25th National Award for Excellence in Energy Management - 2024

Enduring Value

ITC Limited

Agri Business Division

Karnataka Green Leaf Threshing Unit, Mysuru

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ITC LIMITED

GLANCE OF TRIPLE BOTTOM LINE PERFROMANCE

Enduring Value

ECONOMIC

- ₹ 69,446 cr Gross Revenue
- ₹ 20,422 cr PAT
- 25+ World-class Mother Brands
- 200+ Factories
- Among Top 3 Corporates in the Private Sector in Terms of Contribution to Exchequer over the Years
- 12 Future-ready Businesses across Agriculture, Manufacturing and Services

ENVIRONMENTAL

- 50% of ITC's Energy is from Renewable Sources
- 12 LEED® Zero Carbon and 4 LEED® Zero Water Hotels
- Plastic Neutral: Collecting and Sustainably Managing 70,000 MT of Waste
- Afforestation: Over 11.6 lakh Acres Greened
- Watershed Development: Over 16 lakh Acres Covered
- 7 Alliance for Water Stewardship Platinum Certified Sites

SOCIAL

- 60 lakh Sustainable Livelihoods Supported
- Support to Education: Over 15 lakh Children Benefitted
- Over 60 lakh Women reached through Multi-dimensional Programmes
- Skilling: Over 1 lakh Youth Trained
- ITCMAARS: Over 15 lakh Farmers Serviced
- Climate Smart Agriculture: Over 10 lakh Farmers Covered

ITC BRANDS


AASHIRVAAD


Sunfeast


fiama


Farmland


Vivel


classmate


DERMAFIQUE
cell by cell


SUNBEAN


Savlon


MANGALDEEP


Kitchens of INDIA


Sunfeast
YiPPee!
noodles


nimyle


SUNRISE
PURE


Home lites


AIM


Paperkraft


BINGO!


ENGAGE


ITC
MASTER
CHEF


B
Natural

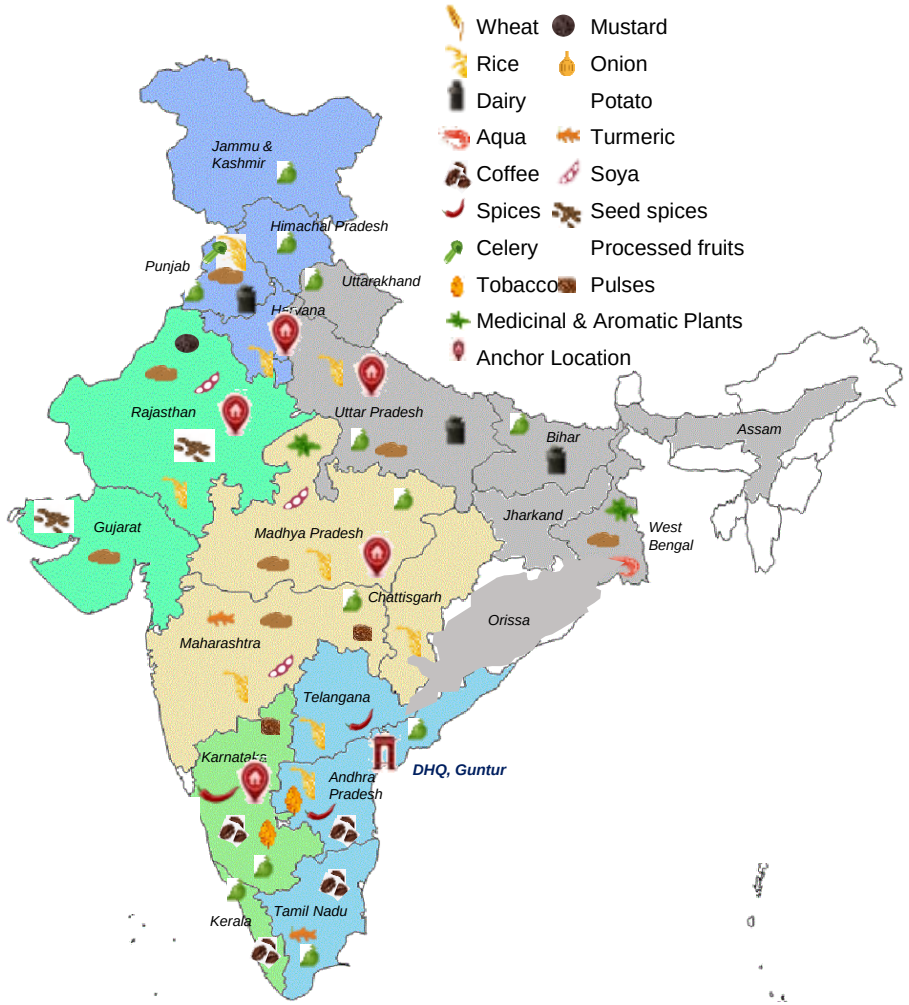

CANDYMAN


ITC HOTELS
RESPONSIBLE LUXURY
MEMENTOS
BY ITC HOTELS
WELCOMHOTEL
STORII
FORTUNE
Member ITC's hotel group
WH
WelcomHeritage
Palaces • Forts • Havelis • Resorts


FABELLE
Exquisite
CHOCOLATES

ITC ORGANIZATION – MULTI BUSINESS

FMCG	Hotels	Paperboards & Packaging	Agri Business	Infotech
Foods	Business Hotels	Paperboards	Grains, Pulses & Oilseeds	
Personal Care	Budget Hotels	Speciality Papers	Spices	
Education & Stationery	Palace & Resorts	Packaging & Printing	Aqua, Coffee	
Matches & Agarbattis	Travel Services		Fruits, Vegetables	
Cigarettes			Leaf Tobacco	



Leaf Tobacco:

- Largest Buyer, Processor & Exporter of Leaf tobaccos in India
- Serving customers over 50 countries & 70 destinations
- Green Leaf Threshing factories in AP & Karnataka

22 States

20+ Agri- Commodities

80+ Countries Export

KARNATAKA GREEN LEAF THRESHING (KGLT) FACTORY

1
M.Kg

195
TPD

5
M.Kg

731
Employees

Green Field Project commissioned 2011

Commercial Production 2012

Spread across 80 Acres

Green Cover 29 Acres (36%)

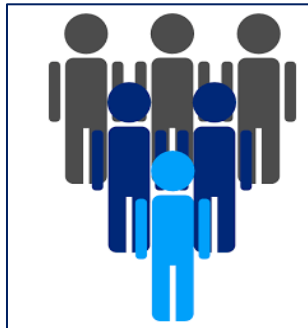
Plant Uptime 97.5%

Tobacco processing is done for following value addition.

- ✓ **Separation of Stem and lamina**
- ✓ **Improve the Shelf life of the product from 3 Months to 3 Years**
- ✓ **Separation of Non Tobacco Related Matter to ensure clean product**

ENERGY MANAGEMENT COMMITTEE

Thermal | Electrical | Water



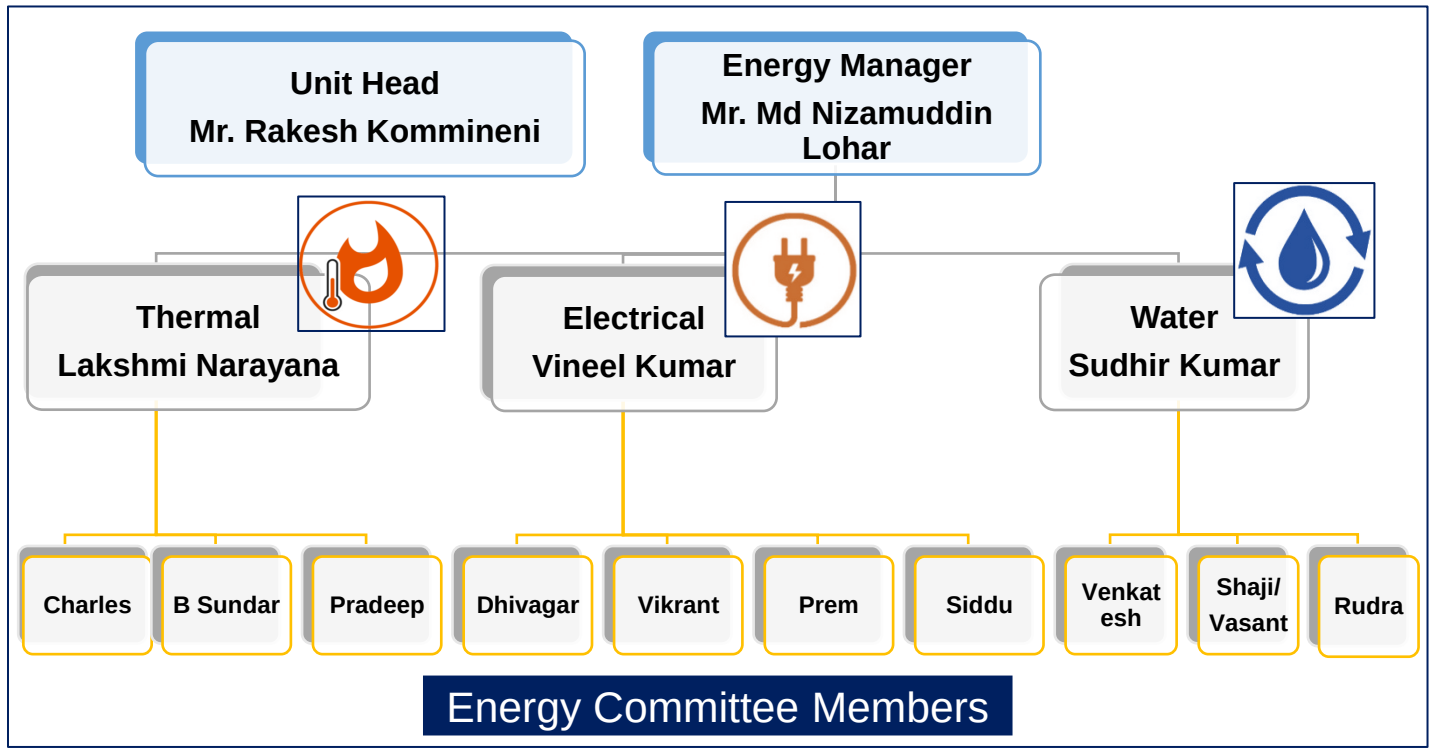
Roles & Responsibilities:

- Energy Management Plan and Execution
- Energy Audits and Assessments - Continual improvement
- Monitoring and Reporting
- Technology scan and faster adoption
- Education ,Motivation and Awareness
- Monthly Review Meetings and Completions

