

SPILL PREVENTION, CONTROL, AND COUNTERMEASURE PLAN

Format and Requirements Based on:
40 Code of Federal Regulations (CFR) 112, and
American Petroleum Institute (API) Recommended Practice Bulletin D-16

Prepared for:

N C Machinery Co – Chehalis Branch
1178 NW Maryland Avenue
Chehalis, WA 98532

Owner:

N C Machinery Company
17025 West Valley Highway
Tukwila, WA 98188

UPDATED JULY 2020

Prepared by:



200 West Mercer Street, Suite 401 ♦ Seattle, Washington ♦ 98119

Tier II Qualified Facility SPCC Plan

This template constitutes the SPCC Plan for the facility, when completed and signed by the owner or operator of a facility that meets the applicability criteria in §112.3(g)(2). This template addresses the requirements of 40 CFR part 112. Maintain a complete copy of the Plan at the facility if the facility is normally attended at least four hours per day, or for a facility attended fewer than four hours per day, at the nearest field office. When making operational changes at a facility that are necessary to comply with the rule requirements, the owner/operator should follow state and local requirements (such as for permitting, design and construction) and obtain professional assistance, as appropriate.

Facility Description

Facility Name NC Machinery Chehalis

Facility Address 1178 NW Maryland Avenue

City Chehalis

State WA

ZIP 98532

County Lewis

Tel. Number (425)251 -5876

Owner or Operator Name NC Machinery

Owner or Operator Address 17035 West Valley Highway

City Tukwila

State WA

ZIP 98188

County King

Tel. Number (425)251 -5800

I. Self-Certification Statement (§112.6(b)(2))

The owner or operator of a facility certifies that each of the following is true in order to utilize this template to comply with the SPCC requirements:

I John R Deans certify that the following is accurate:

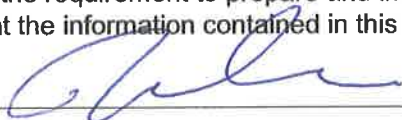
1. I am familiar with the applicable requirements of 40 CFR part 112;
2. I have visited and examined the facility;
3. This Plan was prepared in accordance with accepted and sound industry practices and standards, and with the requirements of 40 CFR part 112;
4. Procedures for required inspections and testing have been established;
5. I will fully implement the Plan;
6. This facility meets the following qualification criteria (under §112.3(g)(2)):
 - a. The aggregate aboveground oil storage capacity of the facility is 10,000 U.S. gallons or less; and
 - b. The facility has had no single discharge as described in §112.1(b) exceeding 1,000 U.S. gallons and no two discharges as described in §112.1(b) each exceeding 42 U.S. gallons within any twelve month period in the three years prior to the SPCC Plan self-certification date, or since becoming subject to 40 CFR part 112 if the facility has been in operation for less than three years (not including oil discharges as described in §112.1(b) that are the result of natural disasters, acts of war, or terrorism).
7. The Plan does not deviate from any requirement of this part as allowed by §112.7(a)(2) and 112.7(d), or include an exemption/measures pursuant to §112.9(c)(6) for produced water containers and any associated piping and appurtenances downstream from the container, except as provided in §112.6(b)(3); and
8. This Plan and individual(s) responsible for implementing this Plan have the full approval of management and I have committed the necessary resources to fully implement this Plan.

I also understand my other obligations relating to the storage of oil at this facility, including, among others:

1. To report any oil discharge to navigable waters or adjoining shorelines to the appropriate authorities. Notification information is included in this Plan.
2. To review and amend this Plan whenever there is a material change at the facility that affects the potential for an oil discharge, and at least once every five years. Reviews and amendments are recorded in an attached log [See Five Year Review Log and Technical Amendment Log in Attachments 1.1 and 1.2.]
3. Optional use of a contingency plan. A contingency plan:
 - a. May be used in lieu of secondary containment for qualified oil-filled operational equipment, in accordance with the requirements under §112.7(k), and;
 - b. Must be prepared for flowlines and/or intra-facility gathering lines which do not have secondary containment at an oil production facility, and;
 - c. Must include an established and documented inspection or monitoring program; must follow the provisions of 40 CFR part 109; and must include a written commitment of manpower, equipment and materials to expeditiously remove any quantity of oil discharged that may be harmful. If applicable, a copy of the contingency plan and any additional documentation will be attached to this Plan as Attachment 2.

I certify that I have satisfied the requirement to prepare and implement a Plan under §112.3 and all of the requirements under §112.6(b). I certify that the information contained in this Plan is true.

Signature



Title: Environmental Supervisor

Name John R Deans

Date: 07 / 01 / 20

II. Record of Plan Review and Amendments Technical Amendments, Applicable Requirements and Professional Engineer Certifications (§112.5(a), (d) and 112.6(b)(2))

Table G-1 Five Year Review and Technical Amendments (§§112.5(a) and 112.6(b)(2) and (3))	
This SPCC Plan will be amended when there is a change in the facility design, construction, operation, or maintenance that materially affects the potential for a discharge to navigable waters or adjoining shorelines. Examples include adding or removing containers, reconstruction, replacement, or installation of piping systems, changes to secondary containment systems, changes in product stored at this facility, or revisions to standard operating procedures. [§112.5(a)] [See Technical Amendment Log in Attachment 1.2]	<input checked="" type="checkbox"/>
Any technical amendments to this Plan (when there is a change in the facility design, construction, operation or maintenance that affects its potential for a discharge) will be re-certified in accordance with Section I of this Plan template if the change does not result in the facility no longer meeting the Tier II qualified facility eligibility. [§112.6(b)(2)]	<input checked="" type="checkbox"/>
If, as a result of any change in the facility design, construction or operation that causes the facility to no longer meet the Tier II qualified facility eligibility, the owner or operator will, within six months following the change, prepare and implement a Plan in accordance with the general Plan requirements in §112.7 and the applicable requirements in subparts B and C of 40 CFR 112, including having the Plan certified by a Professional Engineer. [§112.6(b)(2)(ii)]	<input checked="" type="checkbox"/>
Complete a review and evaluation of this SPCC Plan at least once every five years. As a result of the review, amend this SPCC Plan within six months to include more effective prevention and control measures for the facility, if applicable. Implement any amendment as soon as possible, but no later than six months following the Plan amendment. Document completion of the review and evaluation, and complete the Five Year Review Log in Attachment 1.1. If the facility no longer meets the Tier II qualified facility eligibility, the owner or operator must complete a full PE certified Plan. [§112.5(d)] [See Five Year Review Log in Attachment 1.1]	<input checked="" type="checkbox"/>
If a Professional Engineer certified a portion of your Plan and technical amendments are made that affect your Plan, you must have the amended provisions of your Plan re-certified by a Professional Engineer. [§112.6(b)(2)(i)]	<input checked="" type="checkbox"/>
Alternate methods which provide environmental equivalence are reviewed and certified in writing by a Professional Engineer. The PE review and certification must be included with this Plan. [§112.6(b)(3)(i)]	<input checked="" type="checkbox"/>
Any determinations that secondary containment is impracticable and provisions in lieu of secondary containment have been reviewed and certified in writing by a Professional Engineer. The PE review and certification must be included with this Plan. [§112.6(b)(3)(ii)]	<input checked="" type="checkbox"/>

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Acronyms

Acronym	Definition
API	American Petroleum Institute
AST	aboveground storage tank
CFR	Code of Federal Regulations
EPA	US Environmental Protection Agency
FR	federal register
FRP	Facility Response Plan
FWPCA	Federal Water Pollution Control Act
NOAA	National Oceanic and Atmospheric Administration
NRC	National Response Center
OIT	Organic Incineration Technology
OW	oil/ water
PE	Professional Engineer
PPE	personal protective equipment
RCRA	Resource Conservation and Recovery Act
SPCC	Spill Prevention, Control, and Countermeasure
STI	Steel Tank Institute
UST	underground storage tank

Onshore Facility – Regulatory Cross-reference

Citation	Description	Section
§112.3(d)(1)	Professional Engineer Certification	1.2
§112.5(b)	Management of Five-year Review	Foreword
§112.5(c)	Professional Engineer certification of technical amendments.	Foreword
§112.7	General requirements for Spill Prevention, Control, and Countermeasure Plan (SPCC) Plans for all facilities and all oil types	
§112.7(a)	General requirements: discussion of facility's conformance with rule requirements; deviations from Plan requirements; Facility characteristics that must be described in the Plan; spill-reporting information in the Plan; emergency procedures	1, 2, Appendices A–D
§112.7(b)	Fault analysis	2.1
§112.7(c)	Secondary containment	2.1, 2.3.1
§112.7(d)	Contingency planning	Appendix D
§112.7(e)	Inspections, tests, and records	2.5.3, 2.7, Appendix B
§112.7(f)	Employee training and discharge prevention procedures	1.6, Appendices A and B
§112.7(g)	Security (excluding oil production facilities)	2.4.2, 2.6
§112.7(h)	Loading/unloading (excluding offshore facilities)	2.5
§112.7(i)	Brittle fracture evaluation requirements	2.7
§112.7(j)	Conformance with state requirements	1.8
§112.8	Requirements for onshore facilities (excluding production facilities)	
§112.8(a)	General and specific requirements	2.1–2.4, 2.7
§112.8(b)	Facility drainage	2.3
§112.8(c)	Bulk storage containers	2.1, 2.2, 2.7
§112.8(d)	Facility transfer operations, pumping, and process	2.4, 2.A.7
§112.9	Requirements for onshore production facilities	N/A
§112.10	Requirements for onshore oil drilling and workover facilities	N/A
§112.11	Requirements for offshore oil drilling, production, or workover facilities	N/A

Log of Plan Review and Amendments

NON-TECHNICAL AMENDMENTS

- ◆ Non-technical amendments are not certified by a Professional Engineer (PE).
- ◆ Examples of changes include, but are not limited to, phone numbers, name changes, or any non-technical text change(s).

TECHNICAL AMENDMENTS

- ◆ Technical amendments are certified by a PE (§112.5(c)).
- ◆ Examples of changes include, but are not limited to, commissioning or decommissioning containers; replacement, reconstruction, or movement of containers; reconstruction, replacements, or installation of piping systems; construction or demolition that might alter secondary containment structures; changes of product or service; or addition/deletion of standard operation or maintenance procedures related to discharge prevention measures. It is the responsibility of the facility to determine, and confirm with the regulatory authority as necessary, what constitutes a technical amendment. The preamble of the rule states that an amendment is required only "when there is a change that materially affects the facility's potential to discharge oil" (67 federal register [FR] 47091).
- ◆ An amendment made under this section will be prepared within six (6) months of the change and implemented as soon as possible, but not later than six (6) months following preparation of the amendment.
- ◆ Technical amendments affecting various pages within the plan can be PE-certified on those pages, certifying those amendments only, and will be documented on the log form below.

