### Chapter NR 257

### **ALUMINUM FORMING**

NR 257.01 NR 257.02	Purpose		control technology currently
NR 257.03	Applicability General definitions	NR 257.33	available Effluent limitations represent-
NR 257.04	Monitoring and reporting re-		ing the degree of effluent re-
NR 257.05	quirements Compliance dates		duction attainable by the ap- plication of the best available
NR 257.06	Removal allowances for pre- treatment standards		technology economically achievable
Subchapter 1	-Rolling With Neat Oils	NR 257.34	New source performance stan-
Subcategory NR 257.10	Applicability; description of	NR 257.35	dards Pretreatment standards for
1110 201.10	the rolling with neat oils sub-	NID 057 96	existing sources
NR 257.11	category Specialized definitions	NR 257.36	Pretreatment standards for new sources
NR 257.12	Effluent limitations represent-	Subchapter l	V—Forging Subcategory
	ing the degree of effluent limi-	NR 257.40	Applicability; description of
	tations attainable by applica- tion of the best practicable	NR 257.41	the forging subcategory Specialized definitions
	control technology currently	NR 257.44	New source performance stan-
NR 257.13	available Effluent limitations represent-	NR 257.45	dards Pretreatment standards for
	ing the degree of effluent re-	3TD 055 40	existing sources
	duction attainable by the ap- plication of the best available	NR 257.46	Pretreatment standards for new sources
	technology economically	Subchanter V	W—Drawing With Neat Oils
NR 257.14	achievable New source performance stan-	Subcategory	
	dards	NR 257.50	Applicability; description of the drawing with neat oils sub-
NR 257.15	Pretreatment standards for existing sources		category
NR 257.16	Pretreatment standards for	NR 257.51 NR 257.52	Specialized definitions Effluent limitations represent-
	new sources	1410 201.02	ing the degree of effluent limi-
Subchapter I Subcategory	I—Rolling With Emulsions		tations attainable by applica-
NR 257.20	Applicability; description of		tion of the best practicable control technology currently
	the rolling with emulsions sub- category	NR 257.53	available Effluent limitations represent-
NR 257.21	Specialized definitions	N1C 201.00	ing the degree of effluent re-
NR 257.22	Effluent limitations represent-		duction attainable by the ap-
	ing the degree of effluent limi- tations attainable by applica-		plication of the best available technology economically
	tion of the best practicable	NID OFFE	achievable
	control technology currently available	NR 257.54	New source performance stan- dards
NR 257.23	Effluent limitations represent-	NR 257.55	Pretreatment standards for
	ing the degree of effluent re- duction attainable by the ap-	NR 257.56	existing sources Pretreatment standards for
	plication of the best available		new sources
	technology economically achievable		/I—Drawing With Emulsions or
NR 257.24	New source performance stan-	Soaps Subca NR 257.60	tegory Applicability; description of
NR 257.25	dards Pretreatment standards for	1120	the drawing with emulsions or
	existing sources	NR 257.61	soaps subcategory Specialized definitions
NR 257.26	Pretreatment standards for new sources	NR 257.62	Effluent limitations represent-
Subchanter I	II—Extrusion Subcategory		ing the degree of effluent limi- tations attainable by applica-
NR 257.30	Applicability; description of		tion of the best practicable
NR 257.31	the extrusion subcategory Specialized definitions		control technology currently available
NR 257.32	Effluent limitations represent-	NR 257.63	Effluent limitations represent-
	ing the degree of effluent limi-		ing the degree of effluent re-
	tations attainable by applica- tion of the best practicable		duction attainable by the ap- plication of best available
	•	Reg	ister, November, 1989, No. 407
			•

NR 257

technology economically NR 257.65 Pretreatment standards for existing sources

NR 257.64 New source performance standards

NR 257.66 Pretreatment standards for new sources

NR 257.01 Purpose. The purpose of this chapter is to establish effluent limitations, performance standards, and pretreatment standards for the discharge of process wastes from the aluminum forming point source category and its subcategories.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

- NR 257.02 Applicability. (1) This chapter applies to any aluminum forming facility which discharges or may discharge pollutants to waters of the state or which introduces or may introduce pollutants into a publicly owned treatment works.
- (2) This chapter applies to chemical or electrochemical treatments applied to the surface of the aluminum when these surface treatments are performed at aluminum forming site. When these surface treatments are not performed at the aluminum forming site, regulations for electroplating, ch. NR 260, or metal finishing, ch. NR 261, apply.
- (3) This chapter applies to aluminum casting when the casting is performed as an integral part of aluminum forming and is located at the aluminum forming site. When aluminum forming is performed on the same site as primary aluminum reduction, this chapter applies if the aluminum cools prior to casting. If the aluminum does not cool prior to casting, the regulations for nonferrous metals manufacturing, ch. NR 274, apply.

NR 257.03 General definitions. In addition to the definitions set forth in ss. NR 205.03, 205.04, and 211.03, the following definitions apply to the terms used in this chapter:

- (1) "Aluminum forming" means a set of manufacturing operations in which aluminum and aluminum alloys are made into semifinished products by hot or cold working, such as rolling, drawing, extruding, and forging, and related operations such as heat treatment and casting.
- (2) "Ancillary operation" means a manufacturing operation that has a large flow, discharges significant amounts of pollutants, and may not be present at every plant in a subcategory but when present is an integral part of the aluminum forming process.
- (3) "Cleaning or etching operation" means a chemical solution bath and rinse or series of rinses designed to produce a desired surface finish on the workpiece, including conversion coating and anodizing when performed as an integral part of the aluminum forming operations, and the air pollution scrubbers used to control fumes from the chemical solution baths.
- (4) "Contact cooling water" means any wastewater which contacts the aluminum workpiece or the raw materials used in aluminum forming.
- (5) "Continuous casting" means the production of sheet, rod, or other long shapes by solidifying the metal while it is being poured through an open ended mold using little or no contact cooling water.

- (6) "Degassing" means the removal of dissolved hydrogen from the molten aluminum prior to casting by adding chemicals and bubbling gases through the molten aluminum.
- (7) "Direct chill casting" means an operation in which molten aluminum is poured into a water cooled mold, contact cooling water is sprayed onto the aluminum as the aluminum is dropped into the mold, and the aluminum ingot falls into a water bath at the end of the process.
- (8) "Drawing" means the process of pulling metal through a die or succession of dies to reduce the metal's diameter or alter its shape, using either neat oils, emulsions, or soap solutions as a lubricant.
- (9) "Emulsion" means a stable dispersion of 2 immiscible liquids, usually oil and water.
- (10) "Existing source" means any point source from which pollutants may be discharged either directly into the waters of the state or into a POTW, except a new source as defined in sub. (18).
- (11) "Extrusion" means the application of pressure to a billet of aluminum to force the aluminum to flow through a die orifice.
- (12) "Forging" means the exertion of pressure on dies or rolls surrounding heated aluminum stock to force the stock to change shape and, when dies are used, to take the shape of the die.
- (13) "Heat treatment" means the application of heat of specified temperature and duration to change the physical properties of the metal.
- (14) "Hot water seal" means a water bath heated to approximately 180° F used to seal the surface coating on formed aluminum which has been anodized and coated.
- (15) "lb/million off-lbs" means pounds of pollutant introduced into the wastestream per million pounds of aluminum or aluminum alloy removed from a forming or ancillary operation at the end of a process cycle for transfer to a different machine or process.
- (16) "mg/off-kg" means milligrams of pollutant introduced into the wastestream per kilogram of aluminum or aluminum alloy removed from a forming or ancillary operation at the end of a process cycle for transfer to a different machine or process.
- (17) "Neat oil" means an oil used as a lubricant with few or no added impurities.
- (18) "New source" means any point source for which construction commenced after November 22, 1982 and from which pollutants may be discharged either directly into waters of the state or into a publicly owned treatment works.
- (19) "Rolling" means the reduction in thickness or diameter of a workpiece by passing it between rollers lubricated with either neat oils or emulsions.
- (20) "Stationary casting" means the pouring of molten aluminum into molds and allowing the metal to air cool.

