HINDUSTAN UNILEVER LIMITED
HOSUR BEVERAGES FACTORY

TEAM:

1. VINTI ARORA, FACTORY MANAGER
2. SAI SREE, FACTORY ENGINEER

Unilever

HOSUR SITE PASSPORT

GENERAL

- Unit setup by **Brooke Bond** in **1983** for Instant Coffee.
- Situated **40KM** from Bangalore
- **Population**-300,000 (Males constitute 53%, Females constitute 47%) .
- Average literacy rate of **75%.**
- Official Language – Tamil (Alternate - Telugu and Kannada)
- Total Site Area **– 67217 Sqm** (Constructed Area–15665 Sqm)
- Site GBV: 162 Cr , TO: 400 Cr

MANPOWER

- **5** Managers, **19** Executives and **163** Shopfloor employees.
- Average Age -44 years (shopfloor)
- Direct + Indirect Employment -322

MANUFACTURING

- **14K Tons** Annual Volume (IC ~ 8000 Tons ; CC ~ 6000 Tons)
- Highly process intensive IC production (Roaster, Extraction, Evaporation , Spray Drier)
- **5** packing lines (IC – 3 ; CC- 2)
- **Zero** Discharge plant

PRESENTERS

VINTI ARORA
FACTORY MANAGER

SAI SREE R
FACTORY ENGINEERING MANAGER

ORGANIZATION CHART

Kavita Jain
VP, N&IC, South Asia

Vinti Arora
Factory Manager

Monika Bhima
Manufacturing Manager

Suresh Kumar
General Shift Officer

Chandrasegar K
Shift Officer

Selvam T
Shift Officer

Suriya Raj
Shift Officer

Sivaselvan
Shift Officer

Ranjith Kumar
Shift Officer

Aastha
Shift Officer

Sheetal
Manex Executive

Saisree R
Factory Engineer

Kumaravel
Engg Executive

Nelson
Sr. Utility Executive

Muraloedharan
Safety Officer

Arn. Sundararajan
Sr. Electrical Executive

Reshma
Electrical Executive

Bhuvanesh U
Supply Chain Manager

Sridhar Babu
RM/PM/Engg Store

Chinnathambi. T
Dispatch Officer

Srinidhi Rao
UHRM

Ashikha
HR Executive

Dinesh
HR Officer

Deepika
Quality Exec

5 Managers, 19 WL1+ leading the operations

HOSUR SITE PASSPORT

14 K Tons of Installed Capacity
(IC~8000 Tons ; CC~6000 Tons)

8.3K Tons Annual Volume in 2022
(IC ~ 5367 Tons ;
CC ~ 2952 Tons)

275 Crore Turn Over
162 Cr GBV

Highly Process Intensive IC manufacturing
Roaster, Extractor, Evaporator, Spray Drier

Zero Liquid Discharge Plant

11 SKUs
Only Sourcing unit for SS, HTS , BGL KE & BGL Nice

Total Site Area – 67217 Sqm (16.6 Acres)
Constructed Area–15665 Sqm (3.87 Acres)

5 Packing Lines
(3-IC & 2-CC)

5 Managers
19 Executives
165 Shopfloor Employees
322 Contractual Employees

COFFEE MANUFACTURING PROCESS

ROASTING

Roasting coffee beans and granulising them

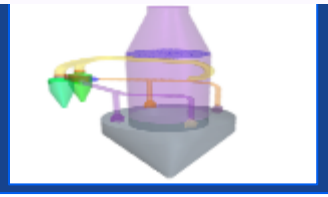
EXTRACTION

Generating liquor from the granulized beans by extracting hot water in pressurized column

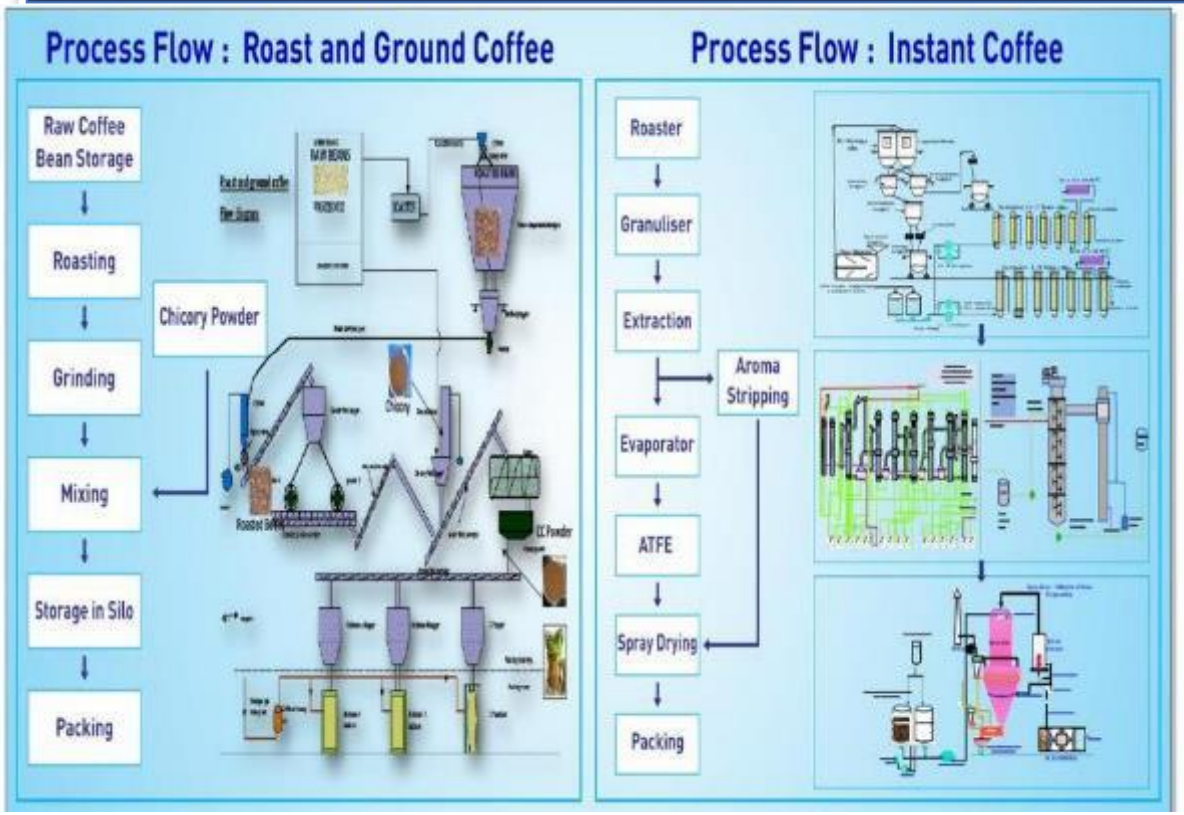
EVAPORATION

Improving the concentration of coffee liquor from 11.5% to 52%

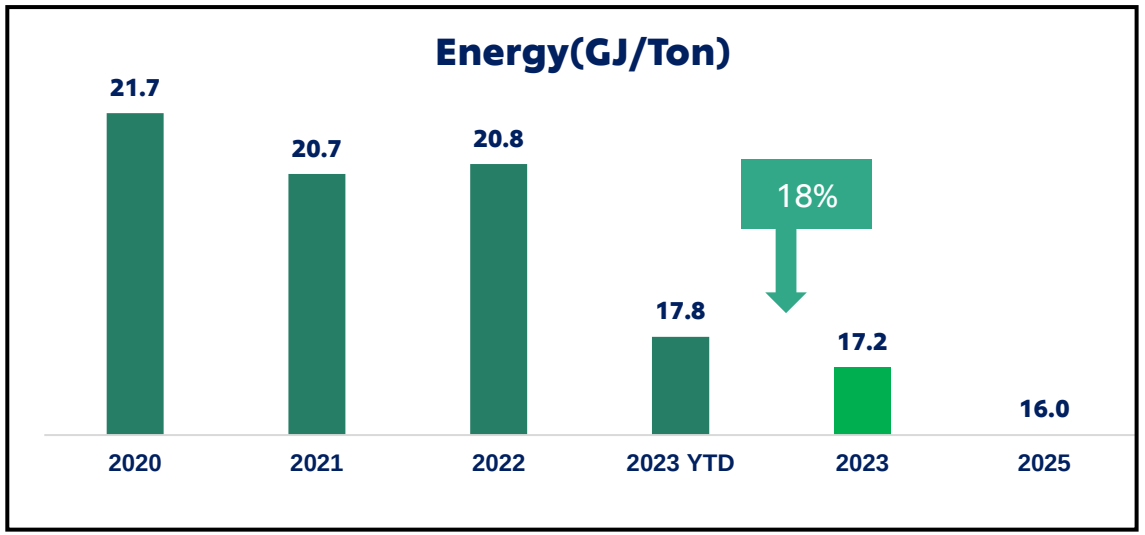
SPRAY DRYING

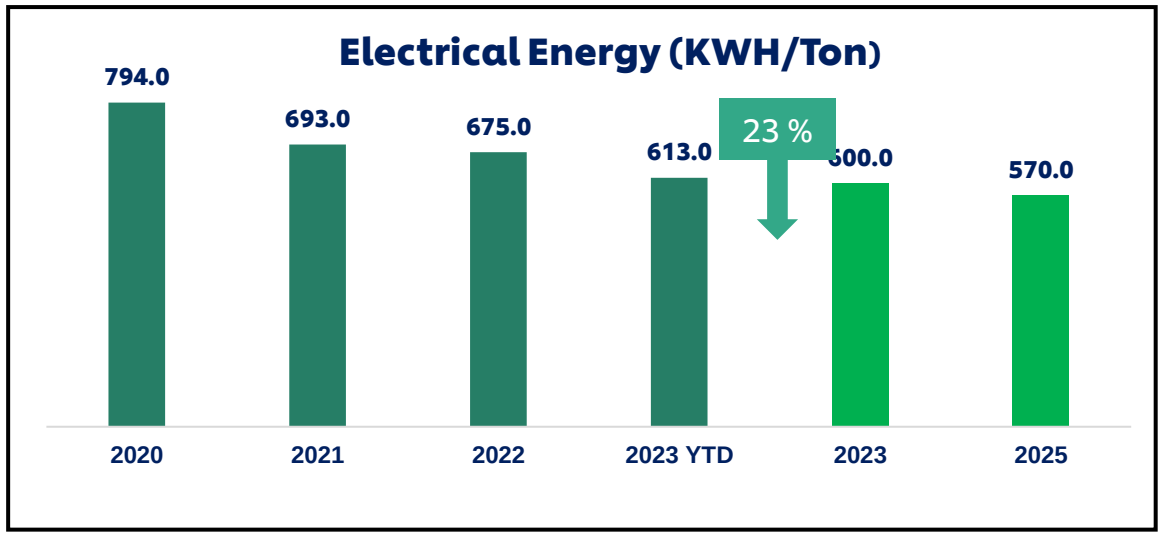


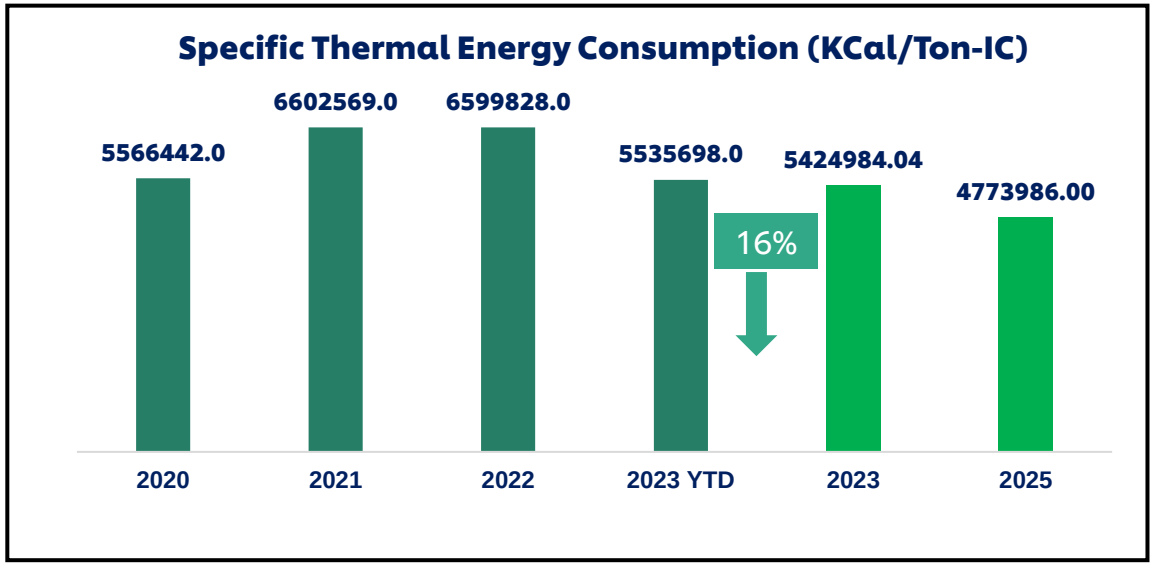
Spraying of the concentrated liquor and collecting the powder

