4 of Appendix B.

At one of the facilities the sampling area was enclosed but did not meet EPA requirements for a total enclosure. Consequently, the capture efficiency was quantitatively estimated and the data were corrected for capture efficiency.

At one facility, emissions due to diesel truck operation could not be segregated from emissions due to truck load-out. Therefore, background concentrations also were sampled. To account for background levels of various pollutants emitted from truck operation, the as-measured background concentrations were subtracted from the capture efficiency corrected load-out emission concentrations. For the most part, values were treated as zero if the background concentration exceeded the capture-efficiency-adjusted run concentration.

Because the asphalt types and temperatures for the two facilities differed, adjustments also were made to normalize the emission data. To account for differences in the volatility of the liquid asphalts used, samples of asphalt were collected during the emission tests and analyzed by ASTM Method D 2872-88, *Effects of Heat and Air on a Moving Film of Asphalt (Rolling Thin Film Oven Test - RTFOT)* to determine the “loss-on-heating” values for the asphalts. Additional loss-on-heating data also were obtained from several State departments of transportation laboratories in order to determine a common RTFOT value to use as a default in those situations where no historical information is available. Based upon the RTFOT data collected and the desire to select a default which encourages the use of site-specific data, a default of -0.5 percent was selected as a default value for use in the predictive emission factor equations developed from the data.

To account for differences in the load-out temperatures of the two facilities the data were adjusted using the Clausius-Clapeyron equation, which relates vapor pressure and temperature of a substance. This equation and the asphalt laboratory data provide a mechanism to normalize the emissions to a temperature of 325°F, which is the maximum midpoint load-out temperature recommended by the Asphalt Pavement Environmental Council's Best Practices Guide dated March 2000.

Using the adjusted data and the temperature and volatility relationship described above, separate predictive emission factor equations were developed for emissions of total PM, organic PM, total organic compounds (TOC), and CO from drum mix and batch mix load-out operations. Additionally, adjusted data for a variety of HAP's were used to develop ratios of the HAP pollutant to either organic PM or TOC (speciation profiles). These speciation profiles are applicable to load-out emissions and yard emissions.

2.2.4 Silo Filling

Silo filling emission factors were developed from one of the emission tests described in the previous paragraphs for load-out emissions (Appendix B Reference 355). These data also were collected and evaluated with stakeholder involvement. Additionally, the same basic methodology described in the previous paragraphs for load-out emissions was used to adjust the data on emissions from silo filling operations. Predictive emission factor equations also were developed for total PM, organic PM, TOC, and CO. A detailed explanation of the methodology used to develop these equations is provided in Section 4.4.4 of Appendix B. Speciation profiles for silo filling emissions were also developed using the methodology described for load-out emissions. The speciation profiles from silo filling are applicable to asphalt storage tank emissions.

2.2.5 Asphalt Storage Tanks

To estimate emissions from heated organic liquid storage tanks, the methodologies described in Chapter 7 of AP-42 and the TANKS software are generally used. The emissions from these types of tanks depend on the contents of the tank, the volume of gas vented, and the operating temperature range of the liquid in the tank. Emissions during the filling of these tanks (working loss) are governed by the saturation concentration of the liquid stored in the tank and the volume of gas displaced by the addition of liquid to the tank. Emissions during other periods (breathing losses) are governed by the saturation concentration of the liquid stored in the tank and the changes in the volume of the gas caused by temperature variations. Although vapor pressure information on paving asphalt is not available to allow the use of the TANKS program without additional information, information was available from the silo filling test report to infer emissions during the filling of the asphalt storage tank and, by extension, the vapor pressure characteristics of paving asphalt at the typical operating temperatures. Using these data, input values for Antoine's equation and liquid and vapor molecular weight were developed for use with the TANKS program to calculate working and breathing losses for asphalt storage tanks. A detailed explanation of the methodology used to develop these values is presented in Section 4.4.5 of Appendix B.