NR 257

(21) "TTO" means the sum of the masses or concentrations of each of the following toxic organic compounds which is found in the discharge at a concentration greater than 0.010 mg/1:

p-chloro-m-cresol tetrachloroethylene 2-chlorophenol toluene 2.4-dinitrotoluene trichloroethylene 1.2-diphenylhydrazine endosulfan sulfate ethylbenzene bis(2-ethyl hexyl) phthalate fluoranthene diethylpthalate isophorone 3,4-benzofluoranthene napthalene benzo(k)fluoranthene N-nitrosodiphenylamine chrysene phenol acenaphthylene benzo(a)pyrene anthracene benzo(ghi)perylene di-n-butyl phthalate fluorene endrin phenanthrene endrin aldehyde PCB-1242, 1254, 1221, 1232, 1248, 1260, 1016 dibenzo(a,h)anthracene indeno(1,2,3-c,d)pyrene pyrene acenaphthene

(22) "Wet scrubber" means an air pollution control device used to remove particulates and fumes from air by entraining the pollutants in a water spray.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.04 Monitoring and reporting requirements. The following special monitoring and reporting requirements apply to all facilities subject to this chapter:

- (1) Analyses for cyanide are not required when both of the following conditions are met:
- (a) The first wastewater sample of the calendar year has been analyzed and found to contain less than 0.07 mg/1.
- (b) The owner or operator of the aluminum forming facility certifies in writing to the department or control authority that cyanide is not and will not be used in the aluminum forming process.
- (2) As an alternative pretreatment monitoring procedure, the POTW user may measure and limit oil and grease to the levels shown in the pretreatment standards in lieu of measuring and regulating TTO.
- (3) Compliance with the maximum monthly average effluent limitations and pretreatment standards is required regardless of the number of samples analyzed and averaged. The maximum monthly average effluent limitations and pretreatment standards shall be the basis for monthly average discharge limits in direct discharge permits and for pretreatment standards.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.05 Compliance dates. (1) Any existing source subject to this chapter which discharges to waters of the state shall achieve;

- (a) the effluent limitations representing BPT by July 1, 1977; and
- (b) the effluent limitations representing BAT by July 1, 1984.

Register, November, 1989, No. 407

- (2) Any new source subject to this chapter which discharges to waters of the state shall achieve NSPS at the commencement of discharge.
- (3) Any existing source subject to this chapter which discharges process wastewater pollutants to a POTW shall achieve PSES by October 24, 1986.
- (4) Any new source subject to this chapter which discharges process wastewater pollutants to a POTW shall achieve PSNS at the commencement of discharge.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.06 Removal allowances for pretreatment standards. Removal allowances for pretreatment standards pursuant to s. NR 211.13 may be granted for the toxic metals limited by this chapter when the toxic metals are used as indicator pollutants.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

### Subchapter I — Rolling With Neat Oils Subcategory

NR 257.10 Applicability; description of the rolling with neat oils subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary rolling with neat oils operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

- NR 257.11 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:
- (1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the rolling operation, such as continuous rod casting, continuous sheet casting, solution heat treatment, and cleaning or etching.
- (2) "Core operation" means rolling using neat oils, roll grinding, sawing, annealing, stationary casting, homogenizing, artificial aging, degreasing, and stamping.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.12 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

#### 228-66 NR 257

### WISCONSIN ADMINISTRATIVE CODE

Table 1 Core with an annealing furnace scrubber BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.0360	0.0147
Cyanide	0.0237	0.0098
Zinc	0.119	0.0498
Aluminum	0.525	0.257
Oil and grease	1.634	0.980
Suspended solids	3,348	1.593
pН	(1)	(1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

## Table 2 Core without an annealing furnace scrubber RPT

	DII	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rolled with neat oils	
Chromium	0.0244	0.010
Cyanide	0.0161	0.0067
Zinc	0.0808	0.0338
Aluminum	0.356	0.174
Oil and grease	1.11	0.664
Suspended solids	2.27	1.079
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

### Table 3 Continuous sheet casting spent lubricant BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•		/million off-lbs) t by continuous methods
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids	0.00086 0.00057 0.0029 0.0127 0.0393 0,805	0.00035 0.00024 0.0012 0.0063 0.0236 0,0383

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

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Table 4
Solution heat treatment contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of alumin	/million off-lbs) im quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zinc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	<b>154.10</b>	92.46
Suspended solids pH	315.91	150.25

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 5 Cleaning or etching bath BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.079 0.052 0.262 1.15 3.58 7.34 (1)	0.032 0.022 0.110 0.573 2.15 3.49

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 6
Cleaning or etching rinse and hot water seal
BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	6.12	2.51
Cyanide Zinc	4.04 20.31	1.67 8.49
Aluminum	89.46	44.52
Oil and grease	278.24	166.95
Suspended solids pH	<b>570.39</b>	$271.29 \atop \tiny \binom{1}{1}$

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 7
Cleaning or etching scrubber liquor

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	7.00	2.86
Cyanide Zinc	$4.61 \\ 23.22$	1.91 9.70
Aluminum Oil and grease	102.24 318.00	50.88 190.80
Suspended solids pH	651.90 (1)	310.05 (1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.13 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

Table 8
Core with an annealing furnace scrubber

	ESZAL	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rolled with neat oils	
Chromium Cyanide Zinc Aluminum	0.036 0.024 0.119 0.525	0.015 0.0098 0.050 0.257

Table 9
Core without an annealing furnace scrubber
BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rolled with neat oils	
Chromium Cyanide Zinc Aluminum	0.025 0.016 0.081 0.356	0.010 0.0067 0.034 0.174

Table 10 Continuous sheet casting spent lubricant

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum sheet cast	
Chromium Cyanide Zinc Aluminum	0.00086 0.00057 0.00287 0.0127	0.00035 0.00024 0.0012 0.0062

NR 257

Table 11 Solution heat treatment contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) am quenched
Chromium	0.897	0.367
Cvanide	0.591	0.245
Zine	2.974	1.243
Aluminum	13.10	6.518

### Table 12 Cleaning or etching bath BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zinc	0.262	0.109
Aluminum	1.151	0.573

### Table 13 Cleaning or etching rinse and hot water seal BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.612	0.251
Cyanide	0.404	0.167
Zinc	2.031	0.849
Aluminum	8.944	4.450

### Table 14 Cleaning or etching scrubber liquor BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide	0.851 0.561	0.348 0.232
Zinc Aluminum	2.822 12.43	$1.179 \\ 6.186$

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.14 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

#### 228-70 NR 257

### WISCONSIN ADMINISTRATIVE CODE

Table 15 Core with an annealing furnace scrubber NSPS

1101 0		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.030	0.0123
Cvanide	0.016	0.0065
Zinc	0.084	0.0343
Aluminum	0.499	0.221
Oil and grease	0.817	0.817
Suspended solids	1.225	0,980
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 16 Core without an annealing furnace scrubber NSPS

	TIDEO	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum rolled with neat oils	
Chromium	0.021	0.0083
Cyanide	0.011	0.0044
Zine	0.057	0.023
Aluminum	0.338	0.150
Oil and grease	0.553	0.553
Suspended solids	0.830	0,664
pH	(1)	(1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

### Table 17 Continuous sheet casting spent lubricant NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) inum cast
Chromium	0.00073	0.00029
Cyanide	0.00039	0.00016
Zinc	0.0020	0.00082
Aluminum	0.012	0.0053
Oil and grease	0.0197	0.019
Suspended solids	0.0295	0.022
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

### DEPARTMENT OF NATURAL RESOURCES

228-71 NR 257

Table 18 Solution heat treatment contact cooling water NSPS

11020	
Maximum for any 1 day	Maximum for monthly average
mg/off-kg (lb of alumin	/million off-lbs) um quenched
0.76 0.41 2.08 12.45 20.37 30,56	0.31 0.17 0.86 5.52 20.37 24,45
	Maximum for any 1 day mg/off-kg (lb of alumint 0.76 0.41 2.08 12.45 20.37

Within the range of 7.0 to 10 at all times.

Table 19 Cleaning or etching bath NSPS

	NOLO	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.066	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0.485
Oil and grease	1.79	1.79
Suspended solids pH	$\overset{2.69}{\overset{(1)}{}}$	$2.15\atop {\tiny (1)}$

Within the range of 7.0 to 10 at all times.

