

**RULE 67.6.2 VAPOR DEGREASING OPERATIONS**  
(Rev. Adopted & Effective February 10, 2021)

**(a) APPLICABILITY**

(1) Except as provided in Section (b) Exemptions, this rule is applicable to all vapor degreasing operations.

(2) Rule 66.1 – Miscellaneous Surface Coating Operations and Other Processes Emitting Volatile Organic Compounds shall not apply to any vapor degreasing operation.

**(b) EXEMPTIONS**

(1) This rule shall not apply to the following:

(i) Vapor degreasing operations that exclusively utilize materials with a volatile organic compound (VOC) content of 25 grams per liter (g/l) (0.21 lbs/gal) of material or less, as used.

It shall be the responsibility of any person conducting such operations to keep a current list of all cleaning materials and the VOC content of each material, as used, to substantiate this exemption.

(ii) Vapor-phase solder reflow units.

(iii) Vapor degreasing operations conducted in a container with a vapor-air interface area of one square foot (0.09 square meters) or less or with a maximum solvent capacity of one gallon (3.8 liters) or less.

**(c) DEFINITIONS**

(1) **"Airless/Air-Tight Vapor Degreaser"** means a system that consists of a sealed vapor degreaser and the devices to condense and recover solvent and emission control devices to remove solvent from all gas streams that vent to the atmosphere. The system must have no open vapor-air interface, and be designed and operated in such a manner as to prevent the discharge or leakage of solvent emissions to the atmosphere during all cleaning and drying operations.

(2) **"Batch-loaded Solvent Degreaser"** means a degreaser in which any material is placed for cleaning and removed as a single batch after the cleaning is finished.

(3) **"CFR"** means Code of Federal Regulations.

(4) **"Degreaser"** means a tank, drum, or other container in which objects to be cleaned are exposed to a solvent or solvent vapors, in order to remove contaminants.

(5) **"Freeboard Height"** means the distance from the solvent vapor-air interface to the top of the degreaser tank, based on inside tank dimensions.

(6) **"Freeboard Ratio"** means the freeboard height divided by the smaller of the interior length or width of the degreaser tank.

(7) **"Liquid Leak"** means any visible leak of a VOC-containing liquid at a rate in excess of three drops per minute.

(8) **"New Vapor Degreasing Operation"** means any vapor degreasing operation for which a complete application for an Authority to Construct in San Diego County was submitted after February 10, 2021.

(9) **"Open-top Vapor Degreaser"** means any batch-loaded vapor degreaser.

(10) **"Perimeter Trough"** means a receptacle within the vapor degreaser located below the primary condenser that conveys condensed solvent and atmospheric moisture to a water separator.

(11) **"Primary Condenser"** means a series of circumferential cooling coils on the inside of walls of a vapor degreaser through which a chilled substance is circulated or recirculated to provide continuous condensation of rising solvent vapors, thereby creating a concentrated solvent vapor zone.

(12) **"Refrigerated Freeboard Chiller"** means an emission control device which is mounted above the degreaser's water jacket or primary condenser coils, and which consists of secondary coils that carry a refrigerant to provide a chilled air blanket above the solvent vapor.

(13) **"Solvent"** means any substance containing an organic compound or combination of organic compounds which is liquid at atmospheric pressure and ambient temperature and which is used as a diluent, thinner, dissolver, viscosity reducer, or cleaning agent, or for other similar purposes.

(14) **"Solvent Carry-Out"** means solvent carried out of a degreaser that adheres to or is entrapped in the part being cleaned.

(15) **"Vapor-Air Interface"** means the area of contact between the solvent vapors and air that is contiguous with the air outside the degreaser. The area of the vapor-air interface shall be calculated as the product of the lengths between internal solvent cleaner walls behind the condensing coils.

(16) **"Vapor-Phase Solder Reflow Unit"** means a device in which parts are immersed in VOC-rich vapor generated by boiling a liquid for heating to melt or soften solder connections of electronic components.

(17) **"Vapor Degreaser"** means a degreaser in which objects to be cleaned are exposed to a boiling solvent or solvent vapors.

(18) **"Vapor Degreasing Operation"** means a cleaning operation that is conducted by immersing parts, products, tools or other items in a boiling solvent or in solvent vapors generated by boiling solvent.

(19) **"Volatile Organic Compound (VOC)"** means the same as defined in Rule 2 – Definitions.

(20) **"VOC Content Per Volume of Material"** means the same as defined in Rule 2 – Definitions.