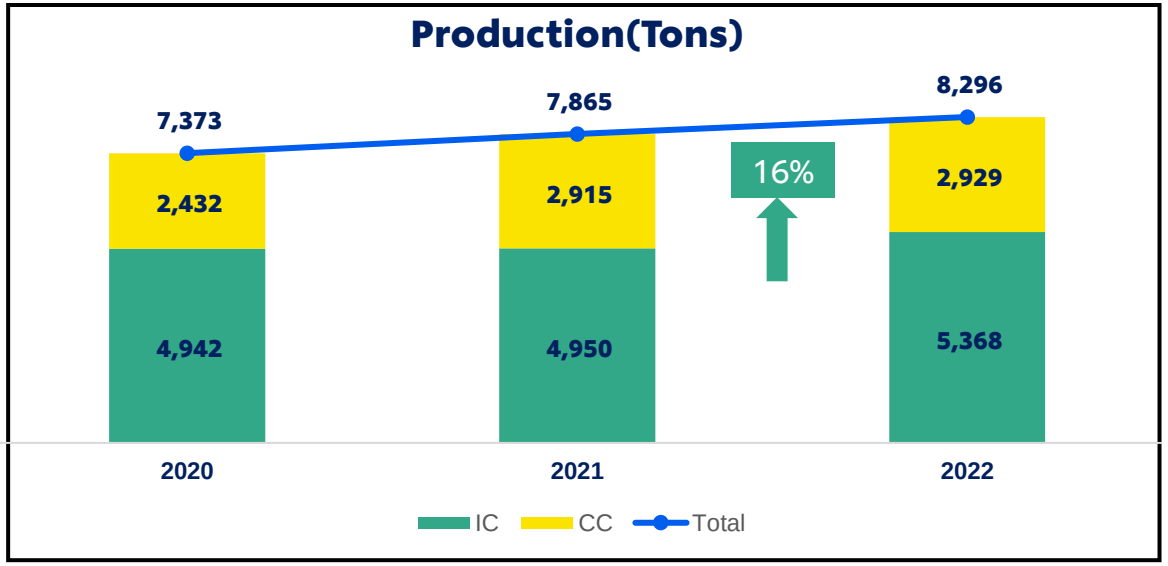


SPECIFIC ENERGY CONSUMPTION



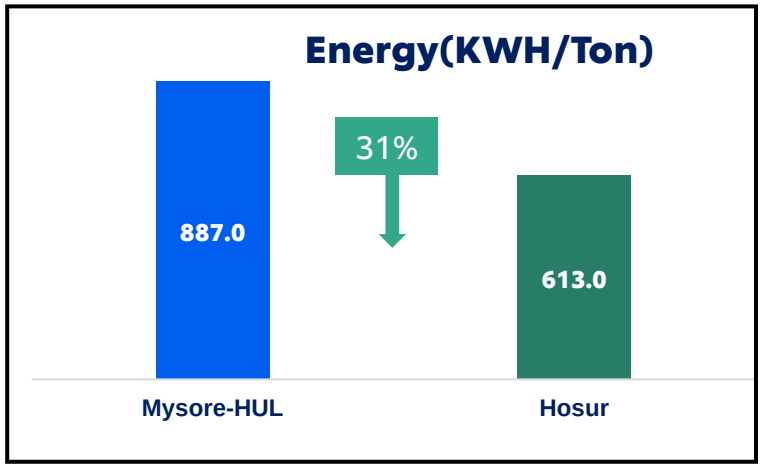




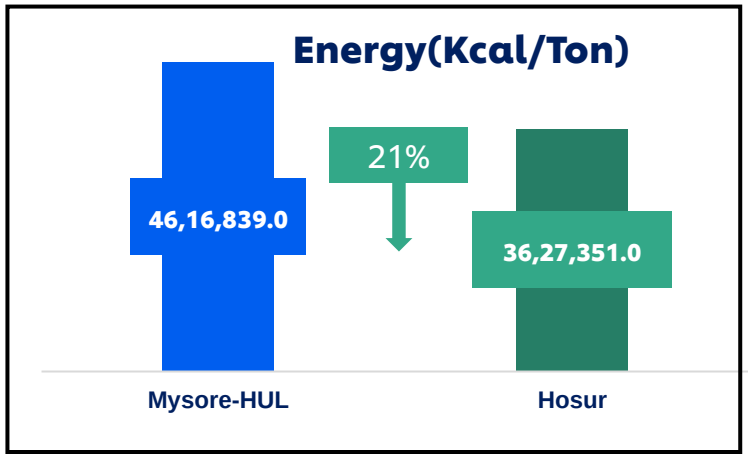


ENERGY BENCHMARKING

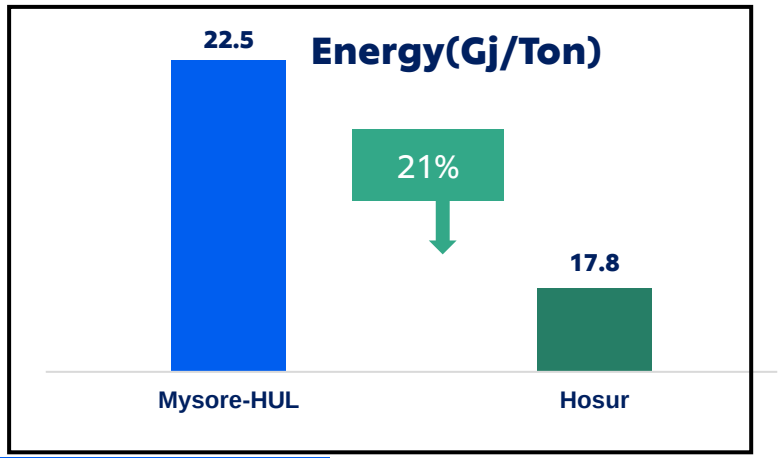
Electrical Energy Benchmarking



Thermal Energy Benchmarking



Energy Benchmarking



Major Encon Projects in 2023-2024

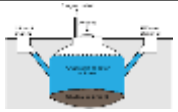
Project	Target Completion Date	Investment
Thermic Fluid Heater	Nov-23	13 Cr
Heat Recovery System for TFH	Dec-23	4 Cr
High Concentration Spray	Feb-23	1.2 Cr
Biofuel Usage in DG Sets	Sep-23	
EC Blowers for DHU	Oct-23	9 Lakhs
FRP Fans for Cooling Towers	Nov-23	6 Lakhs
ATCS for Chillers	Nov-23	8 Lakhs

HOSUR ENERGY MAPPING-AS IS-WHERE WE ARE !

Source	Usage Type	Transmission	Location
Grid 	Electrical Energy 9%	Electrical Energy – 68% LPG – 84% Steam – 87.2%	Instant Coffee
Onsite Solar 	Solar 2%	LPG – 15% Electrical Energy – 14%	Conventional Coffee
Offsite Windmill 	Wind 1%		
Briquette 	Steam 64%	Electrical Energy – 4%	Boiler
LPG Cylinders 	LPG 22%	Electrical Energy – 0.1% HSD– 100%	DGs
		Steam –12.5%	Zero Liquid Discharge Plant
		Electrical Energy – 5%	
		Electrical Energy –8%	Other Utilities
HSD Tanker 	HSD 2%	LPG – 1% Electrical Energy – 0.9%	Admin & Canteen

Annual Energy Consumption ~172800 GJ

HOSUR ENERGY MAPPING-TO BE-OUR VISION !

Source	Usage Type	Transmission	Location
Grid 	Electrical Energy 7%	Electrical Energy – 68% Biofuel – 72.11% Steam – 87.2% Thermic Fluid – 11.5%	Instant Coffee
Onsite Solar 	Solar 4%		
Offsite Windmill 	Wind 1%	Biofuel – 13.7% Electrical Energy – 14%	Conventional Coffee
Briquette 	Steam 64%	Electrical Energy – 4%	Boiler
	Thermic Fluid 11%	Electrical Energy – 0.1% Biofuel– 14.19%	DGs
LPG Cylinders 	LPG 0%	Steam –12.5% Electrical Energy – 5%	Zero Liquid Discharge Plant
Biofuel 	Biofuel 12%	Electrical Energy –8%	Other Utilities
Methane from Digestor 	Biogas 1%	Biogas– 1% Electrical Energy – 0.9%	Admin & Canteen
HSD Tanker 	HSD 0%		

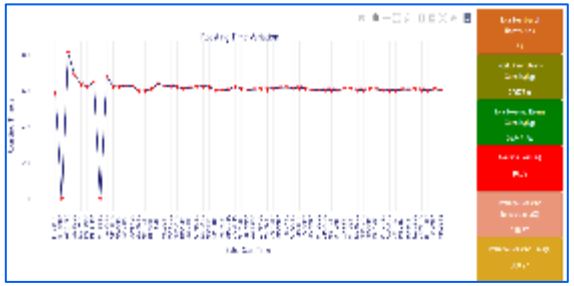
Annual Energy Consumption ~147600 GJ

HISTORY OF ENERGY SAVING PROJECTS IN LAST 3 YEARS

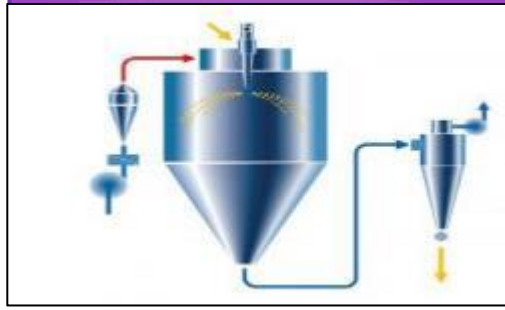
Year	No. of Energy Saving Projects	Investment (INR Million)	Thermal Energy Saving (Million Kcal)	Electrical Energy Savings (Million KWH)	Total Savings (INR Million)	Payback Period (in Months)	Impact on SEC (% Reduction)
2020-2021	2	11.3	2642	-	7.7	8	46 Bps
2021-2022	2	7.1	2191	-	5.1	9	4.6%
2022-2023	5	101.66	6792	1588500	69.16	7	15%

HISTORY OF ENERGY SAVING PROJECTS

Pre-Heating of Air in Coffee Beans Roaster & Reduction in SFC through digitalization



