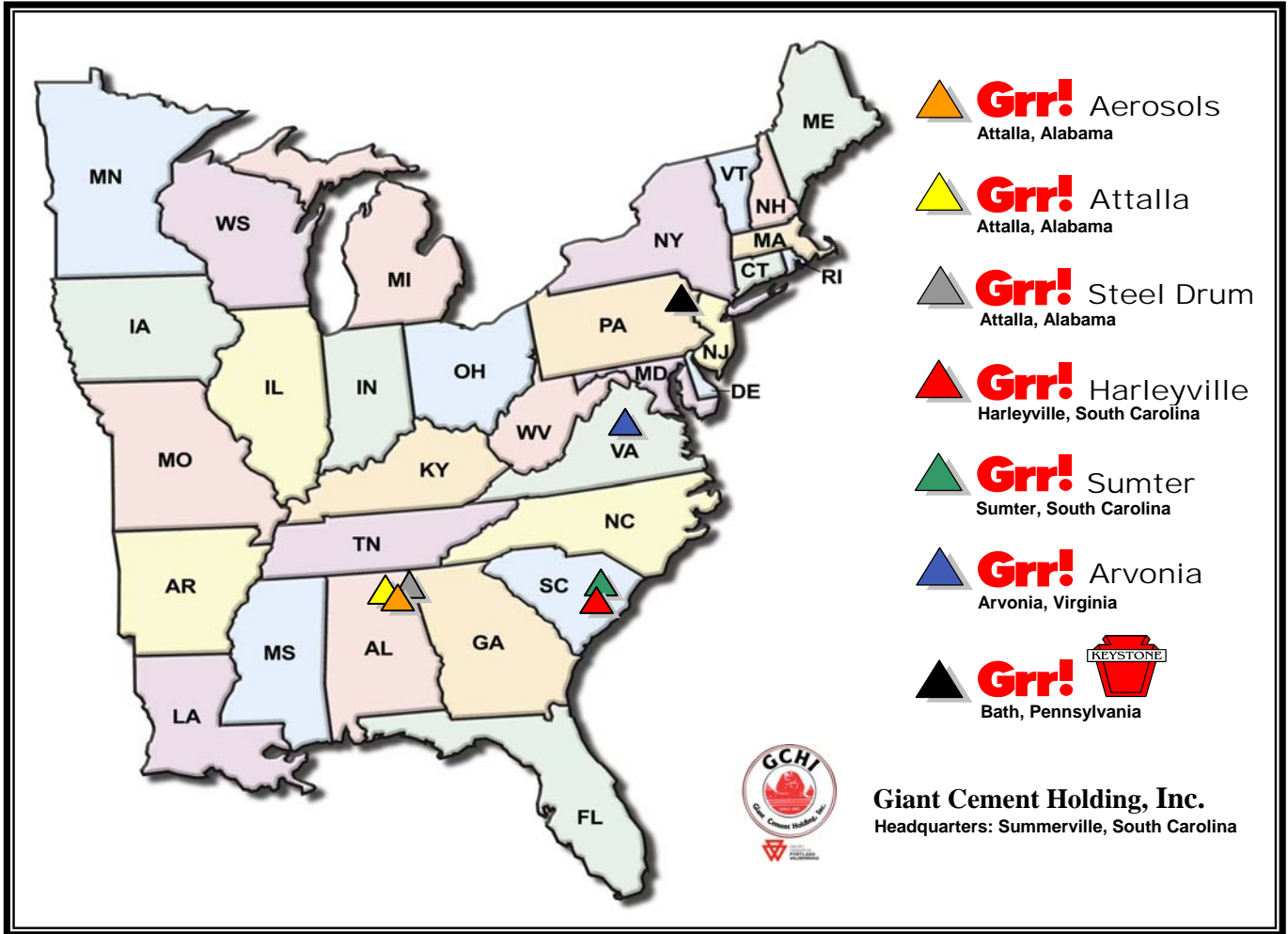


Grr!

The Giant Resource Recovery Facilities



Resource Recovery and Energy Reutilization

Safe, Reliable, Permanent



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Giant Cement Holding, Inc. Giant Resource Recovery, Inc.

A History of Resource Recovery and Energy Reutilization

Giant Cement Holding, Inc. (GCHI) manufactures high quality Portland cement through its subsidiaries **Giant Cement Company** in Harleyville, SC, and **Keystone Cement Company** in Bath, PA. For more than 30 years, the facilities have carefully blended and beneficially reused hazardous and non-hazardous wastes as supplemental fuel in their cement production processes. **Giant Resource Recovery (GRR)**, a subsidiary of GCHI, is the environmental and waste management company responsible for the resource recovery and waste fuels programs.

In 1998, GCHI acquired **Solite Corporation's** lightweight aggregate manufacturing plant and its waste management and fuel blending operation, **Oldover Corporation**, in Arvonnia, VA. At the same time, Giant gained **M&M Chemical and Equipment Company**, a waste processing and container management facility in Attalla, AL, as well as **M&M Steel Drum**, a drum reconditioning facility in nearby Gadsden. In 1999, GCHI furthered its dedication to resource recovery by acquiring a waste management and solvent recovery facility in Sumter, SC, known as **Omni-Southeastern Chemical and Solvents Company**. As members of the Giant family, these three waste management facilities now share the GRR name.

