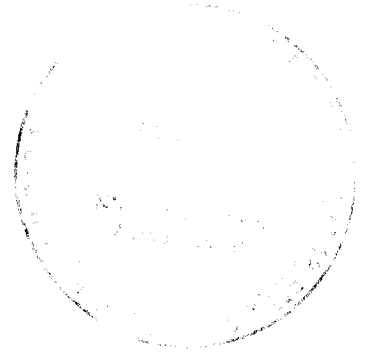




ENTERED



CERTIFIED MAIL RETURN RECEIPT REQUESTED

November 9, 2021

Chief
New Mexico Environment Department
Hazardous Waste Bureau
2905 Rodeo Park Drive East, Building 1
Santa Fe, New Mexico 87505-6313

And:

New Mexico Environment Department
Hazardous Waste Bureau
121 Tijeras Avenue NE
Suite 1000
Albuquerque NM 87102

RE: Waste Minimization Report for 2021
Safety-Kleen Systems, Inc.- Albuquerque Branch
EPA ID # NMD000804294

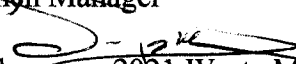
Dear Chief:

Enclosed is the Waste Minimization Report for 2021 as required by Part 2, Condition 2.5 of the facility's RCRA Part B Permit. In addition, a copy of the report has been saved to the enclosed CD as required.

If you have any questions, feel free to contact Nick Culian or Sr. Environmental Compliance Manager at 530-363-2632, or by email at nick.culian@safety-kleen.com.

Sincerely,

Scott Dolk
Branch Manager


Enclosures : 2021 Waste Minimization Report

cc: File 2020

Attachment B
Annual Waste Minimization Report 2021

Safety-Kleen Systems, Inc.
Albuquerque, NM

EPA ID Number. NMD000804294

Safety-Kleen Systems, Inc. – Albuquerque’s (SKAL) 2020 permit specifies:

2.5 WASTE MINIMIZATION PROGRAM

The Permittee shall implement and maintain a waste minimization program to reduce the volume and toxicity of hazardous wastes generated at the Facility (see 40 CFR § 264.73(b)(9)). The waste minimization program shall include proposed, practicable methods currently available to the Permittee to minimize the present and future threat to human health and the environment. The Waste Minimization Program shall include the following items:

1. Plan for reducing the volume and toxicity of hazardous waste at the Facility and recycling of hazardous waste at the Facility;
2. Employee training designed to identify and implement source reduction and recycling opportunities for all hazardous wastes;
3. Waste minimization and recycling implemented over the last year and additional waste minimization efforts that could be implemented at the Facility in the next federal fiscal year; and
4. Estimated costs devoted to waste minimization and recycling of hazardous waste.

The Permittee shall submit to the Department a report regarding progress made in the waste minimization program in the previous year. The report shall address items (1) - (4) above, shall show changes from the previous report, and shall be submitted annually by December 15 for the previous fiscal year ending September 30th.

SKAL implements and maintains a Waste Minimization Plan to minimize the amount and toxicity of hazardous wastes generated at this facility to a degree economically practicable, and that the method utilized for the treatment, storage, or disposal of hazardous waste is the practicable method currently available to this facility which minimizes the present and future threat to human health and the environment. The Plan includes:

1. Sections 3 and 4 of the Waste Minimization Plan address reducing the volume and toxicity of hazardous waste and the recycling of hazardous waste.
2. Section 5.3 of the Waste Minimization Plan addresses Employee training to identify and implement source reduction and recycling opportunities. In addition Attachment A of the Plan includes a Waste Minimization Suggestion Submittal Form to encourage employees to submit ideas to management.
3. Section 9.2 of the Waste Minimization Plan addresses minimization and recycling implemented over the last year and Section 9.3 addresses additional waste efforts that could be implemented at the facility next year.
4. Section 9.5 of the Waste Minimization Plan addresses costs associated to waste minimization and recycling of hazardous waste.

As described in the Plan, the wastes that appear on shipping documents as if they have been generated by Safety-Kleen, are actually generated by customers of Safety-Kleen. These wastes are stored in tanks and/or in containers and subsequently shipped off site to other facilities. Safety-Kleen relies mostly on source reduction for on-site processes which may generate waste, such as washing the parts washer drums returning from customers for reuse, the use of re-usable metal filters rather than disposable, and segregation of more toxic wastes from less toxic wastes to reduce the toxicity of larger quantity waste streams. As a permitted storage facility rather than a manufacturer, waste generated by Safety-Kleen year over year is directly related to the volume of customer generation.