MANAGEMENT REVIEW

- ◆ Management will review this Spill Prevention, Control, and Countermeasure (SPCC) Plan at least every five (5) years and document the review on the form below (§112.5(b)).
- ◆ Signer below confirms that management has reviewed this SPCC Plan.

Review/ Amend Date	Signature* (Specify)	Amend Plan (will/will not)	Description of Review/Amendment	Affected Page(s)	PE Certification (Y/N)

*Typically signed by Manager, Professional Engineer, or plan reviewer.



SPCC Plan Certification

I certify that existing storage tank facilities, spill-related procedures, and personnel training in place at

N C Machinery – Chehalis Branch
1178 NW Maryland Avenue, Chehalis, Washington

have been examined pursuant to 40 Code of Federal Regulations (CFR) Part 112, and that this revised Plan is the result of that examination. I attest that this Plan has been prepared in accordance with good engineering practice, including consideration of applicable industry standards and the requirements of 40 CFR Part 112; that procedures for required inspections and testing have been communicated; and that the SPCC components of this Plan are adequate for the facility. To the best of my knowledge the information contained in this Plan is true, complete, and accurate. Further, I attest that this Plan, when approved and fully implemented by the facility representatives/management, will place these oil storage facilities into compliance with good industry standards and engineering practice.

This certification in no way relieves N C Machinery – Chehalis Branch of its duty to prepare and fully implement this Plan in accordance with the requirements of 40 CFR Part 112. This Plan is valid only to the extent that N C Machinery – Chehalis Branch maintains, tests, and inspects equipment, containment, and other devices, and maintains written documentation of these tests and inspections as prescribed in this Plan. This certification is valid for a period of five (5) years from signing.

Name: Warren G. Hansen

Signature: Warren G. Hansen

Date: July 15, 2016



(EXP. 4/22/17)



N C Machinery – Chehalis Branch
July 2016

Management Approval

I hereby approve the contents of the facility's Spill Prevention, Control, and Countermeasure (SPCC) Plan and have the authority to commit the necessary resources to implement the SPCC Plan, as set forth in this document, in accordance with the federal requirements of 40 Code of Federal Regulations (CFR) Part 112.

Signature: 

Designated person accountable for oil spill prevention at the facility:

Name: Mr. Stephen Bell

Name: Mr. Dave Antilla

Date: _____

Title: Branch Manager

Title: Environmental and Facilities Manager

I hereby approve the contents of the facility's SPCC Plan and have the authority to commit the necessary resources to implement the SPCC Plan, as set forth in this document, in accordance with the federal requirements of 40 CFR Part 112.

Signature: _____

Designated person accountable for oil spill prevention at the facility:

Name: Mr. Dave Antilla

Date: _____

Title: Branch Manager

Title: _____



**Certification of the Applicability of the Substantial Harm Criteria
(excerpt from 40 CFR Part 112 – Attachment CII)**

FACILITY NAME: N C Machinery – Chehalis Branch

FACILITY ADDRESS: 1178 NW Maryland Avenue, Chehalis, Washington 98532

1. Does the facility transfer oil over water to or from vessels and does the facility have a total oil storage capacity greater than or equal to 42,000 gal.?

☐

YES

☒

NO

2. Does the facility have a total oil storage capacity greater than or equal to 1 million gal. and does the facility lack secondary containment that is sufficiently large to contain the capacity of the largest aboveground oil storage tank plus sufficient freeboard to allow for precipitation within any aboveground oil storage tank area?

☐

YES

☒

NO

3. Does the facility have a total oil storage capacity greater than or equal to 1 million gal. and is the Facility located at a distance (as calculated using the appropriate formula in Attachment C-III to this appendix or a comparable formula¹) such that a discharge from the facility could cause injury to fish and wildlife and sensitive environments? For further description of fish and wildlife and sensitive environments, see Appendices I, II, and III to National Oceanic and Atmospheric Administration's (NOAA's) "Guidance for Facility and Vessel Response Plans: Fish and Wildlife and Sensitive Environments" (59 FR 14713, March 29, 1994) and the applicable Area Contingency Plan.

☐

YES

☒

NO

4. Does the facility have a total oil storage capacity greater than or equal to 1 million gal. *and* is the facility located at a distance (as calculated using the appropriate formula in Attachment C-III to this appendix or a comparable formula¹) such that a discharge from the facility would shut down a public drinking water intake?²

☐

YES

☒

NO

5. Does the facility have a total oil storage capacity greater than or equal to 1 million gal. *and* has the facility experienced a reportable oil spill in an amount greater than or equal to 10,000 gal. within the last 5 years?

☐

YES

☒

NO

CERTIFICATION

I certify under penalty of law that I have personally examined and am familiar with the information submitted in this document, and that based on my inquiry of those individuals responsible for obtaining this information, I believe that the submitted information is true, accurate, and complete.

Warren G. Hansen

Signature

Warren G. Hansen, P.E.

Name (please type or print)

Engineer

Title

July 15, 2016

Date

¹ If a comparable formula is used, documentation of the reliability and analytical soundness of the comparable formula must be attached to this form.

² For the purposes of 40 CFR part 112, public drinking water intakes are analogous to public water systems as described at 40 CFR 143.2(c).



Planned Improvements/Recommendations

RECOMMENDATIONS

Status of 2011 recommendations

Item	2011 Recommendations	Status
Exterior drum storage areas	Secondary containment should be installed at all exterior drum storage areas (storing 55-gal. drum volumes or larger) to capture any potential spills or leaks associated with storage of the petroleum products.	Still needed. Additional drums/product stored in southeast pole shed should be moved to the drum storage at the east side of the main building.
Training record documentation	Records documenting annual training programs (or "tool box" training events, as appropriate) should be consistently maintained at the facility in association with this Plan. Example training-related documentation is provided in Appendix B.	Still needed. Records may exist, but were unavailable during the site visit. The forms provided in Appendix B can be used to record inspections. These records need to be kept with the SPCC plan.
Steam cleaning room effluent	This system has been changed. In 2005 the water was treated using an oil/water separator and discharged to the sanitary line. Now water is accumulated in a tank and transferred to the vehicle wash pad. The scope of this SPCC does not address the appropriateness or lack thereof of this practice under the facility's NPDES permit(s). The owner is encouraged to verify that this practice is covered and make changes if necessary to be in compliance.	Tank in steam cleaning room should be labeled (oily wastewater). Oily wastewater tank needs to have a liquid level gauge and high level shutoff to help assure that oil accidentally released in the steam cleaning room is not transferred to the wash pad.
Inspection documentation	Records documenting required SPCC-related equipment inspections should be consistently maintained at the facility in association with this Plan. Example inspection-related documentation is provided in Appendix B.	Still needed. Records may exist, but were unavailable during the site visit. The forms provided in Appendix B can be used to record inspections. These records need to be kept with the SPCC plan.
Sump ejector pump at north loading dock	Owner has indicated that a kill switch will be installed in the vicinity of the loading dock to facilitate pump shutdown in the event of a spill at the loading dock. Currently the pump is controlled by an upstairs circuit breaker which is not readily accessible nor an appropriate means of pump control.	Owner recently indicated that the decision was made to not install a kill switch and has elected to rely on operational safeguard and to use the circuit breaker should the pump need to be deactivated.

Bulk storage tanks	Areas of corrosion on exterior tank should be sanded, primed, and repainted to ensure longevity of the tank and prevent potential discharge concerns. Verify the capacity of each tank (gallons) and label the tank exterior accordingly and otherwise label the tanks to conform to tank-labeling standards (e.g., NFPA labels). Tanks are of unknown age and are not readily inspected at the bottom surfaces and should therefore be tested as soon as possible in accordance with Section 2.7.1 of this plan. Consider providing an additional means of gauging contents (e.g., sight gauges).	Still needed. See additional discussion of the bulk tanks and containment area below and in the discussion of additional recommendations following this table. Bulk tanks exhibited additional corrosion since 2011 and may need to be replaced.
Bulk storage tank containment area	Pipe penetrations through shop building wall at northeast corner of containment need to be caulked/sealed to be water/oil-tight. Disconnected and unused tanks positioned within the containment need to be removed and sold/recycled.	Penetrations have been caulked at the interior side of the wall and should be sufficiently sealed to prevent oil leakage. Only active bulk storage tanks should be located within the containment.

SPCC – Spill Prevention, Control, and Countermeasure Plan

Additional recommendations based on 2016 site visit

Bulk Tanks and Containment Area

1. Three yellow box tanks should be fastened down. A chain is present but is not anchored down at the east side of the tanks. Connecting one end of the chain to the supports of the used oil tank is not good practice. If a chain is used to secure the tanks (understand this is used to provide operational flexibility in the event of a major flood event), then it should be properly installed and anchored. Abrasion by the chain on the tops of the tanks can create the potential for corrosion and some type of protection is needed to prevent this. Be aware that chaining may not provide sufficient anchoring to protect the tanks during seismic events.
2. Consider a major servicing or replacement of the three yellow active bulk tanks. Tanks are corroded and also have corroded abrasions or shallow gashes on their surfaces (see 2011 recommendations regarding these tanks above). The cylindrical used oil tank is in better condition, but should be cleaned and inspected. If the tank is still serviceable it should be repainted. These conditions should be addressed by the owner as soon as possible.
3. In implementing recommendation 2 above, consider rerouting or protecting the pipes currently positioned on the floor of the north portion of the containment (between the tanks and the building wall). Presently workers need to walk among these pipes in order to change the filters mounted on the building wall and this could result in damage to the pipes. All pipe connections should be examined and, where found to be leaking or weeping, re-plumbed. The leaking fitting at the NE corner of the top of the 15-40wt oil tank and the leaking connections/gate valve at the base (NE corner) of the tank should be repaired.
4. Clean the containment area interior and tank surfaces and be sure to operate the containment drain valve as required per SPCC regulations (maintained in the closed position unless used for releasing retained/inspected water). During the site visit the valve was observed



to be in the open position with absorbent material placed on the ground at the discharge. This is not sufficient. In order to minimize accumulated rainwater inside the containment area, the owner should consider installing a roof with one side attached to the building. Per SPCC regulation, all releases from the containment area need to be retained and inspected for oil prior to release. If oil is present it should first be removed. A written record of all inspections (and releases) must be maintained.