GRR grew yet again in early 2002 with the opening of **GRR Aerosols, Inc.** in Arvonnia, VA. GRR Aerosols added the unique capability of disposing of wastes in aerosol containers by recycling 100% of the components in an innovative closed-loop system.

In 2005, the Solite lightweight aggregate plant was sold to Solite, LLC, a subsidiary of Southern Aggregates, LLC. GRR retained ownership of the waste management and fuel blending operation including GRR Aerosols. GRR also entered into a long-term fuel supply agreement with Solite, LLC. Historically, the Solite facility has relied upon waste fuel for approximately 95% of the energy required to manufacture lightweight aggregate, and the use of wastes received and blended into fuel by GRR remains an integral part of the Solite process.

Since its inception, Giant has developed significant proprietary technology to efficiently use solid industrial wastes as a reliable fuel source. GRR-Harleyville completed an extensive \$130 million expansion in 2005 which maximizes the use of the solids processing technology. The following year, the Keystone plant unveiled a \$230 million modernization project. Upon completion of the project, Keystone will join its sister company as one of the most technologically advanced cement plants in the United States, complemented by Giant's industry-leading ability to process wastes into fuel.

GRR continued its efforts to meet the growing needs of generators by expanding and relocating GRR Aerosols to Attalla, AL, in late 2007. GRR Steel Drum was also relocated to Attalla. With increased capacity and a broadened list of acceptable hazardous waste codes, **GRR Aerosols, a Division of GRR-Attalla, Inc.**, handles more volume and types of aerosol wastes than any company in North America.

As its history shows, GRR actively seeks out new technologies and methods of resource recovery and energy reutilization. By combining more than 100 years of experience with a demonstrated commitment to environmental stewardship, the GRR family of companies provides generators with an unparalleled range of safe, reliable, and permanent waste management services.



Giant Resource Recovery Facilities

GRR – Sumter

Sumter, SC

Processes ~ 26 million gallons of containerized and bulk liquids, solids and sludges per year; solvent reclamation and sales

GRR – Attalla

Attalla, AL

Processes ~ 8.5 million gallons of containerized and bulk liquids, solids, and sludges per year; reclaimed solvent sales

GRR Aerosols

Attalla, AL

Recycles and destroys ~ 15 million pounds of aerosol cans per year

GRR Steel Drum

Attalla, AL

Reconditions and sells ~ 65,000 steel drums per year

GRR – Harleyville (Cement Kiln)

Harleyville, SC

Blends and burns ~ 24 million gallons of solid and liquid waste-derived fuel per year

GRR – Keystone (Cement Kiln)

Bath, PA

Blends and burns ~ 17 million gallons of liquid waste-derived fuel per year

GRR – Arvonnia

Arvonnia, VA

Blends ~ 5 million gallons of waste into fuel per year for burning in adjacent Solite, LLC lightweight aggregate kilns



Giant Resource Recovery – Sumter

Giant Resource Recovery – Sumter
P.O. Box 1755
755 Industrial Road
Sumter, SC 29151

Sales and Customer Service:
Phone (803) 773-1400
(877) 473-6664
Fax (803) 775-4145
(803) 775-7016

Permit Status – EPA ID No. SCD036275626

RCRA Part B Permit for storage; originally issued 1/28/1987; reissued 7/17/2002; expired 7/17/2007; timely renewal application submitted March 2007 - pending approval

State Operating Permit No. 2140-0038; issued 9/23/2005; expires 5/31/2010
Permitted Capacity:

Container Storage – 1,578 drums hazardous

No limit on non-hazardous

Bulk Storage and Treatment Tanks – 538,000 gallons hazardous
270,000 gallons non-hazardous

Permitted Waste Codes – D001, F001, F002, F003, F005, D002 (if further describing an F code), D004 through D043

GRR-Sumter, formerly known as Omni-Southeastern Chemical and Solvents, is the largest solvent recovery/fuels blending facility on the East Coast, receiving and processing more than 2.3 million gallons of various materials per month. Most drums received by GRR-Sumter are processed within 24 hours.

GRR-Sumter's main facility is located on 18 acres one mile south of Sumter, SC, and only 56 miles from Giant Cement in Harleyville, SC. There is also a second site located one mile from the main plant. The second site handles rail cars and solvent distribution. This facility has capacity for 510,000 gallons of virgin and reclaimed solvents as well as storage capacity for 500 drums of product solvent.