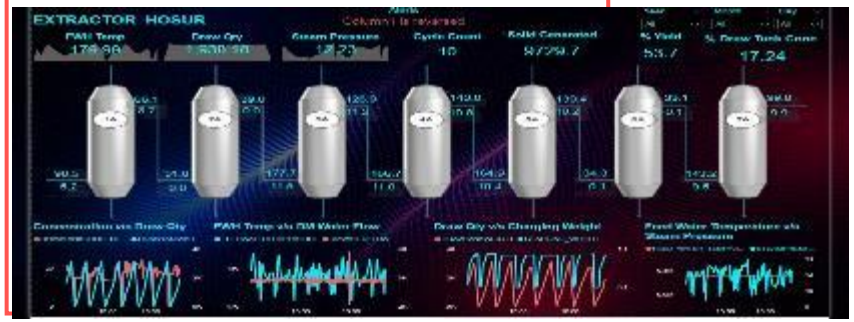
Pre-Heating of Air to Spray Drier



Low-Cost Alternate Fuel Usage

Energy Efficient Pumps & Motors, VFDs

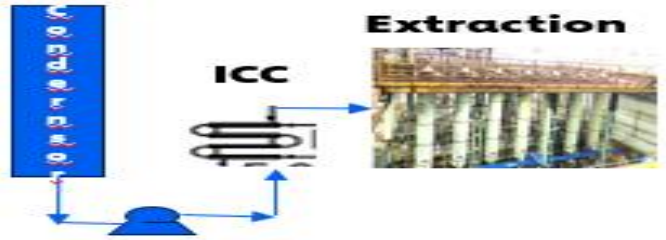
Single Extraction Operation-BCT Reduction & DOF Increase



Evaporator Upgradation

AHFs Installation

Evaporator condenser water recovery & Reuse



Boiler SFR Improvement

INNOVATIVE PROJECTS IMPLEMENTED
1. SINGLE EXTRACTION OPERATION

Feed Water Heater Temperature Variation

PARAMETER	Welded type sprial heat exchanger	Plate Heat exchanger	Shell & Tube heat exchanger
Flow rate	5460kg/h	6000kg/h	7600kg/h
Cleaning Frequency	4 days	6 days	30 days
Asset Life	10 years	10 Years	25 Years
Cost	1.8 L	13 L	15 L

BEFORE

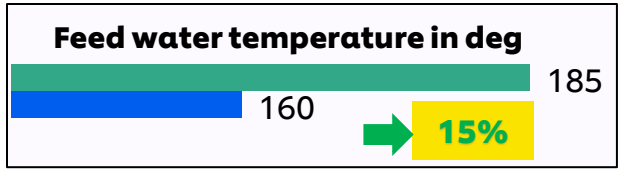
Spiral Welded Type Heat Exchanger

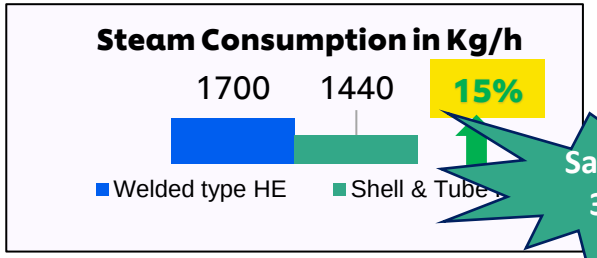
AFTER

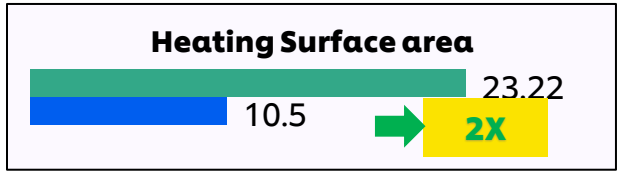
Shell & Tube Heat Exchanger

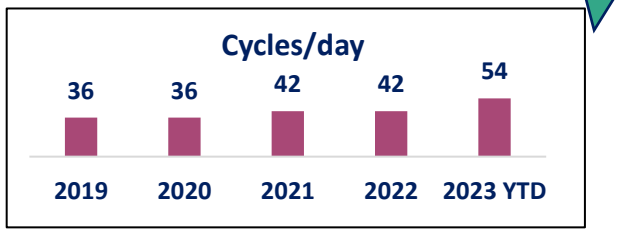
Capex – 15L

B/C – 0.93









Draw Transfer Pump Capacity Upgradation

BEFORE

3 HP Pump
40 NB Pipeline

AFTER

5 HP Pump
50 NB Pipeline

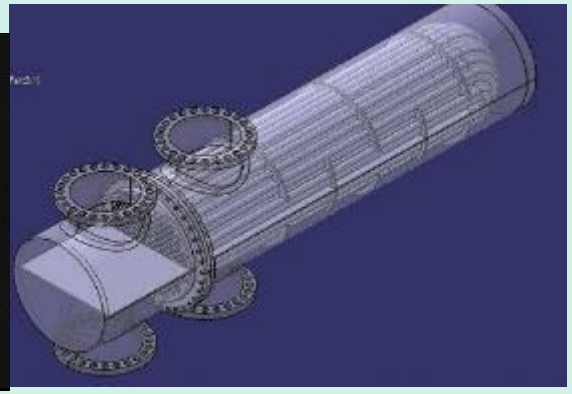
60% redn in Draw transfer time

Post Extraction PHE replacement to Shell n tube

BEFORE

Plate Type Heat Exchanger

AFTER



Shell & Tube Heat Exchanger

Savings – 3.3 Cr

Cleaning Time Reduced by 4X

2. EVAPORATOR UPGRADATION-INCREASE IN WATER EVAPORATION CAPACITY

Increase rate of water evaporation

- Replace with a new evaporator of higher water evaporation capacity → High Capex, High lead time
- Increase recirculation → Scaling Issue in long term, Lower capacity
- Decrease diameter of tubes → Increase in number of tubes-Changes in Design, Long implementation time
- Increase number of effects → Good Steam Economy, Low lead time, Low capex

Value Engineering Capex Avoidance: 4.6 Crores

Capex Avoidance of 4.6 Cr

Existing Evaporator Upgradation			New Evaporator
PARAMETER	**Option-1**	**Option-2**	**Option-3**
Feed rate	5460kg/h	7000kg/h	6000kg/h
Initial Solids	11.5%	11.5%	11.5%
Concentrate Solids	55%	55%	55%
Concentrate Output	1390kg/h	2557kg/h	1000kg/h
Total Water Evaporation	4070kg/h	4,674kg/h	5000kg/h
Steam Economy	4.3	5.5	5.0
Final Price (Cr)	2.01	2.615	7.25

Upgradation by increasing the heat transfer area and number of passes in one effect and by adding additional calandria for the other two existing effects with low capex and no increase on utilities to achieve desired rate of water evaporation.

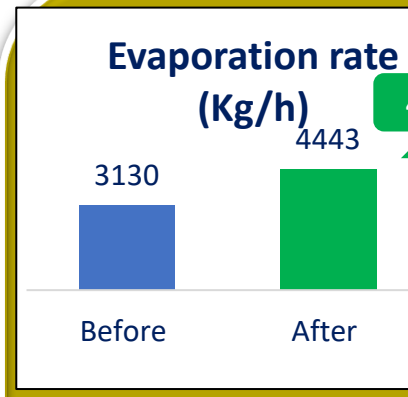
2. EVAPORATOR UPGRADATION & HIGH CONCENTRATION SPRAY

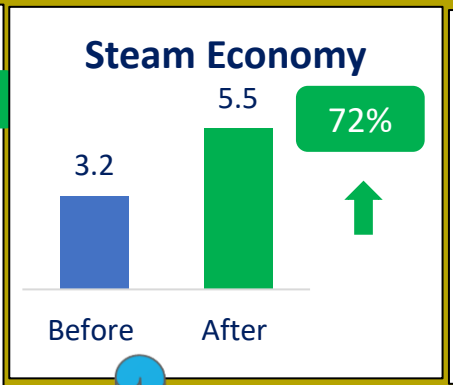
EVAPORATOR UPGRADATION

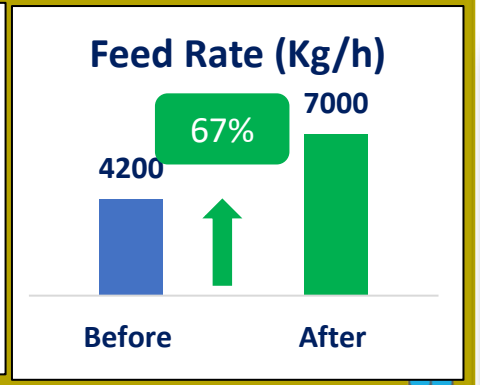
BEFORE

AFTER

Additional Calandria + Muti passes



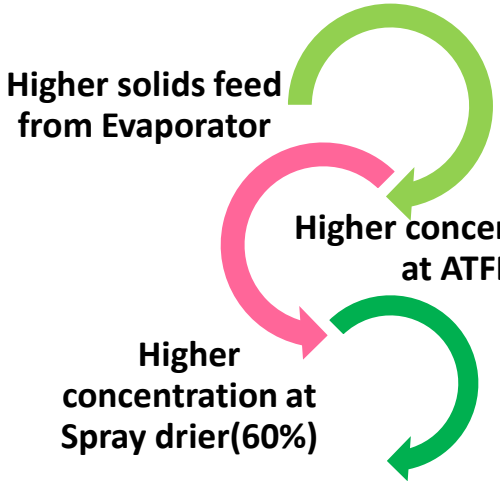


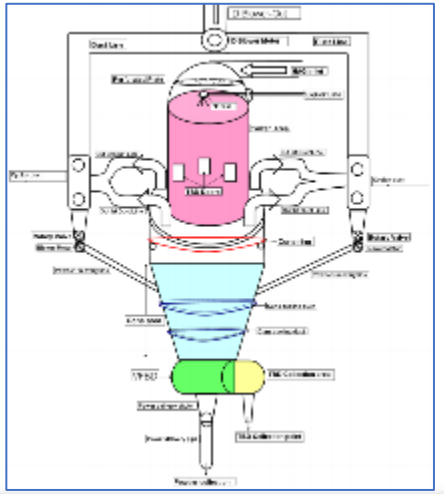


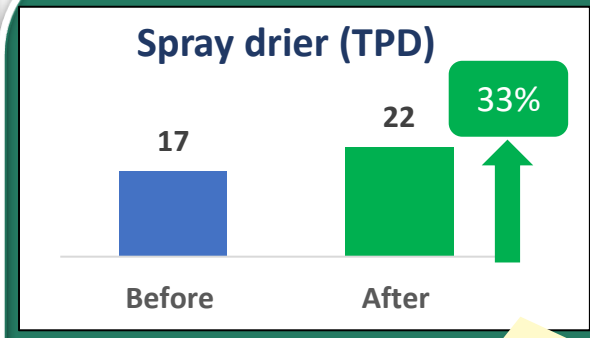
Noise level dropped by 14% through reduction of steam inputs

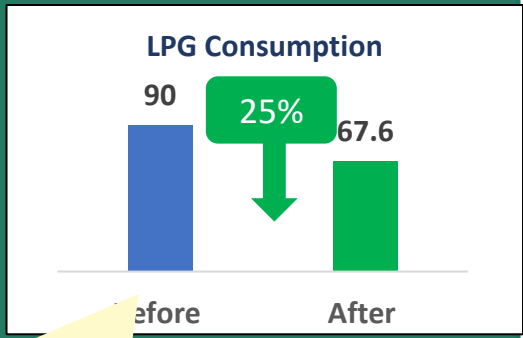
Steam Consumption reduced by 20%

HIGH CONCENTRATION SPRAY









Utility Savings – 1.1 Cr

3. SFR IMPROVEMENT IN BOILER & USAGE OF LOW-COST ALTERNATE FUEL

Higher Outlet Temperature

BEFORE

Single spiral inside boiler tubes of shell drum

AFTER

Two spirals welded together to cover boiler tubes completely

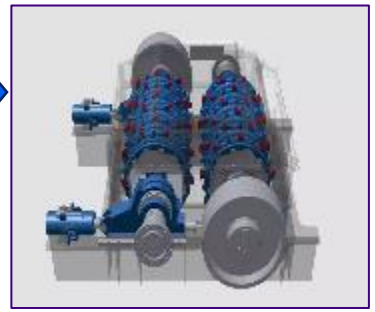
Improved heat recovery **by 15%** from 280deg to 240 deg increasing steam generated