(21) **"Water Separator"** means a device that isolates water from a solvent or a mixture of solvents through mechanical or chemical means.

(d) **STANDARDS**

(1) General Equipment Requirements

A person shall not operate any vapor degreaser unless it is equipped with all of the following:

(i) A cover that can be easily operated without disturbing the vapor layer and that completely covers the solvent tank when work is not performed in the degreaser;

(ii) A primary condenser situated above the boiling solvent;

(iii) A water separator that does not operate by means of evaporation or distillation;

(iv) A perimeter trough;

(v) For vapor degreasers employing sprays:

(A) spray nozzles having a pressure low enough to prevent liquid splashing outside of the tank, and

(B) spray nozzles which produce continuous liquid flow, rather than fine atomized or shower type sprays; or

(C) spray nozzles which are located below the vapor-air interface.

(2) Additional Equipment Requirements

All vapor degreasers shall have one of the following:

(i) A freeboard ratio of at least 1.0; or

(ii) A refrigerated freeboard chiller, where the chilled air blanket temperature measured in degrees Fahrenheit at the center of the air blanket is not greater than 40% of the initial boiling point of the solvent; or

(iii) Be designed in such a manner that its cover or door opens only when the dry part is entering or exiting the degreaser.

### (3) Safety Devices

Vapor degreasers shall be equipped with the following safety devices:

(i) A device which shuts off the sump heat if the condenser's coolant stops circulating. This requirement does not apply to vapor degreasers equipped with refrigerated condensers; and

(ii) A device which shuts off the sump heat if the condenser's coolant or refrigerant temperature becomes higher than the designed operating temperature; and

(iii) A device which is only manually resettable and which shuts off the sump heat if the vapor level rises above the designed operating level;

(iv) For vapor degreasers employing sprays, a device that prevents spray pump operation if the solvent vapor-air interface temperature falls below the designed operating level.

### (4) Operating Requirements

A person shall not operate a vapor degreaser unless all of the following requirements are met:

(i) A permanent, conspicuous, legible label listing the applicable operating requirements is posted on or near the degreaser;

(ii) The degreaser and any emission control equipment are installed and maintained in proper working order. The emission control equipment shall be properly operating at all times when parts are being cleaned or solvent is being heated in the degreaser;

(iii) The cover is not removed except to process workload or to perform maintenance;

(iv) There are no liquid leaks from any portion of the degreaser. Upon detection of a liquid leak, the leak shall be repaired immediately, or the degreaser shall be shut down and drained in a manner that minimizes emissions;

(v) Ventilation fans are not positioned near the degreaser openings in such a way as to disturb the vapor zone;

(vi) At startup, the primary condenser and the refrigerated freeboard chiller, if required, are turned on before the sump heater is turned on. At shutdown, the sump heater is turned off before the primary condenser and refrigerated freeboard chiller are turned off;

(vii) No porous or absorbent materials, such as cloth, leather, wood, or rope are cleaned in a vapor degreaser;

(viii) Solvent is not sprayed above the vapor-air interface;

(ix) Exhaust ventilation rate does not exceed 65 cubic feet per minute per square foot (20 cubic meters per minute per square meter) of the degreaser vapor-air interface area, unless necessary to meet OSHA requirements;

(x) Workloads placed in the degreaser occupy a horizontal cross-sectional area that is less than one half of the vapor-air interface area;

(xi) The water separator is maintained to prevent water from returning to the surface of the boiling solvent sump or from becoming visibly detectable in the solvent exiting the water separator; and

(xii) Solvent carry-out is minimized by all of the following methods:

(A) racking parts for full drainage;

(B) moving parts in and out of the degreaser at a speed of less than 11 feet per minute (3.3 meters per minute);

(C) cleaning the workload in the vapor zone until condensation ceases;

(D) tipping out any pools of solvent on the cleaned parts before removal; and

(E) not removing parts from the degreaser until they are visually dry.

(xiii) Waste solvent and contaminated residue, if any, shall be recycled, or disposed of according to requirements based on the California Health and Safety Code, Division 20, Chapter 6.5 (beginning at section 25100) concerning hazardous waste disposal.

**(e) CONTROL EQUIPMENT**

(1) In lieu of complying with the equipment requirements in Subsections (d)(1), (d)(2), and (d)(3), an owner/operator may use an airless/air-tight vapor degreaser provided that all of the following requirements are met:

(i) The degreaser is operated in accordance with the manufacturer's specifications and is equipped with a door or other pressure sealing apparatus in place during all cleaning and drying cycles;

(ii) All associated pressure relief devices do not allow liquid solvents to drain out. Spills during any solvent transfer shall be wiped up immediately;

(iii) A differential pressure gauge is installed to indicate the sealed chamber pressure;

(iv) The applicable operating requirements of Subsection (d)(4) are met.

