EMISSION TEST REPORT

FPM & Sulfuric Acid Mist Emission Testing on the Line-1 Trimer Control System

at

Guardian Industries, LLC.
14600 Romine Rd
Carleton, MI 48117

Test Date: July 13, 2021

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Test Date: July 13, 2021

Project 21-477

Prepared by:
Empire Stack Testing, LLC. (AETB)
1090 Cain Road
Angola, New York 14006

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General Manager
September 30, 2021

TABLE OF CONTENTS

LIST OF TABLES

LIST OF FIGURES

APPENDICES

1. **Facility Information & Statement of Certification**

Facility Information

Name of Source Operator: Guardian Industries, LLC.

Name of Source Owner: Guardian Industries, LLC.

Address of Owner: 14600 Romine Road, Carleton, Ml 4811 7

Source Identification: Glass Manufacturing

Location of Source: 14600 Romine Road, Carleton, Ml 4811 7

Owners Representative: Benjamin Kroeger

STATEMENT OF CERTIFICATION

I certify that "to the best of my knowledge" the state and federal regulations, operating permits, or plan approvals applicable to this source and/or control device to be tested have been reviewed and that all testing requirements therein have been incorporated into the test plan.

_____	_____
Signature	**Signature**
_____	_____
Title	**Title**
_____	_____
Date	**Date**
Source owner/operator	On-site supervisor for the test team

2. TEST RESULTS SUMMARY (TRS)

Table 2-1: FPM Results Summary

Site	Date	Run	Stack Parameters O_2 (%)	CO_2 (%)	Moisture (%)	Temperature (F)	Flow Rate (DSCFM)
RM 05 Outlet		1	10.1	9.0	14.6	490	34018
		2	10.1	9.0	10.0	527	32405
		3	9.7	9.0	8.7	572	33670
		Average	10.0	9.0	11.1	530	33364

Site	Date	Run	FPM Emissions (lbs/ton glass)	(lbs/hr)	(gr/DSCF)
RM 05 Outlet		1	0.08	1.29	0.0044
		2	<0.17	<2.95	<0.011
		3	0.06	0.95	0.0033
		Average	**<0.10**	**<1.73**	**<0.0062**
Permit Limit			**0.45**	**n/a**	**n/a**

Table 2-2: CTM 013 Results Summary

Date	Run	Stack Parameters O_2 (%)	CO_2 (%)	Moisture (%)	Temperature (F)	Flow Rate (DSCFM)
7/13/2021	1	10.1	9.0	13.7	490	34018
7/13/2021	2	10.1	9.0	15.1	527	32405
7/13/2021	3	9.7	9.0	15.8	572	33670
	Average	10.0	9.0	14.87	530	33364

Date	Run	Emissions H2SO4 (lbs/ton glass)	(lbs/hr)	(ppmvd)
7/13/2021	1	<0.02	<0.35	<0.68
7/13/2021	2	0.19	3.20	6.47
7/13/2021	3	0.19	3.20	6.22
	Average	**<0.13**	**<2.25**	**<4.46**
Permit Limit		**n/a**	**1.6**	**n/a**

Table 2-3: Production Data Summary

Production Data Summary				
		Production Rate		Pressure Drop
Run	Time	Tons/Day	Tons/hr	in. WC
1	1030 - 1215	410.76	17.12	5.6
2	1306 - 1451	410.76	17.12	5.6
3	1551 - 1920	410.76	17.12	5.6

Table 2-4: Summary of Analytical QA/QC Results

Test Method	Parameter	QA/QC Criteria	Ground Site QA/QC Status	Outlet Site QA/QC Status	Within QC Criteria?
RM 2	Pitot Leak Check	Δ 0.0" H_2O / 15 seconds		0.0 @ 4.4" (max)	Yes
RM 5	Sample Train Leak Check (post test)	<0.02 cfm		0.01 cfm @11.0" H_2O (max)	Yes
RM5	Isokinetics	100% +/- 10%		97.7% – 102.8%	Yes
CTM013	Sample Train Leak Check (post test)	<0.02 cfm	0.014 cfm @ 5.0" H_2O (max)		Yes
	Probe Temperature	> 350 °F	359-360°F (avg.)		Yes
	Thimble Temperature	> 500 °F	508-511°F (avg.)		Yes

3. INTRODUCTION

3.1 Introduction

Guardian Industries, LLC. (Guardian) contracted Empire Stack Testing, LLC. (Empire) to perform Filterable Particulate Matter (FPM) and Sulfuric Acid (H_2SO_4) testing services on their glass furnace in Carleton, Michigan. Testing used RM5 and CTM-13 at the Trimer outlet.