Low Fuel Density

BEFORE

Fuel density – 250 kg/m3

AFTER



Fuel density – 450 kg/m3

- Adjusted Roller positions to increase fuel density by **1.8X**
- Increased ID draft to **-2.5mm from -1.5mm**

Low-Cost Alternate Fuels Usage

Mango Seed

Dried Lagoon Sludge

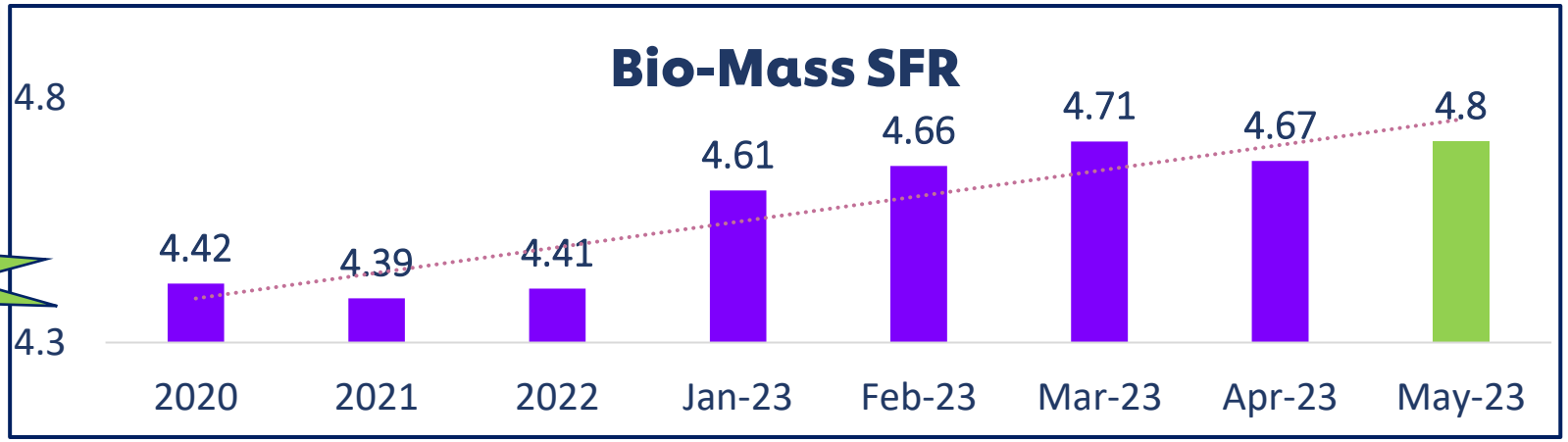
to beat and inflation of 25%

Usage of two alternate low-cost SUPER FUELS:

- Crushed Mango Seed
- Dried Lagoon Sludge

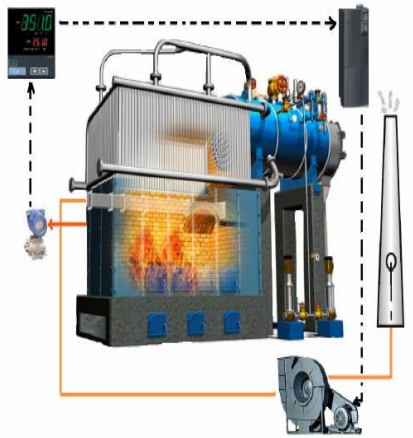
RESULTS

680 Bps



Replication Potential in Boilers across factories

3. BOILER HUB - LEVERAGING DIGITAL TO REACH EXCELLENCE



Improvement in Specific Fuel Consumption in Biomass Utility by **5%**

Data Streaming & Visualisation

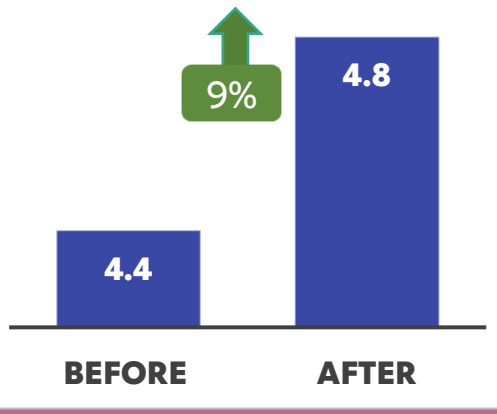
HMI Visualisation | Real time Data Streaming | Dashboards

Delivered Savings of **33L**

And the same is deployed at 8 other sites

Hosur Results

Steam Fuel Ratio-Hosur

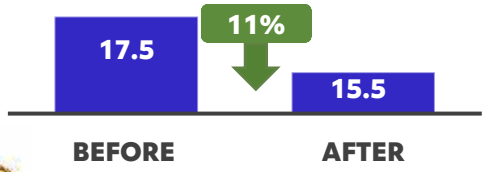


Specific Energy GJ/T-Hosur

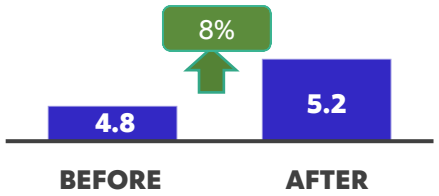
Horizontal Replication Results

Steam Fuel Ratio-Nashik

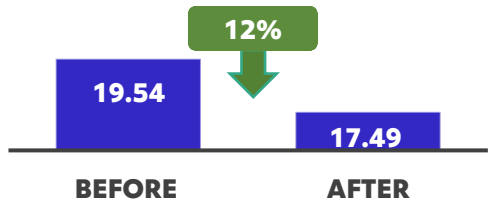
Specific Energy GJ/T-Nashik



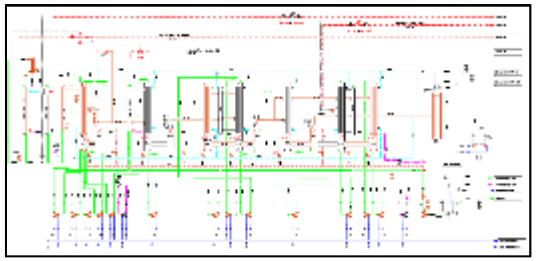
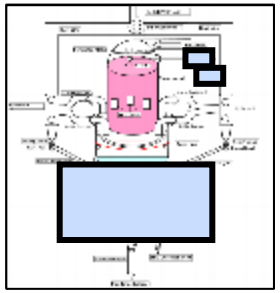
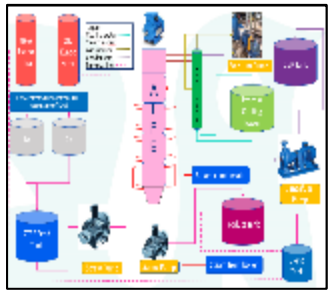
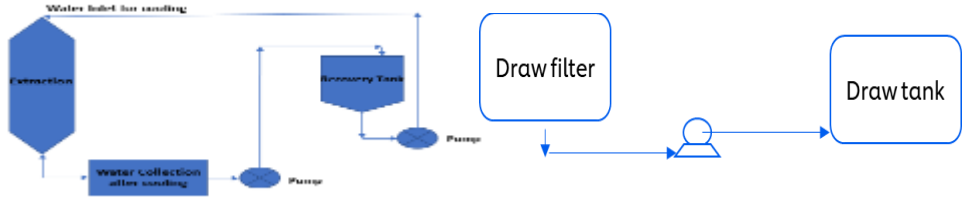
Steam Fuel Ratio-Mysore



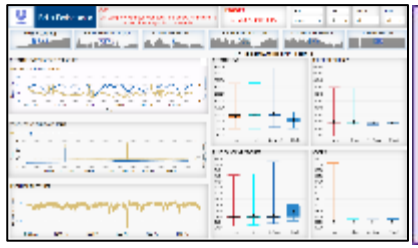
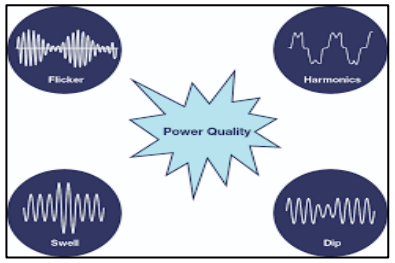
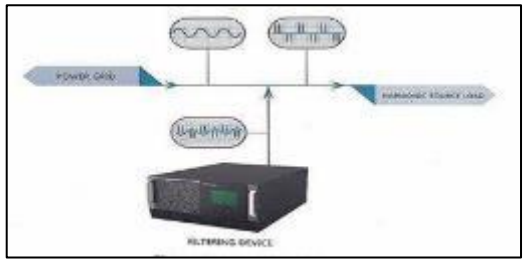
Specific Energy GJ/T-Mysore



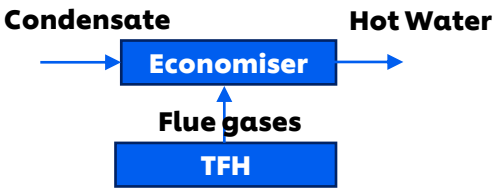
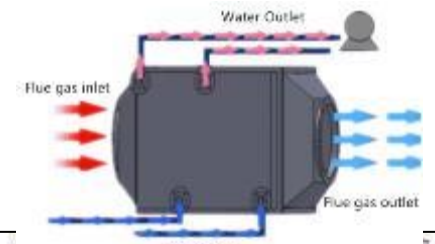
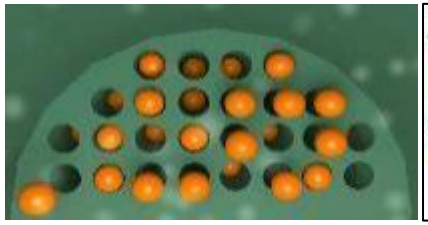
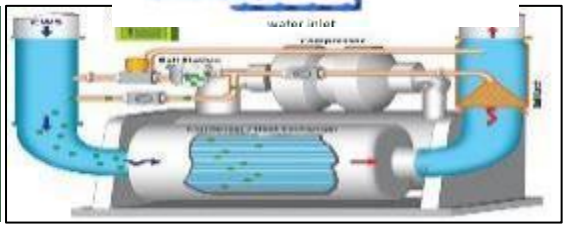
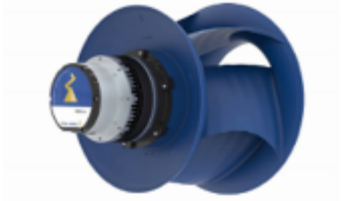
MAJOR ENERGY CONSERVATION PROJECTS IN LAST ONE YEAR

DESCRIPTION	PROJECT	SAVINGS	UNIQUENESS	REPLICATION POTENTIAL
Single Extractor Operation Optimization of Extraction Feed Water Temperature & Increase in Draw off factor		**3.43 Cr**	Capacity Unlock & Energy Savings by **sweating assets**	Replicated in HUL Mysore Factory & replicable in any coffee factory
Evaporator Upgradation Increase in water evaporation capacity by upgrading existing evaporator	 	**1.1 Cr**	Capex avoidance of 4.6 Cr through **Value Engineering**	Easily replicable in any evaporator
High Concentration Spray Increase in spray concentration to decrease LPG & Steam consumption	  	**0.8 Cr**	**Capex Avoidance** for Spray Drier by optimization of operating parameters	Replicated in Mysore Factory. Replicable in other spray driers
Draw filter liquor & Quench Water recovery & Reuse Reuse in Extraction operation and reduction in load on ZLDP		**20 Lakhs**	Conversion of Crisis into Opportunity. **Nothing goes waste!**	Easily replicable. Replicated in Mysore HUL

