APPENDIX B.2

GENERALIZED PARTICLE SIZE DISTRIBUTIONS

CONTENTS

Appendix B.2

Generalized Particle Size Distributions

B.2.1 Rationale For Developing Generalized Particle Size Distributions

The preparation of size-specific particulate emission inventories requires size distribution information for each process. Particle size distributions for many processes are contained in appropriate industry sections of this document. Because particle size information for many processes of local impact and concern are unavailable, this appendix provides "generic" particle size distributions applicable to these processes. The concept of the "generic" particle size distribution is based on categorizing measured particle size data from similar processes generating emissions from similar materials. These generic distributions have been developed from sampled size distributions from about 200 sources.

Generic particle size distributions are approximations. They should be used only in the absence of source-specific particle size distributions for areawide emission inventories.

B.2.2 How To Use The Generalized Particle Size Distributions For Uncontrolled Processes

Figure B.2-1 provides an example calculation to assist the analyst in preparing particle size-specific emission estimates using generic size distributions.

The following instructions for the calculation apply to each particulate emission source for which a particle size distribution is desired and for which no source specific particle size information is given elsewhere in this document:

1. Identify and review the AP-42 section dealing with that process.

2. Obtain the uncontrolled particulate emission factor for the process from the main text of AP-42, and calculate uncontrolled total particulate emissions.

3. Obtain the category number of the appropriate generic particle size distribution from Table B.2-1.

4. Obtain the particle size distribution for the appropriate category from Table B.2-2. Apply the particle size distribution to the uncontrolled particulate emissions.

Instructions for calculating the controlled size-specific emissions are given in Table B.2-3 and illustrated in Figure B.2-1.

Figure B.2-1. Example calculation for determining uncontrolled and controlled particle size-specific emissions.

SOURCE IDENTIFICATION
Source name and address: ABC Brick Manufacturing
24 Dusty Way
Anywhere, USA

Process description: Dryers/Grinders
AP-42 Section: 8.3, Bricks And Related Clay Products
Uncontrolled AP-42 emission factor: 96 lbs/ton (units)
Activity parameter: 63,700 tons/year (units)
Uncontrolled emissions: 3057.6 tons/year (units)

UNCONTROLLED SIZE EMISSIONS
Category name: Mechanically Generated/Aggregated, Unprocessed Ores
Category number: 3

	Particle size (μm)		
	≤ 2.5	≤ 6	≤ 10
Generic distribution, Cumulative percent equal to or less than the size:	15	34	51
Cumulative mass ≤ particle size emissions (tons/year):	458.6	1039.6	1559.4

CONTROLLED SIZE EMISSIONS*
Type of control device: Fabric Filter

	Particle size (μm)		
	0 - 2.5	2.5 - 6	6 - 10
Collection efficiency (Table B.2-3):	99.0	99.5	99.5
Mass in size range** before control (tons/year):	458.6	581.0	519.8
Mass in size range after control (tons/year):	4.59	2.91	2.60
Cumulative mass (tons/year):	4.59	7.50	10.10

* These data do not include results for the greater than 10 μm particle size range.
** Uncontrolled size data are cumulative percent equal to or less than the size. Control efficiency data apply only to size range and are not cumulative.