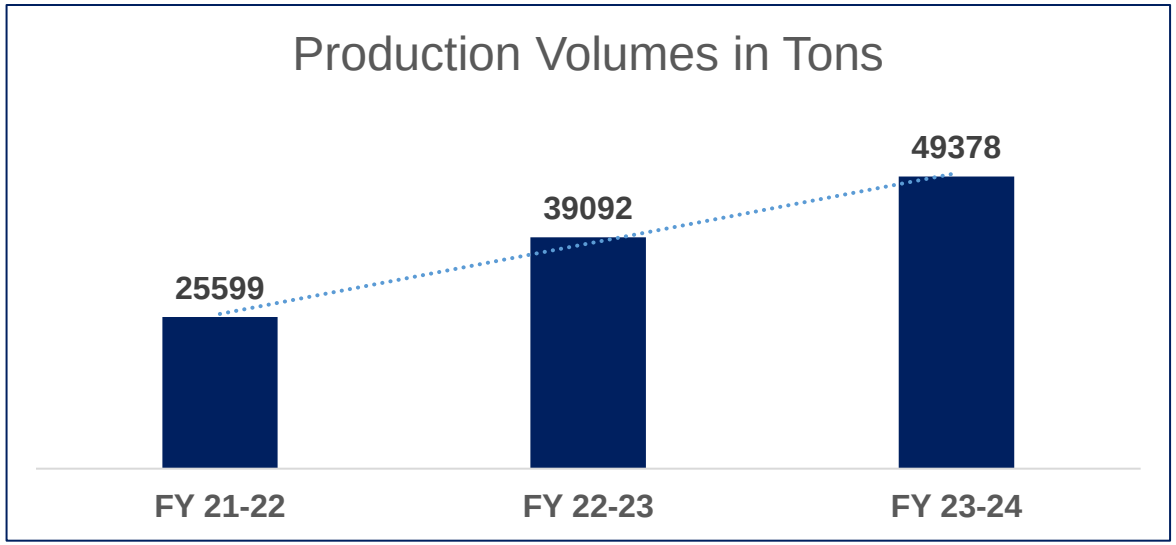
To achieve ESG 2.0 goals and ISO 50001 Certification

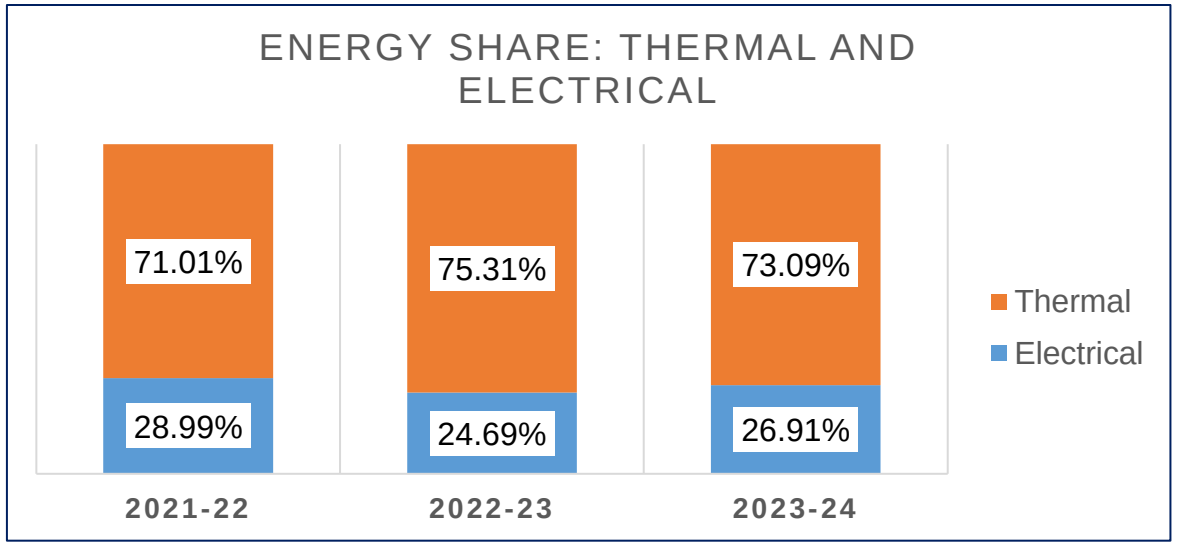
Best Energy Efficient GLT across the Globe

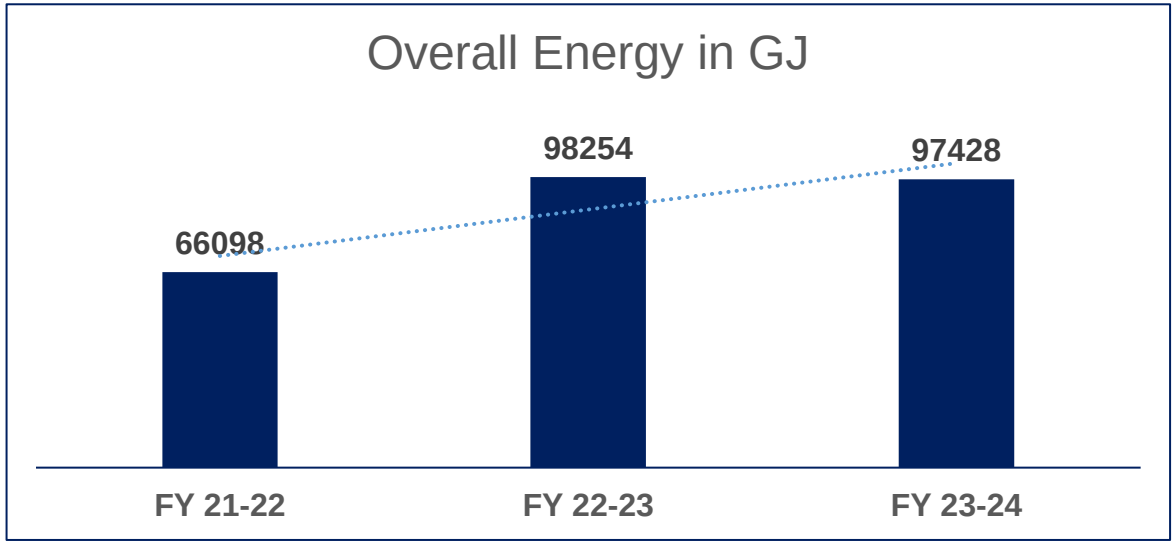
To have a structured approach & to focus on continual improvement towards conserving energy, tracking energy performance and lowering greenhouse gas emissions by educating on importance of effective utilization of energy.