MAJOR ENERGY CONSERVATION PROJECTS IN LAST ONE YEAR

DESCRIPTION	PROJECT	SAVINGS	UNIQUENESS	REPLICATION POTENTIAL
SFR Improvement in Boiler Improvement in SFR from 4.4 to 4.8 through Digitalization	  	**33 Lakhs**	Big results through small changes/kaizens	Easily replicable in CPRG Boilers
Low-Cost Alternate Fuel Usage of low-cost alternate fuels like Mango Seed & Lagoon Sludge	 	**55 Lakhs**	Conversion of Crisis into Opportunity. **Nothing goes waste!**	Easily replicable. 3 Sites in HUL have started trials
Active Harmonic Filters AHF Installation to improve PF and reduce harmonic losses	 	**17.6 Lakhs**	Low-cost solution to reduce harmonic losses	Easily replicable in any factory
Energy Efficient Pumps Usage of energy efficient pumps (IE4 & IE5 motors)	  	**33 Lakhs**	Simple & Energy Efficient	Replicated for high energy consuming pumps. Easily replicable

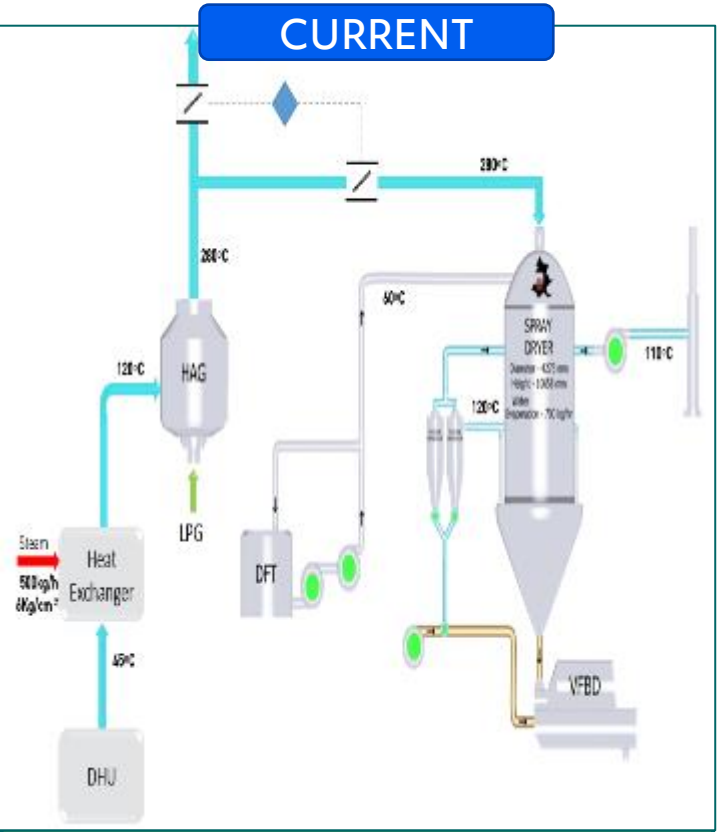
MAJOR ENERGY CONSERVATION PROJECTS IN 2023-WIP

DESCRIPTION	PROJECT	SAVINGS	UNIQUENESS	REPLICATION POTENTIAL
Heat Recovery System-TFH Usage of flue gas from TFH to pre-heat the extraction feed water	 	1.5 Cr	Flue gas heat recovery and elimination of steam usage for heating	Replicable for Boilers and TFH with hot water requirement
ATCS Usage of automatic tube cleaning system for chillers and heat exchangers	 	11 Lakhs	Simple & Energy Efficient. Eliminates chemical cleaning	Easily replicable in Chillers & Shell & Tube Heat Exchangers
FRP Fans for Cooling Towers Usage of FRP fans instead of conventional aluminium fans	 	4 Lakhs	Cost Effective, Simple & Energy Efficient	Easily Replicable for any cooling towers
EC Blowers Usage of EC Blowers in DHUs	 	10 Lakhs	Energy Efficient & Easy to use	Easily replicable
Eco Clean Dosage in Cooling Towers Dosage of Eco Clean Liquid to reduce the blow down frequency and load on ETP	 	7 Lakhs	Low-cost solution to eliminate blowdown	Easily replicable

BIG BETS 2023

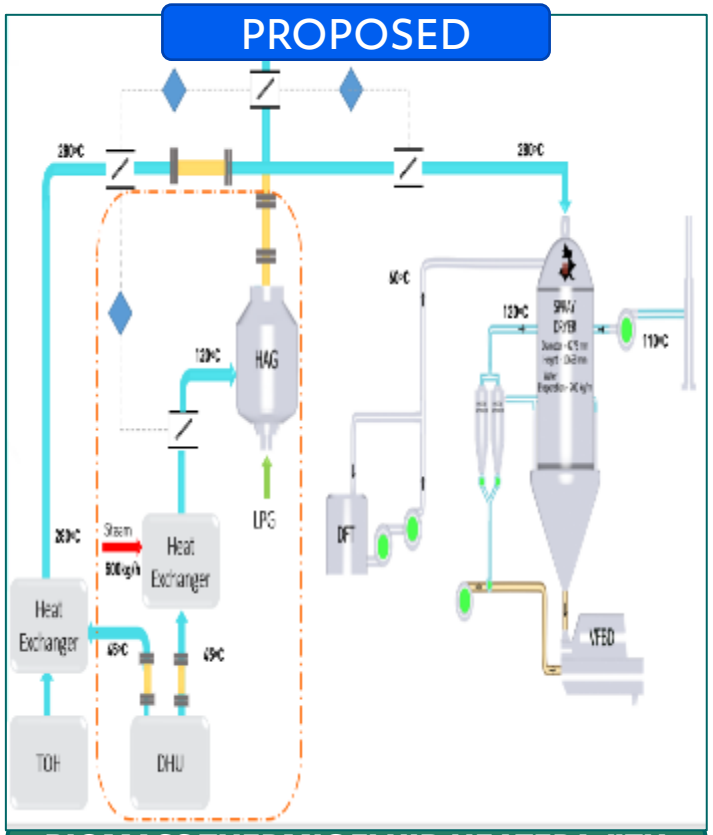
BIOMASS BASED HAG TO ELIMINATE LPG IN SPRAY DRIER

CURRENT



DIRECT FIRED WITH LPG AS FUEL
HAS MULTIFUEL OPTION FOR BIODIESEL/ HSD AND LPG

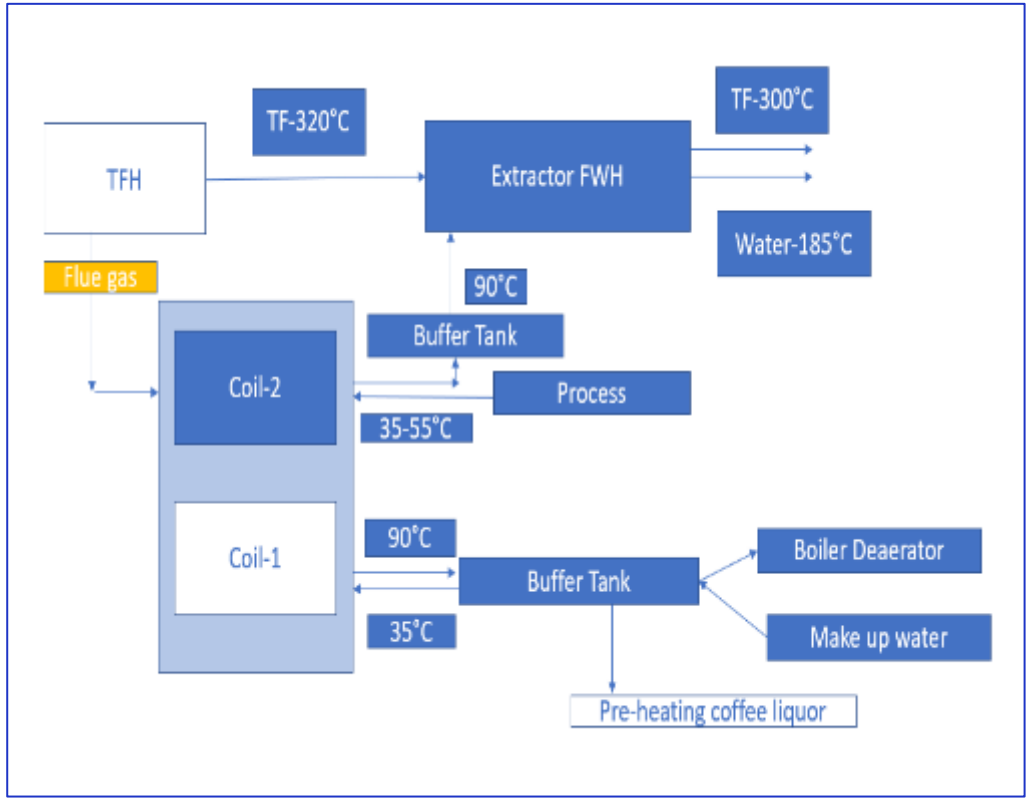
PROPOSED



BIOMASS THERMIC FLUID HEATER WITH LIQUID TO AIR HEAT EXCHANGE
MOVING FROM DIRECT FIRED TO INDIRECT FIRED
EXISTING HAG USED AS BACK UP

Reduction in CO2 by 1887.5 Tons/Year || Annual Savings 4 Cr

HEAT RECOVERY SYSTEM FOR THERMIC FLUID HEATER



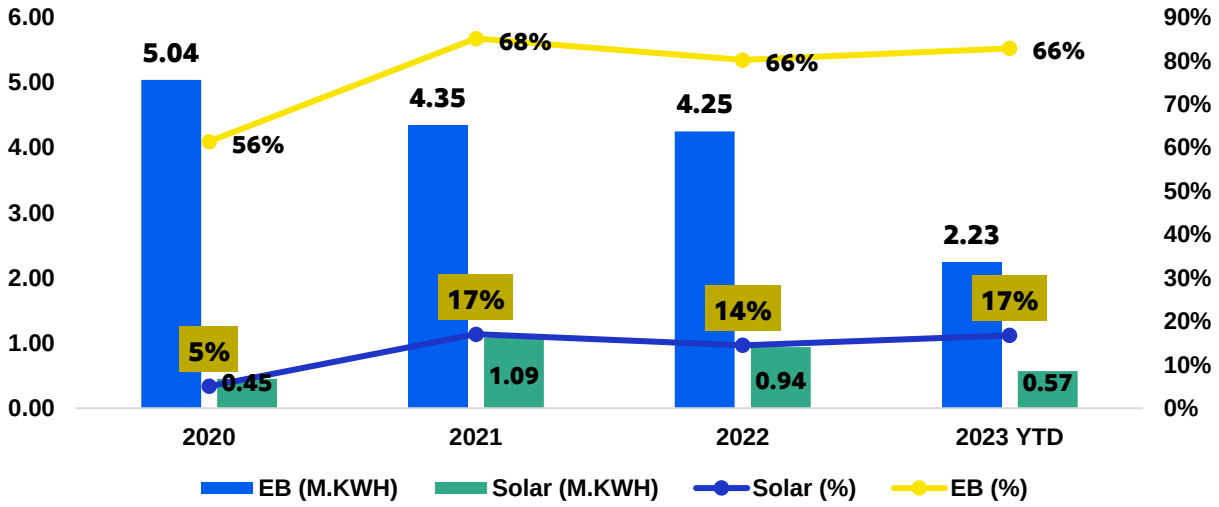
Recovery of Flue gas from TFH and Reuse for pre-heating the Extraction Feed Water, which was earlier heated using steam.