Table B.2-1. PARTICLE SIZE CATEGORY BY AP-42 SECTION

AP-42 Section	Source Category	Category Number*
	External combustion	
1.1	Bituminous and subbituminous coal combustion	a
1.2	Anthracite coal combustion	a
1.3	Fuel oil combustion	
	Residual oil	
	Utility	a
	Commercial	a
	Distillate oil	
	Utility	a
	Commercial	a
	Residential	a
1.4	Natural gas combustion	a
1.5	Liquefied petroleum gas	a
1.6	Wood waste combustion in boilers	a
1.7	Lignite combustion	a
1.8	Bagasse combustion	b
1.9	Residential fireplaces	a
1.10	Residential wood stoves	a
1.11	Waste oil combustion	a
	Solid waste disposal	
2.1	Refuse combustion	a
2.2	Sewage sludge incineration	a
2.7	Conical burners (wood waste)	2
	Internal combustion engines	
	Highway vehicles	c
3.2	Off highway vehicles	1
	Organic chemical processes	
6.4	Paint and varnish	4
6.5	Phthalic anhydride	9
6.8	Soap and detergents	a
	Inorganic chemical processes	
8.2	Urea	a
8.3	Ammonium nitrate fertilizers	a
8.4	Ammonium sulfate	
	Rotary dryer	b
	Fluidized bed dryer	b
8.5	Phosphate fertilizers	3
8.5.3	Ammonium phosphates	
	Reactor/ammoniator-granulator	4
	Dryer/cooler	4
8.7	Hydrofluoric acid	
	Spar drying	3
	Spar handling	3
	Transfer	3
8.9	Phosphoric acid (thermal process)	a
8.10	Sulfuric acid	b
8.12	Sodium carbonate	a
	Food and agricultural	
9.3.1	Defoliation and harvesting of cotton	
	Trailer loading	6
	Transport	6
9.3.2	Harvesting of grain	
	Harvesting machine	6
	Truck loading	6
	Field transport	6
9.5.2	Meat smokehouses	9
9.7	Cotton ginning	b
9.9.1	Grain elevators and processing plants	a
9.9.4	Alfalfa dehydrating	
	Primary cyclone	b
	Meal collector cyclone	7
	Pellet cooler cyclone	7
	Pellet regrind cyclone	7
9.9.7	Starch manufacturing	7
9.12	Fermentation	6,7
9.13.2	Coffee roasting	6
	Wood products	
10.2	Chemical wood pulping	a
10.7	Charcoal	9
	Mineral products	
11.1	Hot mix asphalt plants	a
11.3	Bricks and related clay products	
	Raw materials handling	
	Dryers, grinders, etc.	b

Table B.2-1 (cont.).

AP-42 Section	Source Category	Category Number*
	Tunnel/periodic kilns	
	Gas fired	a
	Oil fired	a
	Coal fired	a
11.5	Refractory manufacturing	
	Raw material dryer	3
	Raw material crushing and screening	3
	Electric arc melting	8
	Curing oven	3
11.6	Portland cement manufacturing	
	Dry process	
	Kilns	a
	Dryers, grinders, etc.	4
	Wet process	
	Kilns	a
	Dryers, grinders, etc.	4
11.7	Ceramic clay manufacturing	
	Drying	3
	Grinding	4
	Storage	3
11.8	Clay and fly ash sintering	
	Fly ash sintering, crushing, screening, yard storage	5
	Clay mixed with coke	
	Crushing, screening, yard storage	3
11.9	Western surface coal mining	a
11.10	Coal cleaning	3
11.12	Concrete batching	3
11.13	Glass fiber manufacturing	
	Unloading and conveying	3
	Storage bins	3
	Mixing and weighing	3
	Glass furnace - wool	a
	Glass furnace - textile	a
11.15	Glass manufacturing	a
11.16	Gypsum manufacturing	
	Rotary ore dryer	a
	Roller mill	4
	Impact mill	4
	Flash calciner	a
	Continuous kettle calciner	a
11.17	Lime manufacturing	a
11.18	Mineral wool manufacturing	
	Cupola	8
	Reverberatory furnace	8
	Blow chamber	8
	Curing oven	9
	Cooler	9
11.19.1	Sand and gravel processing	
	Continuous drop	
	Transfer station	a
	Pile formation - stacker	a
	Batch drop	a
	Active storage piles	a
	Vehicle traffic on unpaved road	a
11.19.2	Crushed stone processing	
	Dry crushing	
	Primary crushing	a
	Secondary crushing and screening	a
	Tertiary crushing and screening	3
	Recrushing and screening	4
	Fines mill	4
	Screening, conveying, handling	a
11.21	Phosphate rock processing	
	Drying	a
	Calcining	a
	Grinding	b
	Transfer and storage	3
11.23	Taconite ore processing	
	Fine crushing	4

Table B.2-1 (cont.).