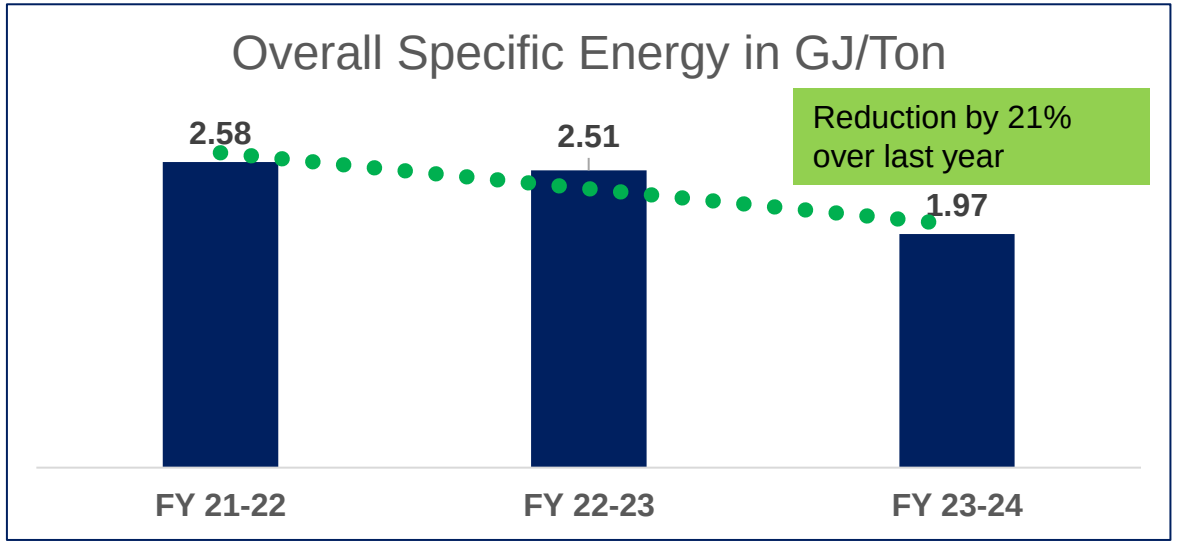


PRODUCTION - ENERGY CONSUMPTION - SEC



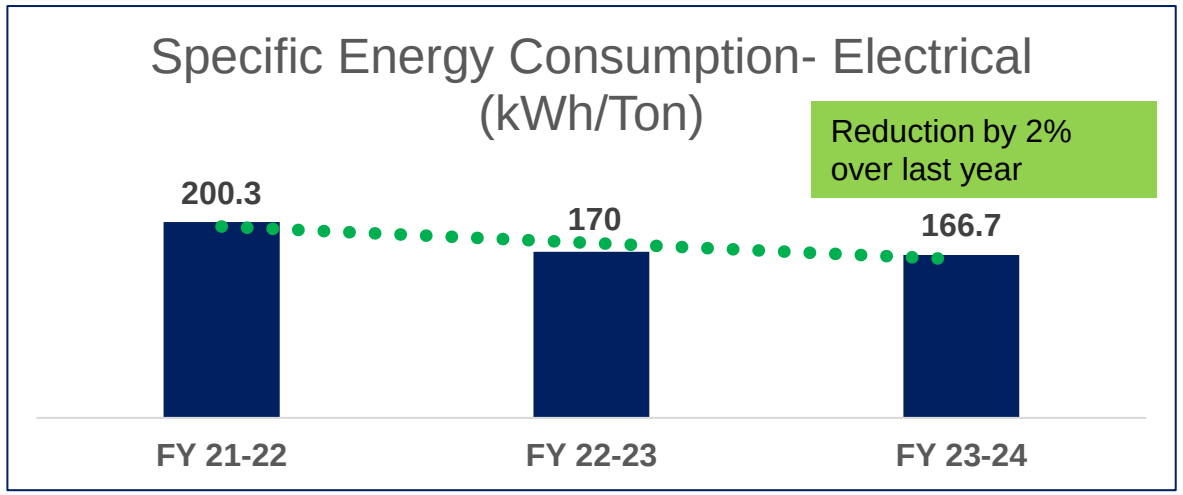


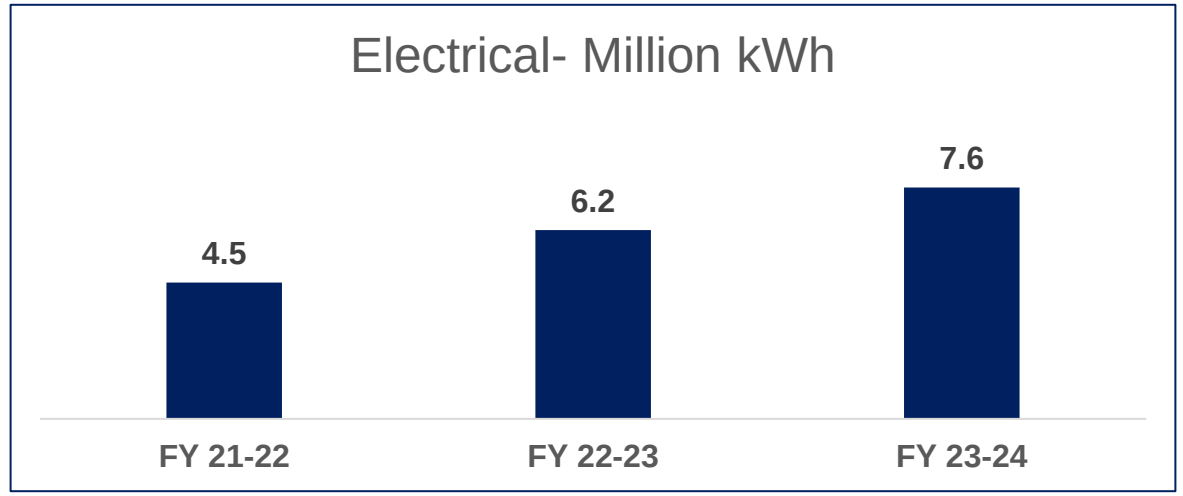




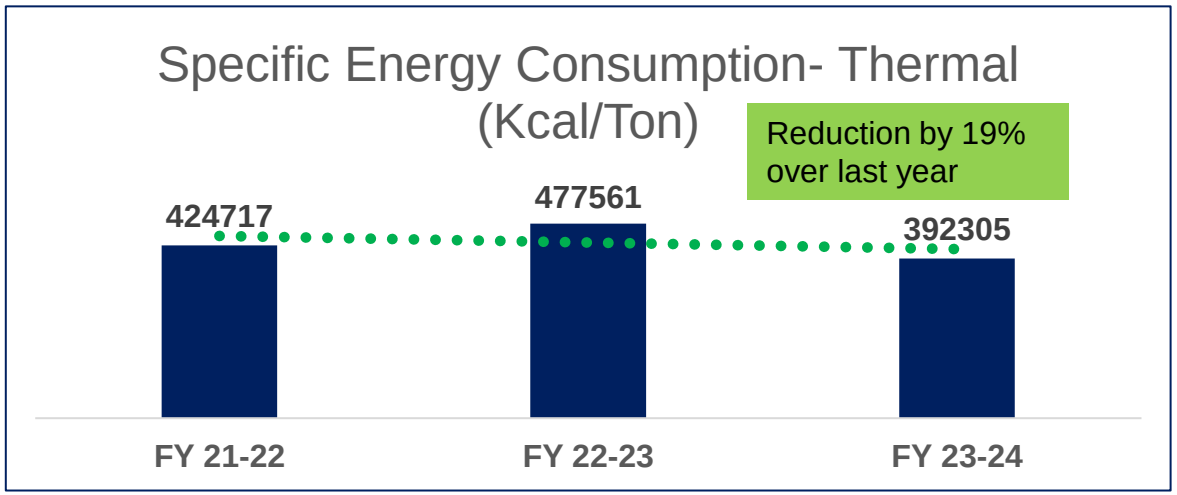
SPECIFIC ENERGY CONSUMPTION – THERMAL & ELECTRICAL

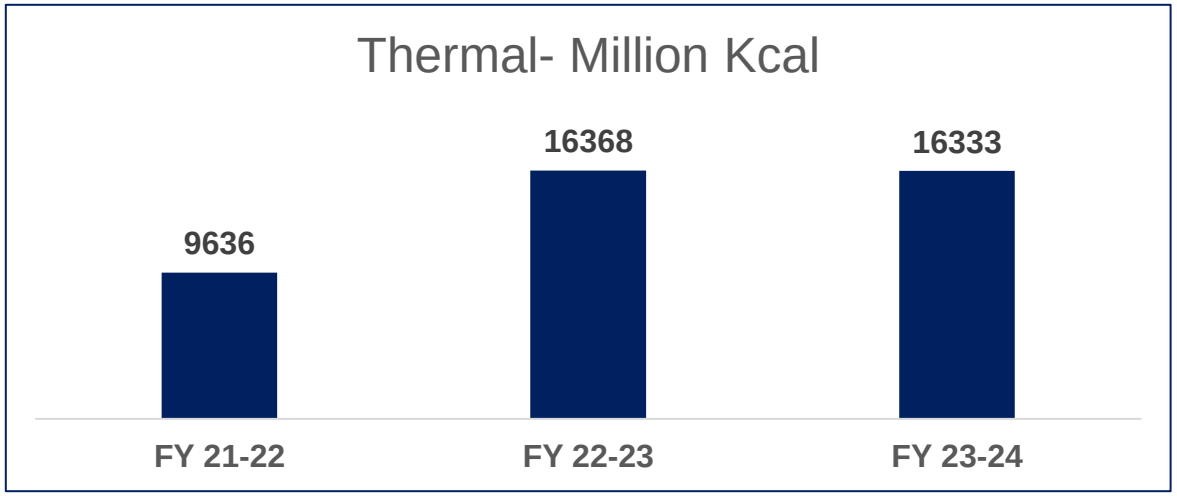
ELECTRICAL



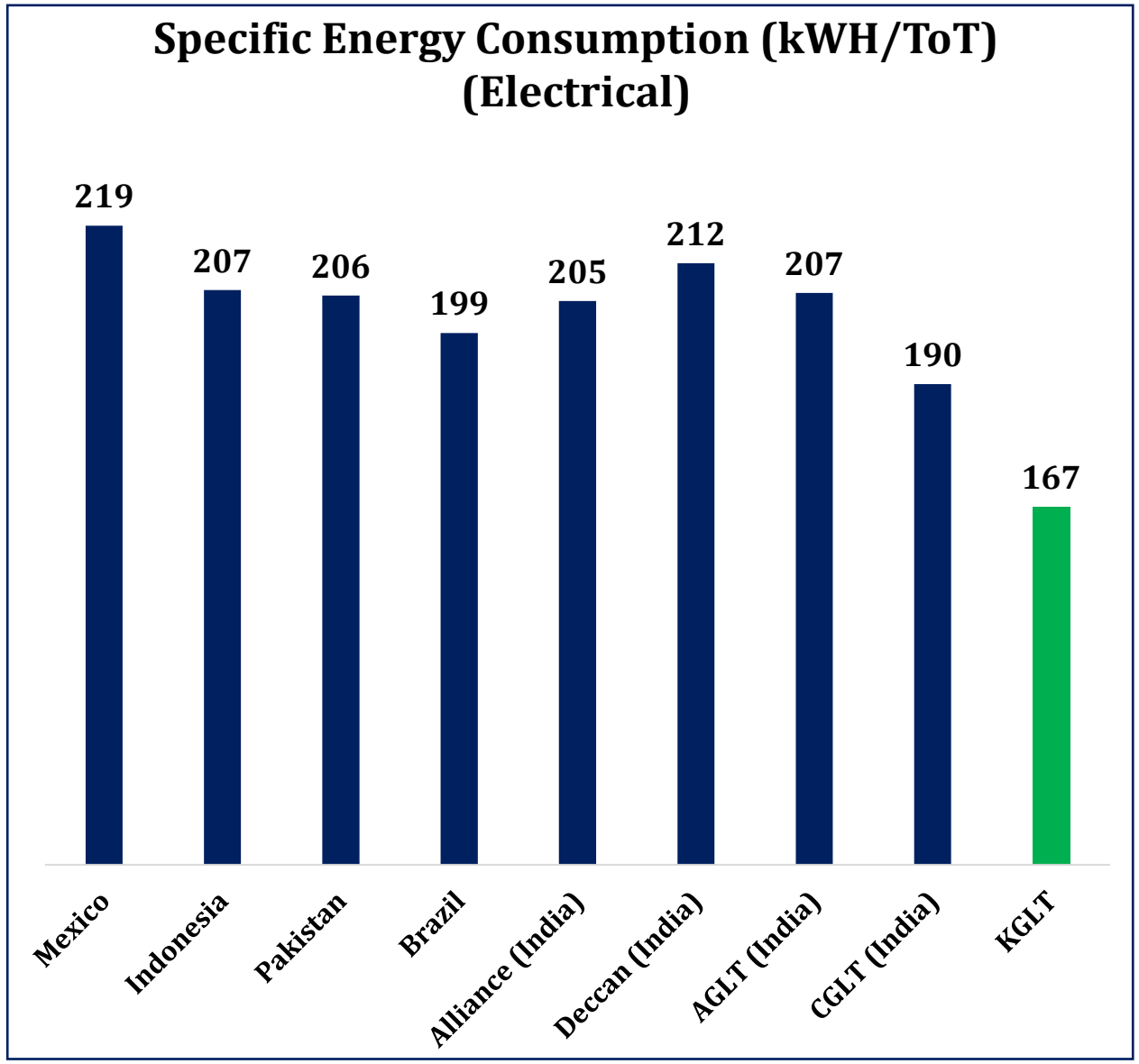


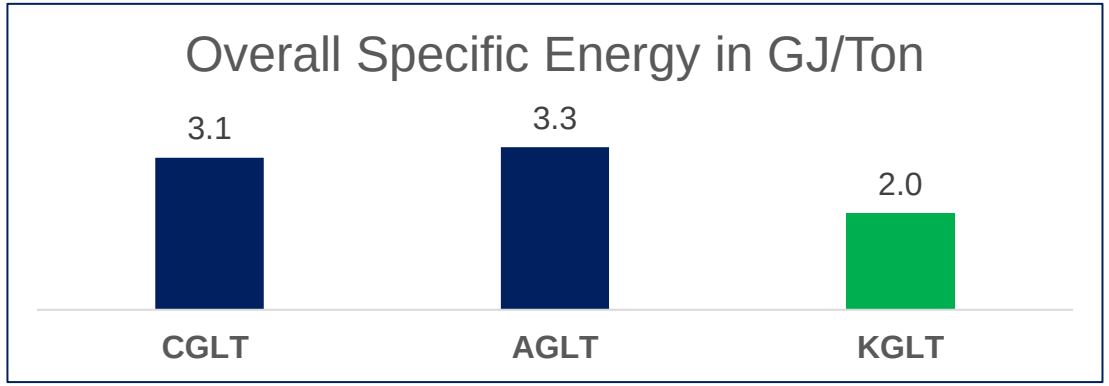
THERMAL

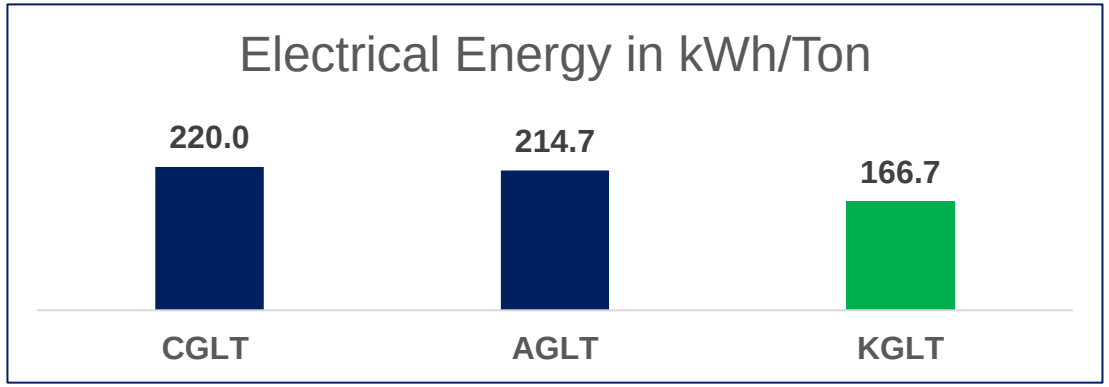


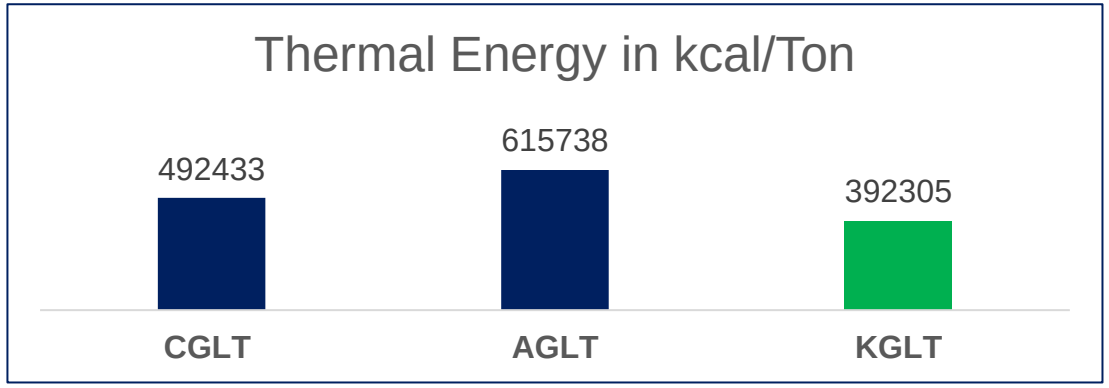


GLOBAL AND NATIONAL BENCHMARK









ITC ESG 2.0 GOALS : KGLT Road Map

ESG PILLARS	2018-19 (Baseline)	TARGET (2029-30) %	2022-23 %	2023-24 %	2024-25 %	2029-30 %
Renewable Energy Share (%)	29	**50**	32.7	62.6	**97.5**	97.4
Specific Energy Reduction (%)	2.82 (GJ/ToP)	**30**	5.9	20.3	**33.3**	39.1
Specific Emissions Reduction (%)	0.20 (TCo2e/To P)	**50**	10.3	59.1	**97.9**	98.1
Specific Water Reduction (%)	1.28 (KL/ToP)	**40**	24.4	35.7	**49.1**	51.7

MEETING ALL THE TARGETS BY 2024-25 (5 Years Sooner)

LIST OF ENCON PROJECTS PLANNED IN FY 24-25 (ELECTRICAL)

Enduring Value

High Energy Efficient equipment and process layout modification

Precision Air conditioners

Inlet guide vanes

252 kWh/Day

Introducing VFDs

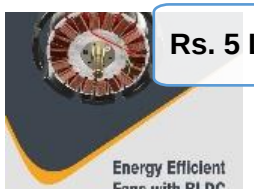
Variable Frequency Drives- Fans

IE5 Motors

610 kWh/Day

Intelligent Controller & BLDC fans and LEDs

Smart FLT Battery Chargers



Intelligent Air flow controller

155 kWh/Day

LIST OF ENCON PROJECTS PLANNED IN FY 24-25 (THERMAL)

Boiler Efficiency Improvement

THERMAX EDGE™ Live

Rs. 10 L

AI/ML MODEL

Improvement by 3-5%

Deploy AI/ML Model to give prescriptive actions to boiler operators to maintain all the critical parameters at optimum level to reduce gap between design and actual efficiency

Reduction in Boiler Fuels

Rs. 20 L

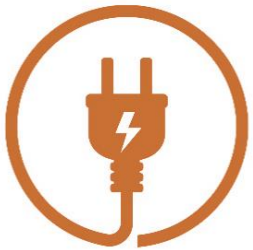
HEAT PUMP

Reduction by 2.5%

Feed water temperature currently at 80-85^0 C and there is potential to improve it further to 97^0 C for 750m altitude without much evaporation in tank.

SUMMARY OF ENCON PROJECTS IMPLEMENTED- LAST 3 YEARS

Electrical



Thermal

Year	No of Energy saving projects	Investment (INR Million)	Electrical savings (Million kWh)	Thermal savings (Million Kcal)	Total Savings (INR Million)	Payback period (in months)
FY 2021-22	19	2.1	0.07	579	0.7	35
FY 2022-23	45	2.5	0.14	543	1.3	23
FY 2023-24	15	111.1	0.16	10260	23	58

SUMMARY OF ENCON PROJECTS IMPLEMENTED- LAST 3 YEARS

Electrical