2.2.6 Yard Emissions

At one of the EPA-sponsored emission tests described in the previous paragraphs for load-out emissions (Appendix B Reference 355), data also were collected on fugitive emissions from loaded trucks as they sat in the yard prior to departure for the job site. As with the other data from this reference, these data were evaluated with stakeholder involvement. The data obtained were fitted to a power function in order to develop an equation for these yard emissions as a function of time. A specific emission factor for cumulative emissions over an 8-minute period (which represents the maximum time represented by the

data) was calculated using the power function equation developed from the emission data. A detailed explanation of the methodology used to develop the equations and the emission factor is provided in Section 4.4.6 of Appendix B.

2.3 OTHER APPLICABLE AP-42 SECTIONS

Emission factors for other generic sources associated with HMA facilities can be found in other sections of AP-42 (<http://www.epa.gov/ttn/chief/ap42/index.html>). As discussed above, methodologies for estimating emissions from asphalt storage tanks can be found in Chapter 7 of AP-42. Methods for estimating fugitive dust emissions from vehicular traffic are presented in AP-42 Chapter 13 (Sections 13.2.1 and 13.2.2). Material handling emissions and storage pile emissions are addressed in AP-42 Chapter 11 (Section 11.19.2) and Chapter 13 (Section 13.2.4). Emission factors for truck exhaust are provided in AP-42 Volume II: Mobile Sources (<http://www.epa.gov/oms/ap42.htm>).

To calculate the material handling and mobile source emission estimates presented in Tables 1 and 2 of this report, suitable emission factors for these material handling and mobile sources were determined. The following paragraphs describe the basis for the emission factors that were used:

- Receipt of new aggregate – Used equation from AP-42 Section 13.2.4, assuming an average moisture content of 1.5 percent and an average wind speed of 10 miles per hour (mph). The resulting PM-10 emission factor is 0.0041 lb/ton of new aggregate. The resulting PM-2.5 emission factor is 0.0013 lb/ton of new aggregate.
- Transfer of aggregate from storage to conveyor belt or between conveyor belts – Used controlled emission factor from AP-42 Section 11.19.2. The PM-10 emission factor is 0.000048 lb/ton of new aggregate.
- Screening of aggregate – Used controlled emission factor from AP-42 Section 11.19.2. PM-10 emission factor is 0.00084 lb/ton of new aggregate.
- RAP crushing – Used controlled tertiary crushing emission factor from AP-42 Section 11.19.2. PM-10 emission factor is 0.00059 lb/ton of new aggregate.
- Paved road dust emissions – Used paved roads equation from AP-42 Section 13.2.1, assuming an average vehicle weight of 22 tons and a road silt content of 3 grams per square meter. The resulting PM-10 emission factor is 0.016 lb per vehicle mile traveled. The resulting PM-2.5 emission factor is 0.0040 lb per vehicle mile traveled.
- Unpaved road dust emissions – Used unpaved roads equation from AP-42 Section 13.2.2, assuming an average vehicle weight of 6 tons, a road silt percentage of 10 percent, a surface moisture content of 0.7 percent. The resulting PM-10 emission factor is 2.04 lb per vehicle mile traveled. The resulting PM-2.5 emission factor is 0.29 lb per vehicle mile traveled.
- Diesel exhaust emissions – Used heavy duty diesel truck emission factors for idling and for an average speed of 10 mph with a 250 brake horsepower engine. The diesel engines get 10 miles per gallon at 10 mph and burn 1 gallon per hour (gal/hr) of fuel at idle. The sulfur content of diesel fuel is 0.05 percent. At idle, the emissions factors for diesel engines are: VOC - 0.208 grams per minute (g/min) (0.00046 pound per minute [lb/min]), CO - 1.57 g/min (0.0035 lb/min), NO_x - 0.917 g/min (0.0020 lb/min), SO₂ - 0.157s pounds per gallon of fuel (lb/gal) (where s is fuel sulfur content) and PM - 0.043 g/min (0.000095 lb/min). When traveling at an average speed of 10 mph, the emission factors for diesel engines are: VOC - 3.18 grams per mile (g/mile) (0.0070 pounds per mile [lb/mile]), CO - 18.82 g/mile (0.041 lb/mile), NO_x - 8.50 g/mile (0.019 lb/mile), SO₂ - 0.157s lb/gal fuel (where s is fuel sulfur content), and PM - 0.1011 grams per brake horsepower hour (0.00022 pounds per horsepower hour). For organic HAP emissions - Used medium duty diesel truck emission

factors from article by Schauer, et. al., in Environmental Science & Technology of May 15, 1999. The volatile HAP emission factors presented were 0.084 grams per kilometer (g/km) (0.00030 lb/mile) and 0.0016 g/km (0.0000057 lb/mile) for PAHs.