Waste Streams which are created at the site are shown below and include Hazardous Waste Debris/Drum Washer Sediment and Used Oil Retain Samples. Yet these streams are directly due to activities with the incoming waste being handled and are based on customers quantities or frequencies of shipment. A single drum of dumpster sediment was created this year, in the two previous years no pure sediment drums were produced as they had higher concentrations of rags and were classified as Debris. See matrix below. Overall volumes of waste generated dropped to 89% of the previous year.

Hazardous Waste Generation Matrix

Location	Description of Waste	Pounds Generated 2020 (October 1, 2019 to September 30, 2020)	Pounds Generated 2021 (October 1, 2020 to September 30, 2021)	% Change from Prior Year
49Return and Fill Station	Hazardous Waste Debris	1,050	450	43
	Drum Washer Sediment		350	N/A
Warehouse	Used oil retain samples	700	750	107
Total		1,750	1,550	89

Safety-Kleen Systems, Inc.

Waste Minimization Plan

March 1996

Reviewed/Revised November 2021

Albuquerque, NM
2720 Girard NE
Albuquerque, NM 87107

EPA ID NMD000804294

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Attachment A-1 Employee Involvement in Waste Minimization
Waste Minimization Suggestion Submittal Form

Attachment A-2 Waste Minimization Certification
To be certified annually

Attachment B Waste Streams Generated at the Albuquerque, NM Branch
Waste Type, Quantities, Current and Proposed Management Methods

Section 1.0
Facility Information

1.1 Facility Identification:

Safety-Kleen Systems, Inc., Albuquerque, NM Branch

1.2 General Information:

Generator: Safety-Kleen Systems, Inc., Albuquerque, NM Branch

Contact Person: Scott Dolk Branch Manager, Nick Culian Env Compliance Mgr.

Facility Phone Number: 505-884-2277 Site, Environmental Compliance Mgr. 530-363-2632

Facility Mailing Address: 2720 Girard NE
Albuquerque, NM 87107

Site Address: Same as mailing address

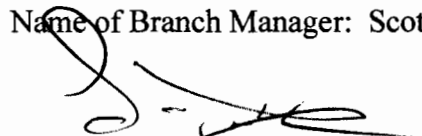
Facility NAICS/SIC Code(s):

48422 - Specialized Freight (except Used Goods) Trucking, Local
48423 - Specialized Freight (except Used Goods) Trucking, Long-Distance
53249 - Other Commercial and Industrial Machinery and Equipment Rental and Leasing
56211 - Waste Collection

1.3 Certification:

I certify that the information contained in this form is true and correct to the best of my knowledge and belief.

Name of Branch Manager: Scott Dolk



Signature of Branch Manager

Date: 11-9-2021

Section 2.0 What is Waste Minimization?

Waste minimization is specifically required by the U.S. Congress in the 1984 “Hazardous and Solid Waste Amendments to the Resource and Conservation and Recovery Act (RCRA).” Waste minimization consists of source reduction and recycling. More specifically, waste minimization is the reduction of the generation and disposal of hazardous waste. It includes source reduction and recycling which results in either:

1. Reduction of the total volume or quantity of hazardous waste, or
2. Reduction of toxicity of hazardous waste.

2.1 Volume (Source) Reduction

Volume or source reduction is any activity that reduces or eliminates the generation of hazardous waste at the source. Controlling the sources of waste generation reduces the volume of waste that is produced at Safety-Kleen locations include but are not limited to the following volume reduction activities.

Substituting Materials - Using materials which do not create waste, or which can be beneficially reused, recycled, or reclaimed.

Examples of Safety-Kleen's source reduction techniques are:

- Using spent mineral spirits instead of clean product for the drum washing activity.
- Using metal filters on the return and fill station equipment instead of the disposable cloth filters.

Technology - Changing processes, equipment, and operations to reduce the amount of waste generated.

Examples of technology changes at Safety-Kleen are:

- Eliminating the use of liner bags inside of parts washer drums thus reducing the amount of waste generated;
- Reducing the number and volume of spills by improving drum closure devices;
- Using a drum spritzer to polish rinse 150 solvent drums (the spritzer uses a small amount of clean solvent) that have been cleaned with spent solvent instead of using a larger amount of clean solvent that is swirled in the drum and dumped out to perform the rinse.

Operating Practices - Segregating waste streams, changing material handling procedures, and changing management practices.