(2) In lieu of complying with the requirements of Subsections (d)(1), (d)(2), and (d)(3), an owner/operator of a vapor degreaser may use an air pollution control system which:

(i) Has been installed in accordance with an Authority to Construct; and

(ii) Has a combined emissions capture and control efficiency of at least 85% by weight.

(3) A person electing to use control equipment pursuant to Subsection (e)(2) shall submit to the Air Pollution Control Officer for approval an Operation and Maintenance plan for the proposed air pollution control system and receive approval prior to operation of the control equipment. Thereafter, the plan can be modified, with Air Pollution Control Officer approval, as necessary to ensure compliance. Such plan shall:

(i) Identify all key system operating parameters. Key system operating parameters are those necessary to ensure compliance with Subsection (e)(2)(ii), such as temperature and/or pressure;

(ii) Include proposed inspection schedules, anticipated ongoing maintenance, and proposed recordkeeping practices regarding the key system operating parameters; and

(iii) Upon approval of the Air Pollution Control Officer, a person subject to the requirements of Subsection (e)(2) shall implement the Operation and Maintenance plan and shall comply with all the provisions of the approved plan.

**(f) RECORD KEEPING REQUIREMENTS**

(1) Any person conducting vapor degreasing operations subject to this rule shall maintain the following records:

(i) A current list of cleaning materials in use, which provides all of the data necessary to evaluate compliance, including but not limited to:

(A) Manufacturer name and identification for each material;

(B) VOC content expressed in g/l (lb/gal) of material as used, and density and mixed ratios for each component; and

(C) Initial boiling point of a cleaning material if a refrigerated freeboard chiller is used.

(2) Any person using control equipment pursuant to Section (e) Control Equipment of this rule shall:

(i) Maintain records in accordance with the requirements of Subsection (f)(1); and

(ii) Maintain daily records of key system operating parameters as approved in the Operation and Maintenance plan pursuant to Subsection (e)(3). Such records shall be sufficient to document continuous compliance with Subsection (e)(2)(ii) during periods of emission producing activities.

All records shall be retained on site for at least three years and shall be made available to the District upon request.

**(g) TEST METHODS**

When more than one test method or set of test methods are specified in this Section, a violation of any requirement of this rule established by any one of the specified test methods or set of test methods shall constitute a violation of the rule.

(1) The VOC content of cleaning materials shall be determined by the South Coast Air Quality Management District (SCAQMD) Method 313-91 (Determination of Volatile Organic Compounds by Gas Chromatography/Mass Spectrometry), February 1997, SCAQMD Method 308-91 (Quantitation of Compounds by Gas Chromatography), February 1993, or any other test methods approved by the Environmental Protection Agency (EPA), California Air Resources Board (CARB), and the Air Pollution Control District.

(2) Measurement of initial boiling point of solvents shall be conducted in accordance with ASTM Standard Test Method D1078-11(2019) (Standard Test Method for Distillation Range of Volatile Organic Liquids), or its most current version.

(3) Hoist speed shall be determined by measuring the distance traveled by the hoist per unit of time.

(4) Temperatures in the vapor zone shall be measured with the use of a properly calibrated temperature probe, with an accuracy of  $\pm 1^\circ \text{F}$ .

(5) The overall control efficiency of air pollution control equipment operated pursuant to Subsection (e)(2)(ii) shall be determined by multiplying the capture efficiency of the emission collection system by the control efficiency of the air pollution control device. The control efficiency of the air pollution control device shall be

determined using EPA Test Methods 18 and 25A (40 CFR 60, Appendix A), August 2017; and in accordance with a protocol approved by the Air Pollution Control Officer. Capture efficiency shall be determined according to EPA Test Methods 204 and 204A through 204F (40 CFR Part 51, Appendix M) as applicable, August 2017; and technical document “Guidelines for Determining Capture Efficiency,” January 1995. Subsequent to the initial compliance demonstration period, appropriate key system operating parameters as determined by the Air Pollution Control Officer may be used as indicators of the performance of the emission control system.

**(h) COMPLIANCE SCHEDULE**

All new vapor degreasing operations shall comply with the applicable requirements of this rule upon initial startup.