Annual Savings: 1.7 Cr, 30 TPD reduction in steam

UTILIZATION OF RENEWABLE ENERGY SOURCES

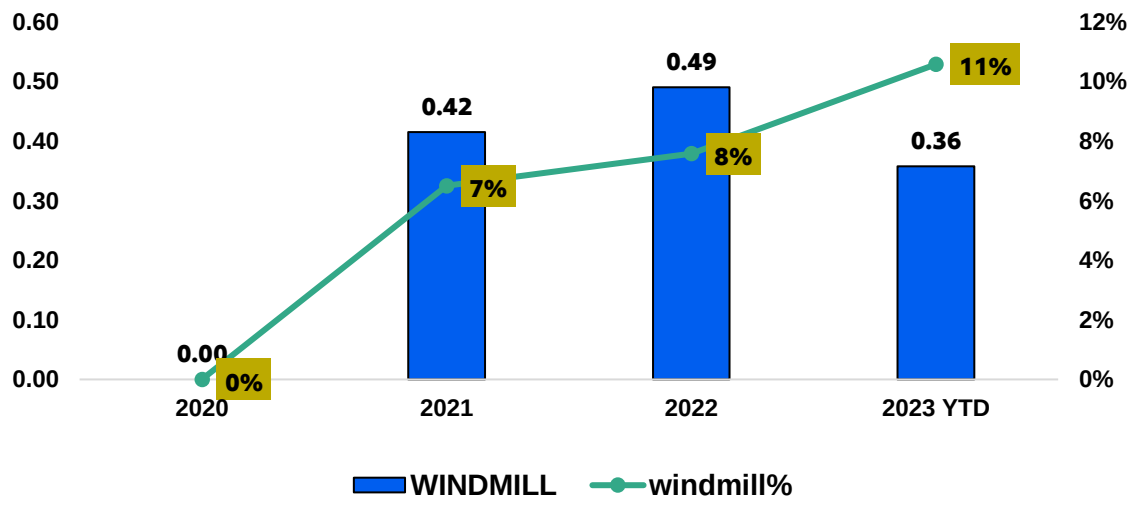
1 MW Onsite Solar Plant

Electrical Onsite-Renewables (Million-KWH)

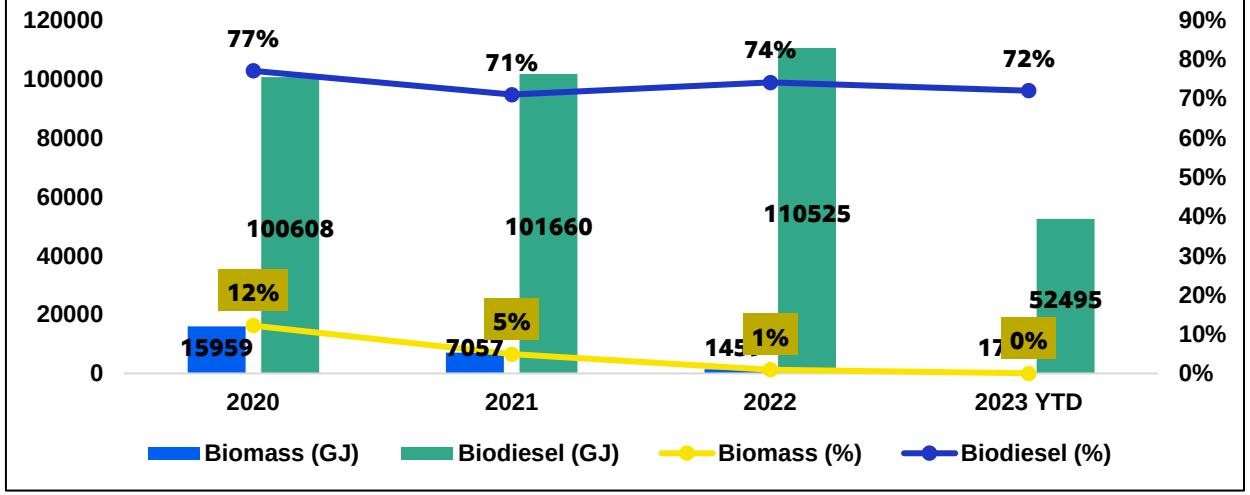


2 Offsite Windmills (225 KW each)

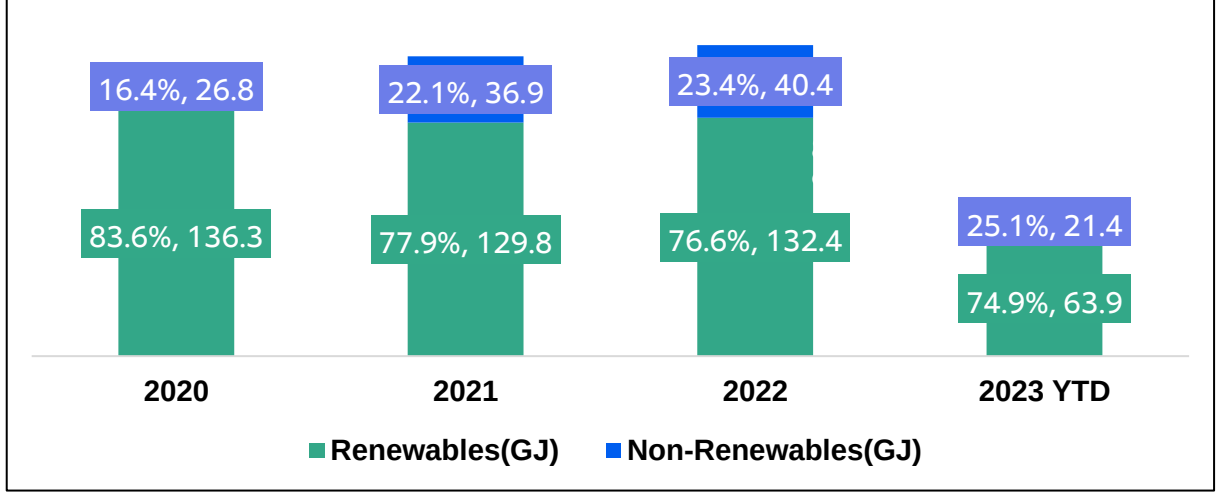
Electrical Offsite Renewables (Million-KWH)



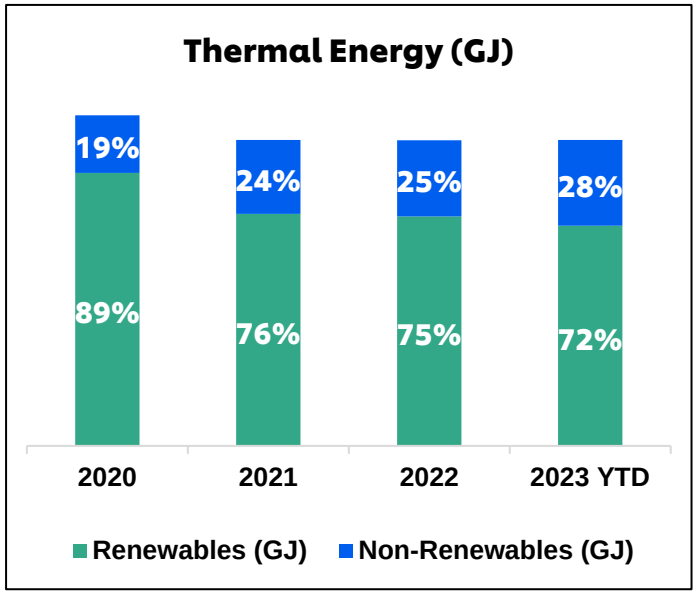
Thermal-Renewables

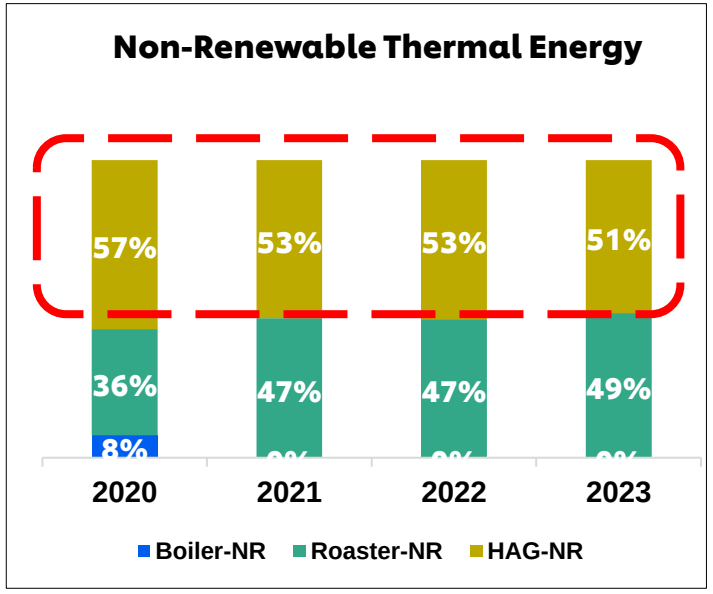


Total Energy (GJ)



RENEWABLE ENERGY MAXIMISATION TO REDUCE GHG EMISSIONS





Biomass Based HAG-Thermic Fluid Heater

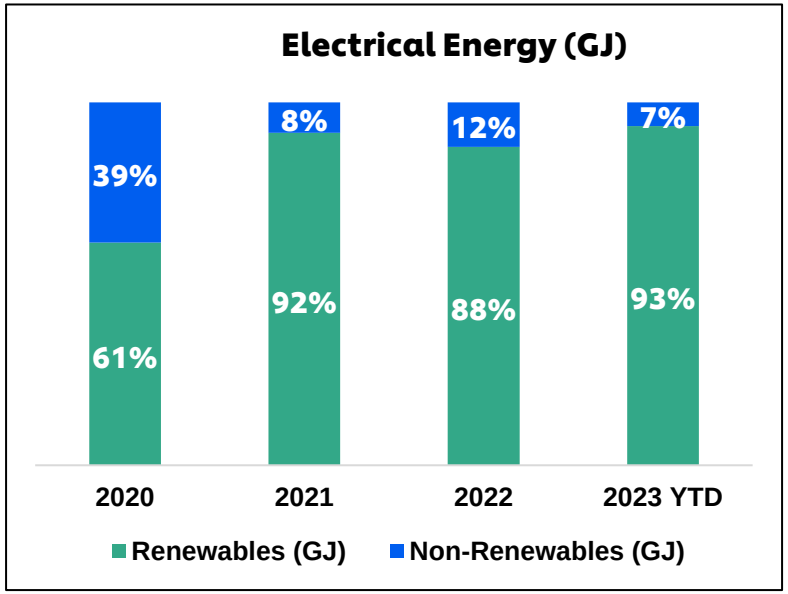
Dual Burner in Roaster for Biodiesel

NIL Use of Oil Boiler

ZERO LPG in Spray Drier by Dec'2023

Capability established but LPG is economical

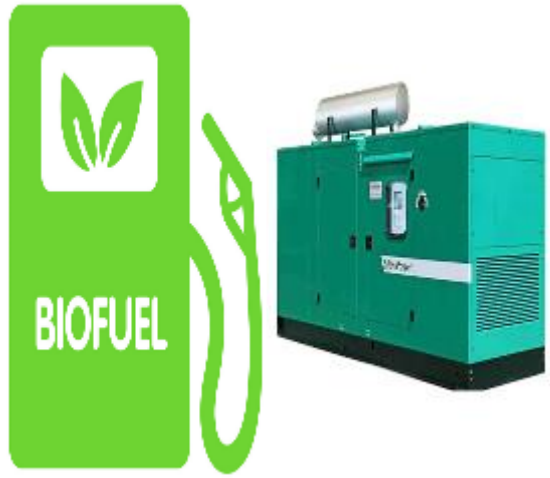
Zero Breakdowns in Bio-Boiler in 2022



1 MW Onsite Solar Plant

3 Offsite Windmills

Biofuel usage in DGs



GREEN SUPPLY CHAIN MANAGEMENT-ORGANISATION'S BRANDING UNILEVER'S SUSTAINABLE LIVING PLAN

Win with our brands, powered by superior products, innovation and purpose

Improve the health of the planet

Climate action	Protect and regenerate nature	Waste-free world
Net zero emissions from all our products from sourcing to point of sale by 2039	Deforestation-free supply chain in palm oil, paper & board, tea, soy and cocoa by 2023	50% virgin plastic reduction by 2025, including an absolute reduction of 100,000 tonnes
Halve greenhouse gas impact of our products across the lifecycle by 2030	Help protect and regenerate 1.5 million hectares of land, forests and oceans by 2030	25% recycled plastic by 2025
Zero emissions in our operations by 2030	100% sustainable sourcing of our key agricultural crops	Collect and process more plastic than we sell by 2025
Replace fossil-fuel derived carbon with renewable or recycled carbon in all our cleaning and laundry product formulations by 2030	Empower farmers and smallholders to protect and regenerate farm environments	100% reusable, recyclable or compostable plastic packaging by 2025
Share the footprint of every product carbon we sell	Implement water stewardship programmes in 100 locations in water-stressed areas by 2030	Halve food waste in our operations by 2025
	100% of our ingredients will be biodegradable by 2030	Maintain zero waste to landfill in our factories