5. The inactive diesel tank (with oil stain beneath) and spent antifreeze tank should be removed from the containment and scrapped if they are not needed. The diesel tank has a temporary sign: "Not in Use – Do Not Fill" but the fill port should also be locked to prevent filling. The spent antifreeze tank was formerly a storage tank for SAE 15-40 wt oil and may not be compatible for use with antifreeze. This tank is in very poor condition and should not be used. The tank fill port should be locked until the tank can be removed.

6. Two large portable tank/pump units labeled "HZ9000" and "HZ9001" were observed positioned inside the bulk tank containment area. Equipment of this nature should not be in the containment and is more appropriately stored in the covered storage area at the east exterior side of the main building (and provided with containment as needed). Moving equipment of this size and weight in/out of the bulk tank containment puts the permanently installed tanks at risk of damage.

7. No spill kit was observed at the bulk tank containment area. A mobile drum-type spill kit should be restored to this location that corresponds with the contents listed in this plan (Appendix D). A drain blocker mat (for blocking storm drain inlets during a spill) should also be included with the bulk tank containment area spill kit as it is described as an equipment resource in this plan.

Oil Bench

The oil drainage bench located inside the south side of the shop area needs to be cleaned. Some containers (e.g., drums containing used oil) should be labeled.

Shop Spill Kit

Restore the spill kit formerly located inside the building to correspond with the contents listed in this plan (Appendix D). Presently only oil absorbent pads are provided.

1 General Information

1.1 CONTACT LIST AND PHONE NUMBERS

The contact list and phone number reference for the facility is provided as follows (check as appropriate):

- ☒ Spill emergency call list is provided in Appendix A (Table A.1).
- ☐ Emergency Notification Phone List is provided in the Facility Response Plan (FRP).

1.2 NOTIFICATION DATA SHEET

A Notification Data Sheet is provided as follows (check as appropriate):

- ☒ Federal Notification Data Sheet and Notification of Qualified Discharge Sheet are provided in Appendix A (Tables A.2 and A.3, respectively).
- ☐ Notification Data Sheet Form provided in the Facility Response Plan (as described in Section 1.4).

1.3 PERSONNEL, TRAINING, AND DISCHARGE PREVENTION PROCEDURES

1.3.1 Training

The facility provides the following minimum training to oil-handling personnel prior to assignment of job responsibilities:

- ◆ Operation and maintenance of equipment to prevent oil discharges
- ◆ Oil discharge procedure protocols
- ◆ Applicable oil spill prevention (state & federal) laws, rules, and regulations
- ◆ General facility operations
- ◆ The contents of the facility Spill Prevention, Control, and Countermeasure (SPCC) Plan and applicable pollution control laws, rules, and regulations

The training program is further described as follows:

Facility personnel who are routinely involved with issues related to and the use of SPCC-related equipment, as described in this plan, are required to be familiar with the contents and protocols outlined in this plan. N C Machinery generally provides training to employees to ensure that they are familiar with the proper use of oil-containing equipment and procedures in the event of an emergency response.



Training is provided to each employee before they are permitted to work with oil-containing equipment, or oil storage and transfer equipment. Training occurs during the employee's initial orientation and during annual safety meetings. Periodic safety meetings and weekly "tool box" meetings are also conducted based on changes in facility operations or employee operational support.

Written records will be maintained with this Plan documenting each employee's training and meetings specific to the requirements and protocols outlined in this Plan. Forms for this documentation are included in Appendix B (Table B.2).

1.3.2 Briefings

The facility conducts prevention briefings for oil-handling personnel at least once a year to ensure adequate understanding of the SPCC Plan for the facility.

These briefings include discussion of:

- ◆ Potential discharges
- ◆ Component failures
- ◆ Precautionary measures

The briefing program is further described as follows:

In general training, briefings include identification and review of any potential changes to SPCC-related procedures or operations specific to the facility. Location of the spill kits and proper use of the equipment/materials they contain is included as part of the yearly briefing. An emphasis on daily housekeeping measures is emphasized. Facility representatives attending the briefings are encouraged to identify any potential risk or other issues that may result in an accidental spill at the facility. Weekly tool box meetings are also used to update facility personnel on the latest issues or specific concerns for the site, as needed.

1.3.3 Documentation

Documentation of these Personnel, Training, and Discharge-Prevention Briefing programs is maintained for a minimum period of three (3) years.

Log forms are provided as follows:

- ◆ Training Logs are provided in ☒ Appendix B or ☐ Other (describe):
- ◆ Discharge-prevention Briefing Logs are provided in ☐ Appendix B or ☒ Other (describe):
 - ◆ Discharge-prevention instruction is provided during the course of employee training; updates are also a component of the weekly tool box meetings, as necessary.



- ◆ Reference supporting documentation maintained separately, as appropriate:
 - ◆ Written documentation of completed SPCC-related equipment inspections and personnel training will be maintained at the facility along with a copy of this Plan.

1.4 FACILITY LAYOUT AND DIAGRAMS

1.4.1 Facility layout

Diagrams specific to the Chehalis Branch are included in Appendix C. The physical layout of the facility is described as follows:

The facility is located in the north part of the City of Chehalis on the east side of Maryland Avenue (opposite Interstate 5). The rear (east side) of the facility is bordered by a truck depot. The north and south sides of the facility are bordered by miscellaneous commercial properties. The facility includes a main building that houses the shop and office areas (see Appendix C). The entrance to the facility is off Maryland Avenue.

There is one main building at the facility and a vehicle wash rack located on the south portion of the property (See Figure C-X). The facility terrain is mostly flat. Runoff from the vicinity of the bulk tank containment and the west and north sides of the main building flow to the catch basins located in the driveway and loading docks and eventually to the ditch at the east side of Maryland Avenue. Drainage then flows north to Salzer Creek and eventually to the Chehalis River. Drainage from the east side of the Main Building flows to the ditch at the east side of the property and then north, eventually to Salzer Creek and the Chehalis River. The facility is located within the Chehalis River plain and is subject to occasional flooding.

Five bulk storage tanks are located in the containment area at the southwest corner of the main building. Additional SPCC-related facilities include a sheltered drum storage area at the east side of the main building and a small product container storage shed at the northeast corner of the main building. SPCC-related equipment in the shop interior include a steam-cleaning room, lubricant dispensing stations, and used oil cart (oil drainage bench).

Further details are provided in Section 2 – Table 2.1.

1.4.2 Facility diagrams

Facility diagrams ☒ are attached (Appendix C) with the following detail and location information (as applicable to the facility):

- ◆ Process equipment, operating equipment, electrical equipment



- ◆ Loading/unloading racks (N/A)
- ◆ Loading/unloading areas
- ◆ Fixed ASTs
- ◆ Transfer stations and connecting lines
- ◆ Completely buried and bunkered tanks (including USTs covered under 40 CFR Part 280 or 281, as applicable) (N/A)
- ◆ Drum and portable container storage areas
- ◆ Spill response equipment and kits
- ◆ The contents of all containers

1.5 PREVENTION, RESPONSE, AND CLEANUP

1.5.1 Prevention

The facility discharge prevention measures, including procedures for routine handling of products (loading, unloading, facility transfers, etc.), are described as follows:

- ☐ Facility Response Plan
- ☐ Other document (describe)
- ☒ Details below:
 - ◆ Vendors, who provide bulk petroleum products to the facility, are checked routinely to ensure that they are knowledgeable on the requirements of product transfer and methods for gauging storage tanks. Fuel transfers are observed throughout the process by the vendor.
 - ◆ Valves that drain the bulk tank areas are checked to ensure that they are closed. As needed, rain water is drained from the impoundments after being inspected and any oil observed is removed prior to release; minimal precipitation in the area of the facility greatly limits the need for draining of impoundments.
 - ◆ Fuel pumps are deactivated during non-operational hours and locked, if possible.
 - ◆ Transfer of product to or from drums/portable containers is completed within designated indoor areas and/or areas provided with secondary containment. Transfer equipment is located within secondary containment.

1.5.2 Countermeasures

The facility discharge discovery, response and cleanup capabilities are described as follows:

- ☐ Facility Response Plan
- ☐ Other document (describe)
- ☒ Details below:

Reference other supporting documentation maintained separately, as appropriate.

- ◆ Facility personnel are instructed during annual reviews (and weekly tool box meetings, as necessary) to be vigilant for any potential releases and to understand the proper reporting protocols in the event of a spill. Observation of the condition of bulk tanks, interstitial spaces of double-walled tanks (as applicable), outdoor areas, shop floors, and stormwater catch basins is advised to ensure prompt detection, reporting, and response in the event of the release of petroleum products.
- ◆ Facility personnel are trained to respond to spills identified in the shop building and immediate exterior areas using equipment and materials in the spill kits located throughout the facility. Granular absorbent materials and drain-blocking devices are used to help prevent any potential spills from entering stormwater infrastructure. Absorbent materials are used to capture and remove petroleum products from shop floors and containment areas, as necessary.
- ◆ North loading dock area: Discharge from the lower catch basin at the north loading dock area is controlled by Breaker No. 15 (labeled "Sump Pump") inside Panel P1 located on the west wall of second floor utility room upstairs from reception area. This breaker normally remains shut off unless weather conditions require the sump pump to be activated.
- ◆ In the event of larger releases that have the potential to leave the property limits or enter offsite stormwater infrastructure, facility personnel rely on contractor assistance (as noted in Appendix D) further contain and remove released petroleum products. In such an event, required notifications are identified in Appendix A.

The resources available to the facility for potential release cleanup are provided in the:

- ☒ Spill emergency call list (provided in Appendix A)
- ☐ Facility Response Plan

Reference supporting documentation maintained separately, as appropriate:

- ◆ Written inspection records, training documentation, and SPCC documentation (this Plan) will be maintained at the facility.



1.5.3 Disposal

The facility has established the following methods of disposal for recovered materials in accordance with applicable legal requirements (check all that apply):

- ☐ Facility Response Plan
- ☐ Other document (describe)
- ☒ Details below:

Recovered oil is transferred offsite by contractor for recycling.