Services and Capabilities

GRR – Sumter

Industrial Waste Services and Capabilities:

- Fuel Blending – Hazardous and non-hazardous wastes; liquids, sludges, and certain solids in bulk, drums, cubic-yard boxes, roll-off containers, tote tanks, and supersacks
- Solvent Recovery – Reclamation and processing for resale as a wash solvent blend or reclamation for sale as a reclaimed product
- Non-Hazardous Solid Waste – Processing for landfill and waste-to-energy
- Non-Hazardous Water – Processing by treatment and discharge to a POTW or stabilizing and landfill
- Hazardous Water – Collection and bulking
- Industrial Oil – Collection and processing for fuels blending or resale
- Laboratory Services – Certified for TCLP analysis
- Solvent Sales – Sale of reclaimed solvents including special blends for various industries
- Special Wastes – Processing of high temperature wastes and wastes requiring special handling that others may refuse because of potential difficulties
- Waste Bulking – Collection and processing of solid wastes to be sent to GRR and incinerators for burning



Waste Approval Procedures **GRR – Sumter**

To obtain approval for a new waste stream, please submit the following prior to shipment:

1. GRR-Sumter Facility Profile Form
2. Credit Application – New customers only
3. Any available analytical, MSDS's, and health and safety information to facilitate quick approval

Samples are not required unless the waste is unusual or has potential for reclaim.

Completed profiles and other information should be mailed or faxed to:

Approvals/Customer Service
GRR-Sumter
P.O. Box 1755
Sumter, SC 29151
Phone: (803) 773-1400
Fax: (803) 775-4145, (803) 775-7016

Typical approval time is 3-4 days, but overnight approvals are available. For questions concerning approvals, call Sales/Customer Service at (877) 473-6664.

Prior to shipment, drum top labels are provided to the generator so that he can indicate the stream number for each drum and viscosity of the contents (such as liquid, sludge, processible solids, or non-processible solids).

Below is the official information needed to complete manifests for materials approved into GRR-Sumter:

Giant Resource Recovery-Sumter, Inc.
755 Industrial Road
PO Box 1755
Sumter, SC 29151
Phone: (803) 773-1400
US EPA ID No. SCD036275626

For assistance, call Sales/Customer Service at (877) 473-6664.



Giant Resource Recovery – Attalla

Giant Resource Recovery – Attalla
1229 Valley Drive
Attalla, Alabama 35954

Sales and Customer Service:
Phone (800) 637-4023
Fax (256) 538-1836

Permit Status – EPA ID No. ALD070513767

RCRA Part B Permit for treatment and storage; originally issued 10/2/1995;
renewed 9/29/2006; expires 9/28/2016

Permitted Capacity:

Container Storage – 2,113 drums

Bulk Storage and Treatment Tanks – 160,000 gallons

Process Treatment Tank – 1 unit

Total Storage and Treatment Tank Capacity – 344,000 gallons

Waste Management Services:

- Fuels Blending – Solids, Sludges, Liquids
- Drum and Bulk Processing
- Fuels Analysis
- SQG Pick-Up Service
- Mid-America and East Coast Transportation Network – Vans, Tankers, Vacs
- Drum Reconditioning and Destruction through **GRR Steel Drum**
- Non-Hazardous Waste Management
- Reclaimed Solvent Sales



Permitted Waste Codes GRR – Attalla

Approved waste codes for bulk liquid fuels and fuel blendable materials in drums:

D001	D021	D033	F001	K022	U002	U080	U162	U227	
D004	D022	D034	F002	K083	U003	U088	U165	U228	
D005	D023	D035	F003	K086	U008	U112	U169	U239	
D006	D024	D036	F004		U009	U113	U171		
D007	D025	D037	F005		U012	U117	U188		
D008	D026	D038			U019	U118	U196		
D009	D027	D039			U031	U121	U209		
D010	D028	D040			U044	U122	U210		
D011	D029	D041			U051	U140	U211		
D018	D030	D042			U056	U154	U213		
D019	D032	D043			U057	U159	U220		
					U077	U161	U226		

Approved waste codes for solids to be bulked and shipped to Giant Cement:

D001	D041	F001	K001	K048	U001	U050	U093	U126	U159	U200	U239
D002	D043	F002	K002	K049	U002	U051	U094	U127	U160	U201	U240
D004		F003	K003	K050	U003	U052	U095	U128	U161	U202	U243
D005		F004	K004	K052	U004	U053	U096	U129	U162	U203	U244
D006		F005	K005	K053	U005	U055	U097	U130	U164	U205	U328
D007		F006	K006	K060	U006	U056	U098	U131	U165	U207	
D008		F007	K007	K061	U007	U057	U099	U132	U166	U208	
D009		F008	K008	K062	U008	U068	U101	U133	U167	U209	
D010		F009	K009	K083	U009	U069	U102	U134	U168	U210	
D011		F010	K010	K084	U010	U071	U103	U136	U169	U211	
D018		F012	K011	K085	U011	U072	U105	U137	U170	U212	
D019		F011	K013	K086	U012	U073	U106	U138	U171	U213	
D021		F024	K014	K087	U014	U074	U107	U140	U172	U214	
D022		F032	K015	K093	U015	U075	U108	U141	U174	U215	
D023		F034	K016	K094	U016	U076	U109	U142	U179	U216	
D024		F035	K017	K095	U017	U077	U110	U143	U180	U217	
D025		F037	K018	K096	U018	U078	U111	U144	U181	U218	
D026		F038	K019	K100	U019	U079	U112	U145	U182	U219	
D027		F039	K020	K101	U020	U080	U113	U146	U183	U220	
D028			K021	K102	U021	U081	U114	U147	U184	U221	
D029			K022	K103	U022	U082	U115	U148	U185	U222	
D030			K023	K104	U023	U083	U116	U149	U186	U223	
D032			K024	K105	U024	U084	U117	U150	U187	U225	
D033			K025	K115	U025	U085	U118	U151	U188	U226	
D034			K026	K141	U026	U086	U119	U152	U190	U227	
D035			K027	K142	U027	U087	U120	U153	U191	U228	
D036			K028	K143	U031	U088	U121	U154	U192	U235	
D037			K029	K144	U039	U089	U122	U155	U193	U236	
D038			K030	K145	U043	U090	U123	U156	U194	U237	
D039			K035	K147	U044	U091	U124	U157	U196	U238	
D040			K046	K148	U045	U092	U125	U158			