The ducted and process fugitive emissions estimates presented in Tables 1, 2, 7, and 11 are based on the following additional assumptions:

- 84,800 ton/yr of new aggregate for batch mix plant.
- 10,000 ton/yr of recycled pavement for batch plant.
- 1.25 million gallons (5,200 tons) of asphalt for batch plant.
- 150,900 ton/yr of new aggregate for drum mix plant.
- 40,000 ton/yr of recycled pavement for drum mix plant.
- 2.5 million gallons (10,400 tons) of asphalt for drum mix plant.
- Two 18,000-gallon asphalt storage tanks.
- Five open conveyor transfer points for new aggregate.
- Front end loader travel over unpaved roads of 0.25 mile per ton of RAP used.
- Vehicle travel over paved roads of 1.5 miles per 25 tons of HMA produced.
- Vehicle idling time of 128,000 min (an average of 4 trucks in line during the average 8-minute load-out time) for batch plant.
- Vehicle idling time of 72,000 min (an average of 6 trucks in line during the average 1.5-minute load-out time) for drum mix plant.

2.4 EMISSION INVENTORY FOR TYPICAL HOT MIX ASPHALT PLANTS

To perform an emission inventory for a typical HMA plant, the first step is to identify the types of emission sources and to count the total number of each type of source. The next step is to identify the best emission estimation tools, which include: (1) facility-specific emissions test data; (2) source-specific emission factors; (3) other types of source-specific data, such as mass balance data; (4) emission factors for similar sources; (5) emission factors for sources that are believed to be somewhat similar to the source being considered; and (6) engineering estimates. After selecting appropriate emission estimation tools, activity factors, such as production rates, should be determined for each source so that emissions can be estimated for a specified period of time. The emissions over the specified period of time for each source and pollutant then are summed to complete the emission inventory. Appendix C provides more detailed information on procedures for performing an emission inventory at an HMA plant.

2.5 EMISSION ESTIMATES FOR TYPICAL HOT MIX ASPHALT PLANTS

Tables 1 and 2 present annual estimates of emissions of criteria pollutants and HAPs for typical batch mix and drum mix HMA plants, respectively. The estimates presented in these tables account for the most significant emission sources at each type of facility. Tables 5 through 12 present more detailed annual emission estimates for typical batch and drum mix HMA plants. Table 5 summarizes the estimated emissions from a typical batch mix plant dryer, hot screens, and mixer. Included in the table are estimates for criteria pollutants as well as specific PAHs, volatile HAPs, and metal HAPs for which emission factors were developed. Estimated annual criteria pollutant, PAH and volatile HAP emissions from typical batch mix plant load-out operations and asphalt storage tank are summarized in Tables 6 and 7. Tables 8, 9, 10, and 11 summarize the estimated annual emissions from a typical drum mix plant dryer, load-out operations, silo filling operations, and asphalt storage tank respectively. These tables includes estimates for criteria pollutants, PAHs, volatile HAPs, and metal HAPs for which emission factors were developed. Finally, Table 12 presents estimates of fugitive emissions from loaded trucks (yard emissions) for a typical

batch mix and drum mix plant. The emissions estimates presented in Tables 5 through 12 are based on the emission factors developed for the HMA industry and the following assumptions:

- Batch mix plant and drum mix plant dryers are fueled with either natural gas or fuel oil. It is estimated that between 70 and 90 percent of HMA plants use natural gas, although some HMA plants use fuel oil as an alternative to natural gas. As shown in Tables 5 and 8, fuel oil-fired mixers and dryers have higher emissions of SO₂, NO_x, and some HAPs.
- Batch mix plant dryer, hot screens, and mixer and drum mix plant dryer emissions are controlled with fabric filters.
- PM emissions from load-out and silo filling are entirely PM-10. (However, the organic portion of these emissions also can be assumed to be PM-2.5. Information is available in AP-42 Appendix B.1, Particle Size Distribution Data and Sized Emission Factors for Selected Sources, for categorizing the inorganic or filterable PM into PM-10 and PM-2.5 fractions.)
- Average asphalt loss on heating is -0.5 percent (asphalt volatility).
- Average HMA load-out temperature is 325°F.
- The typical HMA plant has two asphalt storage tanks that are 50 feet long and 8 feet in diameter. It is estimated that these storage tanks require a total heating capacity of about 200,000 Btu/hr, based on a heat loss of 60 Btu/ft² of tank surface area. The asphalt storage tanks are kept at 325°F continuously for the five months the HMA plant operates. As a result, 720 million Btu are used to maintain the temperature of the asphalt in the storage tank. For a gas-fired hot oil heater, 720,000 ft³ of gas is combusted. For an oil-fired hot oil heater, 5,100 gallons of fuel oil are combusted. It should be noted that this fuel usage is about 3 percent of the fuel used in a typical batch mix plant and 1.6 percent of the fuel used in a typical drum mix plant.

TABLE 3. MATRIX OF EMISSION FACTORS DEVELOPED FOR HMA SOURCES

Plant type	Source	Criteria pollutants	HAPs	Other pollutants
Batch mix	Dryer, hot screens, and mixer	PM-10, NO _x , CO, SO ₂ , VOC	24 organic HAPs 9 metal HAPs	CO ₂ 4 other organics 3 other metals
	Hot oil heaters		22 organic HAPs	
	Load-out	PM, CO, VOC,	41 organic HAPs	3 other organics
	Yard emissions	VOC	19 organic HAPs	
Drum mix	Dryer	PM-10, NO _x , CO, SO ₂ , VOC	58 organic HAPs 11 metal HAPs	CO ₂ 15 other organics, 6 other metals
	Hot oil heaters		22 organic HAPs	
	Load-out	PM, CO, VOC	41 organic HAPs	3 other organics
	Silo filling	PM, CO, VOC	28 organic HAPs	3 other organics
	Yard emissions	VOC	19 organic HAPs	

TABLE 4. LOCATIONS OF SUPPORTING DATA FOR EMISSION FACTORS

Plant Type	Source	Pollutant	Appendix A Table	Appendix B Section	Appendix B Table
Batch Mix	Dryer, hot screens, mixer	PM-10	11.1-1, 11.1-2	4.2.4.3.1-4.2.4.3.6	4-19
		CO	11.1-5	4.2.4.3.7	4-20
		CO ₂	11.1-5	4.2.4.3.8	4-20
		NO _x	11.1-5	4.2.4.3.9	4-20
		SO ₂	11.1-5	4.2.4.3.10	4-20
		TOC/VOC/methane	11.1-6	4.2.4.3.11, 4.2.4.3.12	4-20
		Speciated organics	11.1-9	4.2.4.3.12-4.2.4.3.15	4-22
		Trace metals	11.1-11	4.2.4.3.16	4-21
Drum Mix	Dryer/mixer	PM-10	11.1-3, 11.1-4	4.2.4.1.1-4.2.4.1.6	4-14
		CO	11.1-7	4.2.4.1.7	4-15
		CO ₂	11.1-7	4.2.4.1.8	4-15
		NO _x	11.1-7	4.2.4.1.9	4-15
		SO ₂	11.1-7	4.2.4.1.10	4-15
		TOC/VOC/methane	11.1-8	4.2.4.1.11	4-15
		HCl	11.1-8	4.2.4.1.18	4-17
		Speciated organics	11.1-10	4.2.4.1.12-4.2.4.1.15, 4.2.4.1.19	4-17
		Dioxin/furans	11.1-10	4.2.4.1.17	4-17
		Trace metals	11.1-12	4.2.4.1.16	4-16
Batch or Drum Mix	Hot oil heater	Organic pollutants	11.1-13	4.2.4.2	4-18
	Load-out	PM, organic PM, TOC, CO, speciated organics	11.1-14 11.1-15 11.1-16	4.4.4	4-27 to 4-37, 4-43, 4-44
	Silo filling	PM, organic PM, TOC, CO, speciated organics	11.1-14 11.1-15 11.1-16	4.4.4	4-38 to 4-44
	Asphalt storage	Speciated organics	11.1-15 11.1-16	4.4.5	4-43, 4-44
	Yard emissions	Speciated organics	11.1-15 11.1-16	4.4.6	4-45, 4-46