1.6 IMPRACTICABILITY (AS APPLICABLE)

The containment and/or diversionary structures or equipment to prevent a discharge ☒ are ☐ are not practicable.

If not, the following provides a description of the impracticability:
Refer to Table 2.1 for additional details.

If not practicable, ☐ an oil spill contingency plan is attached (provided in Appendix D) or ☐ refer to the Facility Response Plan.

A written commitment of manpower, equipment, and materials required to expeditiously control and remove any quantity of oil discharged is provided in

☒ Appendix D or ☐ the Facility Response Plan.

- ◆ Appendix A includes a list of contacts to be notified in the event of a spill/release at the facility. An inventory of necessary spill response-related equipment is provided in Appendix D. IF these resources are insufficient to address a spill event, spill response personnel will use contractors listed in Appendix D, as appropriate.

If containment and/or diversionary structures are impracticable for bulk storage container(s), then periodic integrity testing of the container(s) and integrity and leak testing of the valves and piping is required.

- ◆ Existing containment/diversionary structures are sufficient for bulk storage containers at the facility. Necessary inspections are indicated in Section 2.7 of this Plan.

With the following exception:

- ◆ Exterior drum storage areas (55-gal. volumes or greater) should have secondary containment to capture and help prevent potential petroleum product spills.

1.7 DEVIATIONS TO RULE

☒ The facility has no deviations from the rule.



☐ The facility has identified various deviations from the rule and the equivalent environmental protection to support the deviations. The deviations, and the reasons for the deviations, are summarized ☐ below or ☐ in the appropriate sections of this Plan.

1.8 CONFORMANCE WITH OTHER REQUIREMENTS

Describe conformance with other applicable requirements and effective discharge prevention and containment procedures in place at the facility. Include a description of compliance with more stringent state rules, regulations, and guidelines, if any:

- Notification of the Chehalis Fire Department in the event flammable materials or fuels are released off the facility boundary and/or into roadway ditches or storm sewers

2 Onshore Facility Information

2.1 CONTAINERS AND POTENTIAL SPILLS TABLE

The sources of potential spills at the facility are summarized in Table 2.1.

Table 2.1. Potential spills sources at the facility

Oil Source	Associated Substance (Contents)	Source Capacity (gal.)	Potential Failure	Rate of Flow (gpm)	Direction of Flow	Containment System(s)
Aboveground Fixed Containers						
Bulk storage tank (AST) - outdoor containment area at southwest corner of main building.	Used oil	1,000	Overfilling/rupture	10 gpm	Within containment (13,000 gal). Drainage from containment vicinity is toward the west to driveway catch basin. Offsite and north, eventually to Salzer Creek.	Wall-type concrete berm surrounding multiple tanks. Total berm capacity is approximately 13,000 gallons. Interior of containment area is paved. Containment drain valve is at southwest corner of area.
Bulk storage tank (AST) – outdoor containment area at southwest corner of main building.	SAE 15W-40 engine oil	1,000 ^(a)	Overfilling/rupture	10 gpm	Within containment (13,000 gal). Drainage from containment vicinity is toward the west to driveway catch basin. Offsite and north, eventually to Salzer Creek.	Wall-type concrete berm surrounding multiple tanks. Total berm capacity is approximately 13,000 gallons. Interior of containment area is paved. Containment drain valve is at southwest corner of area.

Spill Prevention, Control, and Countermeasure Plan

Oil Source	Associated Substance (Contents)	Source Capacity (gal.)	Potential Failure	Rate of Flow (gpm)	Direction of Flow	Containment System(s)
Bulk storage tank (AST) – outdoor containment area at southwest corner of main building.	SAE 30W transmission drive train oil	1,000 ^(a)	Overfilling/rupture	7 gpm	Within containment (13,000 gal). Drainage from containment vicinity is toward the west to driveway catch basin. Offsite and north, eventually to Salzer Creek.	Wall-type concrete berm surrounding multiple tanks. Total berm capacity is approximately 13,000 gallons. Interior of containment area is paved. Containment drain valve is at southwest corner of area.
Bulk storage tank (AST) – outdoor containment area at southwest corner of main building.	SAE10 wt Hydraulic oil	1,000 ^(a)	Overfilling/rupture	7 gpm	Within containment (13,000 gal). Drainage from containment vicinity is toward the west to driveway catch basin. Offsite and north, eventually to Salzer Creek.	Wall-type concrete berm surrounding multiple tanks. Total berm capacity is approximately 13,000 gallons. Interior of containment area is paved. Containment drain valve is at southwest corner of area.
Completely and Partially Buried Tanks (not covered by 40 CFR Parts 280/281)						
No completely or partially buried tanks are in place at this facility.						
Mobile and Portable Containers						
Sheltered drum and equipment storage area – exterior of main building at east side.	Lubricants/ engine oils	55 gal	Drum puncture, failure	5 gpm	East to ditch at edge of property, then north to storm drain system. Eventually to Salzer Creek.	None
Operational Equipment (Transformers, Manufacturing Equipment, etc.)						
Truck or Rail Loading/Unloading Rack						
No truck or rail loading/unloading racks are present at the facility.						
Truck or Rail Loading/Unloading Areas						
No truck or rail loading/unloading areas are present at the facility.						

Spill Prevention, Control, and Countermeasure Plan

Oil Source	Associated Substance (Contents)	Source Capacity (gal.)	Potential Failure	Rate of Flow (gpm)	Direction of Flow	Containment System(s)
Operational Equipment (Manufacturing Equipment, Process Vessels, etc.)						
Used oil cart (used oil drainage bench/transfer system) – interior of main building shop area – near south wall.	Used oil	300 gal	Small spills from cart splashing or overflow. Leakage from pump transfer lines	1 gpm	Small spills limited to shop interior. Larger spills would flow west to driveway area and catch basin. Offsite and north, eventually to Salzer Creek.	Drip pan under cart.
Oil/lubricant pump and filter manifold – interior south wall of main building (shop area).	Various lubricating products	1,000 gal	Hose leaks, pipe leaks	15 gpm	Small spills limited to shop interior. Larger spills would flow west to driveway area and catch basin. Offsite and north, eventually to Salzer Creek.	Drip pan positioned beneath diaphragm pumps. Purpose is to catch small drips (minimal containment volume). Absorbent pads positioned beneath equipment.
Indoor steam cleaning room.	Oils from equipment	5-30 gal	Releases from washed equipment	2 gpm	Drainage is collected in an oily water storage tank located inside the room.	Room is sloped to central sump that discharges to the oily water storage tank.
Sheltered drum and equipment storage area – exterior of main building at east side.	Lubricants/engine oils	55 gal	Drum puncture, failure	5 gpm	East to ditch at edge of property, then north to storm drain system. Eventually to Salzer Creek.	None
Storage container at northeast corner of main building.	Lubricants/engine oils	30 gal	Container damage	2 gpm	East to ditch at edge of property, then north to storm drain system. Eventually to Salzer Creek.	None

(a) - Tank volumes calculated based on measured outer dimensions of tank shells. Capacity should be verified with manufacturer or through tank documentation (see Planned Improvements/Recommendations)

AST – aboveground storage tank

CFR – Code of Federal Regulations

N/A – not applicable



- ◆ The material and construction of bulk storage containers ☒ **are** compatible with the material stored and conditions of storage, such as pressure and temperature.
- ◆ All bulk storage container installations ☒ **are** ☐ **are not** constructed so that a means of secondary containment is provided for the entire capacity of the largest single container, as well as sufficient freeboard to contain precipitation, with the exception of 55-gal. drum storage areas in exterior locations. **If not**, describe the "impracticability" under Section 1.9.
- ◆ Diked areas ☒ **are** sufficiently impervious to contain discharged oil, with the exception of exterior drum storage areas.
- ◆ Visible discharges, which result in a loss of product from containers, will be promptly corrected and any accumulations of oil in the diked area(s) will be promptly removed.

2.2 BULK STORAGE CONTAINERS

2.2.1 Completely and partially buried tanks (not covered by 40 CFR Parts 280/281)

The facility ☐ **does** ☒ **does not** have completely buried metallic storage tanks that were installed on or after January 10, 1974, or that are not covered by 40 CFR Parts 280/281.

If yes, corrosion protection is provided by ☐ protective coatings and/or ☐ cathodic protection (compatible with local soil conditions) and/or ☐ other:

Completely buried tanks ☐ **are** regularly leak tested.

The facility ☐ **does** ☒ **does not** have partially buried or bunkered metallic tanks (40 CFR Parts 280/281 tanks are not exempt from this requirement).

If yes, corrosion protection is provided by ☐ protective coatings and/or ☐ cathodic protection (compatible with local soil conditions) or ☐ other:

2.2.2 Mobile or portable oil storage containers

Mobile or portable oil storage containers ☒ **are** ☐ **are not** located at the facility (Note: 55-gal. drums and totes **are** examples of mobile or portable containers).

If yes, secondary containment ☒ **is** ☐ **is not** provided that is adequately sized to contain the largest container, plus sufficient freeboard for precipitation. However secondary containment is ☐ **is** ☒ **is not** currently provided for exterior drum storage areas.

See Section 2.3.1 for details. If secondary containment is not provided, document the impracticability in Section 1.9.

2.2.3 Internal heating coils

The facility ☐ **does** ☒ **does not** utilize internal heating coils. If yes, internal heating coil leakage is controlled by (check method that applies):

- ☐ Monitoring of steam return and exhaust lines for contamination, or passing the steam return or exhaust lines through a settling tank or other separation system.
- ☐ Steam return or exhaust lines do not discharge into an open water course.
- ☐ Equivalent environmental protection described as follows:

2.2.4 Fail-safe precautions

Container installation(s) are engineered with at least one of the following devices (check all that apply):

- ☐ High liquid-level alarm, with an audible or visual signal, at a constantly attended operation or surveillance station. In smaller facilities an audible air vent may suffice.
 - ☒ High liquid-level pump cutoff devices set to stop flow at a predetermined container content level (1,000 gallon used oil tank only – flow from interior shop rack is regulated)).
 - ☐ Direct audible or code signal communication between the container gauger and the pumping station.
 - ☐ Fast response system for determining the liquid level of each bulk storage container (e.g., digital computer, telepulse, direct vision gauge). Note: If this alternative is used, a person must be present to monitor gauges and the bulk container.
 - ☒ Equivalent environmental protection.
- ◆ Liquid levels in bulk tanks are monitored through stick gauging during filling.