Waste Approval Procedures **GRR – Attalla**

To obtain approval for a new waste stream, please submit the following prior to shipment:

1. GRR-Attalla Waste Material Profile Form
2. Benzene NESHAP Questionnaire
3. Credit Application – New customers only
4. TC Rule Certification Form – Non-hazardous only
5. Any available analytical, MSDS's, and health and safety information to facilitate quick approval

Samples are not required for approval provided the waste is accurately characterized on the profile. However, if the waste material has characteristics that may cause processing problems (such as compatibility, viscosity, etc.), a one-quart representative sample should be submitted.

Please mail or fax completed profiles and other information to:

Approvals Manager
GRR-Attalla
1229 Valley Drive
Attalla, Alabama 35954
Phone: (256) 538-3800
Fax: (256) 538-1836 or (256) 538-2634

For questions concerning approvals, call Sales/Customer Service at (800) 637-4023.

Below is the official information needed to complete manifests for materials approved into GRR-Attalla:

Giant Resource Recovery-Attalla, Inc.
1229 Valley Drive, Highway 11 North
Attalla, AL 35954, Reece City, AL
Phone: (256) 538-3800
US EPA ID No. ALD070513767

For assistance, call Sales/Customer Service at (800) 637-4023.



Giant Resource Recovery Aerosols

Giant Resource Recovery Aerosols

Sales and Customer Service Office:

P.O. Box 2912

Mechanicsville, VA 23116

Phone (804) 723-5538

Fax (804) 723-5539

Processing Facility:

1229 Valley Dr.

Attalla, AL 35954

Phone (800) 637-4023

Fax (256) 538-1836

Permit Status – EPA ID No. ALD070513767

RCRA Part B Permit for treatment and storage; originally issued 10/2/1995;
renewed 9/29/2006; expires 9/29/2016

GRR Aerosols employs a patented, 100% closed-loop “Kruncher” system to dispose of hazardous and non-hazardous wastes in aerosol cans. The system crushes the containers utilizing an explosion-proof technology that separates the gaseous and liquid components and compacts the cans into a dense metal brick. The propellants are used for energy recovery. The liquids are blended into waste fuel that is burned in the production of cement. The metal bricks are sent to a metals recycler.



Waste Acceptance Guidelines

GRR Aerosols

Hazardous or non-hazardous wastes in aerosol cans and small metal or plastic containers

EPA Waste Codes: See page 11

PCB's: No detectable amount

Unacceptable Materials: Asthmatic and CFC aerosol inhalers, adhesives, silicone gasket-maker products, isocyanates/expanding foam insulation products, zinc-based paint and undercoating products, D002 corrosives, D003 reactives, pepper spray, other aerosols not adequately characterized and approved by GRR Aerosols



Permitted Waste Codes **GRR Aerosols**

D001	D021	D033	F001	U154
D004	D022	D034	F002	
D005	D023	D035	F003	
D006	D024	D036	F004	
D007	D025	D037	F005	
D008	D026	D038		
D009	D027	D039		
D010	D028	D040		
D011	D029	D041		
D018	D030	D042		
D019	D032	D043		



Aerosols

A Division of GRR-Attalla, Inc.

Waste Approval Procedures **GRR Aerosols**

To obtain approval for a new waste stream, please submit the following prior to shipment:

1. GRR Aerosols-Attalla Waste Profile
2. Land Disposal Restriction Notification
3. Benzene NESHAP Questionnaire
4. Credit Application – New customers only
5. Any available analytical, MSDS's, and health and safety information to facilitate quick approval

Samples are not required for approval provided the waste is accurately characterized on the profile. However, if the waste material has characteristics that may cause processing problems (such as compatibility, viscosity, etc.), a representative sample may be requested.

Please mail or fax completed profiles and other information to:

GRR Aerosols
P.O. Box 2912
Mechanicsville, VA 23116
Phone: (804) 723-5538
Fax: (804) 723-5539

For questions concerning approvals, call Sales/Customer Service at 804-723-5538.