TABLE 5. ESTIMATED ANNUAL EMISSIONS FOR A TYPICAL BATCH MIX PLANT DRYER, HOT SCREENS, AND MIXER^a

Pollutant	Oil-fired dryer	Natural gas-fired dryer
	Emissions, lb/yr	
Criteria Pollutants		
PM-10	2,700	2,700
VOC	820	820
CO	40,000	40,000
SO ₂	8,800	460
NO _x	12,000	2,500
PAHs (semi-volatile HAPs)		
Naphthalene	3.6	3.6
2-Methylnaphthalene	7.1	7.1
Acenaphthene	0.090	0.090
Acenaphthylene	0.058	0.058
Anthracene	0.021	0.021
Benzo(a)anthracene	0.00046	0.00046
Benzo(a)pyrene	0.000031	0.000031
Benzo(b)fluoranthene	0.00094	0.00094
Benzo(g,h,i)perylene	0.00005	0.00005
Benzo(k)fluoranthene	0.0013	0.0013
Chrysene	0.00038	0.00038
Dibenz(a,h)anthracene	0.0000095	0.0000095
Fluoranthene	0.016	0.016
Fluorene	0.16	0.16
Indeno(1,2,3-cd)pyrene	0.00003	0.00003
Phenanthrene	0.26	0.26
Pyrene	0.0062	0.0062
Total PAHs	11	11
Volatile HAPs		
Acetaldehyde	32	32
Benzene	28	28
Ethylbenzene	220	220
Formaldehyde	74	74
Quinone	27	27
Toluene	100	100
Xylene	270	270
Total Volatile HAPs	751	751
Metal HAPs		
Arsenic	0.046	0.046
Beryllium	0.015	0.015
Cadmium	0.061	0.061
Chromium	0.057	0.057
Lead	0.089	0.089
Manganese	0.69	0.69
Mercury	0.041	0.041
Nickel	0.3	0.3
Selenium	0.049	0.049
Total metal HAPs	1.35	1.35

^a Dryer, hot screens, and mixer controlled by fabric filter producing 100,000 tons of hot mix asphalt per year. Between 70 and 90 percent of HMA is produced using natural gas; most of the remaining HMA is produced using fuel oil.

TABLE 6. ESTIMATED ANNUAL EMISSIONS FOR TYPICAL BATCH MIX PLANT LOAD-OUT OPERATIONS^a

Pollutant	Emissions, lb/yr
Criteria Pollutants	
PM-10	52
VOC	391
CO	135
PAHs (semi-volatile HAPs)	
Acenaphthene	0.089
Acenaphthylene	0.0095
Anthracene	0.0239
Benzo(a)anthracene	0.0065
Benzo(b)fluoranthene	0.0026
Benzo(k)fluoranthene	0.00075
Benzo(g,h,i)perylene	0.00065
Benzo(a)pyrene	0.00078
Benzo(e)pyrene	0.0027
Chrysene	0.035
Dibenz(a,h)anthracene	0.00013
Fluoranthene	0.017
Fluorene	0.26
Indeno(1,2,3-cd)pyrene	0.00016
2-Methylnaphthalene	0.81
Naphthalene	0.43
Perylene	0.0075
Phenanthrene	0.28
Pyrene	0.051
Total PAHs	2.02
Other semi-volatile HAPs	
Phenol	0.40
Volatile HAPs	
Benzene	0.22
Bromomethane	0.040
2-Butanone	0.20
Carbon disulfide	0.054
Chloroethane	0.00087
Chloromethane	0.062
Cumene	0.46
Ethylbenzene	1.16
Formaldehyde	0.37
n-Hexane	0.62
Isooctane	0.0075
Methylene chloride	0.00
Methyl tert-butyl ether	0.00
Styrene	0.030
Tetrachloroethene	0.032
Toluene	0.87
1,1,1-Trichloroethane	0.00
Trichloroethene	0.00
Trichlorofluoromethane	0.0054
m-/p-Xylene	1.70
o-Xylene	0.33
Total volatile HAPs	6.18

^a Uncontrolled emissions from 100,000 tons of hot mix asphalt per year.