Supported by: **€1 billion Climate & Nature Fund**

GREEN SUPPLY CHAIN MANAGEMENT: BUDGET & POLICY

Budget Allocation

- Unilever Clean Tech Fund: Projects aligned with long term strategic vision for the site on Sustainability

Unilever Clean Tech Fund

Annual Carbon Footprint of UL Manufacturing

X **€70 / Tonne Carbon price**

=

Unilever CleanTech Fund

Financing carbon reduction projects

Our Policy

- Policy displayed in local language at various locations
- Policy approved by central committee
- Regular communication of the policy to ensure good level of awareness among employees

EMS – Environment Management System Pyramid

GHG INVENTORISATION & ACTION PLAN-CARE FOR PLANET

Alternate Fuel usage

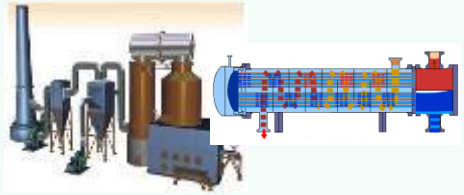
820 Kg/ton CO2 reduction

HSD → LPG in HAG & Roaster ✓

869 Kg/ton CO2 reduction

HSD → Biodiesel in Boiler ✓

1880 Tons/Year of CO2 Reduction



Biomass based TFH for HAG ●

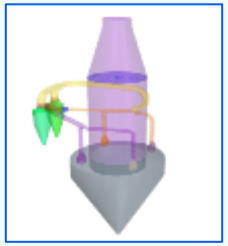
Thermic Fluid Based FWH & HRS ●

Reduce Energy Consumption

Boiler Digitization

Steam Fuel ratio improved from 4.4 → 4.8 ✓

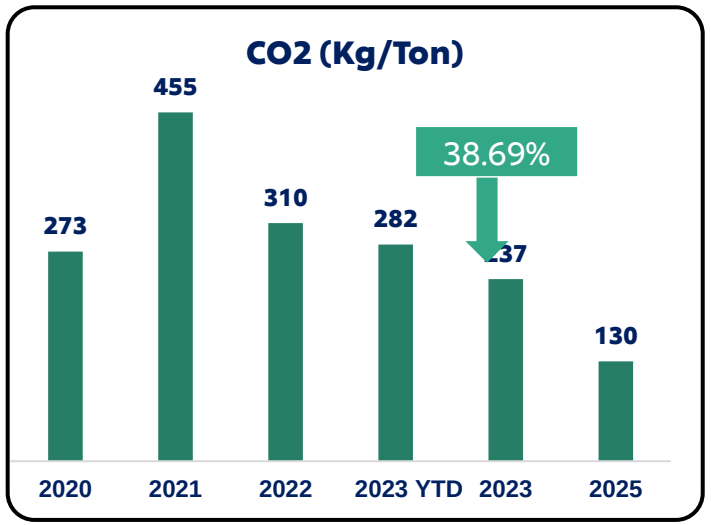
Air Preheater in Roaster ✓

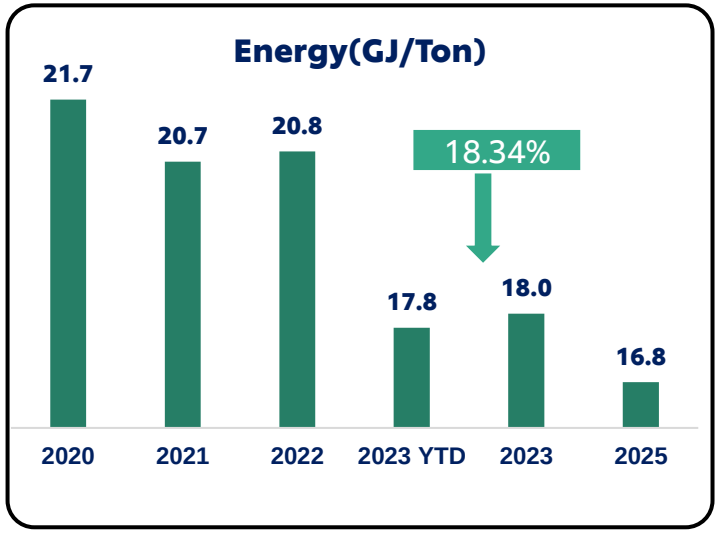


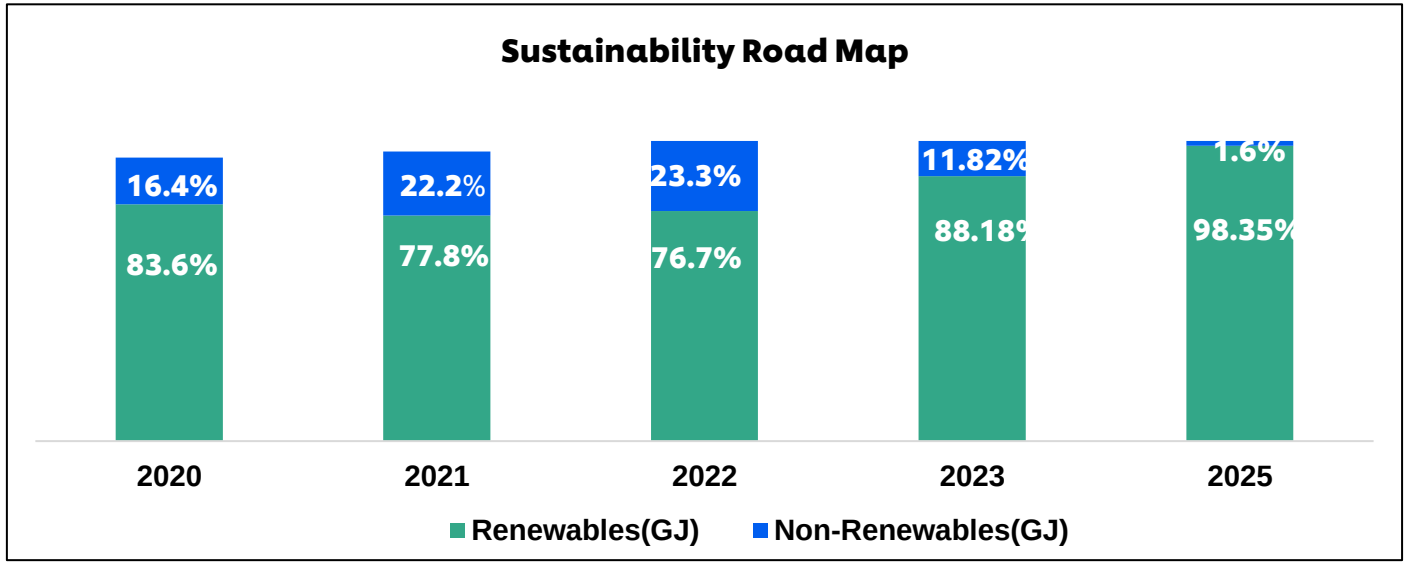
Increase in Spray concentration ✓

- EC Motors for DHUs
- ATCS for Chillers
- FRP Fans in Cooling Towers

●





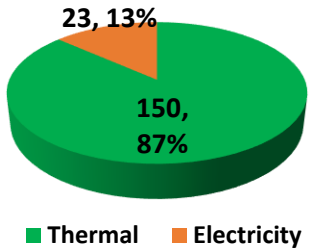


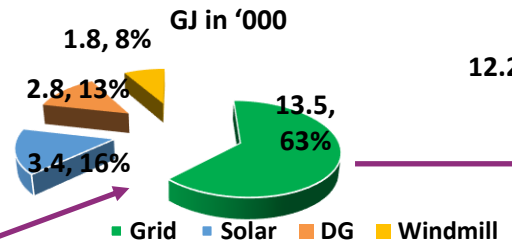
Ambition is 58% reduction in CO_2 & 98% of energy sourced to be GREEN ENERGY by 2025

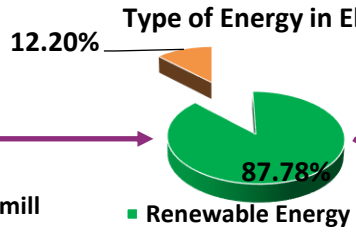
RENEWABLE ENERGY & GHG EMISSIONS-WHERE WE ARE & WHAT WE AIM!!

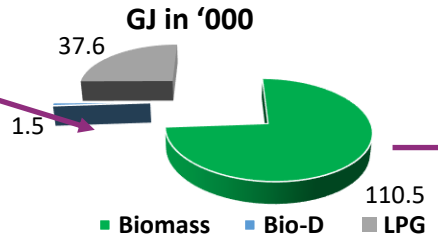
2022 ANALYSIS

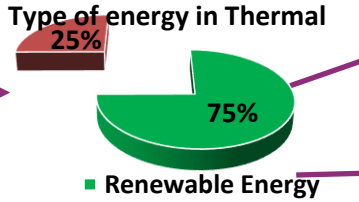
Energy Break up in 000'GJ



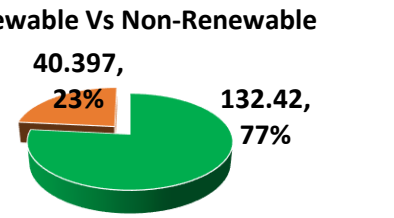






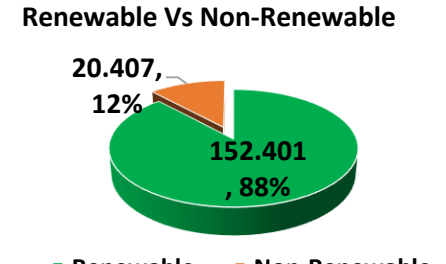


213 ton CO2/annum

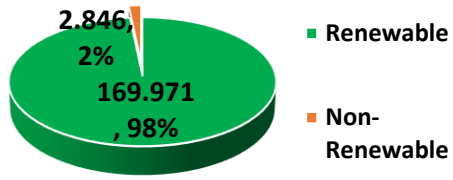


2358 ton CO2/annum

TARGET-2023 FY



Ambition-2025



Thermal Energy

- **Elimination of LPG** in Spray Drier HAG by end of 2023 through Biomass Based HAG.
- Strategic sourcing of biofuel for Roaster to replace LPG since **technical capability is already in place** and cost is the constraint.

ACTION PLAN

Electrical Energy

- **Offsite Solar Boot Model** with banking in addition to the existing 1 MW onsite solar plant.
- **Biofuel usage in DGs** to reduce and eventually eliminate usage of HSD in DGs.