Below is the official information needed to complete manifests for materials approved into GRR Aerosols:

Giant Resource Recovery-Attalla, Inc.
1229 Valley Drive, Highway 11 North
Attalla, AL 35954, Reece City, AL
Phone: (256) 538-3800
US EPA ID No. ALD070513767

For assistance, call Sales/Customer Service at (804) 723-5538.



Giant Resource Recovery – Harleyville

Giant Resource Recovery – Harleyville
P.O. Box 352
654 Judge St.
Harleyville, South Carolina 29448

Sales and Customer Service:
Phone (800) 786-0477
(803) 496-2200
Fax (803) 496-2228

Permit Status – EPA ID No. SCD003351699

RCRA Part B Permit for treatment and storage; effective 10/30/92; renewed 4/11/2005; expires 5/25/2015

Title V Operating Permit which includes all applicable MACT requirements; issued 2/11/2003; expires 3/31/2008; timely renewal application submitted March 2007 - pending approval

GRR-Harleyville is located adjacent to **Giant Cement** on 60 acres of a 1700-acre site north of the town of Harleyville, SC. GRR processes both solid and liquid hazardous and non-hazardous materials into waste-derived fuel. The fuel is then burned by Giant Cement in the production of Portland cement in its rotary kiln. Giant is also able to direct-feed certain liquid waste fuels from a tanker to the kiln.

GRR-Harleyville has the distinction of being the most successful cement kiln in recycling alternate fuels since the program started under BIF in 1992. It is one of only two cement plants in the US that is permitted to store and utilize bulk solid hazardous waste fuels. In 2005, the facility completed a \$130 million expansion which furthered its ability to efficiently and effectively handle these materials.

Examples of wastes that are suitable for GRR's resource recovery program include solvents, waste oils, and coolants, as well as shredded and crushable solids. GRR can receive materials in tankers, roll-offs, end dumps, and rail cars.



Waste Acceptance Guidelines GRR – Harleyville

GRR-Harleyville handles the following categories of wastes:

I. Hazardous and Non-Hazardous Solid Fuel

Examples: Filter Cakes, Paint Solids, Refinery Wastes, Carbon, Resins, PPE, Rags, Debris, Consumer Products

Specifications:

- Heat Content – > 5,000 BTU/lb. (2,000-5,000 BTU may be accepted on a case-by-case basis)
- Chlorides – $\leq 5\%$ (> 5% may be accepted on a case-by-case basis)
- PCB's – < 40 ppm
- Metals – See page 15
- < 10% by volume gravel, rocks, stones, etc.

Examples of materials that are not suitable for the Solid Fuel Program include medical wastes, free liquids, wet sludges, construction debris (concrete, steel, etc.), lab packs, aerosol cans, nitrocellulose, and reactive, explosive, and radioactive materials, as well as other materials that may pose processing problems.

II. Hazardous and Non-Hazardous Liquid Fuel

Examples: Solvents, Waste Oil, Coolants, Alcohols, Off-Spec Fuels

Specifications:

- Heat Content – > 5,000 BTU/lb. (2,000-5,000 BTU may be accepted on a case-by-case basis)
- Chlorides – $\leq 3\%$ (> 3% may be accepted on a case-by-case basis)
- PCB's – < 40 ppm
- Metals – See page 15

III. Non-Hazardous Materials that Can Replace Raw Materials Used in Cement Production

Examples: Fly Ash, Sand, Iron Oxide, High Calcium-Type Materials

Specifications:

- Size – < 20" x 20" x 20"
- Sulfur – < 3%
- Free of debris such as wood, concrete, metal, tires, etc.



Metals Guidelines GRR – Harleyville

The guidelines below apply to all waste fuel materials. Materials that exceed these criteria may be accepted on a case-by-case basis with prior notification if they can be blended to meet the guidelines, except as noted.

Arsenic (As)	750	ppm
Beryllium (Be)	40	ppm
Cadmium (Cd)	440	ppm
Chromium (Cr)	7,500	ppm
Lead (Pb)	2,900	ppm
Mercury (Hg)	10*	ppm
Nickel (Ni)	25,000	ppm
Zinc (Zn)	90,000	ppm

* Until an upper limit for mercury is established, GRR asks that the generator manage his waste shipments to < 10 ppm. This is because the total mercury that GRR receives in waste shipments may vary daily which could affect the acceptance of a load.