TABLE 7. ESTIMATED ANNUAL EMISSIONS FOR TYPICAL BATCH MIX PLANT ASPHALT STORAGE TANK^a

Pollutant	Emissions, lb/yr
Criteria Pollutants	
PM-10	ND
VOC	32
CO	3
PAHs (semi-volatile HAPs)	
Acenaphthene	0.0027
Acenaphthylene	0.0010
Anthracene	0.00092
Benzo(b)fluoranthene	0.00051
Fluoranthene	0.00022
Fluorene	0.00016
Naphthalene	0.087
Phenanthrene	0.025
Pyrene	0.00016
Total PAHs	0.12
Volatile HAPs	
Benzene	0.010
Bromomethane	0.0016
2-Butanone	0.012
Carbon disulfide	0.0051
Chloroethane	0.0012
Chloromethane	0.0074
Ethylbenzene	0.012
Formaldehyde	140
n-Hexane	0.032
Isooctane	0.000099
Methylene chloride	0.000086
Phenol	0.00
Styrene	0.0017
Toluene	0.020
m-/p-Xylene	0.061
o-Xylene	0.018
Total volatile HAPs	140

^a Uncontrolled emissions from plant producing 100,000 tons of hot mix asphalt per year. Includes emissions from oil-fired hot oil heaters. All calculated PAH emissions and almost all of the formaldehyde emissions are from the oil-fired hot oil heater.

TABLE 8. ESTIMATED ANNUAL EMISSIONS FOR
A TYPICAL DRUM MIX DRYER^a

Pollutant	No. 2 fuel oil-fired dryer	Natural gas-fired dryer
	Emissions, lb/yr	
Criteria Pollutants		
PM-10	4,600	4,600
VOC	6,400	6,400
CO	26,000	26,000
SO ₂	2,200	680
NO _x	11,000	5,200
PAHs (semi-volatile HAPs)		
2-Methylnaphthalene	34	15
Acenaphthene	0.28	0.28
Acenaphthylene	4.4	1.7
Anthracene	0.62	0.044
Benzo(a)anthracene	0.042	0.042
Benzo(a)pyrene	0.0020	0.0020
Benzo(b)fluoranthene	0.020	0.020
Benzo(e)pyrene	0.022	0.022
Benzo(g,h,i)perylene	0.0080	0.0080
Benzo(k)fluoranthene	0.0082	0.0082
Chrysene	0.036	0.036
Fluoranthene	0.12	0.12
Fluorene	2.2	0.76
Indeno(1,2,3-cd)pyrene	0.0014	0.0014
Naphthalene	130	18
Perylene	0.0018	0.0018
Phenanthrene	4.6	1.5
Pyrene	0.60	0.11
Total PAHs	180	37
Volatile HAPs		
Isooctane	8.0	8.0
Hexane	184	180
Benzene	78	78
Ethylbenzene	48	48
Formaldehyde	620	620
Methyl chloroform	9.6	9.6
Toluene	580	30
Xylene	40	40
Total volatile HAPs	1,568	1,020
Metal HAPs		
Lead	3	0.12
Mercury	0.52	0.048
Antimony	0.036	0.036
Arsenic	0.11	0.11
Beryllium	0.000	0.000
Cadmium	0.082	0.082
Chromium	1.1	1.1
Manganese	1.5	1.5
Nickel	12.6	12.6
Selenium	0.070	0.070
Total metal HAPs	19	16

^a Dryer controlled by fabric filter producing 200,000 tons of hot mix asphalt per year. Between 70 and 90 percent of HMA is produced using natural gas; most of the remaining HMA is produced using fuel oil.