Table 20 Cleaning or etching rinse and hot water seal NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1.42	0.59
Aluminum	8.50	3.70
Oil and grease	13.91	13.91
Suspended solids pH	<b>20.87</b>	$\overset{16.69}{\overset{(1)}{}}$

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 21 Cleaning or etching scrubber liquor NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.715	0.29
Cyanide	0.387	0.16
Zinc	1.97	0.81
Aluminum	11.81	5.24
Oil and grease	19.33	19.33
Suspended solids	29,00	23.20
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.15 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

Table 22 Core with an annealing furnace scrubber PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium Cyanide	0.036 0.024	0.015 0.010
Zinc TTO	0.119 0.057	0.050
Oil and grease (alternate monitoring parameter)	4.30	2.10

Table 23 Core without an annealing furnace scrubber **PSES** 

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.025	0.010
Cvanide	0.016	0.007
Zinc	0.081	0.034
TTO	0.038	
Oil and grease (alternate monitoring parameter)	2.90	1.50

Table 24 Continuous sheet casting lubricant PSES

	_ ~_~	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) inum cast
Chromium Cyanide Zinc TTO	0.00086 0.00057 0.0029 0.0014	0.00035 0.00024 0.0012
Oil and grease (alternate monitoring parameter)	0.100	0.052

### Table 25 Solution heat treatment contact cooling water PSES

	1010	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) am quenched
Chromium Cyanide Zinc TTO	0.90 0.59 2.98 1.41	0.37 0.25 1.25
Oil and grease (alternate monitoring parameter)	110.0	53.0

### Table 26 Cleaning or etching bath PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
<del>-</del>	mg/off-kg (lb	/million off-lbs) cleaned or etched
Chromium Cyanide Zinc TTO	0.079 0.052 0.262 0.124	0.0032 0.022 0.109
Oil and grease (alternate monitoring parameter)	9.30	4.70

### Table 27 Cleaning or etching rinse and hot water seal PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc	0.61 0.41 2.03	0.25 0.17 0.85
TTO Oil and grease (alternate monitoring parameter)	0.96 73.0	36.0

Table 28
Cleaning or etching scrubber liquor
PSES

1010	
Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) cleaned or etched
0.85	0.35
0.56	0.23
2.82	1.18
1.34	
100.0	50.0
	Maximum for any 1 day mg/off-kg (lb of aluminum of 0.85 0.56 2.82 1.34

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.16 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

Table 29
Core with an annealing furnace scrubber
PSNS

Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	monthly average
	mg/off-kg (lb of aluminum ro	/million off-lbs) lled with neat oils
Chromium	0.030	0.013
Cvanide	0.017	0.007
Zinc	0.084	0.035
TTO	0.057	
Oil and grease (alternate monitoring parameter)	0.817	0.817

Table 30 Core without an annealing furnace scrubber PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum with neat oils	
Chromium	0.021	0.009
Cyanide	$0.0\overline{11}$	0.005
Zine	0.057	0.024
TTO	0.038	
Oil and grease (alternate monitoring parameter)	0.54	0.54

### DEPARTMENT OF NATURAL RESOURCES

NR 257

Table 31 Continuous sheet casting lubricant PSNS

	_ · · · · · · · · · · · · · · · · · · ·	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of alum	/million off-lbs) inum cast
Chromium	0.00073	0.00029
Cyanide	0.00039	0.00016
Zinc	0.0020	0.00082
TTO	0.0014	
Oil and grease (alternate monitoring parameter)	0.020	0.020

Table 32
Solution heat treatment contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) im quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
TTO	1.41	
Oil and grease (alternate monitoring parameter)	20.37	20.37

Table 33
Cleaning or etching bath
PSNS

•		
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	0.067	0.027
Cyanide	0.036	0.015
Zinc TTO	0.183 0.124	0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

Table 34 Cleaning or etching rinse and hot water seal PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum o	/million off-lbs) eleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1.42	0.59
TTO	0.96	
Oil and grease (alternate monitoring parameter)	13.91	13.91

Table 35
Cleaning or etching scrubber liquor
PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs)
Chromium	0.72	0.29
Cyanide	0.39	0.16
Zinc	1.97	0.81
TTO	1.34	
Oil and grease (alternate monitoring parameter)	19.33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

### Subchapter II — The Rolling With Emulsions Subcategory

NR 257.20 Applicability; description of the rolling with emulsions subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary rolling with emulsions operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.21 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

- (1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the rolling operation, such as direct chill casting, solution heat treatment, cleaning or etching, and degassing.
- (2) "Core operation" means rolling using emulsions, roll grinding, stationary casting, homogenizing, artificial aging, annealing, and sawing.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.22 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

Table 36 Core operation BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rolled with emulsions	
Chromium Cyanide	0.057 0.038	0.024 0.016
Zinc	0.19	0.079
Aluminum Oil and grease	0.84 2.60	0.416 1.56
Suspended solids pH	5.33	2.53

Within the range of 7.0 to 10 at all times.

NR 257

Table 37
Direct chill casting contact cooling water
BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•		/million off-lbs) inum cast
Chromium	0.59	0.24
Cyanide	0.39	0.16
Zinc	1.94	0.81
Aluminum	8.55	4.26
Oil and grease	26.58	15.95
Suspended solids	54.49	25.92
pH	(1)	(1)

 $<sup>^{\</sup>mathrm{I}}$  The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without commingling with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

Table 38
Solution heat treatment contact cooling water
BPT

	EDE E	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) ım quenched
Chromium	3.39	0.39
Cyanide	2.24	0.93
Zine	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids	315,91	150,25
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 39 Cleaning or etching bath RPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zinc	0.262	0.109
Aluminum	1.15	0.573
Oil and grease	<b>3.5</b> 8	2.15
Suspended solids pH	$7.34_{(1)}$	$3.49 \atop \stackrel{(1)}{\scriptscriptstyle{(1)}}$

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 40 Cleaning or etching rinse and hot water seal RPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide	6.12 4.04	2.51 1.67
Zinc Aluminum	20.31 89.46	8.49 44.52
Oil and grease Suspended solids pH	$278.24 \\ 570.39 \\ {}_{\binom{1}{1}}$	$166.95 \\ 271.29 \\ {}_{\binom{1}{1}}$

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 41 Cleaning or etching scrubber liquor BPT

	1)1 I	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	7.00	2.86
Cyanide	4.61	1.91
Zinc	23.22	9.70
Aluminum	102.24	50.88
Oil and grease	318.00	190.80
Suspended solids pH	651.90 (1)	$310.05 \atop \stackrel{(1)}{\scriptscriptstyle (1)}$

Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.23 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

Table 42 Core operation BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rolled with emulsions	
Chromium	0.057	0.024
Cyanide	0.038	0.016
Zinc	0.19	0.079
Aluminum	0.8 <del>4</del>	0.42

### DEPARTMENT OF NATURAL RESOURCES

228-79 NR 257

Table 43 Direct chill casting contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•	mg/off-kg (lb/million off-lbs) of aluminum cast	
Chromium	0.59	0.24
Cyanide	0.39	0.16
Zinc	1.94	0.81
Aluminum	8.55	4.26

### Table 44 Solution heat treatment contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
·		/million off-lbs) im quenched
Chromium	0.90	0.37
Cyanide	0.59	0.25
Zinc	2.98	1.25
Aluminum	13.10	6.52

### Table 45 Cleaning or etching bath BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc Aluminum	0.079 0.052 0.26 1.15	0.032 0.022 0.109 0.573

### Table 46 Cleaning or etching rinse and hot water seal BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) cleaned or etched
Chromium Cyanide Zinc Aluminum	0.61 0.41 2.03 8.95	0.25 0.17 0.85 4.45

Table 47 Cleaning or etching scrubber liquor

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) eleaned or etched
Chromium	0.85	0.35
Cyanide	0.56	0.23
Zinc	2.82	1.18
Aluminum	12.43	6.19

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.24 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

Table 48 Core operation NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum rol	/million off-lbs) led with emulsions
Chromium	0.048	0.020
Cyanide	0.026	0.011
Zinc	0.133	0.055
Aluminum	0.80	0.35
Oil and grease	1.30	1.30
Suspended solids	1.95	1.56
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 49
Direct chill casting contact cooling water
NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum cast b	/million off-lbs) y continuous methods
Chromium	0.49	0.20
Cyanide	0.27	0.11
Zinc	1.36	0.56
Aluminum	8.12	3.60
Oil and grease	13.29	13.29
Suspended solids	19,94	15,95
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without commingling with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

NR 257

Table 50
Solution heat treatment contact cooling water NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of alumin	/million off-lbs) um quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
Aluminum	12.45	5.52
Oil and grease	20.37	20.37
Suspended solids	30,56	24,45
pH	(1)	(1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 51 Cleaning or etching bath NSPS

	11010	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	0.067	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0.485
Oil and grease	1.79	1.79
Suspended solids	2,69	$2.15_{\binom{1}{1}}$
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 52 Cleaning or etching rinse and hot water seal NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1.42	0.59
Aluminum	8.50	3.77
Oil and grease	13.91	13.91
Suspended solids pH	$20.87_{\tiny (1)}$	$\overset{16.70}{\overset{(1)}{\scriptstyle{(1)}}}$