Permitted Waste Codes GRR – Harleyville

-	D033	F001	K001	K051	P001*	U001	U052	U099	U136	U172	U217
7777	D034	F002	K002	K052	P006*	U002	U053	U101	U137	U174	U218
D001	D035	F003	K003	K060	P022*	U003	U055	U102	U138	U179	U219
D002	D036	F004	K004	K061	P028*	U004	U056	U103	U140	U180	U220
D003	D037	F005	K005	K062	P029*	U005	U057	U105	U141	U181	U221
D004	D038	F006	K006	K083	P030*	U006	U063	U106	U142	U182	U222
D005	D039	F007	K007	K084	P050*	U007	U066	U107	U143	U183	U223
D006	D040	F008	K008	K085	P053*	U008	U067	U108	U144	U184	U225
D007	D041	F009	K009	K086	P055*	U009	U068	U109	U145	U185	U226
D008	D042	F010	K010	K087	P064*	U010	U069	U110	U146	U186	U227
D009	D043	F011	K011	K088	P074*	U011	U070	U111	U147	U187	U228
D010		F012	K013	K093	P075*	U012	U071	U112	U148	U188	U230
D011		F024	K014	K094	P098*	U014	U072	U113	U149	U190	U231
D012		F032	K015	K095	P105*	U015	U073	U114	U150	U191	U232
D013		F033	K016	K096	P106*	U016	U074	U115	U151	U192	U235
D014		F034	K017	K100	P120*	U017	U075	U116	U152	U193	U236
D015		F035	K018	K101	P127*	U018	U076	U117	U153	U194	U237
D016		F037	K019	K102	P189*	U019	U077	U118	U154	U196	U238
D017		F038	K020	K103		U020	U078	U119	U155	U200	U239
D018		F039	K021	K104		U021	U079	U120	U156	U201	U240
D019			K022	K105		U022	U080	U121	U157	U202	U242
D020			K023	K115		U023	U081	U122	U158	U203	U243
D021			K024	K141		U024	U082	U123	U159	U204	U244
D022			K025	K142		U025	U083	U124	U161	U205	U247
D023			K026	K143		U026	U084	U125	U162	U207	U328
D024			K027	K144		U027	U085	U126	U163	U208	U359
D025			K028	K145		U028	U086	U127	U164	U209	U367
D026			K029	K146		U029	U087	U128	U165	U210	
D027			K030	K147		U030	U088	U129	U166	U211	
D028			K035	K148		U031	U089	U130	U167	U212	
D029			K046	K156		U032	U090	U131	U168	U213	
D030			K048	K157		U036	U091	U132	U169	U214	
D031			K049	K158		U037	U092	U133	U170	U215	
D032			K050	K159		U039	U093	U134	U171	U216	
				K160		U043	U094				
				K161		U044	U095				
				K169		U045	U096				
				K170		U047	U097				
				K171		U048	U098				
				K172		U050					
						U051					

* Although these codes are in Giant’s permit, they are handled on a case-by-case basis and only with written permission from Giant.



Waste Approval Procedures **GRR – Harleyville**

To obtain approval for a new waste stream, please submit the following prior to shipment:

1. GRR Material Profile and Addendum 1
2. South Carolina Air Toxic Survey Form
3. Benzene NESHAP Questionnaire
4. Credit Application – New customers only
5. Representative sample: Liquids – One quart
Solids – Five-gallon pail

All containers must be labeled with the generator's name, the name of the waste as identified on the Profile, and the date the sample was collected. The sample must be shipped in appropriate DOT-approved packaging.

The completed forms and sample should be sent to:

Approvals Department
GRR-Harleyville
482 Seven Mile Rd.
Harleyville, SC 29448
Phone: (803) 496-2220
Fax: (803) 496-2228

For questions concerning approvals, please call Sales/Customer Service at (800) 786-0477.

Below is the official information needed to complete manifests for materials approved into GRR-Harleyville:

Giant Cement Company
654 Judge Street
Harleyville, SC 29448
Phone: (803) 496-2200
US EPA ID No. SCD003351699

For assistance, call Sales/Customer Service at (800) 786-0477.



Giant Resource Recovery – Keystone

Giant Resource Recovery – Keystone
Route 329, P.O. Box A
Bath, PA 18014

Sales and Customer Service:
Phone (610) 837-1881, ask for
Resource Recovery Dept.
Fax (610) 837-2267

Permit Status – EPA ID No. PAD002389559

Interim Status under the Boiler and Industrial Furnace (BIF) Regulations,
40 CFR 266 Subpart H

RCRA Part B Permit for storage; originally issued 12/27/1991; renewed
12/26/2001; expires 12/27/2011

Title V Operating Permit which includes all applicable MACT requirements;
effective 8/31/2001; expired 8/31/2006; timely renewal application
submitted March 2006 - pending approval

GRR-Keystone operates a cement manufacturing facility on 850 acres in Bath, PA. Since 1976, Keystone has blended high-BTU hazardous waste-derived liquid fuels as a supplement to coal in its cement manufacturing process. Keystone was the first cement company in the United States to have an energy recovery program of this type. GRR-Keystone's two cement kilns beneficially use 17 million gallons of waste-derived fuel annually to replace approximately 50% of the coal requirement.

In 2006, Keystone embarked on a \$230 million modernization project. Upon completion in 2010, the expanded facility will enable Keystone to better serve the growing needs of its customers while at the same time reducing plant emissions.

The current hazardous waste management units include four waste fuel storage tanks with a combined capacity of 93,000 gallons. All tanks are above ground, nitrogen blanketed, and agitated. GRR-Keystone also operates an on-site laboratory and offers off-site rail transfer facility services.



Waste Acceptance Guidelines

GRR – Keystone

GRR-Keystone accepts hazardous waste liquids in bulk tankers only. The waste must meet the specifications below upon receipt.