Section 5 of this Report contains the sampling and analytical procedures used to perform the test program. Section 6 details the quality assurance/quality control (QA/QC) procedures for the test program.

3.2 Test Program Objective

This test program is required annually to quantify the FPM and H_2SO_4 emissions from the outlet of the Trimer control system. All testing followed applicable methodologies of the Environmental Protection Agency (EPA), and as defined in Table 3-1, below.

3.3 Test Personnel

Coordinating the test program was:

Benjamin Kroeger
Guardian Industries, LLC.
(734)-654-4283

Ancy Sebastian
ALS Environmental
(905)-331-3111

Michael T. Karter, QSTI
Empire Stack Testing, LLC.
(716)-481-6749

3.4 Test Plan

Testing for all parameters were completed in triplicate following Reference Methods (RMs). The test program incorporates reference methods outlined in the United States Environmental Protection Agency (USEPA) Code of Federal Regulations Title 40, Part 60 (40CFR60), Appendix A. See Table 3-1 below.

3.5 Tentative Test Schedule

Day 1 (July 12):	Mobilize to Guardian and setup
Day 2 (July 13):	Complete Line-1 CTM 013 & RM 5 Sampling Trains (~ 8 hrs.)
Day 3 (July 14):	Complete Line-1 Outlet RATA (~ 8 hrs.)
Day 4 (July 15):	Complete Line-1 Inlet RATA (~ 8 hrs.)
Day 5 (July 16):	Demobilize from site

Table 3-1: Summary of Test Plan

Parameter	Method	Analysis	Sample Duration (minutes)	Test Location	Permit Limit
Flow Rate	RMs 1 & 2	S-Type Pitot Tube & Manometer	60	Outlet	n/a
Dry Molecular Weight	RM 3	O2 & CO_2 Fyrites	Various / Grab Samples	Outlet	n/a
Moisture	RM 4	Gravimetric	60	Outlet	n/a
FPM	RM 5	Gravimetric	60	Outlet	0.45 lbs/ton
H_2SO_4	CTM 013	Titration	60	Outlet	1.6 lbs/hr

NOTES:
CTM: Conditional Test Method
FPM: Filterable Particulate Matter
H_2SO_4: Sulfuric Acid
RM: United States Environmental Protection Agency Reference Method

3.6 Process Description

Flat glass manufacturing Line #1 consists of a raw material melting furnace, glass forming and finishing, and glass cutting. Line #1 produces flat glass using the float method. Materials are weighed and mixed with water in the batch house before entering the natural gas fired Furnace. Glass then enters the tin bath to be formed and drawn. Next, it enters a lehr to reduce its temperature. The emission unit is controlled by a new (Trimer ECS) Control Device consisting of a Dry Scrubber, Particulate Filter, and Selective Catalytic Reduction (SCR).

3.7 Plant data

The plant's SCADA system continuously records the operating data to be included in the test report. The plant provided plant operation and summarized pertinent operating data to represent plant operation. These data and summaries were provided both electronically (MS Excel) and in paper copies.

3.8 Test Report

Empire summarized the test program and subsequent results in this complete test report. An electronic DRAFT copy was provided via email within 35 days of completed testing for review.

The report will include the test results in both tabular and text formats. The report also includes a summary of the methods and procedures followed during the program, and all applicable results from the QA lab. Copies of all field datasheets and onsite QA/QC results are included. The data from at least a single test run were hand calculated to

verify the spreadsheets and included in the report. The first page of the report will contain a Test Results Summary (TRS) that lists the following:

- Source and Source ID numbers
- Avg. Result(s) of each pollutant expressed in units of the Title V Operating Permit limits
- Title V permit limits for each pollutant tested
- Title V Permit Number
- Determination whether each pollutant's test results demonstrate compliance or noncompliance with the Title V Operating Permits for the tested Source.

3.8.1 Executive Summary

The report's Executive Summary discusses in detail the test results and any anomalies, their resolution, and any effect on the results quality or usability. The Executive Summary will list all deviations from the approved pretest procedural Report and problems associated with the sampling, recovery, analysis, or source/control device operation. For instance, dramatic or notable reduction or increase of emission results from test run to test run were documented. In addition, laboratory notables and problems were documented on the laboratory data section summary sheets.

This test report contains language in the executive summary section of the final report concerning any relevant discussions/agreements between the Department and any company and/or testing (includes other essential interested party) personnel of any notable issues that may generally and/or adversely affect testing, recovery, analysis, and process control operations. These types of correspondence may take place at the time of testing in the field or via telephone.