Examples of Safety-Kleen's operating practices that result in waste reduction are:

- Reducing the number of spills that occur by more careful material handling that is taught and emphasized with training courses.
- Reducing the amount of waste generated from the cleanup of a spill by providing secondary containment and/or paved areas where releases are more likely to occur.
- Segregating recyclable materials (i.e. sludge), burnable materials (i.e. labels, personal protective equipment), and non-burnable materials (i.e. metal pieces, glass, rocks) to reduce

the amount of waste to be disposed of as hazardous waste and/or to facilitate recovery of materials that may be recycled.

- Keeping secondary containment areas clean so that any accumulated rainwater does not become contaminated.

Reclassification of Waste - Wastes may be characterized based on generator's knowledge, analytical results or a combination of both. For waste streams that Safety-Kleen suspects could be hazardous, Safety-Kleen will only manage as non-hazardous if analytical results support that classification or the generator certifies in writing that they have knowledge that it is non-hazardous. Being conservative and classifying waste as hazardous, when it may not be, may unnecessarily increase the amount of hazardous waste generated.

See Section 4.0, Achieving Waste Minimization, for more information about volume reduction techniques.

2.2 Toxicity Reduction

Toxicity reduction results in reduced volume and types of waste generated. In some instances, Safety-Kleen has changed a process to limit or exclude the contamination of waste with toxic components. An example of this is to segregate small amounts of wastes with listed codes from large quantities of wastes that are only characteristic wastes. Thus, the toxicity of the larger hazardous waste stream is not increased in toxicity.

2.3 Recycling

Recycling includes using, reusing, or reclaiming a material. Safety-Kleen provides machines that will recycle certain materials at the generator's site while other wastes are collected and sent to Safety-Kleen recycling centers to recover usable products. Additional details on recycling are provided in Section 4.0, Achieving Waste Minimization.

Section 3.0

Safety-Kleen Systems, Inc. Overall Waste Minimization Program

3.1 Established Program

Safety-Kleen is committed to minimizing the amount of waste generated at Safety-Kleen locations that is not related to health and safety or to managing customer waste. These two areas of waste generation are excluded because Safety-Kleen does not want to discourage the proper use of personal protective equipment and the company's business is to manage wastes generated by its customers. Safety-Kleen assists its customers in ensuring proper recycling or disposal of their wastes and while not a specific part of Safety-Kleen's site-specific waste minimization program, provides customers with technologies that can help them reduce the amount and toxicity of hazardous waste they produce.

3.2 Objectives

The objectives of the program are:

- To comply with a key element of the Safety-Kleen's Environmental Management System (EMS), i.e. regulatory and permit requirements.
- To educate Safety-Kleen personnel about waste minimization opportunities.
- Provide Safety-Kleen management with information regarding the Company's responsibility to minimize waste.

3.3 Elements of Safety-Kleen Waste Minimization Program

Safety-Kleen establishes a cost-effective waste minimization program at each of its facilities that includes the following elements:

- **Management Commitment** - The facility personnel understand why waste minimization is important. Management encourages employees to develop and implement ideas that will minimize hazardous waste generation. The Waste Minimization Suggestion Submittal Form included in Attachment A is provided to employees to receive input.
- **Waste minimization assessment** - Facility personnel evaluate ways to reduce and eliminate waste. This assessment analyzes what materials are used, what materials can be substituted, how mixing of waste can be avoided, and whether alternate technologies are available for reducing waste. Management certifies that personnel under his/her direction and supervision are undertaking specific steps in accordance with this program to minimize the amount and toxicity of hazardous wastes generated at each facility. The certification included in Attachment A is renewed annually.

3.4 Phased-Approach to Waste Minimization Program

The following summarizes Safety-Kleen's phased approach to a Waste Minimization Program.

1. Educate employees about waste minimization (what it is and how to achieve it).

2. Train personnel to identify opportunities for waste minimization as it relates to Safety-Kleen facility operations.
3. Train personnel by communicating waste minimization alternatives as it relates to daily facility operations.
4. Provide written waste minimization information to management.
5. Place education labels on customer parts washers which prohibit contamination of wastes which would make the solvent unrecoverable.

This document addresses the four phases of the Safety-Kleen program.

3.5 Waste Stream name and description

Typical waste streams that are routinely generated at the Safety-Kleen branches include the following.

1. Mineral spirits used for cleaning drums in the drum washer and the drum spritzer.
2. Filters used on the return and fill equipment.
3. Mineral spirits sludge generated from cleaning the return and fill station.
4. Storage tank cleanouts.
5. Sampling equipment and personal protective equipment.
6. Used oil samples and sample jars.
7. Used oil rags, sludge, oil from drip pans and buckets, etc.
8. Scrap Metal.
9. Rags / absorbent pads used in the process of servicing customer equipment / Branch facilities
10. Labels, paperwork, and other paper / plastic items that may have become contaminated with hazardous wastes.
11. Aerosol Cans.