With 77 Initiatives
0.37 M KwH
In 3 Years

High Efficiency Motors

279 KWH/Day

No of Initiatives: 14 Nos

Introducing VFDs

659 KWH/Day

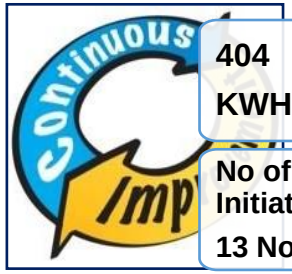
No of Initiatives: 4 Nos

LED lighting

516 KWH/Day

No of Initiatives: 46 Nos

Process Modification



404 KWH/Day

No of Initiatives: 13 Nos

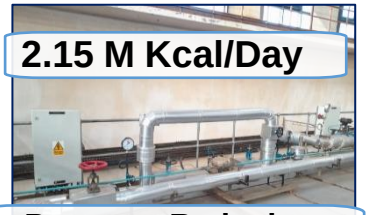
Thermal

With 8 Initiatives
11,382
M.kCal
In 3 Years

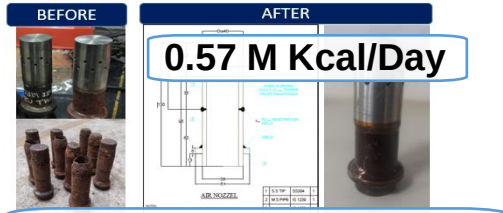
3.84 M Kcal/Day

Heat Exchanger with SS Coil with Al Fins

2.15 M Kcal/Day



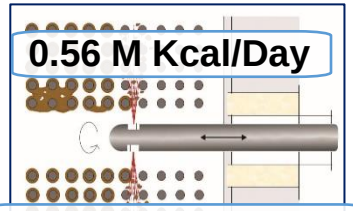
Pressure Reducing Station



0.57 M Kcal/Day

Air Nozzle Design Better Combustion with SS and CI

0.56 M Kcal/Day

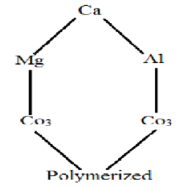


Soot Blower

33.58 M Kcal/Day

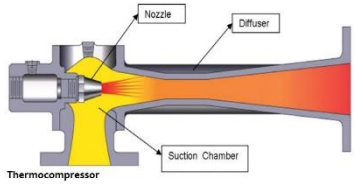
Twin Green Fuel Boilers

4.03 M Kcal/Day



Combustion Catalyst

1.32 M Kcal/Day



Thermo Compressor

0.52 M Kcal/Day

Start-up Traps

LIST OF MAJOR ENCON PROJECTS IMPLEMENTED IN LAST 3 YEARS

2021-22

Energy Saving – 2677 GJ

Type of Energy	No of Processing Days	Initiatives	Electrical savings Million kWh	Thermal savings Million Kcal	Investment Rs. L	Energy Savings (GJ)	Savings in Rs. L	Payback period (in months)
Electrical	131	Layout modifications & Drive rating optimization at identified locations	0.003	-	Nil	10	0.1	94
		Improvement in Energy Efficiency- Motors & Chiller	0.003	-	3.9	10	0.1	
		LED lighting	0.04	-	9.0	131	1.0	
		VFD for DRF system- I	0.03	-	2.1	104	0.8	
Thermal		SS Heat Exchanger at Conditioning cylinder- Steam reduction	-	503	4.0	2105	4.1	12
		Modified Air Nozzles- Improvement in Boiler Efficiency	-	76	2.00	317	1	21
Total			**0.07**	**579**	**20.88**	**2677**	**7**	

LIST OF MAJOR ENCON PROJECTS IMPLEMENTED IN LAST 3 YEARS

2022-23

Energy Saving – 2761 GJ

Type of Energy	No of Processing Days	Initiatives	Electrical savings Million kWh	Thermal savings Million Kcal	Investment Rs. L	Energy Savings (GJ)	Savings in Rs. L	Payback period (in months)
Electrical	200	Layout modifications & Drive rating optimization at identified locations	0.04	-	Nil	131	1.1	32
		Improvement in Energy Efficiency- Motors & Chiller	0.02	-	3.3	85	0.7	
		LED lighting	0.03	-	4.5	114	0.9	
		VFD for DRF system- II	0.04	-	3.0	158	1.3	
Thermal		Soot Blower for Boiler- Improvement in Boiler Efficiency	-	112	7.0	469	2.1	39
		PRS system for LRD system- Steam reduction	-	431	7.00	1804	8	11
Total			**0.14**	**543**	**24.74**	**2761**	**14**	