4. PRESENTATION OF RESULTS / EXECUTIVE SUMMARY

This Executive Summary discusses, in detail, the test results and any anomalies, their resolution, and any effect on the results quality or usability.

4.1 Discussion of Results

Testing was completed on July 13th, 2021 for FPM, H_2SO_4, and SO_2. During this test program, the facility operated at an average production rate of 410.76 tpd.

The results indicate that the measured emissions are compliant with their permit limits, with the exception of H_2SO_4 testing. All field and lab data are included in the appendices of this report.

4.1.1 Isokinetics

Each RM 5 sample run for FPM met the isokinetic limit of 100 % ± 10%. These and other QAQC criteria are summarized in Table 2-4.

4.1.2 FPM Test Result (RM 5)

The average FPM emissions were measured to be <0.1 lbs/ton; which is compliant with limit of 0.45 lbs/ton. See Summary Table 2-1.

4.1.3 H_2SO_4 Test Result (CTM 013)

The average emission rate of sulfuric acid was <2.25 lbs/hr and <0.13 lbs/ton of glass. The unit did not demonstrate compliance with the emission limit of 1.6 lbs/hr. See Table 2-2.

4.2 Anomalies

No anomalies were recorded during testing, analysis, nor report production.

5. SAMPLING AND ANALYTICAL PROCEDURES

This section provides a brief overview of the specific test methods that were used to determine the Sulfuric Acid emissions from each the glass furnace. All test method procedures were performed in accordance with the USEPA Reference Methods given in 40CFR60, Appendix A. The details of each method are given in the following sections.

5.1 Reference Method Test Location

The exhaust stack is fixed with four 10-inch diameter ports. The test ports are located approximately 7 equivalent diameters downstream of a disturbance and 11 equivalent diameters upstream of another disturbance. See Figure 5-1.

5.2 Sampling Point Location

5.2.1 Volumetric Flow

Representative measurement of pollutant emissions and total volumetric flow rate from a stationary source requires a measurement site where the effluent stream is flowing in a known direction and cyclonic flow is not present. See section 5.3.1, below.

According to Reference Method 1, the cross section of the stack is divided into equal areas and a traverse point is then located within each of these areas. The number of duct diameters upstream and downstream from the test location to a flow disturbance determines the number of traverse points in a cross section.

As these stacks have diameters >24 inches the outermost traverse points were at least 1 inch from the stack walls.

Sampling was performed at six traverse points per traverse for a total of 24 sampling points, as set forth by RM 1. See Figures 5-3 and 5-4.

5.3 Stack Gas Velocity and Volumetric Flow Rate

According to Reference Method 2, the gas velocity in a stack was determined from the average velocity head with a type S Pitot tube, gas density, stack temperature, and stack pressure.

The average velocity head was determined by using an inclined manometer and a type S Pitot tube with a known coefficient of 0.84 that is determined geometrically by standards set forth in Reference Method 2. Stack temperatures were taken at each traverse point using a type K thermocouple. Static pressures were determined by using a straight tap and an inclined manometer.

5.3.1 Cyclonic Flow Check

The cyclonic flow check was performed during previous testing and demonstrated non-cyclonic, laminar flow. These data were included in the test report.

5.4 Oxygen & Carbon Dioxide Concentration (RM 3)

The Oxygen and Carbon Dioxide concentrations used in the calculation of the stack gases molecular weight were measured according to RM-3 with grab samples and Fyrite gas analyzers.

5.5 Moisture Determination (RM 4)

The determination of effluent moisture was performed as part of the wet-chemistry sampling, as detailed below in RM 5 and CTM013.

5.6 Filterable Particulate Matter (RM 5)

5.6.1 Background

Reference Method 5 was used to determine the FPM concentrations. An integrated sample was drawn from the stack. The filterable particulate was quantified from the probe and filter catch.

5.6.2 Sampling

An isokinetic sample was collected at a rate of approximately 0.7 cubic feet per minute (cfm) for 72 minutes. A heated glass probe, heated glass filter, and standard full-size impingers were used. The first two impingers contained 100 ml each of distilled water. The third impinger remained empty. The last impinger contained a known amount of silica gel. The second impinger was a Greenburg-Smith design; the remaining impingers were modified Greenburg-Smith designed. A schematic of the sampling train is presented in Figure 5-7. Both the probe and filter were maintained at 250 °F, ±50 °F as required by the method.

5.6.3 Sample Recovery

Recovery of all sample train components were performed in Empire's Mobile Laboratory.