2.3 FACILITY CONTAINMENT, DRAINAGE, AND EFFLUENT TREATMENT

- ◆ Runoff from the vicinity of the tank containment and the west and north sides of the Main Building flow to the catch basins located in the driveway, parking areas and loading docks. These catch basins discharge to the ditch at the east side of Maryland Avenue at a point north of the facility entrance. The catch basins at the loading dock flow to a lift sump that discharges to a driveway catch basin (Figure 2). Drainage then flows north to Salzer Creek and eventually to the Chehalis River. Drainage from the east side of the Main Building flows to the ditch at the east side of the property and then north, eventually to Salzer Creek

and the Chehalis River. Drainage inside the shop area is retained inside the shop. In the event of a spill, drains can be temporarily blocked using absorbent materials or soil to prevent influx of oil. Oil absorbent socks and pads can also be used to remove oil that may flow to either of the perimeter ditches (east or west side). Larger spills will require the assistance of response contractors.

2.3.1 Secondary containment systems

The secondary containment systems present at the facility are summarized in Table 2.2.

Table 2.2. N C Machinery secondary containment systems

Containment ID	Drainage Method	Type of Containment and Material of Construction
Aboveground Fixed Containers (bulk storage)		
Bulk tank containment at southwest corner of main building	Impounded water is inspected. Any oil or fuel sheen or accumulated oil/fuel is removed using absorbent pads prior to releasing impounded water through the gate valve at the southeast corner of the structure.	Perimeter concrete wall. 13,000 gal
Mobile and Portable Containers		
55-gal. drums (interior areas)	Floor grates are located in shop interior. They are pumped out if liquid accumulates in them. Any oil or fuel present in removed liquids is removed and disposed of properly.	Each doorway grate (concrete with steel grated) can contain approximately 20 gallons
55-gal. drums (exterior areas)	Spills from 55-gal. drums stored in exterior areas would drain to open ground/parking areas	Secondary containment is currently not in place for 55-gal. drum storage area at rear of shop building.
Operational Equipment (Oily equipment rack, Shop Equipment, etc.)		
Floor grates at shop doorways	Floor grates are located in shop interior. They are pumped out if liquid accumulates in them. Any oil or fuel present in removed liquids is removed and disposed of properly.	Each doorway grate (concrete with steel grated) can contain approximately 20 gallons
Other Potential Spill Sources (Piping, Surface Impoundments, etc.)		
Interior fuel product transfer piping	Pipes are elevated off the floor to prevent potential damage; spills would be released to the floor and retained in the shop interior.	Spills would be contained within the building interior
Steam Cleaning Room	Oily water generated in steam cleaning room is accumulated in a tank which is moved by forklift to the wash pad for discharge to the wash pad treatment system.	Spills would be contained within the building interior.

Drainage from diked storage area(s) is restrained by ☒ manually operated valves, ☐ pumps, ☐ ejectors, or ☒ other methods:

- Drainage from bulk tank containment area is controlled by a manually operated gate valve located at the southwest corner of the containment area. Interior shop drains are blocked. Any liquid flowing into doorway grates must be manually removed. 2.3.2

2.3.2 Facility diked drainage to surface waters without facility treatment system

Manually operated valves ☒ are ☐ are not (☐ N/A, no valves) normally kept closed and ☒ are ☐ are not resealed following drainage.

Manually activated pumps ☒ are ☐ are not (☐ N/A, no pumps) normally kept off and ☐ are ☒ are not placed in operation following drainage.

- ◆ Pump controlling the lower catch basin in the loading dock area (exterior/north side of warehouse) is controlled by a breaker switch in the upstairs utility room (Panel P1 – switched marked (“Sump Pump”). This breaker is kept open and is manually closed only to remove inspected accumulated water. The facility is planning to provide a cutoff switch near the loading bay area.

Describe valve operation or equivalent environmental protection:

- ◆ Any potentially impounded water is inspected for potential oil accumulation. If sheen is observed, oil product is removed using absorbent materials prior to release of water. Interstitial spaces in the double-walled tank are inspected on a quarterly basis (at a minimum) for any potential accumulated water or oil product.
- ◆ Written records will be maintained on file for all inspections completed at the facility.

2.3.3 Facility drainage to effluent treatment system

Drainage waters ☐ are ☒ are not (☐ N/A) treated in more than one (1) treatment unit.

If yes, and treatment is continuous, two lift stations ☐ are ☐ are not provided, at least one of which is permanently installed.

If not, describe equivalent environmental protection:

2.3.4 Effluent treatment system

The facility ☒ **does** ☐ **does not** treat water prior to discharge off-site. If yes, the measures in place to ensure that system upsets are detected are as follows:

Presently water accumulated in the steam cleaning room is transferred to the vehicle wash pad area for treatment.

2.3.5 Facility un-diked drainage to surface waters

The facility ☒ **does** ☐ **does not** have the potential to discharge into un-diked areas.

If yes, the facility un-diked areas ☒ **do** ☐ **do not** flow to ☐ ponds ☐ lagoons

☒ catchment basins ☒ other: flat, unpaved areas.

If not, describe equivalent environmental protection:

Describe un-diked area drainage or, if not addressed, describe equivalent environmental protection:

- ◆ Some facility drainage flows to the ditch at the east side of the facility. Secondary containment structures for bulk tanks would greatly limit the potential for this to occur. Any potential releases from vehicles in parking areas will be addressed by facility personnel or the resources identified in Appendix D.

2.4 FACILITY TRANSFER OPERATIONS, PUMPING, AND FACILITY PROCESS

2.4.1 Facility piping

The facility ☐ **does** ☒ **does not** have buried piping. Corrosion protection for all new and replaced buried piping is provided as follows (check all that apply):

☐ Wrapping and coating

☐ If wrapping and coating are not provided, describe equivalent environmental protection:

☐ Cathodic protection, or protection meeting the corrosion protection standards in 40 CFR Part 280 or 281

☐ If cathodic protection is not provided, describe equivalent environmental protection:

When a pipe section is exposed, it is examined and corrective action taken as necessary.

Describe the facility piping systems (aboveground and buried):

- ◆ Aboveground product transfer lines are associated with the used oil and product storage tanks located on the SW side of the main shop building. The lines

transfer used oil/product to and from the used oil drainage bench and product dispensers within the shop building. The lines are supported off the ground and are protected from traffic areas.

2.4.2 Out of service piping

Out of service piping terminal connections ☒ **are** ☐ **are not** capped or blank flanged and marked when the piping is not in service, or in standby service for extended periods. **If not**, describe equivalent environmental protection:

2.4.3 Pipe supports

Pipe supports ☒ **are** ☐ **are not** designed to minimize abrasion and corrosion and allow for expansion and contraction. **If not**, describe equivalent environmental protection:

- ◆ There are small above-ground product transfer lines associated with the bulk storage tanks at the southwest corner of the Main Building. These small-diameter pipes transfer product to the pumps and reels located inside the building. The pipes are adequately supported and constructed to transfer the designated product. Interior piping is fastened to overhead beams and/or the walls to help minimize any potential damage caused by facility operations.

2.4.4 Vehicle warnings

Vehicles ☒ **are** ☐ **are not** warned ☒ orally, by ☐ signs, with ☐ bumper guards, or ☐ other methods to be sure that no vehicle endangers aboveground piping or other oil transfer operations. Describe vehicle warning systems/procedures or describe equivalent environmental protection.

2.5. FACILITY TANK CAR & TRUCK LOADING/UNLOADING RACK(S) AND AREA(S)

The facility ☐ **does** ☒ **does not** have a tank truck loading/unloading rack.

The facility ☐ **does** ☒ **does not** have a tank car (rail) loading/unloading rack.

If yes to either, proceed with the following Sections 2.5.1 through 2.5.3. If no, proceed to Section 2.5.4. See the Guidance Document that precedes this template for clarification of a loading/unloading rack.

2.5.1 Tank car & truck containment systems for loading/unloading rack(s)

Loading/unloading rack area drainage ☐ **does** ☐ **does not** (☒ **N/A**) flow into a catchment basin, treatment facility, or a quick drainage system designed to handle discharges.

The containment system ☐ **does** ☐ **does not** (☒ **N/A**) hold the maximum capacity of any single compartment of a tank car or truck loaded or unloaded at the facility.

Describe containment system design, construction materials, and volume (if the containment system does not hold the maximum capacity, then document the impracticability in Section 1.9):

Refer to Table 2.1 for additional details.

2.5.2 Prevention of premature vehicular departure from rack(s)

The methods, procedures, and/or equipment used to prevent premature vehicular departure include (check all that apply): NA

- ☐ Interlocked warning lights
- ☐ Physical barrier systems
- ☐ Warning signs
- ☐ Wheel chocks
- ☐ Vehicle brake interlock systems
- ☐ Company personnel supervising loading/unloading operation

Describe these and other premature vehicular departure prevention measures (for each rack):

- ◆ The facility has no loading/unloading racks.

2.5.3 Drain and outlet inspection for rack(s)

Drains and outlets on tank trucks and cars ☐ **are** ☐ **are not** (☒ **N/A**) checked for leakage before loading/unloading or departure and, if necessary, are tightened, adjusted or replaced. If not, describe equivalent environmental protection:

2.5.4 Facility tank car and truck loading/unloading area(s)

Tank truck loading/unloading (excluding rack area described above) ☐ **does** ☒ **does not** occur at the facility.

Tank car (rail) loading/unloading (excluding rack area described above) ☐ **does** ☒ **does not** occur at the facility.

If yes to either, the containment and/or diversionary structure for the loading/unloading area(s) include (check all that apply):

- ☐ Dikes, berms, or retaining walls
- ☐ Curbing
- ☐ Culverts, gutters, or other drainage systems

- ☐ Weirs, booms, or other barriers
- ☐ Spill diversion ponds
- ☐ Retention ponds
- ☐ Sorbent materials
- ☐ Earthen or natural structures that can contain and prevent discharges
- ☐ Other:

Describe the containment and/or diversionary system: N/A

2.6 SECURITY

The facility ☒ **is** ☐ **is not** fully fenced. Describe the fence or, **if not** fenced, describe equivalent environmental protection. (Note: Fencing all discrete areas directly involved in the handling, processing, and storing of oil would provide equivalent environmental protection, as compared to fencing the entire footprint of the facility.):

- ◆ The facility is surrounded by chain-link fence and uses lockable gates for access/egress.