AP-42 Section	Source Category	Category Number*
	Waste gas	a
	Pellet handling	4
	Grate discharge	5
	Grate feed	4
	Bentonite blending	4
	Coarse crushing	3
	Ore transfer	3
	Bentonite transfer	4
	Unpaved roads	a
11.24	Metallic minerals processing	a
	Metallurgical	
12.1	Primary aluminum production	
	Bauxite grinding	4
	Aluminum hydroxide calcining	5
	Anode baking furnace	9
	Prebake cell	a
	Vertical Soderberg	8
	Horizontal Soderberg	a
12.2	Coke manufacturing	a
12.3	Primary copper smelting	a
12.4	Ferroalloy production	a
12.5	Iron and steel production	
	Blast furnace	
	Slips	a
	Cast house	a
	Sintering	
	Windbox	a
	Sinter discharge	a
	Basic oxygen furnace	a
	Electric arc furnace	a
12.6	Primary lead smelting	a
12.7	Zinc smelting	8
12.8	Secondary aluminum operations	
	Sweating furnace	8
	Smelting	
	Crucible furnace	8
	Reverberatory furnace	a
12.9	Secondary copper smelting	
	and alloying	8
12.10	Gray iron foundries	a
12.11	Secondary lead processing	a
12.12	Secondary magnesium smelting	8
12.13	Steel foundries - melting	b
12.14	Secondary zinc processing	8
12.15	Storage battery production	b
12.18	Leadbearing ore crushing and grinding	4
	Miscellaneous sources	
13.1	Wildfires and prescribed burning	a
13.2	Fugitive dust	a

* Data for numbered categories are given Table B.2-2. Particle size data on "a" categories are found in the AP-42 text; for "b" categories, in Appendix B.1; and for "c" categories, in AP-42 *Volume II: Mobile Sources*.

Figure B.2-2. CALCULATION SHEET

SOURCE IDENTIFICATION
Source name and address: _____
_____
_____

Process description: _____
AP-42 Section: _____
Uncontrolled AP-42
emission factor: _____ (units)
Activity parameter: _____ (units)
Uncontrolled emissions: _____ (units)

UNCONTROLLED SIZE EMISSIONS
Category name: _____
Category number: ____

	Particle size (μm)		
	≤ 2.5	≤ 6	≤ 10
Generic distribution, Cumulative percent equal to or less than the size:			
Cumulative mass ≤ particle size emissions (tons/year):			

CONTROLLED SIZE EMISSIONS*
Type of control device: _____

	Particle size (μm)		
	0 - 2.5	2.5 - 6	6 - 10
Collection efficiency (Table B.2-3):			
Mass in size range** before control (tons/year):			
Mass in size range after control (tons/year):			
Cumulative mass (tons/year):			

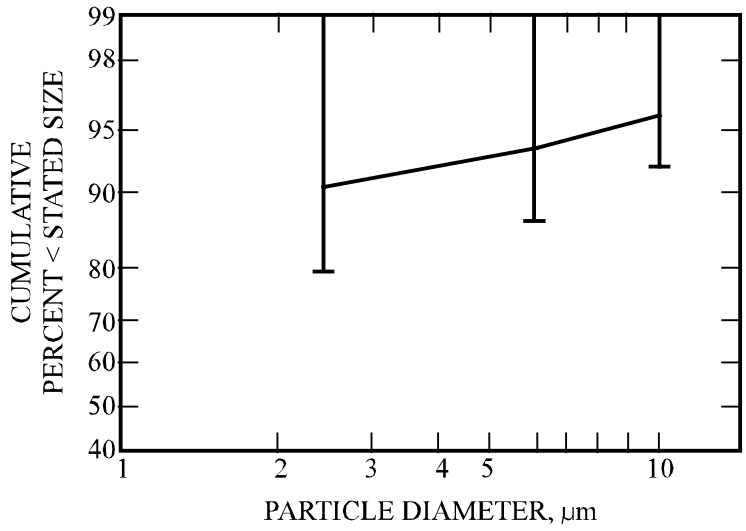
* These data do not include results for the greater than 10 μm particle size range.
** Uncontrolled size data are cumulative percent equal to or less than the size. Control efficiency data apply only to size range and are not cumulative.

Table B.2-2. DESCRIPTION OF PARTICLE SIZE CATEGORIES

Category: 1
Process: Stationary Internal Combustion Engines
Material: Gasoline and Diesel Fuel

Category 1 covers size-specific emissions from stationary internal combustion engines. The particulate emissions are generated from fuel combustion.