Container 1:
The filter was carefully removed from the filter holder with the use of tweezers and disposable surgical gloves, and placed into its Petri dish labeled with the filter ID number and identified as "Container No. 1" for the proper run and location. Any particulate matter and/or fiber filters that adhered to the filter holder or filter holder gasket were carefully transferred to the Petri dish with the use of a dry nylon bristle brush or a sharp-edged blade. The Petri dish was then sealed with parafilm. The probe nozzle, probe liner, and front half of the filter holder were rinsed at least three times with acetone, and the rinses collected in a sample jar labeled "Container No. 2". The container was then sealed, and the fluid level marked.

Container 2:
The particulate matter was recovered from the probe nozzle, union, probe liner, front half of the filter holder, and (if applicable) the cyclone, as follows;

a. The nozzle was rinsed with acetone, brushed with a non-metallic bristle brush, and rinsed with acetone until no visible particles remained. A final acetone rinse was performed.
b. The probe liner was rinsed and brushed at least six times, followed by a final rinse of the brush with acetone.
c. After completing the rinses, the lid on the sample container was tightened and the height of the fluid level marked.

Acetone Blank:
An acetone blank with a volume roughly equal to the rinse volume were saved as a blank.

5.6.4 Analysis

The samples were shipped to ALS Environmental for analysis following RM 5. The filters were desiccated to a constant weight. The gravimetric analysis of the filters and acetone samples were repeated every six to twenty-four hours until stable analyses are obtained.

ALS Environmental uses a 40 mL vial to analyze the acetone rinses, in lieu of evaporation in a 250 mL beaker. This minimizes the tare weight of the vessel; as the vials have a tare weight of approximately 21g compared to a tare weight of approximately 100g with a 250 mL glass beaker. The 250 mL glass beaker has a greater chance of variability; also, the NJ-DEP (the primary NELAC accreditor) has certified ALS Environmental to perform this analysis with the modification listed.

The procedure used is as follows:

- The vials are kept in the balance room at all times prior to use. Lab numbers are put on the vials with a black magic marker and the vial is then desiccated for one hour prior to doing the pre-weight
- Place bottle of solvent onto Navigator balance, enter the weight into the "Bottle and Solvent Weight" column
- Place a ribbed watch glass on the sample container and set in a fume to evaporate to <10 mL
- Transfer the remaining solvent to a pre-cleaned, pre-weighed and pre-numbered 40 mL glass vial
- Place the empty bottle of solvent onto Navigator balance, enter weight into the "Empty Bottle Weight" column
- Reduce to dryness with a gentle stream of N2 using the N-Evap system
- Place vials in desiccators for 24 hours minimum and record the time in the spreadsheet
- Note the appearance of the residue on the worksheet, (light, dark, minimal, copious as l/d/m/c)
- Proceed to 7.4 (Balance use and weighing samples)
- When all weightings are complete a second analyst must select and reweigh 1 of every 10 vials (the vial is to be selected at random)
  Second analyst's result must be ±2 mg of the first analyst's result.

5.7 Sulfuric Acid (CTM-013)

5.7.1 Background

This method was developed as an alternative to EPA Method 8 for determining sulfuric acid emissions from Kraft recovery furnaces. When testing recovery furnaces, EPA Method 8 is subject to significant interference from sulfates, which are present in the particulate matter, and sulfur dioxide. The alternative method uses a quartz in-line thimble to remove particulate matter from the gas stream prior to capturing sulfuric acid. The use of a controlled condensation technique eliminates the potential for interference from sulfur dioxide.

A gas sample is extracted from the sampling point in the recovery furnace stack. The sulfuric acid vapor or mist (including sulfur trioxide) and the sulfur dioxide are separated, and both fractions are measured separately by **Titration.**

5.7.2 Sampling

The sampling train consisted of a glass nozzle and heated glass probe, which were maintained at the temperature of >177°C (350°F). The probe was then connected to

the thimble holder housed in an oven box that were also maintained at the temperature of >500 °F. The thimble holder was constructed of quartz with a quartz thimble filter.

Sampling was performed for a minimum of **60 minutes** at a constant rate (±10%) of ~10.0 lpm (~0.35 cfm).

A condenser connected the thimble to the train. The condenser was filled with water and its temperature was maintained between 75 and 85°C (167 to 185°F). The condenser was connected to the impinger train with a minimal length of unheated Teflon tubing. The first and third impingers consisted of Greenburg-Smith design, the remaining impingers were modified Greenburg-Smith designed impingers. The first two impingers contained 100 ml of 3% hydrogen peroxide (H_2O_2). The third impinger contained 100 ml of distilled deionized water (RODI). The fourth impinger contained approximately 500 g of silica gel desiccant.