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 53 Cleaning or etching scrubber liquor NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc Aluminum	0.72 0.39 1.97 11.81	0.29 0.16 0.81 5.24
Oil and grease Suspended solids pH	19.33 29.00 (1)	19.33 23.20 (1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.25 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

Table 54 Core operation PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum rol	/million off-lbs) led with emulsions
Chromium	0.057	0.024
Cyanide	0.038	0.016
Zinc TTO	0.190 0.090	0.079
Oil and grease (alternate monitoring parameter)	6.80	3.40

Table 55
Direct chill casting contact cooling water
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•	mg/off-kg (lb of aluminum cast by s	/million off-lbs) semicontinuous methods
Chromium Cyanide Zinc	0.59 0.39 1.94	0.24 0.16 0.81
TTO Oil and grease (alternate monitoring parameter)	0.92 69.0	35.0

NR 257

Table 56
Solution heat treatment contact cooling water
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) im quenched
Chromium	0.90	0.37
Cyanide	0.59	0.25
Zinc	2.98	1.25
TTO	1.41	
Oil and grease (alternate monitoring parameter)	110.0	53.0

## Table 57 Cleaning or etching bath PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs)
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zinc	0.262	0.109
TTO	0.124	
Oil and grease (alternate monitoring parameter)	9.30	4.70

### Table 58 Cleaning or etching rinse and hot water seal PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) eleaned or etched
Chromium	0.61	0.25
Cyanide	0.41	0.17
Zinc	2.03	0.85
TTO	0.96	
Oil and grease (alternate monitoring parameter)	73.0	36.0

## Table 59 Cleaning or etching scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium Cyanide	0.85 0.56	0.35 0.23
Zinc TTO	2.83 1.34	1.18
Oil and grease (alternate monitoring parameter)	100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.26 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which in-

troduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:  $\frac{1}{2}$ 

Table 60 Core operation PSNS

	1 0110	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rolled with emulsions	
Chromium Cyanide	0.048 0.026	0.020 0.011
Zine TTO	0.133 0.090	0.055
Oil and grease (alternate monitoring parameter)	1.30	1.30

## Table 61 Direct chill casting contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cast by semicontinuous methods	
Chromium Cvanide	0.49 0.27	0.20 0.11
Zinc	1.36	0.56
TTO Oil and grease (alternate monitoring parameter)	0.92 13.29	13.29

# Table 62 Solution heat treatment contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zine	2.08	0.86
TTO	1.41	
Oil and grease (alternate monitoring parameter)	20.37	20.37

# Table 63 Cleaning or etching bath PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	0.067	0.027
Cyanide	0.036	0.015
Zinc TTO	0.183 0.12 <del>4</del>	0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

Table 64
Cleaning or etching rinse and hot water seal
PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zine	1.42	0.59
TTO	0.96	
Oil and grease (alternate monitoring parameter)	13.91	13.91

## Table 65 Cleaning or etching scrubber liquor PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.72	0.29
Cyanide	0.39	0.16
Zinc	1.97	0.81
TTO	1.34	
Oil and grease (alternate monitoring parameter)	19.33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

### Subchapter III — The Extrusion Subcategory

NR 257.30 Applicability; description of the extrusion subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary extrusion operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.31 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

- (1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the extrusion operation, such as direct chill casting, press or solution heat treatment, cleaning or etching, degassing, and extrusion press hydraulic fluid leakage.
- (2) "Core operation" means extrusion die cleaning, any wet scrubber associated with the die cleaning, dummy block cooling, stationary casting, artificial aging, annealing, degreasing, and sawing.
- (3) "Extrusion die cleaning" means an operation in which the steel dies used for aluminum extrusion are cleaned by dipping the dies into a concentrated caustic bath to dissolve the aluminum and then rinsing the dies with water.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.32 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology cur-

228-86

NR 257

rently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

Table 66 Core operation BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum extruded	
Chromium	0.16	0.066
Cyanide	0.11	0.044
Zinc	0.53	0.22
Aluminum	2.34	1.16
Oil and grease	7.32	4.39
Suspended solids	15,00	7.13
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 67 Extrusion press leakage BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb/million off-lbs) of aluminum extruded	
Chromium	0.65	0.27
Cyanide	0.43	0.18
Zinc	2.16	0.90
Aluminum	9.51	4.73
Oil and grease	29.56	17.74
Suspended solids pH	60.60 (1)	$\overset{\textbf{28.82}}{\overset{(1)}{}}$

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 68
Direct chill casting contact cooling water
BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
-		/off-kg (lb/million off-lbs) of aluminum cast	
Chromium	0.59	0.24	
Cyanide	0.39	0.16	
Zinc	1.94	0.81	
Aluminum	8.55	4.26	
Oil and grease	26.58	15.95	
Suspended solids	54,49	25.92	
pH	(1)	(1)	

<sup>&</sup>lt;sup>1</sup> The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without commingling with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

### DEPARTMENT OF NATURAL RESOURCES

Table 69 Press heat treatment contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (ll of alumin	o/million off-lbs) um quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zinc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids pH	315.91 (1)	150.25

Within the range of 7.0 to 10 at all times.

Table 70 Solution heat treatment contact cooling water BPT

	101 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) im quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zinc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids	315,91	150,25
pН	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 71 Cleaning or etching bath **BPT** 

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zinc	0.26	0.109
Aluminum	1.15	0.573
Oil and grease	3.58	2.15
Suspended solids pH	$7.34 \atop {\scriptstyle (1)}$	3.49

Within the range of 7.0 to 10 at all times.

Table 72 Cleaning or etching rinse and hot water seal

	131 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	6.12	2.51
Cyanide	4.04	1.67
Zinc	20.31	8.49
Aluminum	89.46	44.52
Oil and grease	278.24	166.95
Suspended solids pH	$570.39 \atop {\tiny (1)}$	$271.29 \atop \scriptscriptstyle (1)$

Within the range of 7.0 to 10 at all times.

Table 73 Cleaning or etching scrubber liquor RPT

	IN I	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	7.00 4.61 23.22 102.24 318.00 651,90	2.86 1.91 9.70 50.88 190.80 310,05

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 74
Degassing scrubber liquor
BPT

	AJ1 X	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum degassed	
Chromium	1.15	0.47
Cyanide	0.76	0.32
Zinc Aluminum	3.81 16.78	1.59 8.35
Oil and grease	52.18	31.31
Suspended solids pH	$\substack{\textbf{106.97} \\ (1)}$	<b>50.88</b>

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.33 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except a provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT. Degassing operations may not discharge wastewater pollutants.

NR 257

### Table 75 Core operation BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		o/million off-lbs) .um extruded
Chromium	1.7	0.7
Cyanide	1.2	0.5
Zinc	5.7	2.4
Aluminum	25.0	13.0

### Table 76 Extrusion press leakage BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
,		/million off-lbs) um extruded
Chromium	0.65	0.27
Cyanide	0.43	0.18
Zinc	2.16	0.90
Aluminum	9.51	4.73

# Table 77 Direct chill casting contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•		/million off-lbs) inum cast
Chromium	0.59	0.24
Cyanide	0.39	0.16
Zinc	1.94	0.81
Aluminum	8.55	4.26

## Table 78 Press heat treatment contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium Cyanide Zinc Aluminum	0.90 0.59 2.98 13.10	0.37 0.25 1.25 6.52

# Table 79 Solution heat treatment contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.90	0.37
Cyanide	0.59	0.25
Zinc	2.98	1.25
Aluminum	13.10	6.52

Table 80 Cleaning or etching bath

BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) leaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zinc	0.262	0.109
Aluminum	1.15	0.58

Table 81 Cleaning or etching rinse and hot water seal

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide	1.7 1.2	0.7 0.5
Zinc Aluminum	$5.7 \\ 25.0$	$\begin{array}{c} 2.4 \\ 13.0 \end{array}$

Table 82 Cleaning or etching scrubber liquor

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.85	0.35
Cyanide	0.56	0.23
Zinc	2.82	1.18
Aluminum	12.43	6.19

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.34 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards. Degassing operations may not discharge wastewater pollutants.