3.6 Waste Reduction Measures

Safety-Kleen considers the following waste reduction measures through out the company:

1. **Mineral spirits used for cleaning drums in the drum washer** - Safety-Kleen will continue utilizing used solvent or Continued Use solvent when available to wash drums instead of using new product. This process will continue to provide an annual source reduction of approximately 2 million pounds.
2. **Filters used on the return and fill equipment** - Safety-Kleen will continue utilizing metal filters that can be cleaned and reused instead of using new disposal fabric filters. This process will continue to provide an annual source reduction of approximately 1000 pounds. If a metal filter must be replaced, the replaced filter may be cleaned and managed as scrap metal.
3. **Operating Practices** - Safety-Kleen will continue its operating Practices - Segregating waste streams, changing material handling procedures, and monitoring waste

management practices to minimize the generation of hazardous waste. This process cannot be quantified.

4. **Mineral spirits sludge generated from cleaning of the Return and Fill station-** This waste stream is originally generated by Safety-Kleen customers. The more solvent Safety-Kleen picks up from its customers, the more sludge is generated. It is not feasible to reduce this waste stream. However, Safety-Kleen will investigate options that may reduce the ratio of sludge generated per volume of solvent.
5. **Storage tank cleanouts** – This waste stream is generated by Safety-Kleen customers; this is the fine silt like material which passes the drum dumpster filters and settles out over time in the tank. The more solvent Safety-Kleen picks up from its customers, the more silt/sludge is generated. However, Safety-Kleen can minimize this waste stream by cleaning the tank biennially or even every 3 or 4 years, allowing the silt to concentrate. Pumpable silty sludge can be recycled through our regular solvent refining process.
6. **Sampling equipment and personal protective equipment** - Same as item 4 above. However, Safety-Kleen segregates these wastes from recyclable materials (i.e. sludge), and non-burnable materials (i.e. metal pieces, glass, rocks) to increase the amount of material that can be economically recycled and potentially reduce the toxicity of the larger quantity waste streams.
7. **Used oil sample jars.** This waste is generated from the sampling of used oil generated by Safety-Kleen's customers. Reduction of this waste is not feasible. However, Safety-Kleen switched from glass to smaller, lighter, 4-ounce plastic bottles in 2012/2013 which reduced the weight of this waste stream approximately in half.
8. **Used Oil Rags, filter sludge, etc.** These are accumulated in containers designated to be used only for these materials. Not commingling these with hazardous waste streams reduces the quantity of hazardous waste generated.
9. **Rags, paper, plastic, etc.** These wastes streams are managed in a variety of ways to minimize generation of additional amounts of hazardous waste. Some sites use shop rags that may be laundered and reused while servicing their customers. Others use absorbent wipes that are reused throughout the day and only discarded at the end of the day if they won't be serviceable for the entire next day's operations. These are placed in containers used only for these wastes and sampling equipment and PPE thus reducing the toxicity and quantity of dumpster sludge generated at a branch.

As described above, the wastes that appear on shipping documents as if they have been generated by Safety-Kleen are actually generated by customers of Safety-Kleen. These wastes are stored in tanks and/or in containers and subsequently shipped off site to other facilities. Safety-Kleen relies mostly on source reduction for on-site processes that may generate waste, such as washing the parts washer drums returning from customers, the use of re-usable metal filters rather than disposable, and segregation of more toxic wastes from less toxic wastes to reduce the toxicity of larger quantity waste streams.

Section 4.0 Achieving Waste Minimization

Safety-Kleen achieves waste minimization in several ways. The following briefly discusses options that Safety-Kleen practices at its facilities.

4.1 Source Reduction through Good Operating Practices

Safety-Kleen operating practices facilitate reduction of waste at the source as follows:

Waste Segregation - Encouraging employees to use specific waste receptacles for different wastes generated at the branch as discussed earlier. This minimizes the quantities of wastes that require special handling when generated.

Material Handling and Inventory Practices - Safety-Kleen management ensures that hazardous materials are properly stored to avoid spillage or damage and the resulting cleanup of waste material. Proper inventory management ensures that materials are not discarded due to age. Similarly, hazardous materials are ordered in quantities sufficient for operation. Larger quantities are not stored that could result in improper storage, exceeding of shelf life, and spills or accidents involving crowded storage areas.