A vacuum line connected the outlet of the last impinger to the control module. The control module consisted of a vacuum gauge, rotary pump, by-pass and main valve, dry gas meter, orifice, and an inclined manometer. The sample train is illustrated in Figure 3-8.

Coinciding with the sampling were velocity, moisture, and dry molecular weight determinations.

5.7.3 Sample Purge

At the completion of the test run, the probe was separated from the thimble, and a 15-minute purge with clean air (ambient) were performed at the same rate at the test run, as required by the method.

5.7.4 Sample Recovery

Recovery was performed onsite in Empire's mobile laboratory at the completion of each test run.

Container 1:
Rinse separately the probe, quartz thimble holder and the H_2SO_4 condenser with deionized water using multiple rinse. After completing the rinses, the lid on the sample container were tightened and the height of the fluid level marked. The thimble was discarded.

Container 2:
The liquid from the first two impingers were quantitatively transferred into a clean sample bottle (glass or plastic). (SO_2 analysis only)

Container 3:
The water from the third impinger were weighed in the field, and then discarded.

Blank H_2O_2:
Take ~100 ml of H_2O_2 and place it in a recovery bottle. The liquid level on the bottle was marked.

Blank H_2O:
Take ~100 ml of H_2O and place it in a recovery bottle. The liquid level on the bottle was marked.

5.7.5 Analysis

The **container-1 and blank** samples were shipped to ALS Environmental of Mississauga, Ontario, Canada for H_2SO_4 analysis **via titration**.

Figure 5-1: Test Port Location (Outlet)

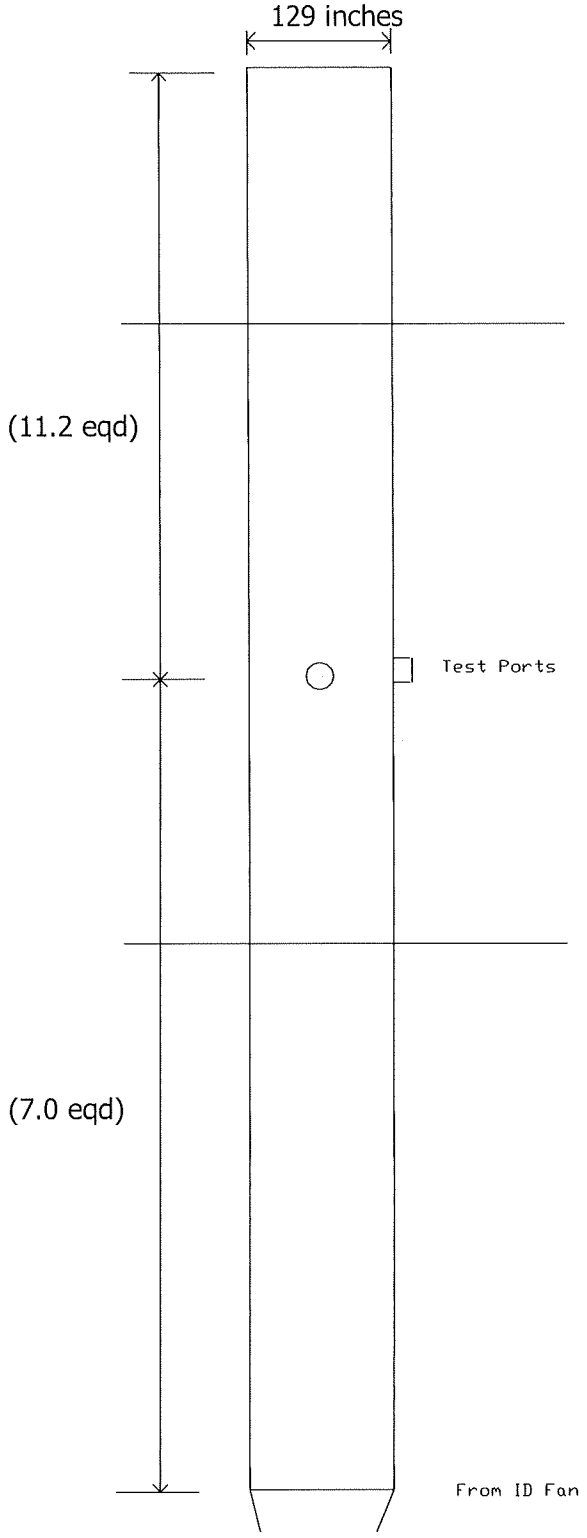
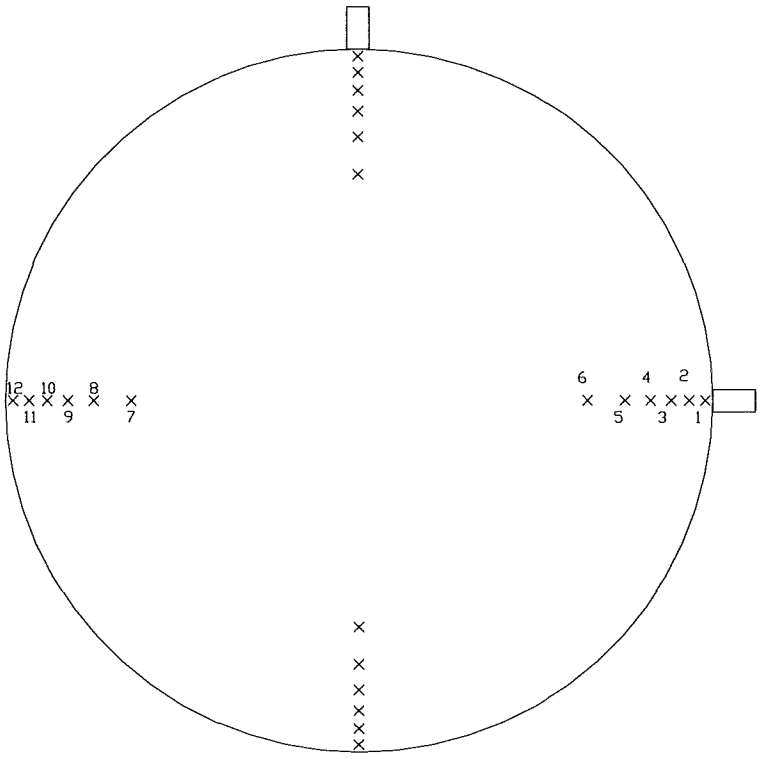