REFERENCES: 1,9



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	82			
2.0[a]	88			
2.5	90	78	99	11
3.0[a]	90			
4.0[a]	92			
5.0[a]	93			
6.0	93	86	99	7
10.0	96	92	99	4

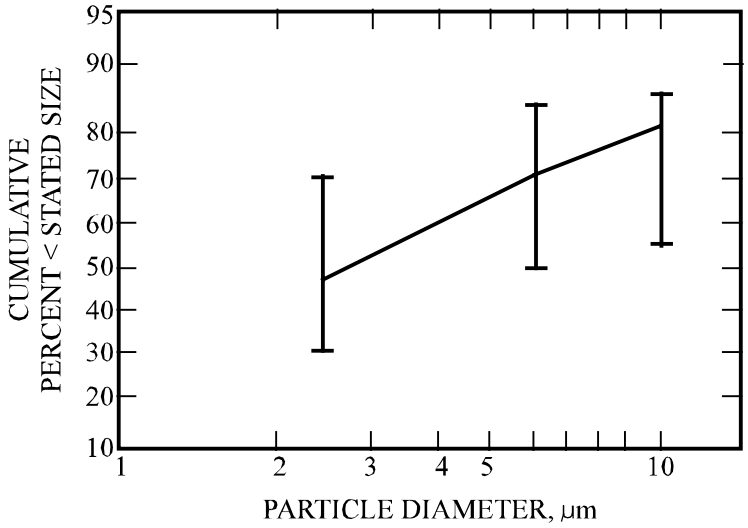
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 2
Process: Combustion
Material: Mixed Fuels

Category 2 covers boilers firing a mixture of fuels, regardless of the fuel combination. The fuels include gas, coal, coke, and petroleum. Particulate emissions are generated by firing these miscellaneous fuels.

REFERENCE: 1



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	23			
2.0[a]	40			
2.5	45	32	70	17
3.0[a]	50			
4.0[a]	58			
5.0[a]	64			
6.0	70	49	84	14
10.0	79	56	87	12

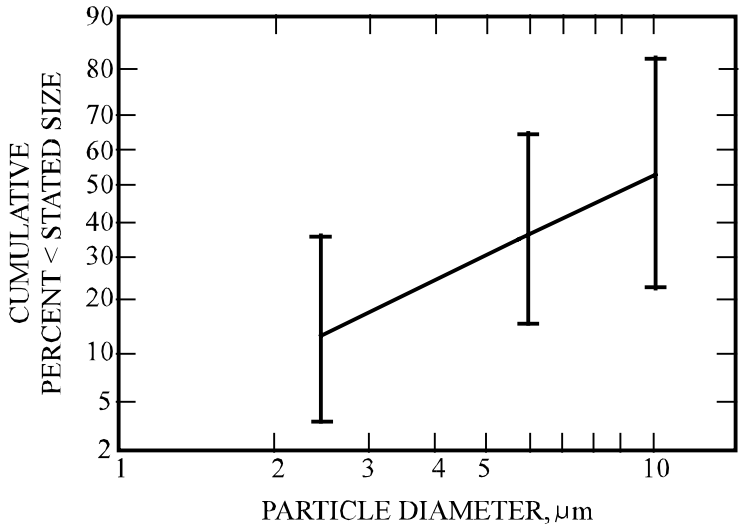
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 3
Process: Mechanically Generated
Material: Aggregate, Unprocessed Ores

Category 3 covers material handling and processing of aggregate and unprocessed ore. This broad category includes emissions from milling, grinding, crushing, screening, conveying, cooling, and drying of material. Emissions are generated through either the movement of the material or the interaction of the material with mechanical devices.