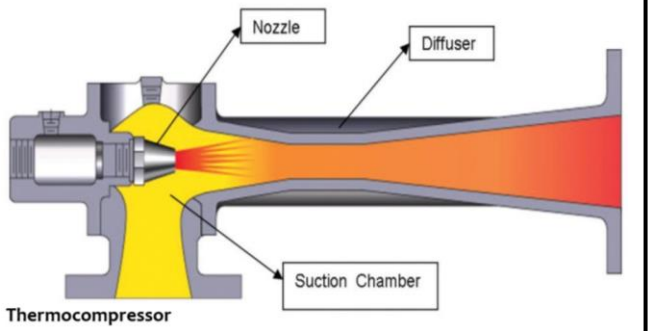
LIST OF MAJOR ENCON PROJECTS IMPLEMENTED IN LAST 3 YEARS

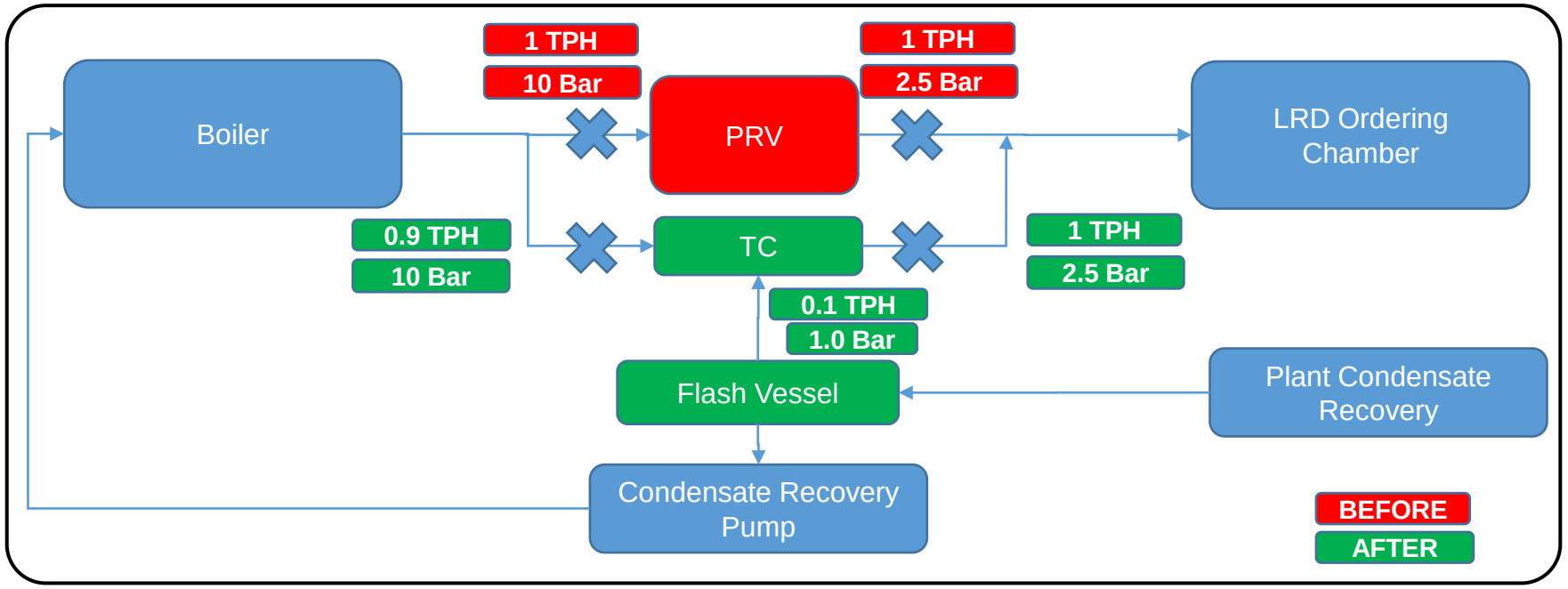
2023-24

Energy Saving – 13700 GJ

Type of Energy	No of Processing Days	Initiatives	Electrical savings Million kWh	Thermal savings Million Kcal	Investment Rs. L	Energy Savings (GJ)	Saving in Rs. L	Payback period (in months)
Electrical	249	LED Replacement	0.04	-	2.8	188	1.5	94.8
		Drive Rating & Process Optimization and Load deletion	0.03	-	0.3	131	1.0	
		Energy Efficient Equipment	0.02	-	29.4	75	0.6	
		Introducing VFD for identified drives	0.04	-	5.3	205	1.6	
Thermal		Green Fuel Boiler	-	8736	1052	11973	196	57.2
		Start-up trap for Steam distribution network	-	136	0.6	570	3	
		Thermo Compressor – Lamina Re-dryer		344	14	144	6.6	
		Introducing Combustion Catalyst along with Biofuels		1048	8	438	20.1	
Total			**0.13**	**10260**	**1112**	**13700**	**230**	58

INNOVATIVE PROJECT 1 – THERMO COMPRESSOR

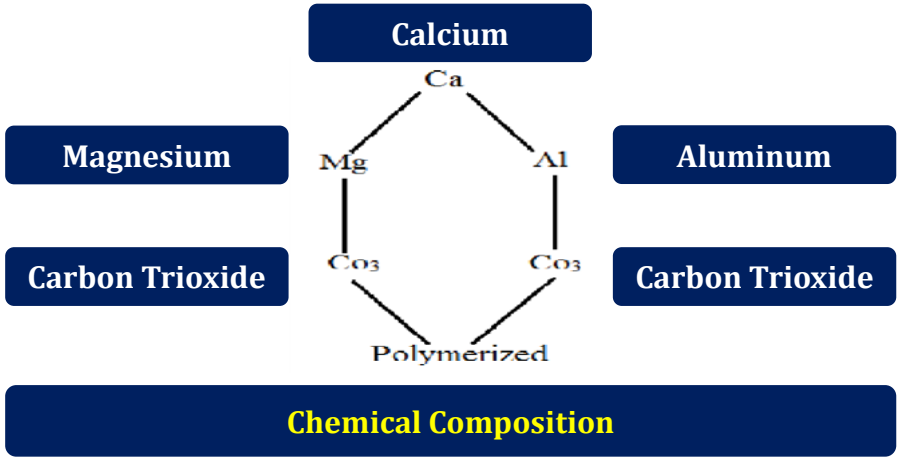




- **KGLT consumes around 65-74 Tons of steam per day**
- **Condensate recovery stands at 45%.**
- **Condensate will have 6-10% of flash steam with flow of 0.1 to 0.15 TPH**
- Uses flash steam from condensate recovery
- Increases pressure from **1 bar to 3-5 bar** for localized consumption
- **Saving 260 Tons of steam/Annum**

Reduction in Specific Steam Consumption by 2%

INNOVATIVE PROJECT 2 – COMBUSTION CATALYST



- Reduces **ignition temperature** of **carbon** from **454^0 C to 320^0 C**
- **Calcium**: Extends the **fusion temp of ash** from **925-975^0 C to 1152^0 C**
- **Magnesium**: Improves heat transfer by forming **magnesium film on the tubes** and this will not allow soot depositions
- **Aluminum**: Neutralize the So2 and So3 by converting them into Aluminum Sulphates and **Ionizes the air** whereby **air will act as efficient conductor** and act as transfer media.

0.1% of dosing with fuel

(1 Kg for 1000 Kg of Fuel)

S No	Description	UOM	Without Catalyst	With Catalyst	Improvement	%
1	Fuel Qty	Kg	36,230	44,790		
2	Fuel GCV	Kcal/ Kg	3,800	3,800		
3	Steam Generation	Kg	1,73,329	2,27,619		
4	Steam Enthalpy @ 12 Bar (Saturated Steam)	Kcal / Kg	569	572		
5	Total Heat Input	Kcal	13,76,74,000	17,02,02,000		
6	Total Heat Output	Kcal	9,85,57,536	13,02,59,715		
7	**Boiler Efficiency**		**71.59%**	**76.53%**	**4.94%**	**6.91%**
8	**SF Ratio**		**4.78**	**5.08**	**0.30**	**6.22%**

Boiler efficiency improvement by ~5%

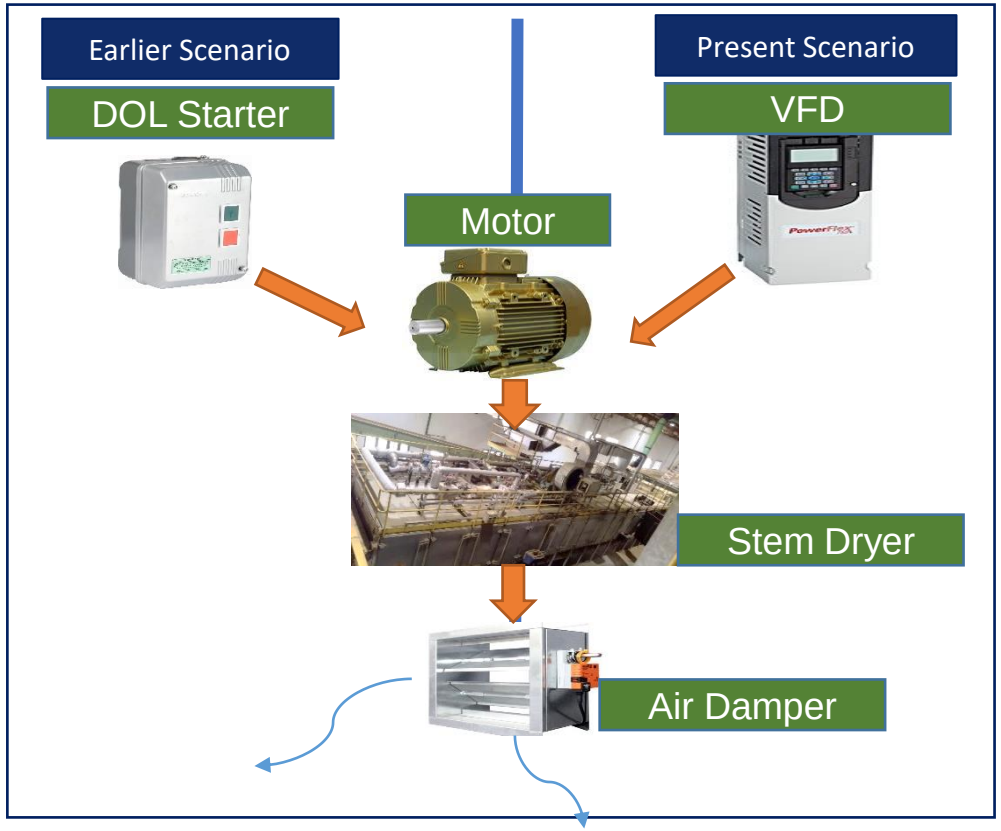
INNOVATIVE PROJECT 3 – VFDs for Stem Dryer

Electrical Consumption in KWH per Day	
With DOL	With VFD
All Product Grades (Top, Medium & Low)	
1196 KWH/Day	990 KWH/Day

Savings 206 KWH/Day

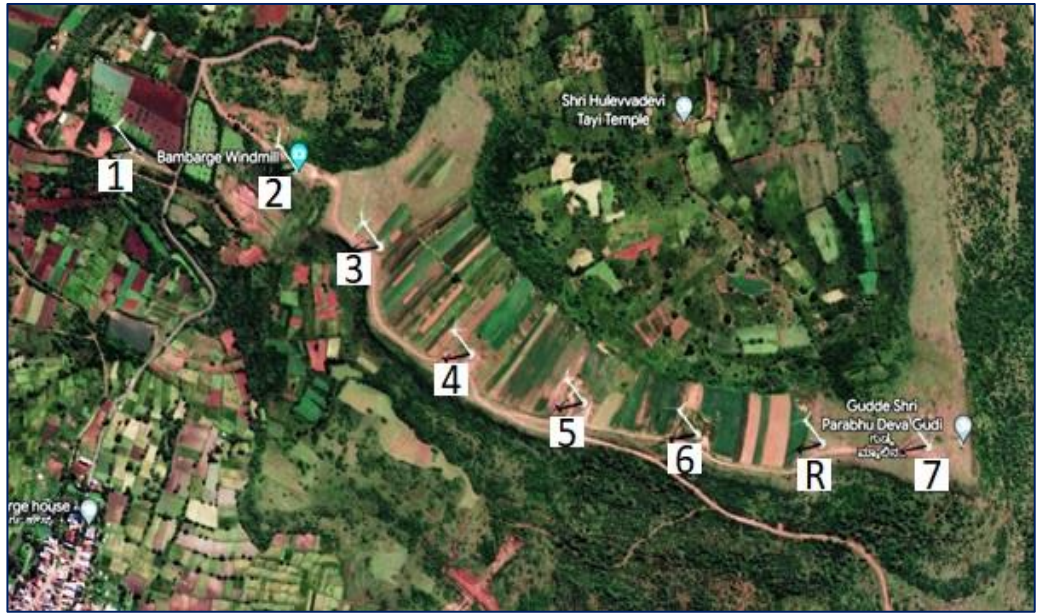
Stem Dryer-

Erstwhile the air velocity inside the heating chambers are regulated through air dampers. By introducing the VFDs, the heating chambers are regulated under variable speed on basis of desired heating chamber temperature without effecting product integrity



Business Need	**Energy Conservation Initiatives**	**Innovation Component**	**Introducing VFDs for all heating chamber fans – 8 Nos**
Project Outcome	**Energy Saving Potential– 53542 kWh** **Savings in Rs. – 1.61 Lakhs (Rs. 3 per kWh)** **Payback – 41 Months**	**Organization Benefit**	**Lower Energy & Maintenance Cost**