Table 83 Core operation NSPS

Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) ım extruded
0.13	0.051
0.068	0.027
0.35	0.14
2.07	0.92
3.39	3.39
$5.10_{(1)}$	<b>4.07</b>
	any 1 day mg/off-kg (lb of alumin 0.13 0.068 0.35 2.07 3.39

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 84 Extrusion press leakage NSPS

	11010	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um extruded
Chromium	0.11	0.045
Cyanide	0.060	0.024
Zinc	0.31	0.126
Aluminum	1.82	0.81
Oil and grease	2.98	2.98
Suspended solids	4.47	3.58
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 85 Direct chill casting contact cooling water

	Nors	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum cast by	o/million off-lbs) semicontinuous methods
Chromium	0.49	0.20
Cyanide	0.27	0.11
Zinc	1.36	0.56
Aluminum	8.12	3.60
Oil and grease	13.29	13.29
Suspended solids	19.94	15,95
pH	(1)	(1)

 $<sup>^1</sup>$  The pH shall be maintained within the range of 7.0 to 10.0 at all times, except for those situations when this waste stream is discharged separately and without commingling with any other wastewater, in which case the pH shall be within the range of 6.0 to 10.0 at all times.

Table 86 Press heat treatment contact cooling water **NSPS** 

	11020	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) im quenched
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.76 0.41 2.08 12.45 20.37 30.56 (1)	0.31 0.17 0.86 5.52 20.37 24.45 (1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

### 228-92 NR 257

### WISCONSIN ADMINISTRATIVE CODE

Table 87 Solution heat treatment contact cooling water NSPS

Maximum for any 1 day	Maximum for monthly average
mg/off-kg (lb of aluminu	/million off-lbs) im quenched
0.76	0.31
	0.17 0.86
12.45	5.52
30.56 (1)	$20.37 \\ 24.45 \\ \stackrel{(1)}{\stackrel{(1)}{1}}$
	any 1 day mg/off-kg (lb of alumint 0.76 0.41 2.08 12.45 20.37

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

# Table 88 Cleaning or etching bath NSPS

Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) cleaned or etched
0.067 0.036 0.183 1.094 1.79 2.69	0.027 0.015 0.075 0.485 1.79 2.15
	any 1 day  mg/off-kg (lb of aluminum of 0.067 0.036 0.183 1.094 1.79

<sup>1</sup> Within the range of 7.0 to 10 at all times.

### Table 89 Cleaning or etching rinse and hot water seal NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•		/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1.42	0.59
Aluminum	8.50	3.77
Oil and grease	13.91	13.91
Suspended solids	20,87	16,70
pΗ	(1)	(1)

Within the range of 7.0 to 10 at all times.

### DEPARTMENT OF NATURAL RESOURCES

NR 257

Table 90 Cleaning or etching scrubber liquor NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.72 0.39 1.97 11.81 19.33 29.00	0.29 0.16 0.81 5.24 19.33 23.20

<sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.35 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources. Degassing operations may not discharge wastewater pollutants.

Table 91 Core operation PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) um extruded
Chromium	0.15	0.061
Cyanide	0.098	0.041
Zinc	0.49	0.21
TTO	0.23	
Oil and grease (alternate monitoring parameter)	18.0	8.8

### Table 92 Extrusion press leakage PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of alumin	/million off-lbs) ım extruded
Chromium	0.65	0.27
Cyanide	0.43	0.18
Zinc TTO	2.16 1.02	0.90
Oil and grease (alternate monitoring parameter)	77.0	39.0

Table 93
Direct chill casting contact cooling water
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum cast	
Chromium Cyanide	0.59 0.39	0.24 0.16
Zinc TTO	1.94 0.92	0.81
Oil and grease (alternate monitoring parameter)	69.0	35.0

Table 94
Press heat treatment contact cooling water
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) im quenched
Chromium Cyanide Zinc TTO	0.90 0.59 2.98 1.41	0.37 0.25 1.25
Oil and grease (alternate monitoring parameter)	110.0	53.0

Table 95
Solution heat treatment contact cooling water PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of alumin	/million off-lbs) ım quenched
Chromium Cvanide	0.90 0.59	0.37 0.25
Zinc TTO	2.98 1.41	1.25
Oil and grease (alternate monitoring parameter)	110.0	53.0

### Table 96 Cleaning or etching bath PSES

Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	<u>mon</u> thly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
<u>-</u>		
Chromium	0.079	0.032
Cvanide	0.052	0.022
Zinc	0.26	0.109
TTO	0.124	
Oil and grease (alternate monitoring parameter)	9.30	4.70

NR 257

Table 97 Cleaning or etching rinse and hot water seal PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	1.7	0.7
Cyanide	1.2	0.5
Zinc	5.7	2.4
TTO	2.7	
Oil and grease (alternate monitoring parameter)	200.0	100.0

#### Table 98 Cleaning or etching scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.85	0.35
Cyanide Zinc	$0.56 \\ 2.82$	$0.23 \\ 1.18$
TTO	1.34	<b>**</b> 0.0
Oil and grease (alternate monitoring parameter)	100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.36 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources. Degassing operations may not discharge wastewater pollutants.

Table 99 Core operation PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum extruded	
Chromium Cyanide	0.13 0.07	0.05 0.03
Zine TTO	0.35 0.24	0.15
Oil and grease (alternate monitoring parameter)	3.40	3.40

### Table 100 Extrusion press leakage PSNS

Maximum for any 1 day	Maximum for monthly average
mg/off-kg (lb/million off-lbs) of aluminum extruded	
0.11	0.05
0.06	0.03
0.31	0.13
0.21	
2.98	2.98
	any 1 day mg/off-kg (lb of alumin 0.11 0.06 0.31 0.21

# Table 101 Direct chill casting contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) inum cast
Chromium	0.49	0.20
Cyanide	0.27	0.11
Zinc	1.36	0.56
TTO	0.92	
Oil and grease (alternate monitoring parameter)	13.29	13.29

## Table 102 Press heat treatment contact cooling water PSNS

	1 0110	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
TTO	1.41	
Oil and grease (alternate monitoring parameter)	20.37	20.37

# Table 103 Solution heat treatment contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) ım quenched
Chromium	0.76	0.31
Cyanide	0.41	0.17
Zinc	2.08	0.86
TTO	1.41	
Oil and grease (alternate monitoring parameter)	20.37	20.37

Table 104 Cleaning or etching bath PSNS

Pollutant or pollutant property	Maximum for	Maximum for
	any 1 day	monthly average
		/million off-lbs) cleaned or etched
Chromium	0.067	0.027
Cyanide	0.036	0.015
Zinc TTO	$0.183 \\ 0.124$	0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

Table 105 Cleaning or etching rinse and hot water seal PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc TTO	1.42 0.96	0.59
Oil and grease (alternate monitoring parameter)	13.91	13.91

# Table 106 Cleaning or etching scrubber liquor PSNS

Maximum for	Maximum for monthly average
mg/off-kg (lb	/million off-lbs)
of aluminum o	leaned or etched
0.72	0.29
0.39	0.16
1.97	0.81
1.34	
19.33	19.33
	any 1 day mg/off-kg (lb of aluminum of 0.72 0.39 1.97 1.34

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

# Subchapter IV — The Forging Subcategory

NR 257.40 Applicability; description of the forging subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary forging operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.41 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

(1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the forging operation, such as forging air pollution scrubbers, solution heat treatment, cleaning or etching.

# ${\color{red}228-98 \atop NR~257} \qquad {\color{blue}WISCONSIN~ADMINISTRATIVE~CODE}$

(2) "Core operation" means forging, artificial aging, annealing, degreasing, and sawing.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.44 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

Table 107 Core operation NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
<del>-</del>		/million off-lbs) num forged
Chromium	0.019	0.008
Cyanide	0.010	0.004
Zinc	0.051	0.021
Aluminum	0.305	0.135
Oil and grease	0.50	0.50
Suspended solids pH	0.75 (1)	<b>0.60</b> (1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 108
Forging scrubber liquor
NSPS

	TABL D	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb/million off-lbs) of aluminum forged	
Chromium	0.035	0.014
Cyanide	0.019	0.008
Zinc	0.096	0.04
Aluminum	0.576	0.256
Oil and grease	0.943	0.95
Suspended solids pH	$\frac{1.42}{\binom{1}{1}}$	${\overset{1.13}{\overset{(1)}{\scriptscriptstyle{(1)}}}}$

Within the range of 7.0 to 10 at all times.

# Table 109 Solution heat treatment contact cooling water NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) um quenched
Chromium	0.76	0.31
Cyanide	0.41	0.163
Zinc	2.08	0.86
Aluminum	12.45	5.52
Oil and grease	20.37	20.37
Suspended solids pH	$30.56 \atop {\scriptstyle (1)}$	$24.45 \atop \stackrel{(1)}{\scriptscriptstyle (1)}$

Within the range of 7.0 to 10 at all times.