REFERENCES: 1-2,4,7



Particle Size, µm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	4			
2.0[a]	11			
2.5	15	3	35	7
3.0[a]	18			
4.0[a]	25			
5.0[a]	30			
6.0	34	15	65	13
10.0	51	23	81	14

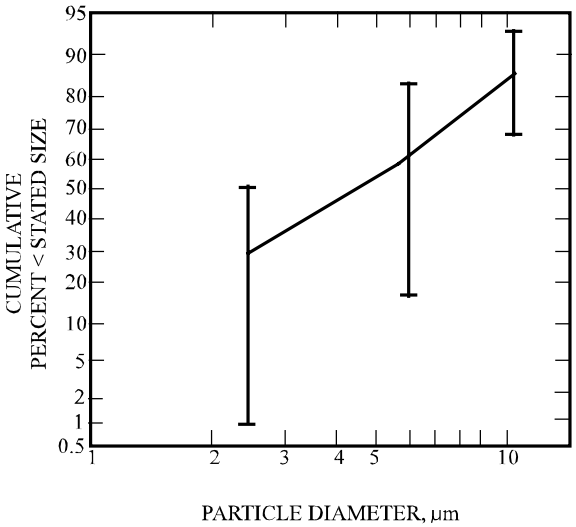
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 µm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 4
Process: Mechanically Generated
Material: Processed Ores and Nonmetallic Minerals

Category 4 covers material handling and processing of processed ores and minerals. While similar to Category 3, processed ores can be expected to have a greater size consistency than unprocessed ores. Particulate emissions are a result of agitating the materials by screening or transfer during size reduction and beneficiation of the materials by grinding and fine milling and by drying.

REFERENCE: 1



Particle Size, µm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	6			
2.0[a]	21			
2.5	30	1	51	19
3.0[a]	36			
4.0[a]	48			
5.0[a]	58			
6.0	62	17	83	17
10.0	85	70	93	7

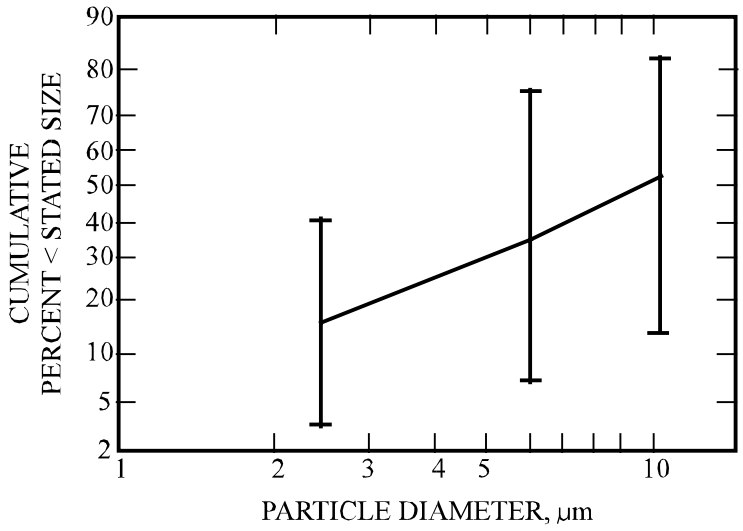
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 µm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 5
Process: Calcining and Other Heat Reaction Processes
Material: Aggregate, Unprocessed Ores

Category 5 covers the use of calciners and kilns in processing a variety of aggregates and unprocessed ores. Emissions are a result of these high temperature operations.

REFERENCES: 1-2,8



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	6			
2.0[a]	13			
2.5	18	3	42	11
3.0[a]	21			
4.0[a]	28			
5.0[a]	33			
6.0	37	13	74	19
10.0	53	25	84	19

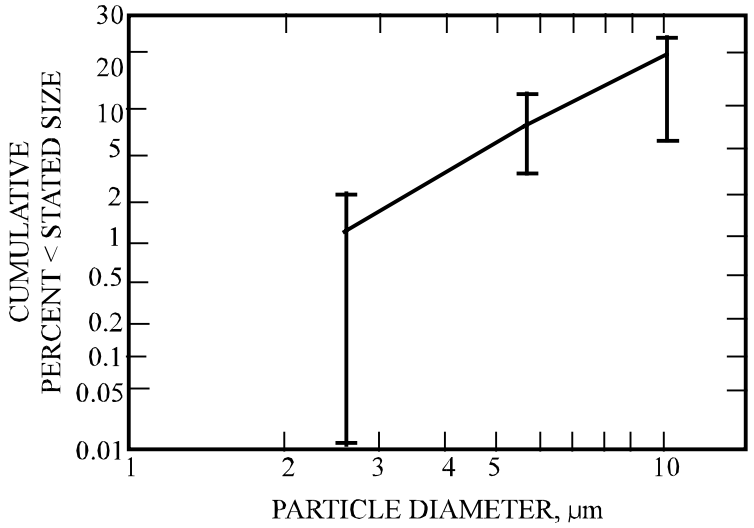
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 6
Process: Grain Handling
Material: Grain

Category 6 covers various grain handling (versus grain processing) operations. These processes could include material transfer, ginning and other miscellaneous handling of grain. Emissions are generated by mechanical agitation of the material.