UTILIZATION OF RENEWABLE ENERGY SOURCES



Commissioned in 2013
Mannikeri, Belgaum, Karnataka

Total Capital investment	: 43.45 Cr.
Total Installed Capacity	: 8.75 MW
No of WTGs	: 7 Nos
Capacity of each WTG	: 1.25 MW

RPO OBLIGATION: NOT OBLIGATED
Power drawn from DISCOM and Own Wind farm only

FY	Sum of Gross KWH in Lakhs	Sum of Net KWH in Lakhs	KGLT		
			Own Consumption KWH in Lakhs	RE Foot print	% Utilization
2021-22	164	146	44.5	99.0%	30.5
2022-23	171	151	58.2	93.1%	38.3
2023-24	163	150	74.9	98.5%	49.9
Grand Total	**498**	**443**	**173**	**97%**	**39.7**

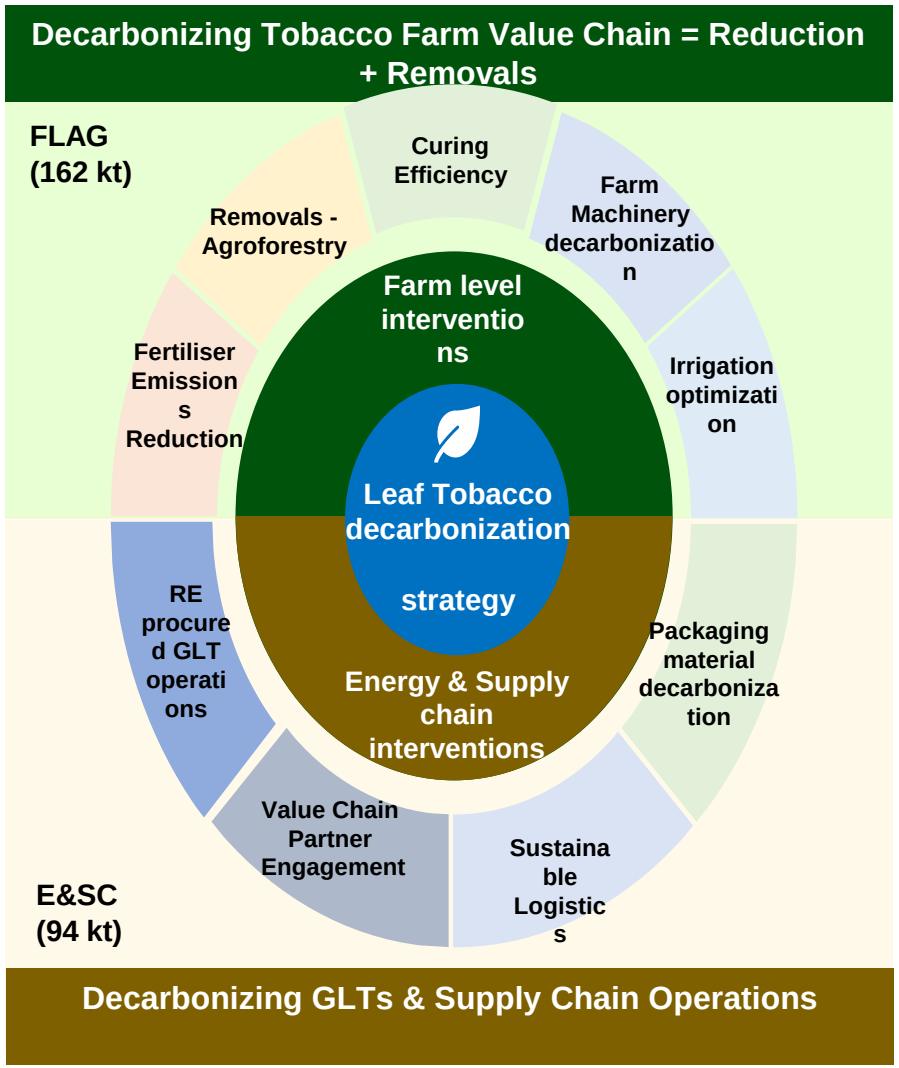
96% Machine Uptime

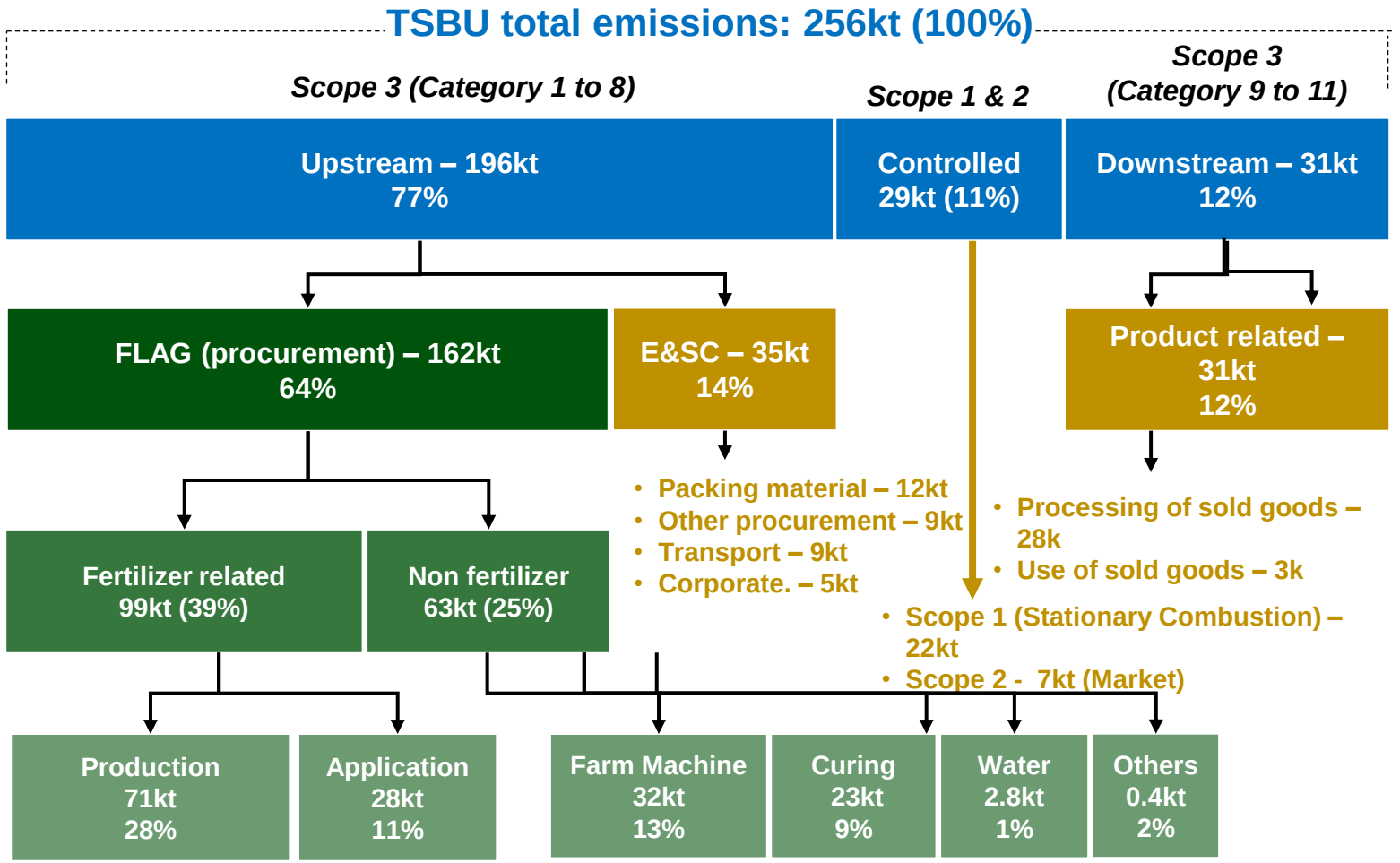
98% Grid Uptime

21% PLF

The Captive Wind Farm has net generation of 150 Lakh units per Year. 60% of Energy is wheeled to other Units and Businesses basis on profitability ranking.

TSBU's GHG Inventory aligned to SBTi





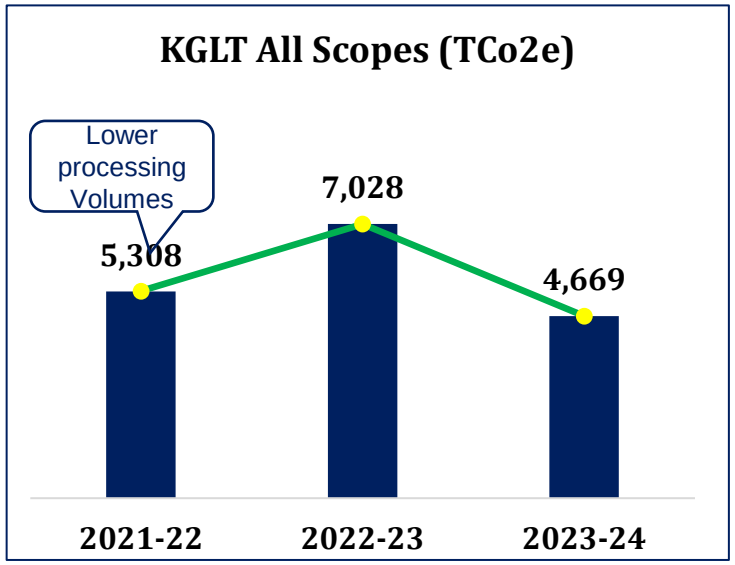
TSBU's emissions are dominated by Scope 3 (89% - 227 kt)

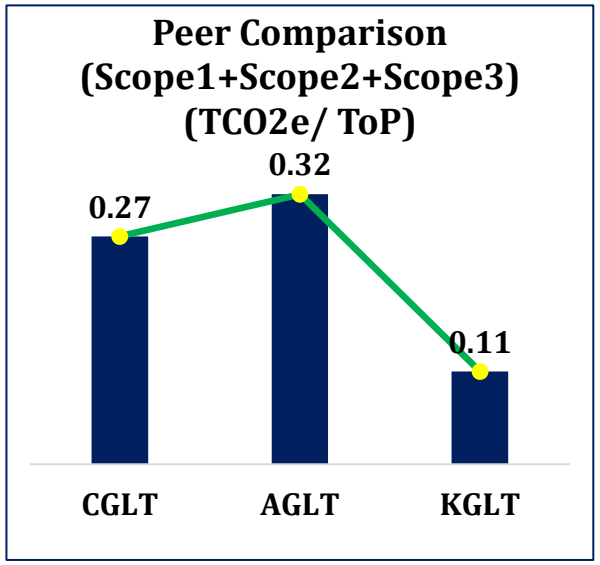
FLAG emissions are significant contributors, followed by E&SC