Loss Prevention - Materials can become wastes when equipment leaks, or spills occur. In addition, using too much of a material results in waste generation (for example, using too much solvent creates more waste). Safety-Kleen management reminds employees to properly maintain equipment and to avoid mishaps such as spills of solvents.

Cost Accounting Procedures - For Safety-Kleen facilities, cost accounting of waste disposal encourages significant waste minimization. When specific departments are held accountable for their own waste disposal cost, they are more waste conscientious. Management periodically reviews each facility's performance in waste generation and management.

Production Schedules - The product Distribution Centers schedule their trips to service centers to reduce the need for frequent equipment cleaning, which could result in waste generation.

4.2 Source Reduction through Process Modifications

Safety-Kleen management considers the following options to reduce waste using process modifications:

- Changes in production methods
- Changes in equipment
- Changes in operating conditions, such as flow rates, temperature, pressure, residence time

4.3 Source Reduction through Product Changes

Safety-Kleen considers opportunities to minimize waste by changing products. Changes include:

- Substituting products - Safety-Kleen replaced its old formula Immersion Cleaner 609 with a less toxic non-halogenated formula (Immersion Cleaner 699)
- Conserving products
- Changing the composition of the product - Safety-Kleen has traditionally used two solvent products (105 & 150). One is inherently hazardous for ignitability (when spent), and the other remains non-hazardous if the customer's process doesn't add hazardous constituents when the solvent is spent. In 2011 Safety-Kleen discontinued routine use of 105 solvent which was ignitable and routinely offered only our 150 solvent which is non-ignitable.
- Providing options to customers to use aqueous cleaners versus petroleum solvents. This continues to be an on-going marketing process. Our 4-in-1 aqueous cleaner is nonhazardous even in the concentrated form.

4.4 Waste Minimization through Material Recycling and Recovery

Recycling: Use or Reuse

Recycling may be achieved through use or reuse of a waste material. Essentially the waste material is returned to a process to replace a certain amount of new material. The process may be the same process from which the waste came, or an entirely new process.

Examples of Safety-Kleen's recycling practices include:

- Reusing old paints in a painting process that does not require a specific color
- Using sludge as fuel.

Recovery: Reclamation

Reclamation involves recovering a valuable material from hazardous wastes and non-hazardous wastes. Generally, a reclaimed material is not used at the same facility where it was generated.

Examples of Safety-Kleen's reclamation practices are:

- Reclaiming clean parts washer solvent from dirty parts washer solvent
- Recovering silver from film processing wastewater equipment.

Safety-Kleen Recycling and Recovery Services

Safety-Kleen provides many services to its customers that can help them meet waste minimization responsibilities through recycling and recovery. Examples of Safety-Kleen's services are:

- Safety-Kleen collects spent antifreeze, waste oil, and organic solvents and distills these to remove solids and contaminants. The waste material then becomes reusable for Safety-Kleen customers.
- Safety-Kleen also fuel blends cleanup materials from hazardous waste spills and organic-based absorbent material and sludge from storage tank maintenance. Fuel blenders who operate permitted facilities mix these wastes with fuel for energy generation.

Section 5.0

Identifying Waste Minimization Opportunities

Safety-Kleen management encourages evaluation of the following opportunities to establish a successful waste minimization program.

5.1 Understanding the Facility Processes

Safety-Kleen management assesses where hazardous waste is generated at a facility, what kinds of wastes are generated, and analyzes the processes associated with products or services. Management then determines which kinds of waste minimization techniques are feasible.

5.2 Knowing the Materials Used

Knowing what is used in a facility process is important in determining waste minimization options. Management considers whether:

- A substitute to the material can be used.
- The material quantity can be reduced.
- Wastes can be introduced back into the process to reduce the amount of new materials used.

5.3 Training Employees and Education

Once management establishes a plan for waste minimization, employees must be trained in implementing it.

Training includes:

- Explaining that waste minimization is important because it:
 - ✦ Protects the health of workers
 - ✦ Protects the environment
 - ✦ Meets regulatory requirements
 - ✦ Saves the Company money
- Explaining the requirements of the work plan:
 - ✦ Who is responsible for the different parts of the plan
 - ✦ How facility processes will change
 - ✦ How the program will be monitored
- Emphasizing management commitment to waste minimization:
 - ✦ Checking with staff on the progress of the waste minimization program
 - ✦ Rewarding employees for waste minimization

Section 6.0

Understanding the Costs/Benefits of Waste Minimization

Safety-Kleen managers understand that waste minimization is required and that there are costs associated with waste minimization. However, there are also very significant benefits.