REFERENCES: 1,5



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	0.07			
2.0[a]	0.60			
2.5	1	0	2	1
3.0[a]	2			
4.0[a]	3			
5.0[a]	5			
6.0	7	3	12	3
10.0	15	6	25	7

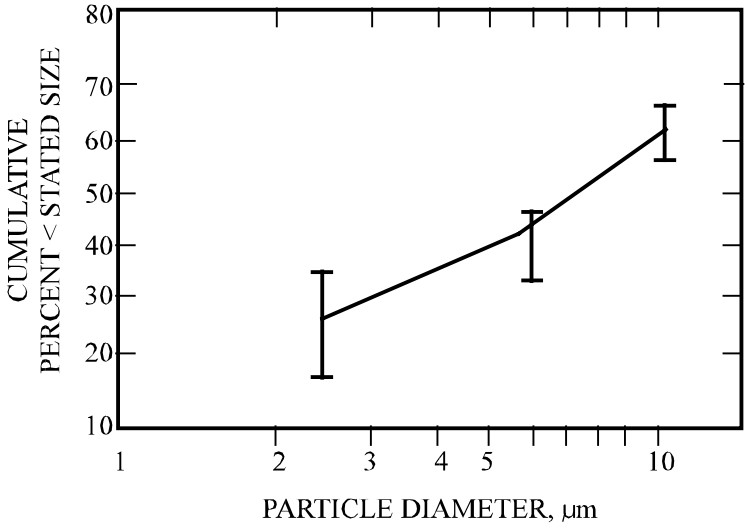
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 7
Process: Grain Processing
Material: Grain

Category 7 covers grain processing operations such as drying, screening, grinding, and milling. The particulate emissions are generated during forced air flow, separation, or size reduction.

REFERENCES: 1-2



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	8			
2.0[a]	18			
2.5	23	17	34	9
3.0[a]	27			
4.0[a]	34			
5.0[a]	40			
6.0	43	35	48	7
10.0	61	56	65	5

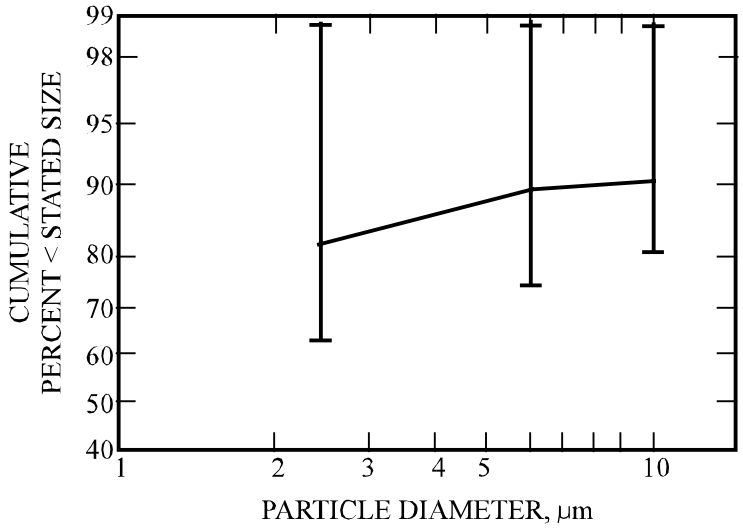
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 8
Process: Melting, Smelting, Refining
Material: Metals, except Aluminum

Category 8 covers the melting, smelting, and refining of metals (including glass) other than aluminum. All primary and secondary production processes for these materials which involve a physical or chemical change are included in this category. Materials handling and transfer are not included. Particulate emissions are a result of high temperature melting, smelting, and refining.