Table 110 Cleaning or etching bath NSPS

	11010	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.066	0.027
Cyanide Zinc	$0.036 \\ 0.183$	0.015 0.075
Aluminum	1.094	0.485
Oil and grease Suspended solids	$\begin{array}{c} 1.79 \\ 2.69 \\ {}_{1} \end{array}$	$\begin{array}{c} 1.79 \\ 2.15 \\ \end{array}$
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 111 Cleaning or etching rinse and hot water seal NSPS

	INDE D	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) :leaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1.42	0.59
Aluminum	8.50	3.77
Oil and grease	13.91	13.91
Suspended solids	20,87	16,69
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 112 Cleaning or etching scrubber liquor NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.72	0.29
Cyanide	0.39	0.155
Zine	1.97	0.812
Aluminum	11.81	5.24
Oil and grease	19.33	19.33
Suspended solids	29,00	23,20
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.45 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. 211 and achieve the following pretreatment standards for existing sources:

### Table 113 Core operation PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) num forged
Chromium Cyanide Zinc TTO	0.022 0.015 0.073 0.035	0.009 0.006 0.031
Oil and grease (alternate monitoring parameter)	2.6	1.3

# Table 114 Forging scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) num forged
Chromium Cyanide Zinc	0.042 0.028 0.140	0.017 0.011 0.058
TTO Oil and grease (alternate monitoring parameter)	0.065 4.9	2.5

# Table 115 Solution heat treatment contact cooling water PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) im quenched
Chromium Cyanide	0.897 0.591	0.37 0.25
Zinc TTO	2.98 1.41	1.24
Oil and grease (alternate monitoring parameter)	110.0	53.0

### Table 116 Cleaning or etching bath PSES

	I OLIO	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs)
Chromium	0.079 0.052	0.032 0.022
Cyanide Zinc	0.26	0.022
TTO Oil and grease (alternate	0.123 9.30	4.70
monitoring parameter)	0.00	1110

Table 117
Cleaning or etching rinse and hot water seal
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
- -	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	1.7	0.7
Cyanide	1.2	0.5
Zine	5.7	2.4
TTO	2.7	
Oil and grease (alternate monitoring parameter)	200.0	100.0

#### Table 118 Cleaning or etching scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum c	/million off-lbs)
Chromium Cyanide	0.851 0.561	0.35 0.23
Zinc TTO	2.82 1.34	1.18
Oil and grease (alternate monitoring parameter)	100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.46 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

Table 119 Core operation PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumi	/million off-lbs) num forged
Chromium	0.019	0.008
Cyanide	0.010	0.004
Zinc	0.051	0.021
TTO	0.035	
Oil and grease (alternate monitoring parameter)	0.50	0.50

# Table 120 Forging scrubber liquor PSNS

	_ ~	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs)
Chromium -	0.035	0.014
Cyanide	0.019	0.008
Zinc	0.096	0.040
TTO	0.065	
Oil and grease (alternate monitoring parameter)	0.95	0.95

### Table 121 Solution heat treatment contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.76	0.31
Cyanide	0.41	0.16
Zinc TTO	2.08 1.41	0.86
Oil and grease (alternate monitoring parameter)	20.37	20.37

### Table 122 Cleaning or etching bath PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.067	0.027
Cyanide	0.036	0.015
Zinc TTO	0.183 0.124	0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

# Table 123 Cleaning or etching rinse and hot water seal PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	0.52	0.21
Cyanide	0.28	0.11
Zinc	1.42	0.59
TTO	0.96	
Oil and grease (alternate monitoring parameter)	13.91	13.91

Table 124 Cleaning or etching scrubber liquor PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb	/million off-lbs)
Chromium Cyanide Zinc TTO	0.72 0.39 1.97 1.34	0.29 0.16 0.812
Oil and grease (alternate monitoring parameter)	19.33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

# Subchapter V — The Drawing With Neat Oils Subcategory

NR 257.50 Applicability; description of the drawing with neat oils subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary drawing with neat oils operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

- NR 257.51 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:
- (1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the drawing operation, such as continuous rod casting, solution heat treatment, and cleaning or etching.
- (2) "Core operation" means drawing with neat oils, stationary casting, artificial aging, annealing, degreasing, sawing, and swaging.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.52 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

Table 125 Core operation BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum dr	/million off-lbs) awn with neat oils
Chromium Cyanide Zinc	0.022 0.015 0.073	0.0090 0.0050 0.031
Aluminum Oil and grease Suspended solids pH	0.97 2.04 (1)	$0.598 \atop 0.972 \atop (1)$

Within the range of 7.0 to 10 at all times.

Table 126 Continuous rod casting spent lubricant BPT

Maximum for	Maximum for
any 1 day	monthly average
mg/off-kg (lb	/million off-lbs)
of alumin	um rod cast
0.00086	0.00035
0.00057	0.00024
0.00287	0.0012
0.0127	0.0063
0.0393	0.0236
0,0805	0.0383
(1)	(1)
	any 1 day mg/off-kg (lb of alumin 0.00086 0.00057 0.00287 0.0127

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 127 Continuous rod casting contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) um rod cast
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.684 0.451 2.271 10.00 31.10 63.76 (1)	0.28 0.187 0.949 4.976 18.66 30.322

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 128 Solution heat treatment contact cooling water BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	3.39	1.39
Cvanide	2.24	0.93
Zinc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids	315,91	150,25
Ha	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 129 Cleaning or etching bath BPT

	272 2	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.079 0.052 0.26 1.150 3.58 7.34	$egin{array}{c} 0.032 \\ 0.022 \\ 0.11 \\ 0.57 \\ 2.15 \\ 3.49 \\ (1) \end{array}$

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 130 Cleaning or etching rinse and hot water seal BPT

	171 1	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) cleaned or etched
Chromium	6.12	2.51
Cyanide	4.40	1.67
Zinc	20.31	8.49
Aluminum	89.46	44.52
Oil and grease	278.24	166.95
Suspended solids pH	570.39	271.29

<sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 131 Cleaning or etching scrubber liquor BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
<del>-</del>	mg/off-kg (lb	/million off-lbs)
Chromium	7.00	2.86
Cyanide	4.61	1.91
Zinc	23.22	9.70
Aluminum	102.24	50.88
Oil and grease	318.00	190.80
Suspended solids	651,90	310,05
pH	(1)	(1)

<sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.53 Effluent limitations representing the degree of effluent reduction attainable by the application of the best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

### Table 132 Core operation BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum dra	/million off-lbs) awn with neat oils
Chromium	0.022	0.009
Cyanide	0.015	0.006
Zine	0.073	0.031
Aluminum	0.321	0.16

#### Table 133 Continuous rod casting spent lubricant BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium	0.00086	0.0004
Cyanide	0.0006	0.0002
Zinc	0.0029	0.0012
Aluminum	0.0127	0.0063

#### Table 134 Continuous rod casting contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium Cyanide Zinc Aluminum	0.086 0.056 0.283 1.247	0.035 0.024 0.118 0.621

# Table 135 Solution heat treatment contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		million off-lbs) m quenched
Chromium Cyanide Zinc Aluminum	0.896 0.591 2.974 13.10	0.367 0.245 1.243 6.519

# Table 136 Cleaning or etcing bath BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc Aluminum	0.079 0.052 0.262 1.151	0.032 0.022 0.109 0.563

Table 137 Cleaning or etching rinse and hot water seal BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc Aluminum	0.512 0.404 2.031 8.944	0.251 0.167 0.849 4.451

Table 138 Cleaning or etching scrubber liquor BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.851	0.348
Cyanide	0.561	0.232
Zine	2.82	1.179
Aluminum	12.43	6.19

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.54 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

Table 139 Core operation NSPS

	TIDE	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum drawn with neat oils	
Chromium	0.019	0.008
Cyanide	0.010	0.004
Zinc	0.051	0.021
Aluminum	0.304	0.135
Oil and grease	0.498	0.498
Suspended solids	0.747	0.598
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 140 Continuous rod casting spent lubricant NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.0008 0.0004 0.002 0.012 0.02 0.03 (1)	0.0003 0.0002 0.0008 0.006 0.02 0.024 (1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 141 Continuous rod casting contact cooling water NSPS

	11010	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium	0.072	0.029
Cyanide	0.039	0.016
Zinc	0.198	0.082
Aluminum	1.185	0.526
Oil and grease	1.939	1.939
Suspended solids	2,909	2,327
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 142
Solution heat treatment contact cooling water
NSPS