6.1 Cost to Facilities

The facility personnel who implement waste minimization evaluate their business and the alternatives available to them. The time spent performing this evaluation has a cost. In addition, if the facility substitutes materials or uses additional recycling services, there may be some cost associated with this.

6.2 Benefits of Waste Minimization

Waste minimization has many benefits. Safety-Kleen management emphasizes these benefits, as discussed below.

Economic Benefits

- Disposal Cost Reduction - The costs of landfilling and incinerating hazardous waste is increasing. Disposal options will become costlier and more limited over time.
- Costly Alternative Treatments - Certain waste streams will become more and more difficult to treat as disposal options become limited. Alternate technology to treat waste is expensive.
- Savings in Materials Cost - When a facility practices waste minimization, it uses fewer materials. This reduces the cost of operating the business.

Regulatory Benefits

- Specific Requirements - All generators of hazardous waste are required to minimize the waste they generate. Generators must demonstrate waste minimization when they sign a waste manifest, when they submit a biennial report under RCRA, or when applying for facility permits.
- Land Ban - Since some waste is banned from land disposal, waste minimization avoids this regulatory limitation.

Liability Benefits

- Generator Liability - RCRA established cradle-to-grave liability. Therefore, Safety-Kleen is responsible for managing wastes stored at facilities, in transit, and when disposed of. Waste needs to be disposed of properly to avoid becoming a potentially responsible party for the cleanup of the contamination. Safety-Kleen must encourage employees to avoid liability by minimizing waste generation.
- Potential Worker Safety - The U.S. Environmental Protection Agency (U.S. EPA) and the Occupational Safety and Health Administration (OSHA) evaluate whether facilities are properly protecting their employees from hazardous materials and wastes found in the workplace. Safety-Kleen management minimizes potential employee exposure to hazardous waste by encouraging waste minimization.
- Public Image Benefits - Safety-Kleen's ability to operate responsibly helps the Company obtain its customers' confidence. This is especially important when Safety-Kleen demonstrates to community members that its business is a safe and productive addition to the community.

Section 7.0

Programs to Assist Generators in Waste Minimization (U.S. EPA)

Safety-Kleen strives to be the leader in providing services, which are user safe and environmentally friendly in the workplace. Safety-Kleen continues to work on new technologies designed to assist generators in meeting the waste minimization goals of the U.S. EPA, as well as state-specific requirements.

7.1 Premium Solvent Parts Washing Service (mid 1993)

The purpose of the Premium Solvent program is to provide customers with a Waste Minimization Program alternative to parts cleaning customers who currently utilize hazardous materials to accomplish this task. Often customers who use the Premium Solvent may show by analytical methods that their used solvent is not a hazardous waste. In 2011 Safety-Kleen switched all customers to Premium Solvent or Aqueous Parts Washer. Premium Solvent is the standard solvent offered to customers.

7.2 Aqueous Parts Washer Service

The purpose of the Aqueous Parts Washer service is to provide an alternative to organic-based solvents for generators. Safety-Kleen provides generators with aqueous parts washer solvent options to achieve waste minimization objectives. To further boost the reliability of this service Safety-Kleen introduced the 4 in 1 aqueous solution in the spring of 2012. This material has two advantages; the concentrate has a pH below RCRA limits so even should the concentrate spill no hazardous waste is created. In addition, the material is a superior cleaning agent that works even when not heated making it easier and more cost effective for generators to use and more likely to switch to this service.

7.3 Model 250 Parts Washer Service

Safety-Kleen has a SK Model 250 recycling parts washer. The Model 250 is designed to provide customers another option to meet their parts cleaning needs while at the same time address concerns for reducing hazardous waste output. Model 250s provide on-site recycling of 150 Premium Gold Solvent producing used oil by-product that can be managed as used oil in most cases. The Model 250 contains a distillation unit within that will return dirty solvent back as usable product. The solvent that is returned to the reservoir maintains virtually all its original form and cleaning capabilities.

7.4 The Minimizer III Solvent Distillation Equipment

Safety-Kleen Systems Inc.'s Minimizer equipment condenses solvents from paint wastes, and similar waste streams, allowing them to be reutilized in the process rather than sent to disposal. The Minimizer condenses the solvent vapors from paint wastes utilizing a water tower. The water tower transfers heat to the solvent giving it a higher recovery rate than most recycling equipment.