REFERENCES: 1-2



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	72			
2.0[a]	80			
2.5	82	63	99	12
3.0[a]	84			
4.0[a]	86			
5.0[a]	88			
6.0	89	75	99	9
10.0	92	80	99	7

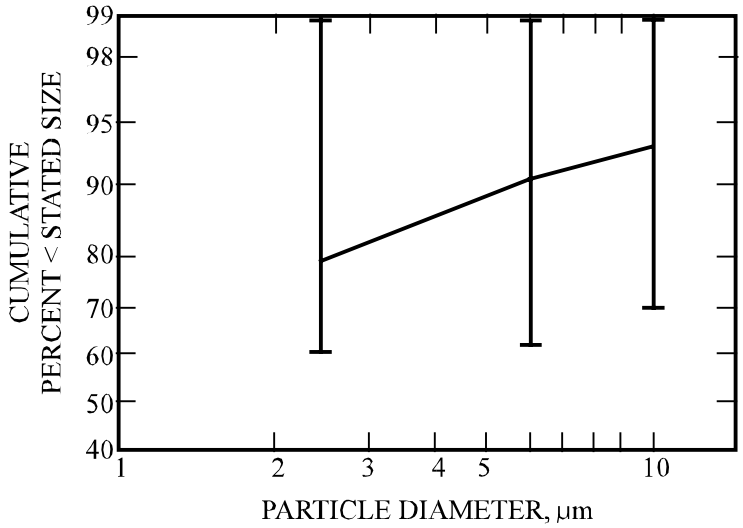
[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

Table B.2.2 (cont.).

Category: 9
Process: Condensation, Hydration, Absorption, Prilling, and Distillation
Material: All

Category 9 covers condensation, hydration, absorption, prilling, and distillation of all materials. These processes involve the physical separation or combination of a wide variety of materials such as sulfuric acid and ammonium nitrate fertilizer. (Coke ovens are included since they can be considered a distillation process which separates the volatile matter from coal to produce coke.)

REFERENCES: 1,3



Particle Size, μm	Cumulative % ≤ Stated Size (Uncontrolled)	Minimum Value	Maximum Value	Standard Deviation
1.0[a]	60			
2.0[a]	74			
2.5	78	59	99	17
3.0[a]	81			
4.0[a]	85			
5.0[a]	88			
6.0	91	61	99	12
10.0	94	71	99	9

[a] Value calculated from data reported at 2.5, 6.0, and 10.0 μm. No statistical parameters are given for the calculated value.

B.2.3 How To Use The Generalized Particle Size Distributions For Controlled Processes

To calculate the size distribution and the size-specific emissions for a source with a particulate control device, the user first calculates the uncontrolled size-specific emissions. Next, the fractional control efficiency for the control device is estimated using Table B.2-3. The Calculation Sheet provided (Figure B.2-2) allows the user to record the type of control device and the collection efficiencies from Table B.2-3, the mass in the size range before and after control, and the cumulative mass. The user will note that the uncontrolled size data are expressed in cumulative fraction less than the stated size. The control efficiency data apply only to the size range indicated and are not cumulative. These data do not include results for the greater than 10 µm particle size range. In order to account for the total controlled emissions, particles greater than 10 µm in size must be included.

B.2.4 Example Calculation

An example calculation of uncontrolled total particulate emissions, uncontrolled size-specific emissions, and controlled size specific emission is shown in Figure B.2-1. A blank Calculation Sheet is provided in Figure B.2-2.

Table B.2-3. TYPICAL COLLECTION EFFICIENCIES OF VARIOUS PARTICULATE CONTROL DEVICES[a]
(%)

AIRS Code[b]	Type Of Collector	Particle Size (µm)		
		0 - 2.5	2.5 - 6	6 - 10
001	Wet scrubber - hi-efficiency	90	95	99
002	Wet scrubber - med-efficiency	25	85	95
003	Wet scrubber - low-efficiency	20	80	90
004	Gravity collector - hi-efficiency	3.6	5	6
005	Gravity collector - med-efficiency	2.9	4	4.8
006	Gravity collector - low-efficiency	1.5	3.2	3.7
007	Centrifugal collector - hi-efficiency	80	95	95
008	Centrifugal collector - med-efficiency	50	75	85
009	Centrifugal collector - low-efficiency	10	35	50
010	Electrostatic precipitator - hi-efficiency	95	99	99.5
011	Electrostatic precipitator - med-efficiency			
	boilers	50	80	94
	other	80	90	97
012	Electrostatic precipitator - low-efficiency			
	boilers	40	70	90
	other	70	80	90
014	Mist eliminator - high velocity >250 FPM	10	75	90
015	Mist eliminator - low velocity <250 FPM	5	40	75

Table B.2-3 (cont.).