IADI D	
Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) im quenched
0.754	0.306
0.408	0.163
2.08	0.856
12.45	5.52
20.37	20.37
<b>30.56</b>	24.45
	any 1 day  mg/off-kg (lb of alumint 0.754 0.408 2.08 12.45 20.37

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 143 Cleaning or etching bath NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) eleaned or etched
Chromium	0.066	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0.485
Oil and grease	1.79	1.79
Suspended solids	2,69	2.15
pH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 144 Cleaning or etching rinse and hot water seal NSPS

	110=0	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
~	mg/off-kg (lb	/million off-lbs) eleaned or etched
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids	0.515 0.278 1.42 8.50 13.91 20.87	0.209 0.111 0.584 3.77 13.91 16,70
pH	20.01	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 145
Cleaning or etching scrubber liquor

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb	/million off-lbs) eleaned or etched
Chromium Cyanide Zinc Aluminum Oil and grease	0.715 0.387 1.97 11.81 19.33	0.290 0.155 0.812 5.24 19.33
Suspended solids pH	29.00	23.20

<sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.55 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

Table 146 Core operation PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum dr	/million off-lbs) awn with neat oils
Chromium	0.022	0.009
Cyanide	0.015	0.006
Zinc TTO	0.073 0.035	0.031
Oil and grease (alternate monitoring parameter)	2.6	1.3

Table 147 Continuous rod casting lubricant PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc	0.0009 0.0006 0.0029	0.0004 0.0003 0.0012
TTO Oil and grease (alternate	0.0029 0.0014 0.10	0.0012
monitoring parameter)	0.10	0.000

# Table 148 Continuous rod casting contact cooling water PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) um rod cast
Chromium Cyanide Zinc TTO	0.086 0.057 0.283 0.133	0.035 0.023 0.118
Oil and grease (alternate monitoring parameter)	10.00	5.10

# Table 149 Solution heat treatment contact cooling water PSES

	I DIID	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium Cyanide Zinc TTO	0.896 0.591 2.98 1.41	0.367 0.245 1.24
Oil and grease (alternate monitoring parameter)	110.0	53.0

#### Table 150 Cleaning or etching bath PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium	0.079	0.033
Cyanide	0.052	0.022
Zínc TTO	$0.262 \\ 0.124$	0.109
Oil and grease (alternate monitoring parameter)	9.30	4.70

Table 151 Cleaning or etching rinse and hot water seal PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) cleaned or etched
Chromium	0.612	0.251
Cyanide	0.404	0.17
Zinc	2.03	0.85
TTO	0.96	
Oil and grease (alternate monitoring parameter)	73.0	36.0

Table 152 Cleaning or etching scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.851	0.348
Cyanide Zinc	0.561 2.82	0.232 1.18
TTO	1.34	1.10
Oil and grease (alternate monitoring parameter)	100.0	50.0

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.56 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

Table 153 Core operation PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminum dr	/million off-lbs) awn with neat oils
Chromium	0.019	0.008
Cyanide	0.010	0.004
Zinc	0.051	0.021
TTO	0.035	
Oil and grease (alternate monitoring parameter)	0.50	0.50

# Table 154 Continuous rod casting lubricant PSNS

	10110	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-		/million off-lbs) um rod cast
Chromium Cyanide Zinc	0.0007 0.0004 0.0020	0.0003 0.0002 0.0008
TTO Oil and grease (alternate monitoring parameter)	0.0014 0.020	0.020

# Table 155 Continuous rod casting contact cooling water PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um rod cast
Chromium Cyanide	0.072 0.039	0.029 0.016
Zinc TTO	0.039 0.198 0.134	0.082
Oil and grease (alternate monitoring parameter)	1.94	1.94

# Table 156 Solution heat treatment contact cooling water PSNS

	10110	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.76	0.306
Cyanide	0.41	0.163
Zinc TTO	2.08 1.41	0.856
Oil and grease (alternate monitoring parameter)	20.37	20.37

# Table 157 Cleaning or etching bath PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) leaned or etched
Chromium	0.067	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
TTO	0.124	
Oil and grease (alternate monitoring parameter)	1.79	1.79

Table 158
Cleaning or etching rinse and hot water seal
PSNS

Maximum for any 1 day	Maximum for monthly average
	/million off-lbs) cleaned or etched
0.52	0.21
0.28	0.11
1.42	0.59
0.96	
13.91	13.91
	any 1 day mg/off-kg (lb of aluminum o 0.52 0.28 1.42 0.96

# Table 159 Cleaning or etching scrubber liquor PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	0.72	0.29
Cyanide	0.39	0.16
Zinc	1.97	0.812
TTO	1.34	
Oil and grease (alternate monitoring parameter)	19.33	19.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

# Subchapter VI — The Drawing With Emulsions or Soaps Subcategory

NR 257.60 Applicability; description of the drawing with emulsions or soaps subcategory. This subchapter applies to the discharge of pollutants to waters of the state and the introduction of pollutants into POTWs from core and ancillary drawing with emulsions or soaps operations.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.61 Specialized definitions. In addition to the definitions set forth in s. NR 257.03, the following definitions apply to the terms used in this subchapter:

- (1) "Ancillary operation" means any operation which is not a core operation but which is performed on-site following or preceding the drawing operation, such as continuous rod casting, solution heat treatment, and cleaning or etching.
- (2) "Core operation" means drawing with emulsions or soaps, stationary casting, artificial aging, annealing, degreasing, sawing, and swaging.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.62 Effluent limitations representing the degree of effluent limitations attainable by application of the best practicable control technology currently available. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BPT:

Table 160 Core operation BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium	0.205	0.084
Cyanide	0.135	0.056
Zinc	0.680	0.285
Aluminum	3.00	1.50
Oil and grease	9.33	5.60
Suspended solids	19,12	$9.10_{\binom{1}{1}}$
рH	(1)	(1)

Within the range of 7.0 to 10 at all times.

Table 161 Continuous rod casting spent lubricant BPT

	DI I	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
•		/million off-lbs) inum cast
Chromium	0.0009	0.0004
Cyanide	0.0006	0.0003
Zinc	0.0029	0.001
Aluminum	0.013	0.007
Oil and grease	0.040	0.024
Suspended solids pH	0.081 (1)	<b>0.039</b>

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 162 Continuous rod casting contact cooling water BPT

	DL I	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) inum cast
Chromium	0.684	0.28
Cyanide	0.450	0.187
Zinc	2.27	0.949
Aluminum	10.00	4.976
Oil and grease	31.10	18.66
Suspended solids pH	<b>63.76</b> (1)	30.323

Within the range of 7.0 to 10 at all times.

Table 163
Solution heat treatment contact cooling water
BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) im quenched
Chromium	3.39	1.39
Cyanide	2.24	0.93
Zinc	11.25	4.70
Aluminum	49.55	24.66
Oil and grease	154.10	92.46
Suspended solids	315,91	150,25
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

# Table 164 Cleaning or etching bath BPT

	IN I	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	0.079	0.032
Cyanide	0.052	0.022
Zinc	0.262	0.109
Aluminum	1.15	0.573
Oil and grease	3.58	2.15
Suspended solids	$7.34_{(1)}$	3.49
υH	(1)	(1)

Within the range of 7.0 to 10 at all times.

#### Table 165 Cleaning or etching rinse and hot water seal BPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	6.12	2.51
Cyanide	4.04	1.67
Zinc	20.31	8.49
Aluminum	89.46	44.519
Oil and grease	278.24	166.95
Suspended solids pH	570.39	271.29

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

Table 166 Cleaning or etching scrubber liquor RPT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	7.00	2.86
Cyanide	4.61	1.91
Zinc	23.22	9.70
Aluminum	102.24	50.88
Oil and grease .	318.00	190.80
Suspended solids pH	651.90	310.05 (1)

Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.63 Effluent limitations representing the degree of effluent reduction attainable by the application of best available technology economically achievable. Except as provided in 40 C.F.R. ss. 125.30 to 125.32, any existing point source subject to this subchapter shall achieve the following effluent limitations representing the degree of effluent reduction attainable by the application of BAT:

Table 167 Core operation BAT

	~~~~	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium	0.205	0.084
Cyanide Zinc	0.135 0.681	0.056 0.285
Aluminum	3.00	1.49

Table 168 Continuous rod casting spent lubricant BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) um rod cast
Chromium	0.0009	0.0004
Cyanide	0.0006	0.0003
Zinc	0.0029	0.0012
Aluminum	0.013	0.0063

#### Table 169 Continuous rod casting contact cooling water BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um rod cast
Chromium	0.086	0.035
Cyanide	0.056	0.024
Zinc	0.283	0.118
Aluminum	1.25	0.62

### DEPARTMENT OF NATURAL RESOURCES

228-117 NR 257

		Table	170		
Solution	heat	treatment	contact	cooling	water
		BA'	r	Ū	

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of alumin	/million off-lbs) im quenched
Chromium	0.897	0.37
Cyanide	0.591	0.25
Zinc	2.98	1.24
Aluminum	13.10	6.52

### Table 171 Cleaning or etching bath BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_		/million off-lbs) cleaned or etched
Chromium Cyanide Zinc	0.079 0.052 0.262	0.032 0.022 0.11
Aluminum	1.15	0.57

### Table 172 Cleaning or etching rinse and hot water seal BAT

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc Aluminum	0.612 0.404 2.03 8.95	0.251 0.167 0.849 4.45

# Table 173 Cleaning or etching scrubber liquor

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) cleaned or etched
Chromium	0.85	0.348
Cyanide	0.561	0.232
Zinc	2.82	1.18
Aluminum	12.43	6.19

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.64 New source performance standards. Any new source subject to this subchapter shall achieve the following performance standards:

Table 174 Core operation NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium	0.173	0.070
Cyanide	0.094	0.038
Zinc	0.476	0.196
Aluminum	2.85	1.27
Oil and grease	4.67	4.67
Suspended solids pH	7.00	5.60

Within the range of 7.0 to 10 at all times.

#### Table 175 Continuous rod casting spent lubricant NSPS

	IADE D	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um rod cast
Chromium	0.0008	0.0003
Cyanide	0.0004	0.0002
Zinc	0.0020	0.0008
Aluminum	0.012	0.0053
Oil and grease	0.020	0.020
Suspended solids pH	0.030	0.024

Within the range of 7.0 to 10 at all times.

### Table 176 Continuous rod casting contact cooling water NSPS

Maximum for any 1 day	Maximum for monthly average
mg/off-kg (lb/million off-lbs) of aluminum rod cast	
0.072	0.029
0.039	0.016
0.198	0.081
1.184	0.526
1.940	1 <b>.940</b>
2,91	2.33
(1)	(1)
	any 1 day mg/off-kg (lb of alumin 0.072 0.039 0.198 1.184

<sup>1</sup> Within the range of 7.0 to 10 at all times.

# DEPARTMENT OF NATURAL RESOURCES

228-119 NR 257

Table 177
Solution heat treatment contact cooling water
NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb of aluminu	/million off-lbs) im quenched
Chromium	0.754	0.31
Cyanide	0.408	0.16
Zinc	2.08	0.86
Aluminum	12.450	5.52
Oil and grease	20.00	20.37
Suspended solids	20.56	24,45
pH	(1)	(1)

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

# Table 178 Cleaning or etching bath NSPS

	Nord	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.066	0.027
Cyanide	0.036	0.015
Zinc	0.183	0.075
Aluminum	1.094	0.49
Oil and grease	1.79	1.79
Suspended solids	2.69	$2.15_{\binom{1}{1}}$
$pH^{-}$	(1)	(1)

Within the range of 7.0 to 10 at all times.

# Table 179 Cleaning or etching rinse and hot water seal NSPS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium	0.515	0.21
Cvanide	0.278	0.11
Zinc	1.42	0.59
Aluminum	8.50	3.77
Oil and grease	13.911	13.91
Suspended solids pH	<b>20.87</b>	16.70 (1)

Within the range of 7.0 to 10 at all times.

Table 180 Cleaning or etching scrubber liquor NSPS

	21020	
Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
<del>-</del>	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc Aluminum Oil and grease Suspended solids pH	0.72 0.387 1.97 1.18 19.33 29.00	0.290 0.155 0.812 5.24 19.33 23.20

<sup>&</sup>lt;sup>1</sup> Within the range of 7.0 to 10 at all times.

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.65 Pretreatment standards for existing sources. Except as provided in ss. NR 211.13 and 211.14, any existing source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for existing sources:

Table 181 Core operation PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium Cyanide	0.205 0.135	0.084 0.056
Zinc TTO	0.681 0.32	0.285
Oil and grease (alternate monitoring parameter)	25.0	12.0

Table 182
Continuous rod casting lubricant
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod cast	
Chromium Cyanide	0.0009 0.0006	0.0004 0.0003
Zine TTO	0.0029 0.0014	0.0012
Oil and grease (alternate monitoring parameter)	0.10	0.052

# DEPARTMENT OF NATURAL RESOURCES

228-121 NR 257

Table 183
Continuous rod casting contact cooling water
PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
		/million off-lbs) um rod cast
Chromium Cyanide Zinc	0.086 0.056 0.283	0.035 0.024 0.119
TTO Oil and grease (alternate monitoring parameter)	0.134 10.0	5.1

# Table 184 Solution heat treatment contact cooling water PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
-	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium	0.896	0.367
Cyanide	0.591	0.245
Zinc	2.98	1.25
TTO	1.41	
Oil and grease (alternate monitoring parameter)	110.0	53.0

# Table 185 Cleaning or etching bath PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc TTO	0.079 0.052 0.262 0.124	0.032 0.022 0.11
Oil and grease (alternate monitoring parameter)	9.30	4.70

# Table 186 Cleaning or etching rinse and hot water seal PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb of aluminum o	/million off-lbs) cleaned or etched
Chromium	0.612	0.251
Cyanide Zinc	0.404 2.03	0.167 0.849
TTO Oil and grease (alternate monitoring parameter)	0.96 73.0	36.0

#### Table 187 Cleaning or etching scrubber liquor PSES

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched		
Chromium Cyanide Zinc TTO Oil and grease (alternate monitoring parameter)	0.851 0.561 2.82 1.34 100.0	0.348 0.232 1.18 50.0	

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

NR 257.66 Pretreatment standards for new sources. Except as provided in s. NR 211.13, any new source subject to this subchapter which introduces pollutants into a POTW shall comply with ch. NR 211 and achieve the following pretreatment standards for new sources:

#### Table 188 Core operation PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum drawn with emulsions or soaps	
Chromium Cyanide Zinc TTO	0.173 0.094 0.48 0.32	0.070 0.038 0.196
Oil and grease (alternate monitoring parameter)	4.67	4.67

# Table 189 Continuous rod casting lubricant PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average	
-	mg/off-kg (lb/million off-lbs) of aluminum rod cast		
Chromium	0.0008	0.0003	
Cyanide	0.0004	0.0002	
Zinc	0.0020	0.0008	
TTO	0.0014		
Oil and grease (alternate monitoring parameter)	0.020	0.020	

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Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum rod east	
Chromium Cyanide	0.072 0.039	0.029 0.016
Zinc TTO	$0.198 \\ 0.134$	0.082
Oil and grease (alternate monitoring parameter)	1.94	1.94

# Table 191 Solution heat treatment contact cooling water PSNS

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Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum quenched	
Chromium Cyanide	0.76 0.41	0.306 0.163
Zinc TTO	2.08 1.41	0.856
Oil and grease (alternate monitoring parameter)	20.37	20.37

# Table 192 Cleaning or etching bath PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
_	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cyanide Zinc TTO	0.067 0.036 0.183 0.124	0.027 0.015 0.075
Oil and grease (alternate monitoring parameter)	1.79	1.79

### Table 193 Cleaning or etching rinse and hot water seal PSNS

Pollutant or pollutant property	Maximum for any 1 day	Maximum for monthly average
	mg/off-kg (lb/million off-lbs) of aluminum cleaned or etched	
Chromium Cvanide	0.52 0.28	0.21 0.11
Zinc TTO	1.42 0.96	0.59
Oil and grease (alternate monitoring parameter)	13.91	13.91

# Table 194 Cleaning or etching scrubber PSNS

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	Maximum for monthly average
0.715	0.290
0.387	0.155
1.97	0.812
1.34	
9.33	19.33
	imum for y 1 day mg/off-kg (lb/1 of aluminum ck 0.715 0.387 1.97 1.34 9.33

History: Cr. Register, November, 1989, No. 407, eff. 12-1-89.

S	tate Code	Corresponding Feder	al Regulation
s.	NR 205.03	40 C.F.R. s.	401.11
s.	NR 205.04	40 C.F.R. s.	401.11
ch.	NR 211	40 C.F.R. Part	403
s.	NR 211.03	40 C.F.R. s.	403.3
s.	NR 211.13	40 C.F.R. s.	403.7
s.	NR 211.14	40 C.F.R. s.	403.13
ch.	NR 257	40 C.F.R. Part	467