Figure 5-2: Sampling Point Locations (Outlet)



Traverse Point Number	Distance from Inner Wall (%)	Distance from Port Edge (inches)
1	2.1	48.7
2	6.7	54.6
3	11.8	61.2
4	17.7	68.8
5	25.0	78.3
6	35.6	91.9
7	64.4	129.1
8	75.0	142.8
9	82.3	152.2
10	88.2	159.8
11	93.3	166.4
12	97.9	172.3

Diameter: 129″
Nipple: 46″

Figure 5-3: RM 5 Sampling Train

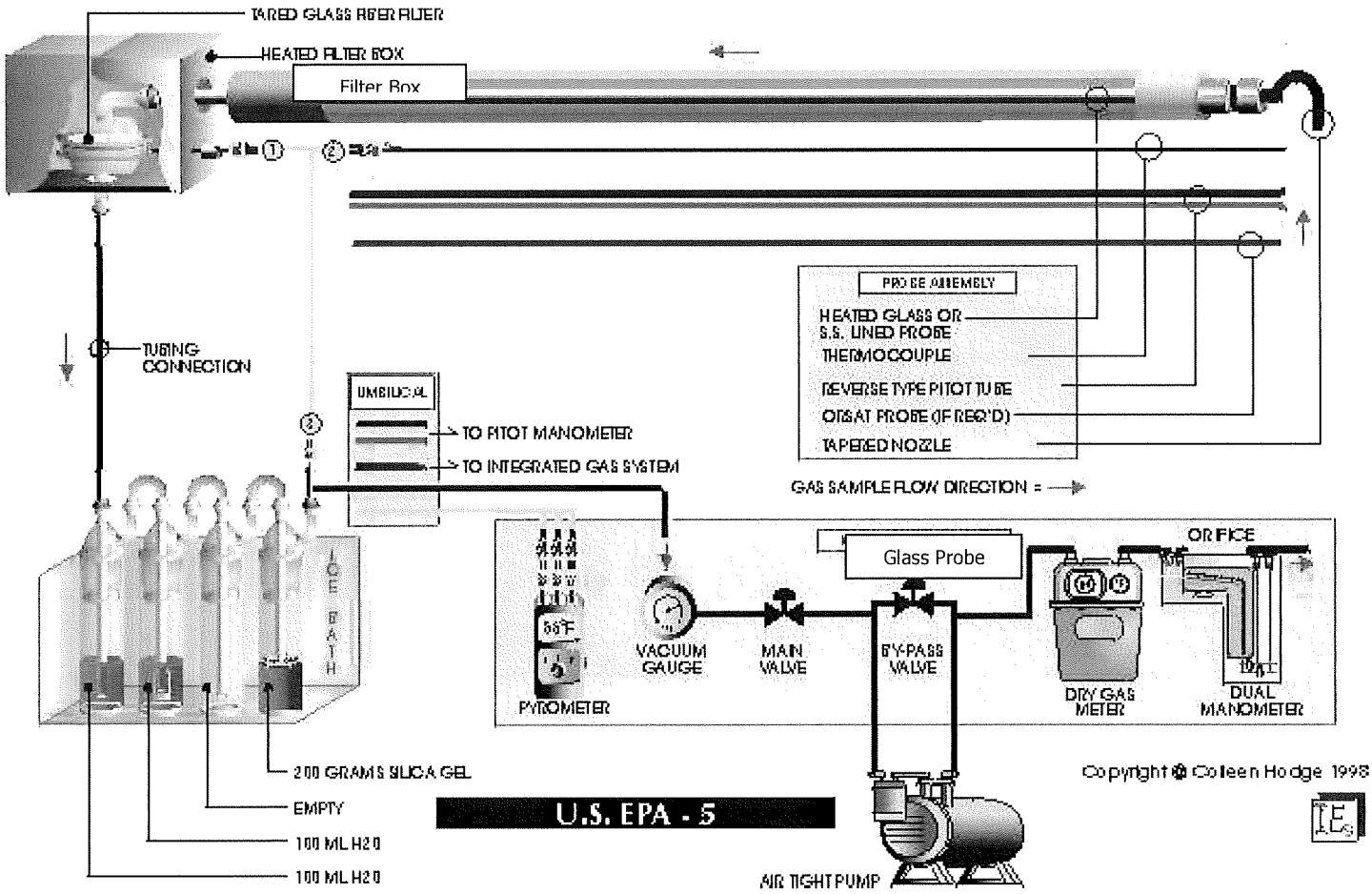
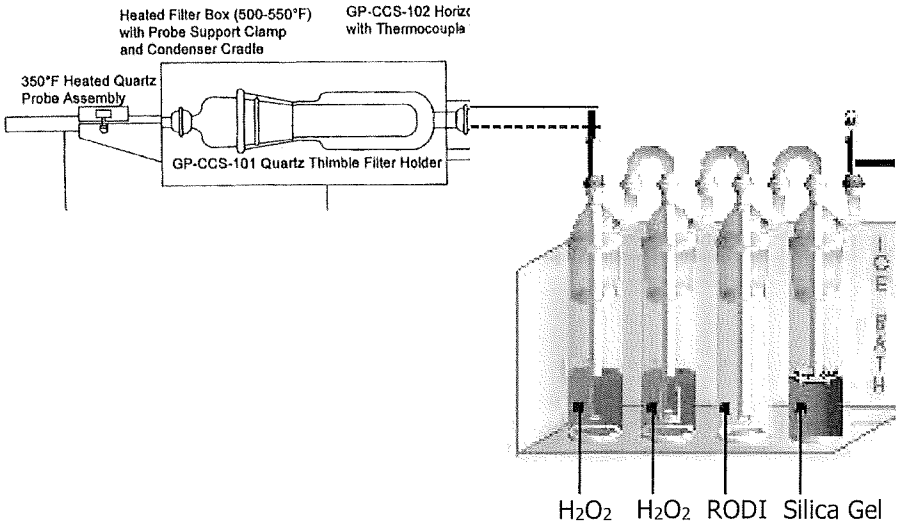


Figure 5-4: CTM 013 Sampling Train



6. QUALITY ASSURANCE AND QUALITY CONTROL (QA/QC)

Quality control procedures for all aspects of field sampling, sample preservation and holding time, reagent quality, analytical methods, analyst training and safety, instrument cleaning, calibration, and safety were followed. These procedures were consistent with EPA Guidelines documented in:

EPA 600/9-76-005, Quality assurance Handbook for Air Pollution Measurement Systems, Volume I
EPA 454/R-98-004, Quality assurance Handbook for Air Pollution Measurement Systems, Volume II
EPA 600/R-94-038c, Quality assurance Handbook for Air Pollution Measurement Systems, Volume III

6.1 Chain of Custody

Documentation of the Chain-of-Custody of samples and data obtained during the test program is essential for ensuring the validity of the test program results. Chain-of-Custody procedures were followed during sampling, sample and data transport, sample preparation and analysis, storage of data, as well as with archived samples and reported results. Empire follows the Report listed in SW 846, Section 1.3 during field sampling and in-house laboratory analysis.