The Minimizer may be used for many other applications besides paint waste. It can recycle a wide range of chemicals such as acetone, Xylene, MEK, alcohol, and toluene, just to name a few. The kinds of waste streams can be found in many industries such as boat manufacturers, hospitals, aircraft industry, electronics, printers, cabinet manufacturers etc. In general, the Minimizer III can recycle

chemicals with a boiling temperature that is less than <380 degrees F (193 degrees C) and an auto ignition temperature that is greater than >482 degrees F (250 degrees C).

Section 8.0 Identifying Other Informational Sources (USEPA)

Safety-Kleen management informs employees about other sources of waste management information.

8.1 Federal Government

The U.S. EPA Region 6 - provides guidance for the Safety-Kleen Albuquerque, NM Branch.

The U.S. EPA provides businesses with assistance in waste minimization. Safety-Kleen and its customers can call the U.S. EPA RCRA/Superfund Hotline at (800) 424-9346 or U.S. EPA Region 6.

In addition, the U.S. EPA publishes several guidance documents for pollution prevention (PP) and waste minimization. Safety-Kleen and its customers can obtain these guides through the U.S.EPA or the U.S. Government Printing Office (202) 783-3238.

8.2 State and Local Assistance

In addition to the federal agencies above, state and local agencies may have information. In general, Safety-Kleen and its customers can contact environmental agencies or health departments for reference to local agencies that deal with hazardous waste issues.

Section 9.0
Site-Specific Waste Minimization Program
Albuquerque, NM Branch

9.1 Waste Minimization Program at the Safety-Kleen Albuquerque NM Branch

Typical waste streams that are routinely generated at the Safety-Kleen Branches are included in Section 3.5 above. Safety-Kleen will continue to implement the selected waste reduction measures identified in Section 3.6. Additional waste streams will be evaluated for source reduction/waste minimization opportunities.

9.2 Selected Measures

Attachment B identifies quantities of branch-generated waste streams from October 1, 2020 to September 30, 2021. Current management methods and proposed management methods that are selected as waste reducing alternatives are identified as follows:

1. **Branch-contaminated debris** – The Albuquerque branch encourages employees to segregate non-hazardous wastes from the hazardous waste debris. This will result in reducing volume of hazardous waste.
2. **Dumpster mud sludge**- The Albuquerque branch continues to segregate sludge and contaminated debris. This will keep the recyclable waste (sludge) separate from the burnable material (debris) and ensures that sludge is recycled to the maximum quantity. It also reduces the volume of the branch hazardous debris which is a more toxic waste stream. The segregation also eliminates operational problems in the distillation columns.
3. **Non-hazardous water**- The Albuquerque branch only pumps contaminated water from tank farms and return and fill secondary containment into used Mineral Spirit storage tanks. This eliminates unnecessary increases in the volume of hazardous waste solvents.
4. **Universal wastes**- The Albuquerque branch ensures that universal waste streams are handled properly per state-specific regulations. This eliminates unnecessary increase in the volume of hazardous waste.
5. **Empty aerosol cans**- The Albuquerque branch follows Safety-Kleen’s aerosol can management BOG. When possible Safety-Kleen ships aerosols as Universal waste rather than hazardous waste.
6. **Removal of solvents from Safety-Kleen machines at customer sites** – Safety-Kleen has trained the service representatives to empty solvents from machines to be removed out of service at customer sites. This is necessary to comply with transportation requirements of hazardous waste. In addition, this method reduces the volume of waste that would be generated at the branch.

7. **Metal** – Metal parts and pieces from cleaning dumpster screens, metal solvent filters that must be replaced, nuts, bolts, etc., empty, punctured aerosol cans, may be sent for scrap metal recovery.

9.3 Measures Identified for further evaluation

The following waste streams have been identified for further evaluation.

1. **Recycling of aqueous parts washer (APW) at customer site** – Safety-Kleen could evaluate possibility of use of a portable recycling unit at customer sites for APW. This would reduce the volume of this non-recyclable material that is currently discharged subsequent to treatment.
2. **Processing Aerosol Cans for Scrap Metal** - Safety-Kleen could evaluate the economics of setting up a puncturing system to deactivate and empty aerosol cans and putting the processed aerosol cans into a scrap metal container vs. disposal as Hazardous Waste. Alternatively, when handling the aerosols as Universal the materials are designated for recycling.

9.4 Goal

Safety-Kleen goal is to continue to minimize the volume of hazardous wastes generated (relative to production rate) at this location.

9.5 Annual Review

This plan will be reviewed on an annual basis to monitor effectiveness of selected measures and to identify additional potential waste stream that may be reduced.