TABLE 9. ESTIMATED ANNUAL EMISSIONS FOR TYPICAL
DRUM MIX PLANT LOAD-OUT OPERATIONS^a

Pollutant	Emissions, lb/yr
Criteria Pollutants	
PM-10	104
VOC	780
CO	270
PAHs (semi-volatile HAPs)	
Acenaphthene	0.177
Acenaphthylene	0.0191
Anthracene	0.0477
Benzo(a)anthracene	0.013
Benzo(b)fluoranthene	0.0052
Benzo(k)fluoranthene	0.0015
Benzo(g,h,i)perylene	0.0013
Benzo(a)pyrene	0.00157
Benzo(e)pyrene	0.0053
Chrysene	0.070
Dibenz(a,h)anthracene	0.00025
Fluoranthene	0.034
Fluorene	0.53
Indeno(1,2,3-cd)pyrene	0.00032
2-Methylnaphthalene	1.62
Naphthalene	0.85
Perylene	0.015
Phenanthrene	0.55
Pyrene	0.10
Total PAHs	4.05
Other semi-volatile HAPs	
Phenol	0.80
Volatile HAPs	
Benzene	0.43
Bromomethane	0.080
2-Butanone	0.41
Carbon disulfide	0.11
Chloroethane	0.0017
Chloromethane	0.12
Cumene	0.91
Ethylbenzene	2.3
Formaldehyde	0.73
n-Hexane	1.25
Isooctane	0.015
Methylene chloride	0.00
Methyl tert-butyl ether	0.00
Styrene	0.06
Tetrachloroethene	0.064
Toluene	1.74
1,1,1-Trichloroethane	0.00
Trichloroethene	0.00
Trichlorofluoromethane	0.011
m-/p-Xylene	3.40
o-Xylene	0.66
Total volatile HAPs	12.35

^a Uncontrolled emissions from 200,000 tons of hot mix asphalt per year.

TABLE 10. ESTIMATED ANNUAL EMISSIONS FOR TYPICAL
DRUM MIX PLANT SILO FILLING OPERATIONS^a

Pollutant	Emissions, lb/yr
Criteria Pollutants	
PM-10	120
VOC	2,400
CO	240
PAHs (semi-volatile HAPs)	
Acenaphthene	0.24
Acenaphthylene	0.0071
Anthracene	0.066
Benzo(a)anthracene	0.028
Benzo(e)pyrene	0.0048
Chrysene	0.11
Fluoranthene	0.076
Fluorene	0.51
2-Methylnaphthalene	2.7
Naphthalene	0.92
Perylene	0.015
Phenanthrene	0.91
Pyrene	0.22
Total PAHs	5.8
Other semi-volatile HAPs	
Phenol	0.00
Volatile HAPs	
Benzene	0.78
Bromomethane	0.12
2-Butanone	0.95
Carbon disulfide	0.39
Chloroethane	0.095
Chloromethane	0.56
Ethylbenzene	0.93
Formaldehyde	17
n-Hexane	2.4
Isooctane	0.0076
Methylene chloride	0.0066
Styrene	0.13
Toluene	1.5
m-/p-Xylene	4.6
o-Xylene	1.4
Total volatile HAPs	31

^a Uncontrolled emissions from 200,000 tons of hot mix asphalt per year.

TABLE 11. ESTIMATED ANNUAL EMISSIONS FOR TYPICAL DRUM MIX PLANT ASPHALT STORAGE TANK^a

Pollutant	Emissions, lb/yr
Criteria Pollutants	
PM-10	ND
VOC	64
CO	6
PAHs (semi-volatile HAPs)	
Acenaphthene	0.0027
Acenaphthylene	0.0010
Anthracene	0.00092
Benzo(b)fluoranthene	0.00051
Fluoranthene	0.00022
Fluorene	0.00016
Naphthalene	0.087
Phenanthrene	0.025
Pyrene	0.00016
Total PAHs	0.12
Volatile HAPs	
Benzene	0.020
Bromomethane	0.0031
2-Butanone	0.025
Carbon disulfide	0.010
Chloroethane	0.0025
Chloromethane	0.015
Ethylbenzene	0.024
Formaldehyde	140
n-Hexane	0.064
Isooctane	0.00020
Methylene chloride	0.00017
Phenol	0.00
Styrene	0.0035
Toluene	0.040
m-/p-Xylene	0.12
o-Xylene	0.036
Total volatile HAPs	140

^a Uncontrolled emissions from plant producing 200,000 tons of hot mix asphalt per year. Includes emissions from an oil-fired hot oil heater. All of the calculated PAH emissions and almost all of the formaldehyde emissions are from the oil-fired hot oil heater.