AIRS Code[b]	Type Of Collector	Particle Size (µm)		
		0 - 2.5	2.5 - 6	6 - 10
016	Fabric filter - high temperature	99	99.5	99.5
017	Fabric filter - med temperature	99	99.5	99.5
018	Fabric filter - low temperature	99	99.5	99.5
046	Process change	NA	NA	NA
049	Liquid filtration system	50	75	85
050	Packed-gas absorption column	90	95	99
051	Tray-type gas absorption column	25	85	95
052	Spray tower	20	80	90
053	Venturi scrubber	90	95	99
054	Process enclosed	1.5	3.2	3.7
055	Impingement plate scrubber	25	95	99
056	Dynamic separator (dry)	90	95	99
057	Dynamic separator (wet)	50	75	85
058	Mat or panel filter - mist collector	92	94	97
059	Metal fabric filter screen	10	15	20
061	Dust suppression by water sprays	40	65	90
062	Dust suppression by chemical stabilizer or wetting agents	40	65	90
063	Gravel bed filter	0	5	80
064	Annular ring filter	80	90	97
071	Fluid bed dry scrubber	10	20	90
075	Single cyclone	10	35	50
076	Multiple cyclone w/o fly ash reinjection	80	95	95
077	Multiple cyclone w/fly ash reinjection	50	75	85
085	Wet cyclonic separator	50	75	85
086	Water curtain	10	45	90

[a] Data represent an average of actual efficiencies. Efficiencies are representative of well designed and well operated control equipment. Site-specific factors (e. g., type of particulate being collected, varying pressure drops across scrubbers, maintenance of equipment, etc.) will affect collection efficiencies. Efficiencies shown are intended to provide guidance for estimating control equipment performance when source-specific data are not available. NA = not applicable.

[b] Control codes in Aerometric Information Retrieval System (AIRS), formerly National Emissions Data Systems.

References For Appendix B.2

1. Fine Particle Emission Inventory System, Office Of Research And Development, U. S. Environmental Protection Agency, Research Triangle Park, NC, 1985.

2. Confidential test data from various sources, PEI Associates, Inc., Cincinnati, OH, 1985.

3. *Final Guideline Document: Control Of Sulfuric Acid Production Units*, EPA-450/2-77-019, U. S. Environmental Protection Agency, Research Triangle Park, NC, 1977.

4. *Air Pollution Emission Test, Bunge Corp., Destrehan, LA*, EMB-74-GRN-7, U. S. Environmental Protection Agency, Research Triangle Park, NC, 1974.

5. I. W. Kirk, "Air Quality In Saw And Roller Gin Plants", *Transactions Of The ASAE*, 20:5, 1977.

6. *Emission Test Report, Lightweight Aggregate Industry. Galite Corp.*, EMB- 80-LWA-6, U. S. Environmental Protection Agency, Research Triangle Park, NC, 1982.

7. *Air Pollution Emission Test, Lightweight Aggregate Industry, Texas Industries, Inc.*, EMB-80-LWA-3, U. S. Environmental Protection Agency, Research Triangle Park, NC, 1975.

8. *Air Pollution Emission Test, Empire Mining Company, Palmer, Michigan*, EMB-76-IOB-2, U. S. Environmental Protection Agency, Research Triangle Park, NC, 1975.

9. H. J. Taback, *et al*., *Fine Particulate Emissions From Stationary Sources In The South Coast Air Basin*, KVB, Inc., Tustin, CA, 1979.

10. K. Rosbury, *Generalized Particle Size Distributions For Use In Preparing Particle Size-Specific Emission Inventories*, U. S. EPA Contract No. 68-02-3890, PEI Associates, Inc., Golden, CO, 1985.