1. No capital dollars have been expended in the last year to increase source reduction of hazardous waste in the last year. The hazardous wastes generated by the Albuquerque branch are exclusively related to the success of Safety-Kleen's business at this branch. The better the business, the more hazardous waste will be generated. The branch achieved a 89% reduction in hazardous waste from 2019/20 year. The decrease in hazardous waste generation was fairly evenly split between both waste streams.
2. Safety-Kleen provides services to its customers to help them reduce the amount of hazardous waste they generate and provides services for its customers for them to recycle their hazardous wastes. Given the nature of Safety-Kleen's business, contacting other agencies for ideas on source reduction would not be fruitful.
3. Some additional potential waste minimization activities are identified in Section 9.3, however the amount of waste reduction that would be achieved by these would be miniscule.
4. Safety-Kleen has reviewed the following waste minimization techniques:
 - a. The Albuquerque Branch does not remove coatings from parts before applying new coats – thus all of the potential waste minimization techniques identified in the permit are not applicable to this location.
 - b. When using solvents (spent solvent wastes) for parts cleaning operations:

- i. The use of water-soluble cutting fluids instead of oil-based fluids. This does not apply to the Albuquerque branch processes. The solvents returned by Safety-Kleen's customers are used to wash drums. Utilizing another product would increase the amount of waste produced and not reduce it.
- ii. The use of bead-blasting for paint-stripping. While Safety-Kleen has products to supply to customers to accomplish this activity, it is not an activity performed by Safety-Kleen and thus this is not applicable.
- iii. The prevention of cross-contamination. Safety clean has procedures and trains its employees to be cognizant of the potential to cross-contaminate its non-hazardous wastes with hazardous wastes. Safety-Kleen has a mineral spirits solvent that has no RCRA hazardous waste properties unless contaminated by the customer during its use.
- iv. The use of peel coatings in place of protective oils. Safety-Kleen is not a manufacturer of parts that are coated with protective oils and thus this is not applicable.
- v. Reduce the number of different solvents. Reducing the number of solvents provided by Safety-Kleen to its customers and thus the number of spent solvents returned to the branch does not change the amount of hazardous waste produced by Safety-Kleen.

As stated earlier, the hazardous waste generation rate at the Albuquerque branch is dependent upon the number of customers that the branch services. Having a goal to reduce its hazardous waste generation routinely without any further major changes in process would be to have a goal to go out of business. That being said, Safety-Kleen provides many potential services to its customers that will assist them to recycle and/or reduce the amount of hazardous waste they generate.

Attachment A
Employee Involvement in Waste Minimization

The form in Example A-1 is used for employee suggestions for waste minimization at Safety-Kleen facilities. This form is signed by the employee and reviewed by his manager before being submitted to the Regional Environmental Manager. A copy of the form is filed in EHS file 2020 - Waste Minimization.

Wherever possible, the employee includes cost justification savings that would result from implementation of the idea.

Regional Environmental personnel review ideas and refer them to upper management for possible implementation.

Attachment A-1
Waste Minimization Suggestion Submittal Form

Description of the procedure or process change suggested (attach additional pages and diagrams if needed):

Estimated capital cost of the change: \$ _____

Estimated annual expenses from the change: \$ _____

Estimated annual savings from the change: \$ _____

Employee Name

Manager Name

Signature

Signature

Title

Title

____/____/____
Date

____/____/____
Date

Plant ALB
File: EHS 2020

Attachment A-2

**Waste Minimization Certification
2021**

Safety-Kleen Systems, Inc.
Albuquerque, NM Branch

EPA ID No. NMD000804294

I hereby certify under penalty of law that personnel under my direction and supervision at this facility are undertaking specific steps in accordance with a program in place to minimize the amount and toxicity of hazardous wastes generated at this facility to a degree economically practicable and that the method utilized for the treatment, storage, or disposal of hazardous wastes is the practicable method currently available to this facility which minimizes the present and future threat to human health and the environment. I am aware that there are significant penalties for false certification, including the possibility of fine and imprisonment.



Signature

Scott Dolk

Name

Branch Manager

Title

11-10-2021

Date

Attachment B

**Branch-Generated Waste Streams
(October 1 to September 30, 20xx)**

Albuquerque, NM Branch

Hazardous Waste Generation Matrix

<u>LOCATION</u>	<u>DESCRIPTION OF WASTE</u>	<u>POUNDS GENERATED</u>
Return and Fill Station	Hazardous Waste Debris, and	
	Drum Washer Sediment	
Warehouse	Used oil retain samples	
Total		

Note: See Latest Annual Report for Volumes