UNIT - GHG INVENTORISATION

GHG Inventorization & Public Disclosure

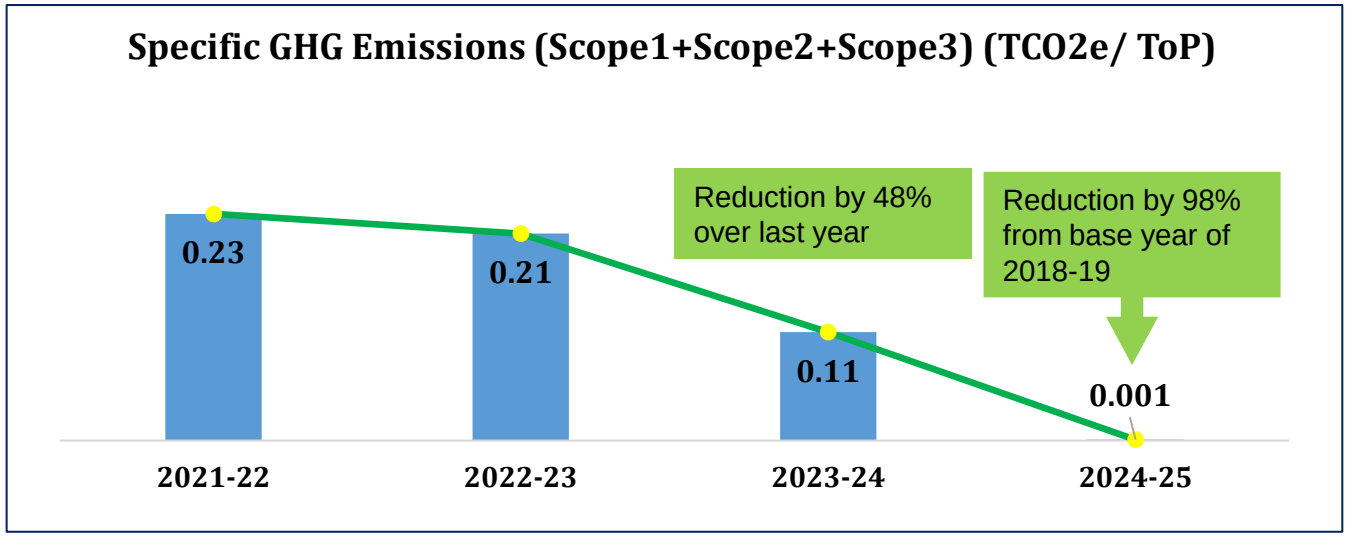
All Scope 1, 2 & 3 emissions being captured and disclosed to public on ITC Portal.
link:
https://www.itcportal.com/sustainability/sustainabilty-reports.aspx



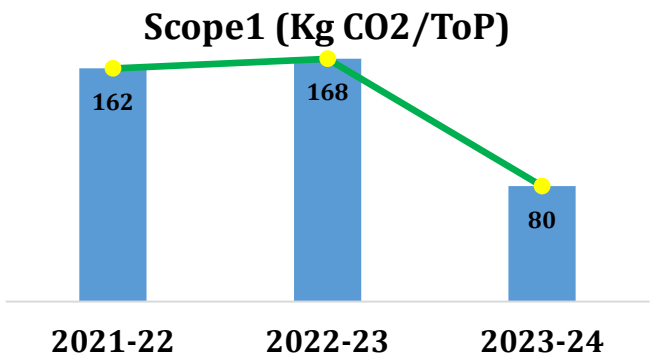


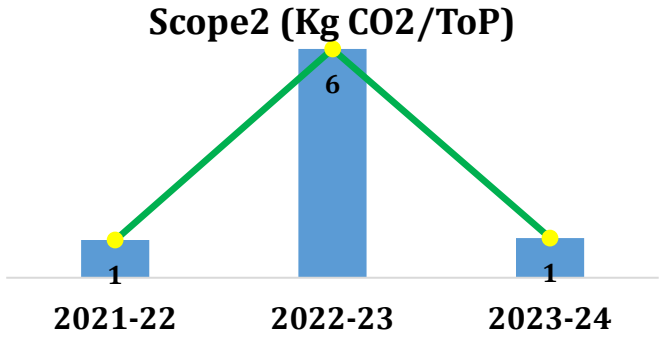
2023 Target for Emission Reduction

- Target : 50% reduction from baseline year 2018-19 (Scope1+Scope2) by 2030
- By 2024-25, Unit is achieving 99.5% reduction through planned initiatives

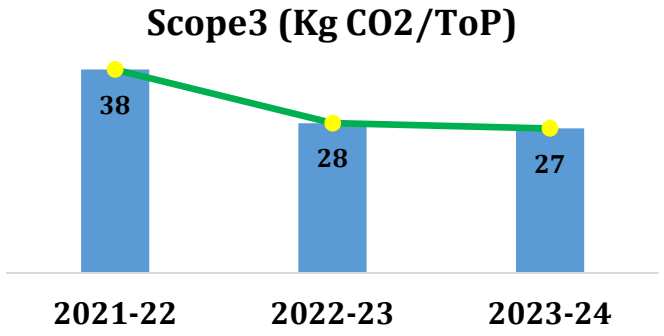


UNIT GHG INVENTORISATION – ACTION PLAN





	Wind : Grid : DG
2020-21	98.84 : 0.88 : 0.28
2021-22	98.98 : 0.61 : 0.41
2022-23	93.00 : 6.58 : 0.40
2023-24	98.50 : 0.7 : 0.80



Year	2021-22	2022-23	2023-24
Inward - Kms/Ton	1347	357	242
Outward - Kms/Ton	417	350	443

Initiatives towards GHG emission reduction

- Bio Fuel fired Boiler 9.0 TPH

- Improve renewable energy utilization to 99.5% by setting up 3.5 MWp On-site Solar PV system

- Optimizing Travel KM of raw material by avoiding intermittent storage

- Continuous improvement- Energy conservation initiatives

- Minimize DG operation thru increase in Grid availability

GHG REDUCTION INITIATIVES – ENERGY ACTION PLAN

Commissioned in 23-24 : 9 TPH (2 x 4.5 TPH) Boiler (Investment- Rs 10.59 Cr)

New Boiler Advantages

- **Effective load management with Twin Boiler design**
- **Multi Fuel (Solid) Boiler with Reciprocating Grate can go with 100% bio fuels**
- **Efficiency improvement 45% vs 75%**

NEW 3.5 MW SPV PLANT

Need for improving RE Generation:

1. **Banking facility- Annually to Monthly basis**
2. **Low wind season**
3. **Due to increase in Energy demand**
4. **Excess energy sharing with other ITC units**

Type	Solar - Ground Mounted
Investment in Rs. Crores	27
Year of Implementation	2025-26
Total Generation	56.7

GREENING OF FARM & SUPPLY CHAIN (FY 21-22 TO FY 23-24)

	Initiative	Investment (Rs. Million)	Benefits	Concept
	• Loose Leaf - Smart Curing Barns in place of traditional barns	60.6	**54%** Fuel Savings (384.34 M Kcal)	PID Controlled Temperature and RH
	• Energy Conservation in Tobacco Curing Barns	15.1	**29%** Fuel Savings: (5345.61 M Kcal)	Introduced turbo ventilators for improving heat utilization
	• Installation of Solar PV Plant in Godowns	21.3	**70%** RE Foot print with generation KWH: 5.1L	Introduced 421 kWp SPV system at Raw Material Godown
PDF ITC - Code of Conduct	• Supplier code of conduct - Environment	As a practice, we take a declaration "ITC-Code of Conduct" from all its key / major vendors on complying laws of all environment and adopt environment friendly technologies		

EMS, ISO 50001 CERTIFICATION & LEARNINGS FROM CII

Energy Monitoring System

1. **Energy Dashboard Review with different frequencies**
2. **Monthly EMC meeting**
3. **Competitions**
4. **Data Analysis**
5. **Reviews with Senior Management at Unit, Division and Corporate**

Challenges:

- Combined energy monitoring system not available
- Manual noting of energy consumption at some areas

Upgradation Planned:

- **Piloting of Historian in CGLT planned in 23-24** for combined energy monitoring system
- **Replication at unit by 24-25**

Energy Management System

Step 1: Initiated process for certification and started preparations for initial audit

Step 2: Final Certification Audit during FY 25-26

Learnings from CII Energy Awards

- Recognition for accomplishments and exposure to new ideas, and opportunities to refine skills
- Insights into best practices, benchmarking against industry leaders
- Enhance organizations process and strategies
- Gain credibility and expand professional network

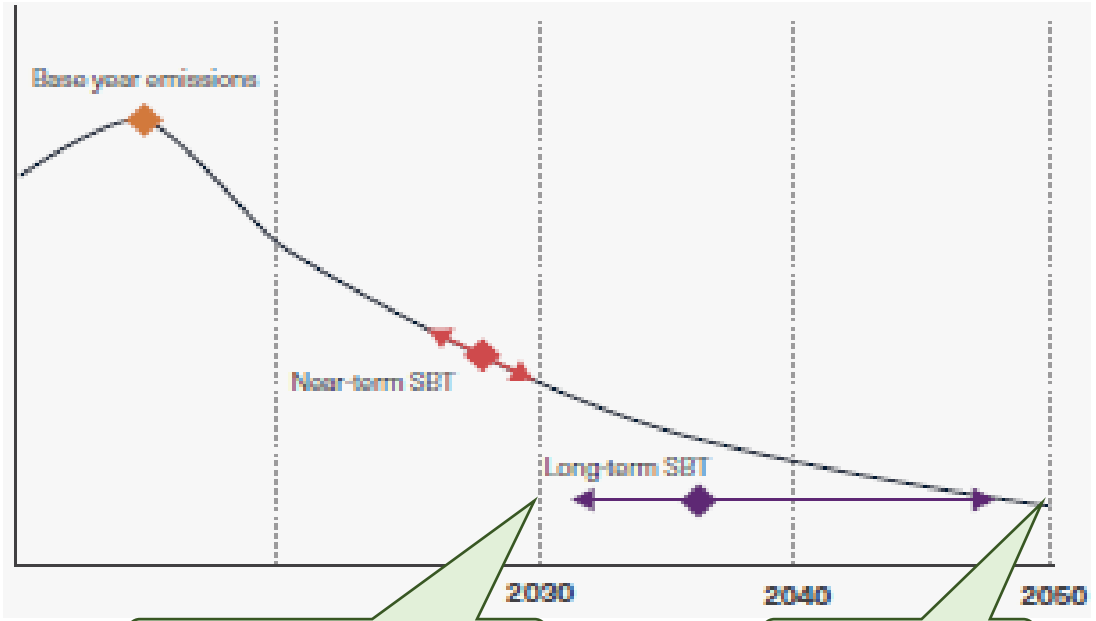
NET ZERO ROADMAP

SUSTAINABLE DEVELOPMENT GOALS

SCIENCE BASED TARGETS

DRIVING AMBITIOUS CORPORATE CLIMATE ACTION

SBTi- Reducing scope 1, 2, and 3 emissions - 1.5°C



ESG 2.0

ITC has published its ESG2.0 goals publicly for near term goals. Accordingly goals for individual divisions assigned, which are to be achieved by 2030 and 2050.