EMS SYSTEM & LEARNINGS FROM CII

Need

- ✓ **Risk of misreporting energy consumption due to manual intervention.**
- ✓ **Limited coverage of feeders.**

System Description

- ✓ **Wireless system for monitoring energy via energy meters**
- ✓ **Live status of machines on web portal – current, power factor, load**

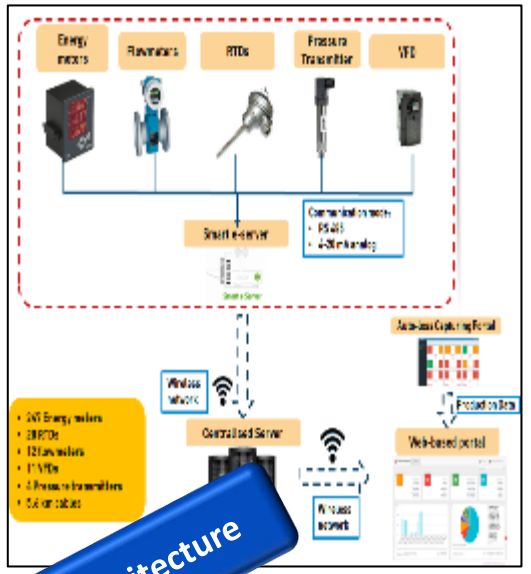
Benefits

- ✓ **Live energy consumption monitoring**
- ✓ **Minimal inaccuracy**
- ✓ **Timely action possible with dynamic data availability and monitoring**

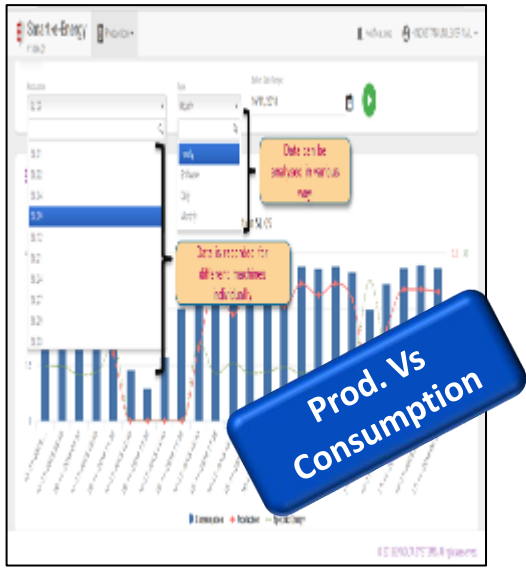
2022	2023	2024 JQ
▪ 30 Energy Meters Installed.	Setting up the architecture and covering all feeders & installation of 30 Energy Meters.	Cover Full Factory under EMS

- Real time monitoring of energy in key areas and analysis by comparing against golden batch specifications.
- 100% Feeders will be covered by 2024 JQ and full factory will be under EMS.

1. Daily monitoring of DG & Air Compressors performance
2. Daily monitoring of factory maximum demand
3. Daily monitoring of high energy consumption loads
4. Real time monitoring of SFR & steam consumption in critical areas with alerts.



Production Vs Consumption Trend



LEARNINGS FROM CII

Three Phase
induction motor with blower

HP Consumption : 157 HP
Power consumption per day=1611KWH

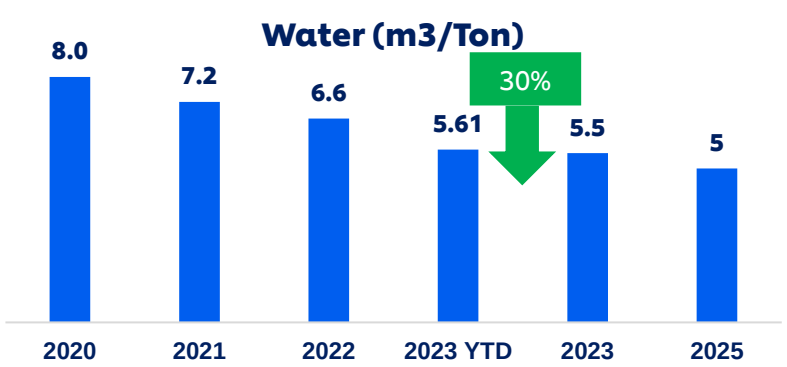
Electronically Commutated motor with blower

HP Consumption : 55 HP
Power Consumption per day=814KWH

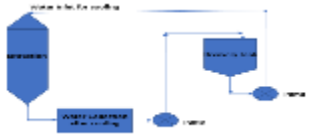
Idea of replacing conventional motors in our DHUs with **Electronically commutated motors** was adopted from one of the best practices presented in CII Energy Awards

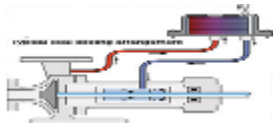
CARE FOR PLANET-WATER & WASTE

Water



Extraction quench water recovery
10 KL/day water savings





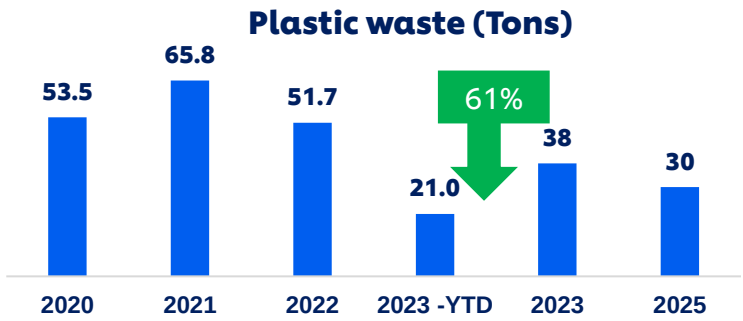
Recovery and reuse of Pump seal cooling water and quench water
3 KL/day water savings

RO system is used in the place of DM to reduce regeneration water.
20 KL/day water savings

Eco-Clean Dosing in Cooling Towers to reduce frequency of blow down

30% reduction in water consumption in past 5 years

Plastic Waste



24 Kl Liquid Chicory SS Tanks instead of Plastic Tanks

25 tons/year

Elimination of outer carry bags in HTS Coffee packs.

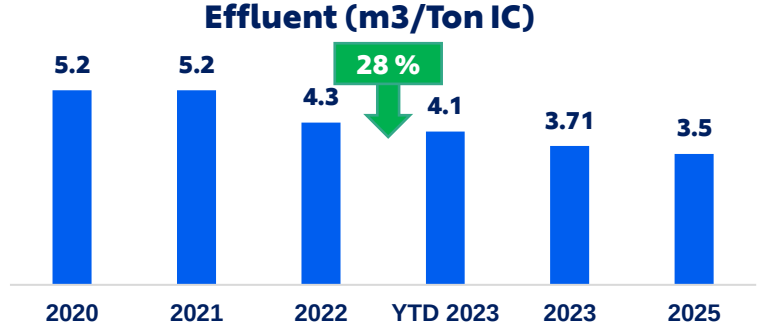
7.8 tons/year

MLP laminate change in SS/Tripti 200g

Repurposing of shredded laminate for making biofuel

75% reduction in plastic waste generation

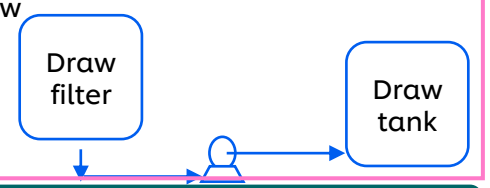
Effluent



Anaerobic Lagoon to Digester
9900 kl/year increase in water reuse

ETP sludge to boiler briquette
746 tons/year

Recovery of extractor draw filter liquor
360 kl/year of effluent reduction



18% reduction in Effluent generation

BEST PRACTICES & KEY INITIATIVES @ HOSUR

ZERO LIQUID DISCHARGE PLANT TREATED WATER USED BACK IN PROCESS

USAGE OF ALTERNATE FUELS LIKE MANGO SEEDS

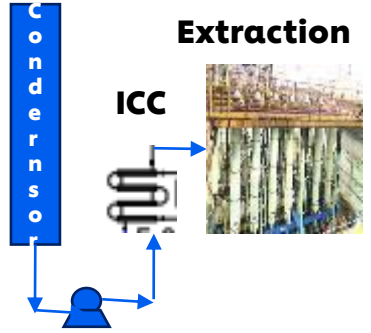
REPLACEMENT OF BAG FILTERS WITH ESP

Reduction in PM from 150 Mg/Nm^3 to 50 Mg/Nm^3

INSTALLATION OF RECD FOR DGS

~90% reduction in PM & CO, 50% reduction in NO2 and SO2

CONDENSATE RECOVERY & REUSE IN EXTRACTION



INSTALLATION OF ANAEROBIC DIGESTOR AND DEMOLITION OF 40-YEAR-OLD SLUDGE LAGOON

- Installation and commissioning of **Anaerobic Digestor** with Flare System.
- Emptying of anaerobic lagoon by removing **5000+ tons of sludge** with ZERO near misses & incidents.
- **Reuse** of the lagoon sludge as boiler fuel post drying and mixing it with briquettes.
- Backfilling will be done.
- Elimination of one of the significant risks in factory.
- Reduction in effluent treatment by **15 Kl/day** during monsoons **(~780 Kl/year)** with an equivalent utility savings of **~5 Lakh/annum**.

AWARDS & RECOGNITIONS-WAY TO NET ZERO

2019

Achievements

1. Co2 Reduction – 680 Kg/ ton
2. Water Reduction- 1.8 Kl/ton
3. Energy Reduction – 0.7 GJ/ton
4. Waste Reduction - 6.7 tons

2020

Achievements

1. Co2 Reduction – 187 Kg/ton
2. Water Reduction – 0.6 Kl/ton
3. Energy Reduction – 0.1 GJ/ton
4. Waste Reduction – 4.5 tons

2021

Achievements

1. Co2 Reduction – 25 kg/ ton
2. Water Reduction – 0.8 Kl/ton
3. Energy Reduction – 1.0 GJ/ton
4. Waste Reduction – 22.4 tons

2022

Achievements

1. Co2 Reduction – 133 Kg/ton
2. Water Reduction – 0.1 Kl/ton
3. Energy Reduction – 0.2 GJ/ton

2025

Forecast

1. Co2 Reduction – 99%
2. Water Reduction – 50%
3. Energy Reduction – 19%
4. Waste Reduction – 65%

AMBITION TO BE PLASTIC AND WATER NEUTRAL WITH 98% GREEN ENERGY BY 2025

INTERNAL & EXTERNAL RECOGNITIONS

WOW STORIES

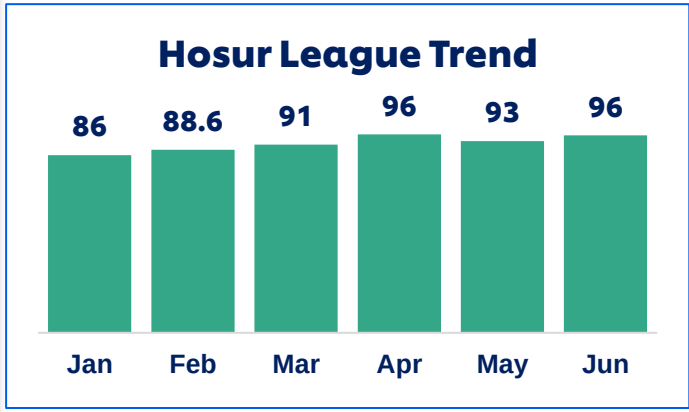
CII NATIONAL AWARD FOR ENVIRONMENTAL BEST PRACTICES

Leading in environmental practices

Our Hosur, Sonipat and Rajahmundry factories have each received CII's National Awards 2023 for Environment Best Practices.

Congratulations to the teams!

FACTORY LEAGUE PERFORMANCE



4th in SA Factory league

2nd in Cost League

Thank you

THANK YOU

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