Heat Content	\geq 8000 BTU/lb.
Total Halogens	< 3.0%
PCB's	Not present
pH	2.0 – 12.5
Specific Gravity	0.6 – 1.2 @ 60° F
Viscosity	< 7000 cps @ 60° F < 12000 cps @ 35° F
Organic peroxide	Not present
Sulfur	< 2.2%
Ash	< 20%
Compatibility	Must pass compatibility test
Metals:	
Arsenic (As)	100 ppm
Barium (Ba)	50,000 ppm
Beryllium (Be)	20 ppm
Cadmium (Cd)	1,000 ppm
Chromium (Cr)	1,000 ppm
Lead (Pb)	2,500 ppm
Mercury (Hg)	10 ppm
Nickel (Ni)	1,000 ppm



Permitted Waste Codes

GRR – Keystone

Primary Waste Codes:

D001	F001	K014	K028	U001	U055	U154
D018	F002	K015	K035	U002	U056	U159
D035	F003	K016	K036	U004	U057	U161
	F004	K017	K048	U009	U112	U169
	F005	K018	K049	U012	U113	U171
		K019	K050	U019	U115	U188
		K020	K051	U031	U117	U194
		K022	K052	U051	U140	U220
		K023	K083	U052	U153	U239
		K025	K086- solvent washing only			
		K026	K087			

The following secondary waste codes are permitted when they are applicable due to the mixture or derived-from rule and are not substantial constituents of the waste:

D004	D009	D022	D027	D034	D039
D005	D010	D023	D028	D035	D040
D006	D011	D024	D029	D036	D041
D007	D019	D025	D030	D037	D042
D008	D021	D026	D032	D038	D043



Waste Approval Procedures

GRR – Keystone

Each new bulk liquid waste stream must be approved by the GRR-Keystone Approvals Department and by the Pennsylvania Department of Environmental Protection (PADEP) prior to shipment. For assistance, call the Resource Recovery Department at (610) 837-1881 or your GRR sales representative.

Below is the official information needed to complete manifests for materials approved into GRR-Keystone:

Keystone Cement Company
Routes 329 & 512
Bath, PA 18014
Phone: (610) 837-1881
US EPA ID No. PAD002389559

For assistance, call Sales/Customer Service at (610) 837-1881, Ext. 2232.



Giant Resource Recovery – Arvonía

Giant Resource Recovery

Sales and Service Office:
P.O. Box 2912
Mechanicsville, VA 23116

Phone (804) 723-5538
Fax (804) 723-5539

Processing Facility:
11049 Bridgeport Rd.
Arvonía, VA 23004

Phone (434) 581-3226
Fax (434) 581-1017

Permit Status – EPA ID No. VAD098443443

RCRA Part B Permit for storage; issued 10/29/1995; expired 10/29/2005;
timely renewal application submitted May 2005 - pending approval
Title V Operating Permit which includes all applicable MACT requirements;
effective 12/3/2001; renewed 12/3/2006; expires 12/2/2011

GRR-Arvonía operates a waste fuel blending facility in Arvonía, VA, about 60 miles southwest of Richmond. GRR-Arvonía receives hazardous and non-hazardous liquid wastes in bulk tankers. These materials are blended into waste fuel that is burned in the manufacture of lightweight aggregate and cement. Types of wastes suitable for GRR's process include spent solvents, coatings and resins, waste petroleum products, still bottoms, and waste organic chemicals.

Upon arrival at GRR, wastes are analyzed and transferred to the GRR tank farm where they are blended to meet fuel specifications. The tank farm consists of 15 receiving and storage tanks with a total capacity of 300,000 gallons. The waste fuel is then piped to Solite, LLC on the adjacent property or delivered to other GRR-affiliated kilns for use in their production processes. Historically, the Solite facility has relied upon waste fuel for approximately 95% of the energy required to manufacture lightweight aggregate.



Waste Acceptance Guidelines GRR – Arvonía

Hazardous or non-hazardous bulk liquids

EPA Waste Codes: See page 24

Heat Content: $\geq 5,000$ BTU/lb. (2,000-5,000 BTU/lb. may be accepted on a case-by-case basis)

Halogens: $\leq 2\%$ ($> 2\%$ may be accepted on a case-by-case basis)

Compatibility: Must be compatible with other wastes typically handled by GRR

PCB's: No detectable amount

Unacceptable materials: Corrosives, organic cyanides, sulfides, lachrymates, mercaptans, listed pesticides and herbicides, explosives, radioactive, reactives



Permitted Waste Codes GRR – Arvonía

Permitted Waste Codes:

D001	F001-F005	K022-K025	U002	U080	U169
D004-D008*	F037-F038	K027	U009	U112	U171
D010-D011*		K029-K030	U019	U117-U118	U188
D018-D019		K083	U031	U121-U122	U196
D021-D030		K085-K086	U037	U140	U210-U211
D032-D043			U043-U044	U154	U220
			U051-U052	U159	U226-U228
			U056-U057	U161-U162	U239
			U070	U165	U359