Entrance gates ☒ **are** ☐ **are not** (☐ N/A) locked and/or guarded when the facility is unattended or not in production. Describe the gate security or, **if not** locked or guarded, describe equivalent environmental protection:

Any valves that permit direct outward flow of a container's contents to the surface ☒ **have** ☐ **do not have** (☐ N/A) adequate security measures so that they remain closed when in non-operating or standby status. Describe valve security, or **if not** secure, describe equivalent environmental protection:

- ◆ Buildings are locked during off-hours to protect those containers within buildings not fitted with locking mechanisms.

Starter controls on all oil pumps in non-operating or non-standby status ☒ **are** ☐ **are not** (☐ N/A) locked in the off position and located at a site accessible to only authorized personnel. Describe pump starter control security, or **if not** locked, describe equivalent environmental protection:

- ◆ Transfer equipment associated with the transfer of product from the bulk tanks to dispensers within the shop building is located inside the building and accessible to authorized and trained personnel only.

When facility piping is not in service, or is in standby service for an extended time, the loading/unloading connections ☐ **are** ☐ **are not** (☒ N/A) securely capped or blank

flanged. This applies to piping that is emptied of its liquid content either by draining or by inert gas pressure. If not secure, describe equivalent environmental protection:

Facility lighting ☒ is ☐ is not (☐ N/A) commensurate with the operation, type, and location of the facility to assist in the discovery of discharges, and to prevent discharges occurring through acts of vandalism. Describe facility lighting or, if lighting is not commensurate, describe equivalent environmental protection:

-
- Yard lighting is in place.
-

2.7 INSPECTIONS, TESTS, AND RECORDS

2.7.1 Container testing and inspections

Describe the facility aboveground bulk storage container integrity testing and inspection program. Include inspection frequency, records of inspections, and any equivalent environmental protection:

- ◆ The facility shall follow a qualified container integrity inspection program as provided in the Steel Tank Institute (STI) Standard for Inspection of In-Service Shop-Fabricated ASTs for Storage of Combustible and/or Flammable Liquids (SP-001-03), along with other requirements established by the US Environmental Protection Agency (EPA) as indicated in the federal register.
- ◆ Inspections that shall be completed and specific frequency are as follows:
 - ◆ Daily (undocumented):
 - ◆ Facility general inspections (walk-through)
 - ◆ Monthly (documented):
 - ◆ Inspection of fuel storage containers and associated piping for signs of leakage or potential leakage, including inspection of containment areas
 - ◆ Inspection for the presence of water in bulk ASTs at the facility
 - ◆ Quarterly (documented):
 - ◆ Inspection of interstitial spaces of double-walled tanks (as available) for the presence of accumulated water or fuel product
 - ◆ Inspection of condition of exterior of tanks and cleaning of tank relief valves and vents, as necessary
 - ◆ Annually (documented):

- ♦ Inspection of tank foundations, supports, appurtenances, and seals/gaskets of emergency tank vents
- ♦ Every 10 years (documented):
 - ♦ Tank inspection (performed by a Certified Tank Inspector) in accordance with the requirements of STI SP-001-03. Those primary tank surfaces that connect directly must either be exposed for inspection or checked by the Certified Inspector using an approved form of non-destructive testing, based on the requirements outlined in the most current SPCC standard (40 CFR Part 112).

Based on the results of any of the above inspections, ASTs determined to be defective or damaged will be immediately emptied and taken out of service. Corrective actions, as established by STI, will be implemented before the damaged/defective tank is returned to service. Inspection/repair of the suspect tank will be documented at the facility.

All written testing documentation will be maintained at the facility as part of this Plan.

In the event that a field-constructed aboveground container undergoes a repair, alteration, reconstruction, or change in service, the container ☐ will be evaluated for risk of discharge or failure because of brittle fracture or other catastrophe.

- ♦ N/A, the facility has no field-constructed ASTs.

Describe the facility leak testing program for completely buried tanks. Include frequency, records of inspections, and any equivalent environmental protection:

- ♦ N/A, the facility has no completely buried tanks.

Describe the frequency and method to test liquid level-sensing devices at the facility:

- ♦ N/A for this facility

2.7.2 Buried piping integrity and leak testing

Buried piping ☐ is ☒ is not present.

Integrity and leak testing of buried piping is performed at the time of ☐ installation, ☐ modification, ☐ construction, ☐ relocation, or ☐ replacement.

2.7.3 Aboveground piping examination

All aboveground valves and piping (including flange joints, valve glands and bodies, catch pans, pipe supports, locking valves, and metal surfaces) will be regularly examined.

Describe the facility piping inspection program (and integrity and leak testing, as appropriate). Include inspection frequency, records of inspections, and any equivalent environmental protection:

- ◆ Piping and associated appurtenances used to transfer/manage petroleum products used at the facility will be visually inspected for leakage or potentially damaged conditions (bending/crushed piping, damaged joints, corrosion, etc.) that could potential result in a spill or leak from the equipment. Daily visual inspections (walk-through, etc.) satisfy this requirement and can be undocumented.
- ◆ Monthly inspections of transfer piping within containment areas will be completed and documented at the facility.

2.7.4 Dike drainage inspections

Describe the procedure for supervising the drainage of rainwater from secondary containment into a storm drain or an open watercourse. Include description of (a) inspection for pollutants and (b) method of securing valves:

- ◆ The containment structure surrounding the bulk storage tanks at the southwest corner (exterior) of the shop building will be visually inspected on a monthly basis for any signs of damage or cracking, or indications of leakage. Any penetrations through the containment structure (piping, etc.) will be inspected to ensure that they are properly caulked and sealed to prevent potential leakage.
- ◆ Any stormwater within the containment structures at the facility will be visually inspected for the potential presence of petroleum products prior to removing the accumulated stormwater. Any observed oily sheens/product will be removed with absorbent materials prior to re leasing accumulated water. Access to containment areas is limited because of provided fencing and security protocols at the facility.

2.7.5 Other applicable inspections

Describe other applicable facility inspections, including effluent discharge inspections and inspections of effluent-bypassing systems, if applicable:

2.7.6 Documentation

Inspection and test record forms are provided in Appendix B. These forms should be completed according to the indicated schedules and records maintained with this SPCC plan.

APPENDIX A. NOTIFICATIONS

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A.1 Contact Lists and Phone Numbers

Notify as appropriate for the specific situation. Ambulance and emergency services will be needed in the event accidents involve injury. The fire department should be notified in the event fuel spills endanger the public, enter storm drains, or flow off site.

Contact List and Phone Numbers

NOTE: YOU MUST FIRST DIAL "9" TO GET AN OUTSIDE LINE FROM THE FACILITY

N C Machinery:

In the event of a catastrophic failure, fuel/oil spills, or other emergency contact one of the following personnel (preferably in the order they appear below):

Table A.1 N C Machinery emergency contacts

NAME	OFFICE PHONE	HOME PHONE	CELL PHONE
Dave Antilla	360 748-8845	(none)	360 508-2222
Jim Ewers	360 748-8845	(none)	360 827-1134
Stephen Bell	425 251-5876 (ext 2876)	(none)	206 786-7202

Agencies:

How To Report a Spill

Spills of oil or hazardous substances must be reported.

The law requires the person in charge of a facility who witnesses or sees a spill that discolors the surface of the water – creates a "sheen" – to report the spill to the U.S. Coast Guard or the National Response Center at 1-800-424-8802 immediately. Failure to report may result in the assessment of a civil penalty and/or criminal sanctions. State and local reporting requirements must also be satisfied.

Who to Call

Oil/Fuels	<p>Spills entering or endangering navigable waters (Ditches/Salzer Creek/Chehalis River): US Coast Guard National Response Center: 1-800-424-8802 EPA Region 10 (unless notified by Response Center): 206-553-4973 All spills endangering the environment: Washington State: 1-800-258-5990</p>
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Fuel spills endangering the public, entering storm drains, or flowing off site:

Chehalis Fire Department: 911 (360 748-3394)

(weekends: Dial 911)

Ecology's Regional Offices:

All Other Materials

Southwest Office, Lacey: 1-360-407-6300

Useful Information

You may request that your personal information be kept confidential.

To the best of your ability please be ready with the following information:

Where is the spill?

Is anyone cleaning up the spill?

What spilled?

Are there resource damages?

How much spilled?

Who is reporting the spill?

How concentrated is the spilled material?

How can we get back to you?

Who spilled the material?

Additional emergency contacts

As noted above, ambulance and emergency services will be needed in the event accidents involve injury. The fire department should be notified in the event fuel spills endanger the public, enter storm drains, or flow off site.

Table A.2 Additional emergency notification contacts

Response Type	Name	Telephone Number
Police	Chehalis Police Department	Emergency: 911 (360 748-8605)
Fire/Offsite releases of fuel.	Chehalis Fire Department	Emergency: 911 (360 748-3394)
Ambulance	Emergency Dispatch	Emergency: 911
Hospital:	Providence Hospital - Centralia 914 S. Scheuber Rd Centralia WA 98531	360 736-2803 Emergency dept: 360 330-8516
Washington Poison Center		1- 800 222-1222

NOTE: FOR FLOOD EMERGENCIES: REFER TO ADDITIONAL NOTIFICATION REQUIREMENTS AND ACTIONS AS MAY BE REQUIRED IN THE BRANCH FLOOD PLAN & EMERGENCY PLAN (JANUARY 2002).



A.2 Federal Notification Procedures and Forms

Section 311 of the Federal Water Pollution Control Act (FWPCA) requires immediate notification of spills of oil or hazardous substances into any body of water. This applies to releases into wetlands, lakes, streams, rivers, and navigable waters offshore out to approximately 200 miles. All such spills MUST be reported to the National Response Center (NRC) by calling:

1-800-424-8802.

Use the attached federal notification data sheet to record notifications.