6.2 Equipment and Sampling Preparation

Sampling equipment was cleaned, checked, and calibrated prior to use in the field. Each parameter's sampling method requires specific cleaning methods of the glassware, train components, and recovery containers. These materials were then sealed prior to shipment to the field.

6.3 Calibrations

6.3.1 Pitot Calibration

Pitot tubes were calibrated according to Reference Method 2, Section 10.1. Pitot tubes were given a baseline coefficient of 0.84 when they meet certain geometrically measured angles and dimensions as set forth in the method.

6.3.2 Thermocouple Display Calibration

Following Method 2, Section 10.3, an NIST Traceable Electronic Thermocouple Calibrator/Simulator (ALTEK) for post-test calibrations was used. If the display being calibrated and the ALTEK were within +/-1°F and/or +/-2% of the reference temperature, the calibration is acceptable, else the display is re-calibrated.

6.3.3 Thermocouple Calibration

According to EMTIC GD-28, a single point (at ambient temperature) check of the thermocouple was made prior to and following each test program. If the thermocouple being calibrated and the certified thermometer were within +/- 2.0 °F of each other, the calibration was acceptable. The thermocouple must also respond appropriately to a change in temperature. Thermocouples that fail either of these criteria were repaired or discarded.

6.3.4 Barometer Calibration

During testing, the barometric station pressure was obtained online from the nearest NOAA or FAA weather station.

6.4 Leak Checks

6.4.1 Sample Trains (CTM013)

A leak-check prior to the sample run was optional; however, a leak-check after the sampling run was mandatory. The leak check was conducted in accordance with the procedures outlined in Reference Method 5, Section 8.5.9, except that it was conducted at a vacuum equal to or greater than the maximum value reached during the sampling run. If the leakage rate is found to be no greater than 0.02 cfm, the results were acceptable, and no correction were applied to the total volume of dry gas metered.

6.4.2 Sample Trains (FPM)

Both pre- and post-run leak checks were conducted. A pre-test leak check was performed to verify integrity of the vacuum system. A leak check was mandatory at the conclusion of each isokinetic sampling run. The leak check was conducted in accordance with the procedures outlined in Reference Method 5, Section 8.5.9, except that it was conducted at a vacuum equal to or greater than the maximum value reached during the sampling run. If the leakage rate was found to be no greater than 0.02 cfm, the results were acceptable, and no correction was applied to the total volume of dry gas metered.

6.4.3 Pitot Leak Check

The pitot tubes used during the test program were leak checked prior to the test series and following each traverse set, as prescribed in RM 2, Section 8.1. The leak check was performed by pressurizing the positive side of the pitot to at least 3 inches of water. No loss of pressure for 15 seconds indicated a successful leak check. This procedure was repeated with a vacuum applied to the negative side of the Pitot tube as well.

6.5 Sample Recovery

All sample volumes and reagent volumes were measured and recorded on Empire's recovery data sheets and included in the report. All recovery procedures were intended to meet the requirements of the methods.

6.6 Sample Recovery

All sample volumes and reagent volumes were measured and recorded on Empire's recovery data sheets and included in the report. All recovery procedures were intended to meet the requirements of the methods.

6.7 Data Reduction

The QA/QC procedures for data reduction include using computer programs to generate tables of results. Results for at least one test run were double-checked and re-calculated by hand. These pages were included in the report.

The wet-chemistry data was logged directly to a separate laptop hard drive, where calculations were performed using MS-Excel spreadsheets. These data were archived nightly to flash media. Copies of these data were available in the field electronically or in print form, upon request. Paper datasheets will only be used in an emergency.

6.8 Performance Audits

Due to a lack of audit materials from certified vendors, the audit program is disbanded. Therefore, no audit materials were obtained and analyzed.

6.9 Safety

These methods involve hazardous materials, operations, and equipment. Empire established appropriate safety and health practices and determined the applicability of regulatory limitations before performing this test program.

The test site shall meet the criteria of RM 1. Test ports (loosened and cleaned), safe access, and suitable power to be provided by the client. The above items need to be ready upon arrival of the test crew.

Delay or Lost Time (delays) of the field crew due to causes beyond the control of Empire Stack Testing, LLC. (Empire) may include (but were not limited to) weather, cyclonic flow conditions, process upsets or failure, or the facility's inability to maintain the desired test conditions). Inclement weather includes (but is not limited to) lightning, strong rains, blizzards, high winds (≥30 mph), high humidity, and/or working temperatures below 20 °F or above 90 °F. Empire's field leader retained the right of final refusal to stop testing for any unsafe condition.