The codes below are permitted if they are applicable only due to the Mixture or Derived-From Rule and are not substantial constituents of the waste:

F006-F012*	K001	P001-P009	P108-P112	U001	U155-U158
F019*	K002-K008*	P010-P013*	P113-P115*	U003-U008	U160
F024-F025	K009-K011	P014	P116	U010-U012	U163-U164
F032	K013-K021	P015*	P118	U014-U018	U166-U168
F034-F035	K026	P016-P018	P119-P122*	U020-U030	U170
F039	K028	P020-P024	P123	U032*	U172-U174
	K031-K052	P026-P028		U033-U036	U176-U187
	K060	P029*		U038-U042	U189-U194
	K061*	P030-P031		U045-U050	U197
	K062	P033-P034		U053	U200-U203
	K064-K066	P036-P051		U055	U204-U205*
	K069*	P054		U058-U064	U206-U209
	K071*	P056-P060		U066-U069	U212-U215
	K073	P062-P073		U071-U079	U216-U217*
	K084	P074*		U081-U099	U218-U219
	K087-K088	P075-P078		U101-U103	U221-U223
	K090-K091	P081-P082		U105-U111	U225
	K093-K099	P084-P085		U113-U116	U230-U238
	K100*	P087*		U119-U120	U240
	K101-K105	P088-P089		U123-U138	U242-U244
	K106*	P092-P098		U141-U144	U246-U249
	K107-K118	P099*		U145*	U328
	K123-K126	P101-P103		U146-U150	U353
	K131-K132	P104*		U151*	
	K136	P105-P106		U152-U153	

*** These codes and ranges of codes must have a heating value of 5000 or more BTU per pound at the point of generation.**



Waste Approval Procedures GRR – Arvonía

For **bulk liquid hazardous** materials, please submit:

1. GRR-Arvonía Waste Profile
2. Land Disposal Restriction Notification
3. Benzene NESHAP Questionnaire
4. Credit Application – New customers only
5. Representative Sample – One pint in a glass jar labeled with the generator's name, the name of the waste as identified on the Profile, and the date the sample was collected. The sample must be shipped in appropriate DOT-approved packaging. Analyses from any lab that uses standard reference methodology and produces accurate and reliable data may be considered in lieu of sample. Specific information must be submitted with the analyses including the lab's EQL's or PQL's. Contact your sales representative for further details.

For **bulk liquid non-hazardous** materials, please submit:

1. GRR-Arvonía Waste Profile
 2. Non-Hazardous Certification Statement
 3. Credit Application – New customers only
- Normally, no sample is required for non-hazardous materials.

The completed forms, sample (if required), available analyses, MSDS's, and health and safety information should be sent to:

Giant Resource Recovery, Inc.
6462 Boatswain Lane
Mechanicsville, VA 23111
Phone: (804) 723-5538
Fax: (804) 723-5539

The typical turnaround time for approval is 2 weeks from the date all complete and correct paperwork and any required sample are received. For questions concerning approvals, please call Sales/Customer Service at 804-723-5538.

Below is the official information needed to complete manifests for materials approved into GRR-Arvonía:

Giant Resource Recovery-Arvonía, Inc.
11049 Bridgeport Rd.
Arvonía, VA 23004
Phone: (434) 581-3226
US EPA ID No. VAD098443443

For assistance, call Sales/Customer Service at (804) 723-5538.



Manifest Information Giant Resource Recovery

Below are the official designated facility names, site addresses, US EPA ID numbers, and facility phone numbers for manifests accompanying shipments into the GRR facilities. For additional assistance, please call or fax the Sales/Customer Service number.

Giant Resource Recovery – Sumter, Inc.

755 Industrial Road
PO Box 1755
Sumter, SC 29151
Phone: (803) 773-1400
US EPA ID No. SCD036275626

Sales/Customer Service: (877) 473-6664
Fax: (803) 775-4145

Giant Resource Recovery – Attalla, Inc., including GRR Aerosols GRR Steel Drum

1229 Valley Drive, Highway 11 North
Attalla, AL 35954, Reece City, AL
Phone: (256) 538-3800
US EPA ID No. ALD070513767

GRR-Attalla, GRR Steel Drum:
Sales/Customer Service: (800) 637-4023
Fax: (256) 538-1839
GRR Aerosols
Sales/Customer Service: (804) 723-5538
Fax: (804) 723-5539

Giant Cement Company

654 Judge Street
Harleyville, SC 29448
Phone: (803) 496-2200
US EPA ID No. SCD003351699

Sales/Customer Service: (800) 786-0477
Fax: (803) 496-2228

Keystone Cement Company

Routes 329 & 512
Bath, PA 18014
Phone: (610) 837-1881
US EPA ID No. PAD002389559

Sales/Customer Service: (610) 837-1881, Ext. 2232
Fax: (610) 837-2313

Giant Resource Recovery – Arvonnia, Inc.

11049 Bridgeport Rd.
Arvonnia, VA 23004
Phone: (434) 581-3226
US EPA ID No. VAD098443443

Sales/Customer Service: (804) 723-5538
Fax: (804) 723-5539