Table A.3 Federal notification data sheet

The Facility will utilize the following form to relate information in the event of a discharge reportable to the U.S. EPA/Coast Guard::

Date: _____ **Time:** _____

INCIDENT DESCRIPTION

Reporter's Full Name: _____ **Position:** _____
Day Phone Number: _____ **Evening Phone Number:** _____
Company: _____ **Organization Type:** _____
Facility Address: _____ **Owner's Address:** _____

Facility Latitude: _____ **Facility Longitude:** _____
Spill Location: _____
(if not at Facility) _____
Responsible Party's Name: _____ **Phone Number:** _____
Responsible Party's Address: _____
Source and/or cause of discharge: _____

Nearest City: _____
County: _____ **State:** _____ **Zip code:** _____
Section: _____ **Township:** _____ **Range:** _____ **County:** _____
Distance from City: _____ **Direction from City:** _____
Container Type: _____ **Container Storage Capacity:** _____
Facility Oil Storage Capacity: _____
Material: _____

Total Quantity Released	Water Impact (YES or NO)	Quantity into Water

RESPONSE ACTION(S)

Action(s) taken to Correct, Control, or Mitigate Incident: _____

Number of Injuries: _____ **Number of Deaths:** _____
Evacuation(s): _____ **Number Evacuated:** _____
Damage Estimate: _____
More information about impacted medium: _____

CALLER NOTIFICATIONS

National Response Center (NRC): 1-800-424-8802
Additional Notifications (Circle all applicable): _____ **State** _____ **Other** _____

ADDITIONAL INFORMATION

Any information about the incident not recorded elsewhere in this report (add page if needed): _____

NOTE: DO NOT DELAY NOTIFICATION PENDING COLLECTION OF ALL INFORMATION.



A.2.1 SUBMITTAL OF INFORMATION TO REGIONAL ADMINISTRATOR FOR QUALIFIED DISCHARGE(S) (FEDERAL NOTIFICATIONS)

In the event of a qualified discharge or discharges, this page can be utilized to provide official notification to the Regional Administrator. If the Facility has had a discharge or discharges which meet one of the following two criteria, then this report must be submitted to the Regional Administrator within 60 days. (Check as appropriate)

- ☐ This Facility has experienced a reportable spill as referenced in 40 CFR Part 112.1(b) of 1,000 gal. or more.
- ☐ This Facility has experienced two (2) reportable spills (as referenced in 40 CFR Part 112.1(b) of greater than 42 gal. each within a 12-month period.

Table A.4 Notification of qualified discharge

Required Information	Facility-specific Information
Facility name and location:	
Facility contact person (name, address/phone number):	
Facility maximum storage or handling capacity:	
Facility normal daily throughput:	
Describe the corrective action and countermeasures taken (include description of equipment repairs and replacements):	
Describe the facility (maps, flow diagrams and topographical maps <u>attached</u> as necessary):	
Describe the cause of discharge (as referenced in 40 CFR Part 112.1(b)) including failure analysis of the system is:	
Describe the preventative measures taken or contemplated to be taken to minimize the possibility of recurrence:	
Other pertinent information:	



APPENDIX B. LOGS AND RECORDS

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Rainwater accumulated in the tank containment area is inspected prior to release and, if necessary, oil is removed prior to release.

[illegible]

- | | |
|--------------------------------|---------------|
| 1 – tank areas and containment | 3 – ditches |
| 2 – storm drain inlets | 4 – shop area |



B.2 Record of SPCC Training

I/we hereby acknowledge receipt of instruction and training regarding the Spill Prevention, Control and Countermeasures (SPCC) Plan for the facility indicated below. Further, I/we acknowledge having read the SPCC Plan, including the project site specific attachments. I/we have knowledge and familiarity with the SPCC-related facilities and operations discussed in the plan.

**Table B.2 Employees' acknowledgement of training and instruction
(N C Machinery – Chehalis Branch)**

Printed Name	Signature	Date

I hereby certify that SPCC-related training was conducted on the date indicated below:

Table B.3 Facility manager's acknowledgement of training and instruction

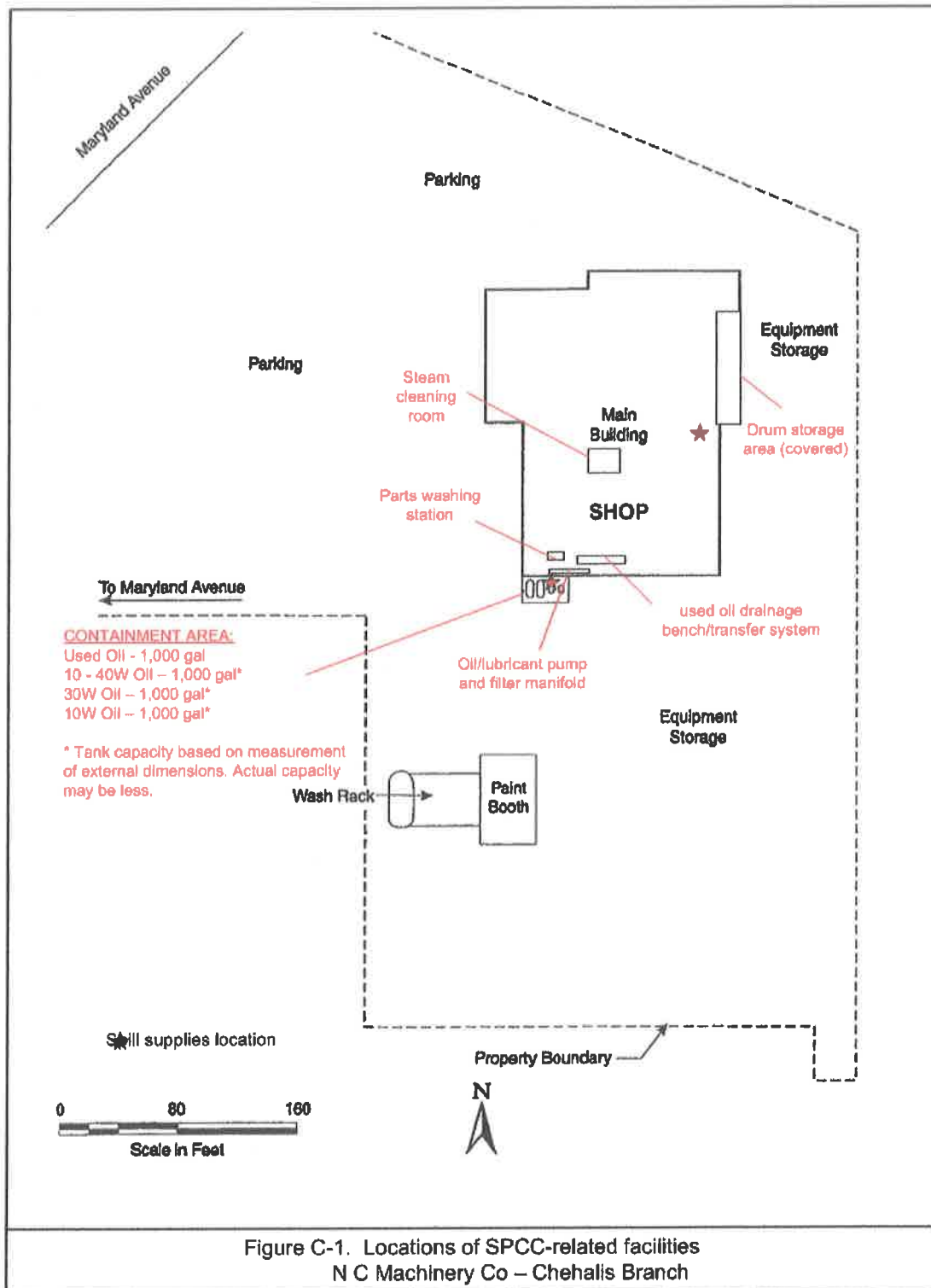
Facility Manager	Signature	Date

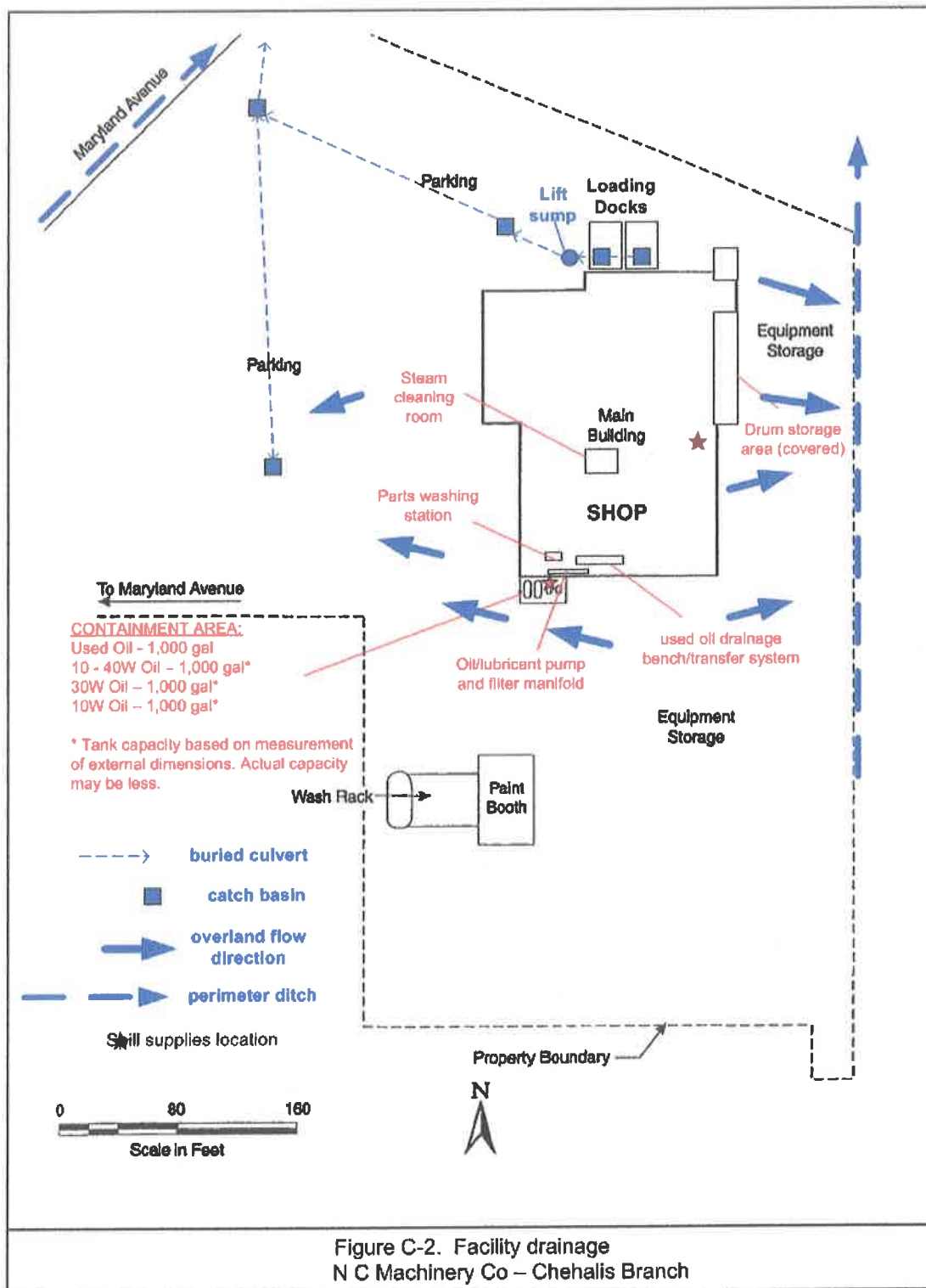
APPENDIX C. FACILITY DIAGRAMS

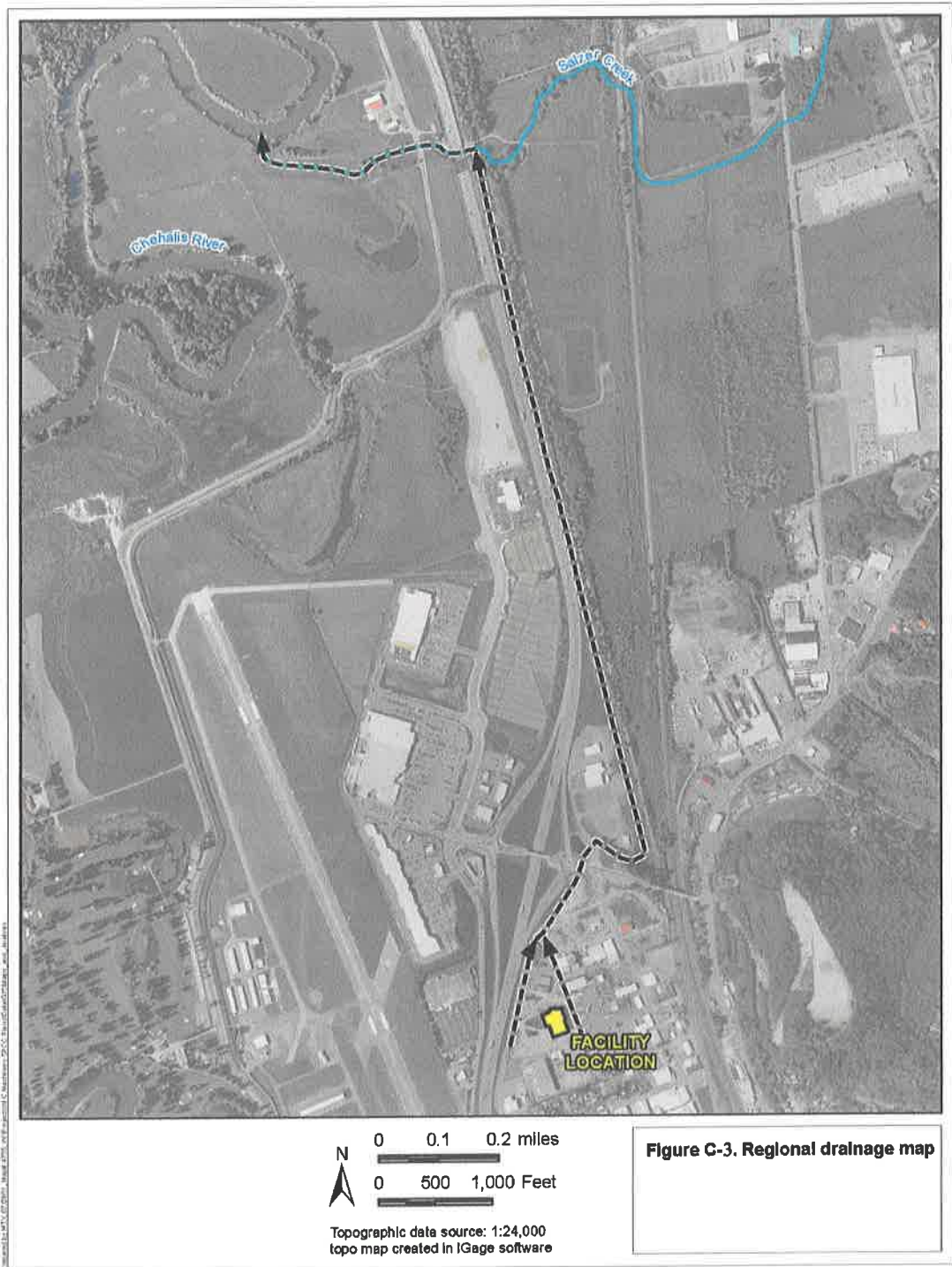
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APPENDIX D. OIL SPILL RESPONSE PROCEDURES

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D.1 Oil Spills

D.1.1 GENERAL PROCEDURES

1. **Personal Safety First:** Make sure the spill area is evacuated.
2. **Quickly Assess the Spill Situation:** Type of spilled material, source, current and probable extent.
3. **Secure Pumps and Valves:** Where safe to do so, shut down and secure the spill source.
4. **Control/Minimize the Source:** If safe to do so and within the capabilities of equipment available onsite, take efforts to contain and minimize the release. For small releases, use equipment provided in the spill kits. Periodically transfer collected liquids to larger containers. Follow up by using absorbent pads or socks in the spill kit. If the leak is originating at an inadvertently opened valve, close the valve immediately.
5. **Make Notification:** As described in the SPCC Plan and as posted.
6. **Additional Help:** Assess the need for additional response resources and coordinate with the Environmental Manager.
7. **Further Secure the Spill Area:** Once the spill is secured, continue to keep the area clear of personnel and vehicles not directly involved in response and cleanup. Identify and eliminate any ignition hazards. If the spill is stabilized and rainy conditions exist, the spill area can be covered using plastic sheeting to prevent contaminated runoff. Redirect any rainwater flowing into the spill area using earthen barriers or other means as may be available.
8. **Cleanup:** Make sure all collected liquids and contaminated solids (rags, absorbent materials, soil) are stored and disposed of in an appropriate manner. Verify the appropriate disposal methods by contacting the Environmental and Facilities Manager.
9. **Reporting:** Complete the spill incident and spill summary reports as may be required by Ecology and other agencies. Include records of the spill and response/notification actions with the SPCC Plan.

D.2 Inventory of Spill Response Equipment

Inventory of Chehalis Branch spill response kits.

Table D.1 Tank containment area (Spill-Tech, Woodinville WA, OL-18 spill response box)

Equipment	Number of Items
3" x 4' Sock	3
3/8" x 14" x 14" Absorbent Pads	85
20 Gal. Haz Mat bag/tie	2
Gloves (pair)	1
Hazmat labels	2
Oil-absorbent pads	2
Technical booklet	1
Flat-blade shovel	1
Soda ash (10-gal. containers)	3
Feet containment boom (terrestrial use)	40

Table D.2 Inside shop area doorway

Equipment	Number of Items
Absorbent sock, 4" x 10	1
Absorbent pillows 17" x 17"	2
Absorbent GP natural fiber pads	3
Disposal bags	1
Gloves	
Wheelbarrow	1
Spill blanket	1

D.3 Additional Spill Response Support

Some emergency spill situations may require additional equipment and/or specially trained personnel to assist in spill response and cleanup. N C Machinery routinely works with contractors who provide daily services such as used oil removal/recycling and engine fueling. These same contractors may also provide spill response services.

The following resources are available, if needed. If possible (i.e., if the spill situation is stabilized), use of these resources should be coordinated through the company's Environmental Manager.



Table D.3 Emergency resources

Resource Name	Resources Available	Emergency Phone Number
Emerald Services Spill Response (contact: Jim Munnell)	Cleanup crews, vacuum truck	(888) 832-3008
Cowlitz Clean Sweep	Storm drain catch basin cleaning and jet cleanout of drain lines	(888) 423-6316
Windward Environmental (contact: Warren Hansen)	Technical/environmental services for spill cleanup oversight, documentation, spill sampling and reporting	(206) 812-5434 (direct) (206) 830-9459 (mobile)

D.4 Special Notes

This plan necessarily addresses problems of a general nature. With respect to particular circumstances, local, state, and federal laws and regulations should be reviewed.

The preparer of this plan is not undertaking to meet the duties of employers, manufacturers, or suppliers to warn and properly train and equip their employees, and others exposed, concerning health and safety risks and precautions, nor undertaking their obligations under local, state, or federal laws.

The preparer of this plan is not undertaking to meet the duties of the facility owner in completing required inspections, properly maintaining equipment, implementing housekeeping measures, or completing inspection/training records as required.

Information concerning safety and health risks and proper precautions with respect to particular materials and conditions should be obtained from the employer, the manufacturer or supplier of that material, or the material safety data sheet.

Nothing contained in this plan is to be construed as granting any right, by implication or otherwise, for the manufacture, sale, or use of any method, apparatus, or product covered by letters patent. Neither should anything contained in the plan be construed as insuring anyone against liability for infringement of letters patent.

This plan was prepared in accordance with generally accepted professional practices for the nature and conditions of work completed at similar localities, at the time the work was performed. It is intended for the exclusive use of the facility owner or operator for specific application to the referenced property. The SPCC Plan is only one component of the overall program to prevent and control spills and comply with governing regulations. Others include management support, good housekeeping, safety, employee training, maintenance of spill response resources, record keeping, equipment inspections and testing, diligent implementation of the plan requirements, and other measures that are the sole responsibility of the facility owner or operator.

Other related facility plans may include emergency requirements related to oil storage or handling equipment. The facility owner/operator is solely responsible for resolving any conflicts as may exist among the various plans and this SPCC Plan.

Facilities typically change over time, and the SPCC rule includes a requirement for periodic review and, if necessary, changes to the SPCC Plan. Currently the rule requires that this review be performed at least every 5 years or when there is a significant change to the SPCC-related facilities or practices. This plan may be invalid if it is 5 years older than the date of certification and there is no written record of review.

Oil spills and accidental releases can result from many causes, including Acts of God. The preparer of this plan makes no warranties or guarantees, either expressed or implied, that all possible spill conditions can be foreseen or adequately controlled by available resources and is therefore not responsible for damages or costs as may result from spills originating from the subject facility.