TABLE 12. ESTIMATED ANNUAL YARD VOC EMISSIONS FOR TYPICAL BATCH MIX AND DRUM MIX HMA PLANTS^a

	Batch mix ^b	Drum mix ^c
Pollutant	Emissions, lb/yr	
Criteria Pollutants		
PM-10	ND	ND
VOC	110	220
CO	36	72
PAHs (semi-volatile HAPs)	ND	ND
Other semi-volatile HAPs		
Phenol	0.00	0.00
Volatile HAPs		
Benzene	0.057	0.11
Bromomethane	0.011	0.021
2-Butanone	0.054	0.11
Carbon disulfide	0.014	0.029
Chloroethane	0.00023	0.0046
Chloromethane	0.017	0.033
Cumene	0.12	0.24
Ethylbenzene	0.31	0.62
Formaldehyde	0.10	0.19
n-Hexane	0.17	0.33
Isooctane	0.0020	0.0040
Methylene chloride	0.00	0.00
Styrene	0.0080	0.016
Tetrachloroethene	0.0085	0.017
Toluene	0.23	0.46
Trichlorofluoromethane	0.0014	0.0029
m-/p-Xylene	0.45	0.90
o-Xylene	0.088	0.18
Total volatile HAPs	1.6	3.3

^a Fugitive VOC emissions from loaded haul truck for eight minutes after completion of load-out.

^b Uncontrolled emissions from plant producing 100,000 tons of hot mix asphalt per year.

^c Uncontrolled emissions from plant producing 200,000 tons of hot mix asphalt per year.

APPENDIX A

AP-42 Section 11.1
Hot Mix Asphalt Plants

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APPENDIX B

Emission Factor Documentation for AP-42 Section 11.1
Hot Mix Asphalt Production

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APPENDIX C

Chapter 3:
Preferred and Alternative Methods for Estimating
Air Emissions from Hot Mix Asphalt Plants
Emission Inventory Improvement Program (EIIP)
July 1996

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16. ABSTRACT The United States Environmental Protection Agency (EPA) Emission Factors and Inventory Group (EFIG) is investigating the Hot Mix Asphalt industry to identify and quantify criteria and hazardous air pollutants (HAP's) emitted from kiln stacks, transport truck loading and silo filling. EFIG obtained over 300 emission tests from kiln stacks that characterize emissions of criteria pollutants and hazardous air pollutants' emissions. EFIG requested that EPA's Emission Measurement Center (EMC) conduct the required testing of the transport truck and silo filling operations. Under separate EPA contracts, Midwest Research Institute (MRI) and Pacific Environmental Services (PES) performed two emissions tests. The primary objective of the testing program was to characterize uncontrolled emissions of the criteria pollutants particulate matter (PM) and total hydrocarbons (THC) and emissions of volatile and semi-volatile organic HAP's including polycyclic organic matter, phenol, benzene, toluene, xylene, ethyl benzene, 2-butanone, cumene, formaldehyde, hexane, isooctane and others. The results of the two test reports and responses to comments on these test reports are covered in separate EPA reports (EPA 454/R-00-024, EPA 454/R-00-025 (a through h), EPA 454/R-00-026, EPA 454/R-00-027, EPA 454/R-00-028 and EPA 454/R-00-029). This document characterizes hot mix asphalt plant operations, summarizes emissions from the typical batch mix and drum mix plants, presents emission factors specifically developed for hot mix asphalt plants and presents analyses used to develop the emission factors developed and presents information needed to inventory the emissions at hot mix asphalt plants.		
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