Low Carbon Transition Plan

Baselining and inventorisation of total emissions (Scope1, Scope2 and Scope 3) was done by TERI and deployed Accenture for preparing low carbon transition plan using SBTi FLAG guidelines

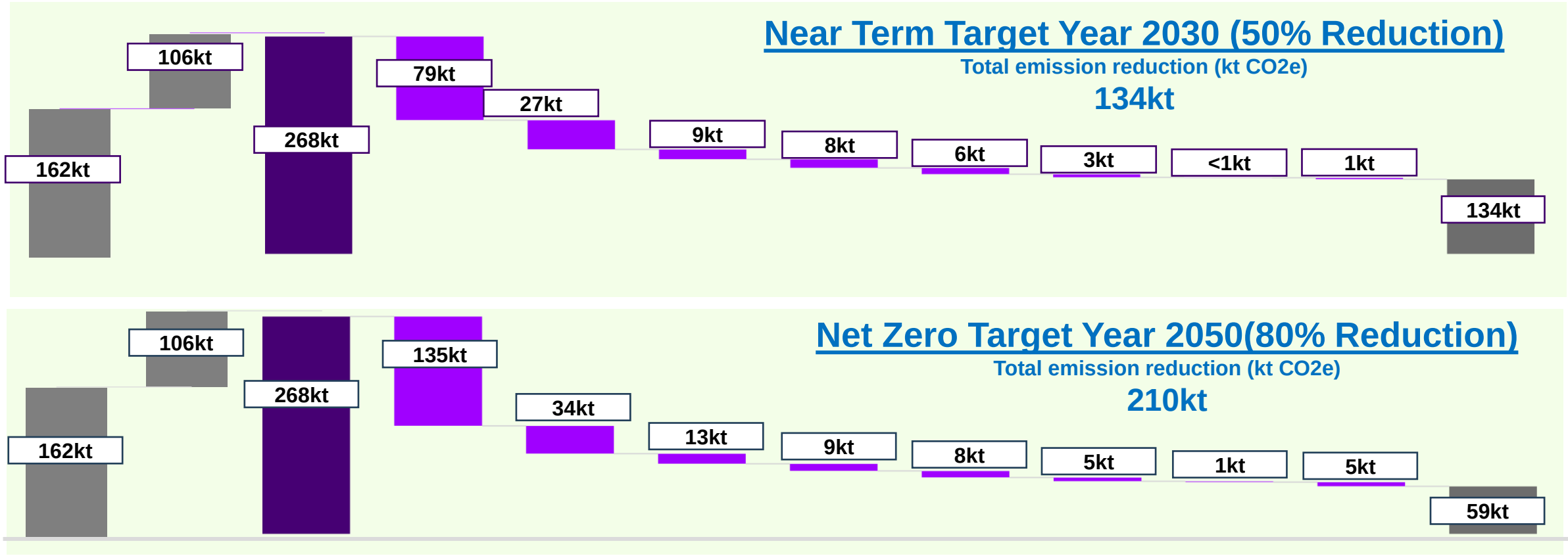
teri

Baselining & Inventorisation

accenture

Low carbon transition plan for all the emissions covering all ABD operations

DECARBONISATION STRATEGY - Farm



DECARBONISATION STRATEGY - Farm

Year 0

2023-24

- Completed baseline emissions calculation
- **Designed low carbon transition plan for TSBU**

Year 1

2024-25

- Create farmer segmentation in the system
- Pilot farmer score card - design and deploy in Burley (non-FCV)
- **System integration of GHG calculator with ITC MAARs and SAP and ensure unified data capture**
- Pilot decarbonization toolkit across all FCV growth regions

Year 2

2025-26

- Review and finalize the farmer scorecard and roll out of initiatives
- **Roll out initiatives** as per plan to meet 2030 targets
- Monitor y-o-y inventory changes of GHG emissions
- Finalize financing, incentive structure for FCV with all the stakeholders – Farm Customer and trade

2026-30

- Implement incentive structures for farmers
- Monitor y-o-y inventory changes of GHG emissions

2030-50

- Re-view and re-evaluate initiatives based on emerging technology and industry trends

NEAR TERM & NET ZERO TARGET

Planning, developing systems and pilots initiating and scale-up

DECARBONISATION STRATEGY - Energy and Supply Chain

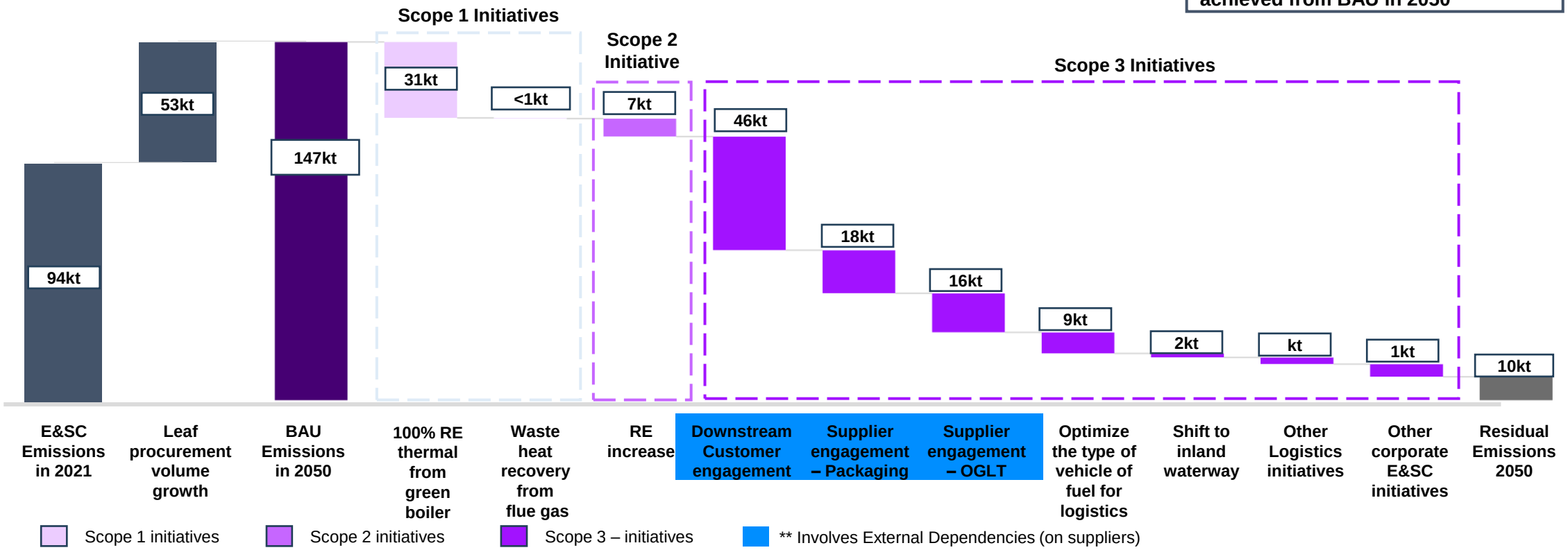
Enduring Value

Net Zero Target year: 2050

Potential reduction of ~ 93% of total E&SC emissions

Absolute Emissions in tCO2e
Base year: 2021

136k tCO2
Total emission reduction (tCO2) achieved from BAU in 2050



DECARBONISATION STRATEGY - Energy and Supply Chain

Execution strategy

… and continue to evaluate the latest technologies available beyond 2030 to meet the net zero targets

Year 0

2023-24

- **Completed baseline emissions** calculation
- Implement **100% RE green boiler for KGLT**
- Designed **low carbon transition plan** for ITC TSBU
- **Socialize plan** with key stakeholders

Year 1

2024-25

- Focus on sustaining **agro-based fuel feeding systems for CGLT**
- **Initiate supplier engagement** for OGLT & packaging and downstream customer engagement activities
- **Develop requirements for system integration** of GHG calculator with SAP and ensure unified data capture
- **Ready for submission to SBTi** with 2023 baseline

Year 2

2025-26

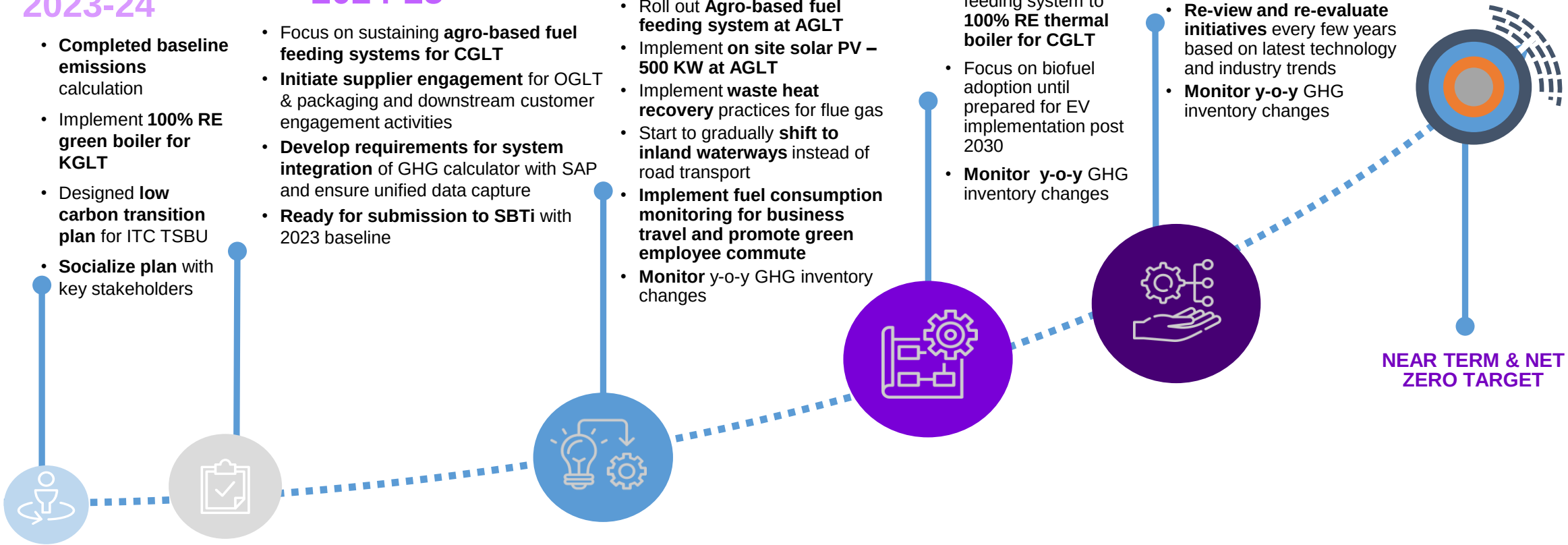
- Roll out **Agro-based fuel feeding system at AGLT**
- Implement **on site solar PV – 500 KW at AGLT**
- Implement **waste heat recovery** practices for flue gas
- Start to gradually **shift to inland waterways** instead of road transport
- **Implement fuel consumption monitoring for business travel and promote green employee commute**
- **Monitor** y-o-y GHG inventory changes

2026-30

- Shift from fuel feeding system to **100% RE thermal boiler for CGLT**
- Focus on biofuel adoption until prepared for EV implementation post 2030
- **Monitor y-o-y** GHG inventory changes

2030-50

- Shift to more optimal logistics modes like **EV and waterways**
- **Re-view and re-evaluate initiatives** every few years based on latest technology and industry trends
- **Monitor y-o-y** GHG inventory changes



NEAR TERM & NET ZERO TARGET

Handling Balance through Agroforestry- Removal

Farm level abatement is 80% and Energy& Supply Chain abatement is 93% through **reduction of emission**

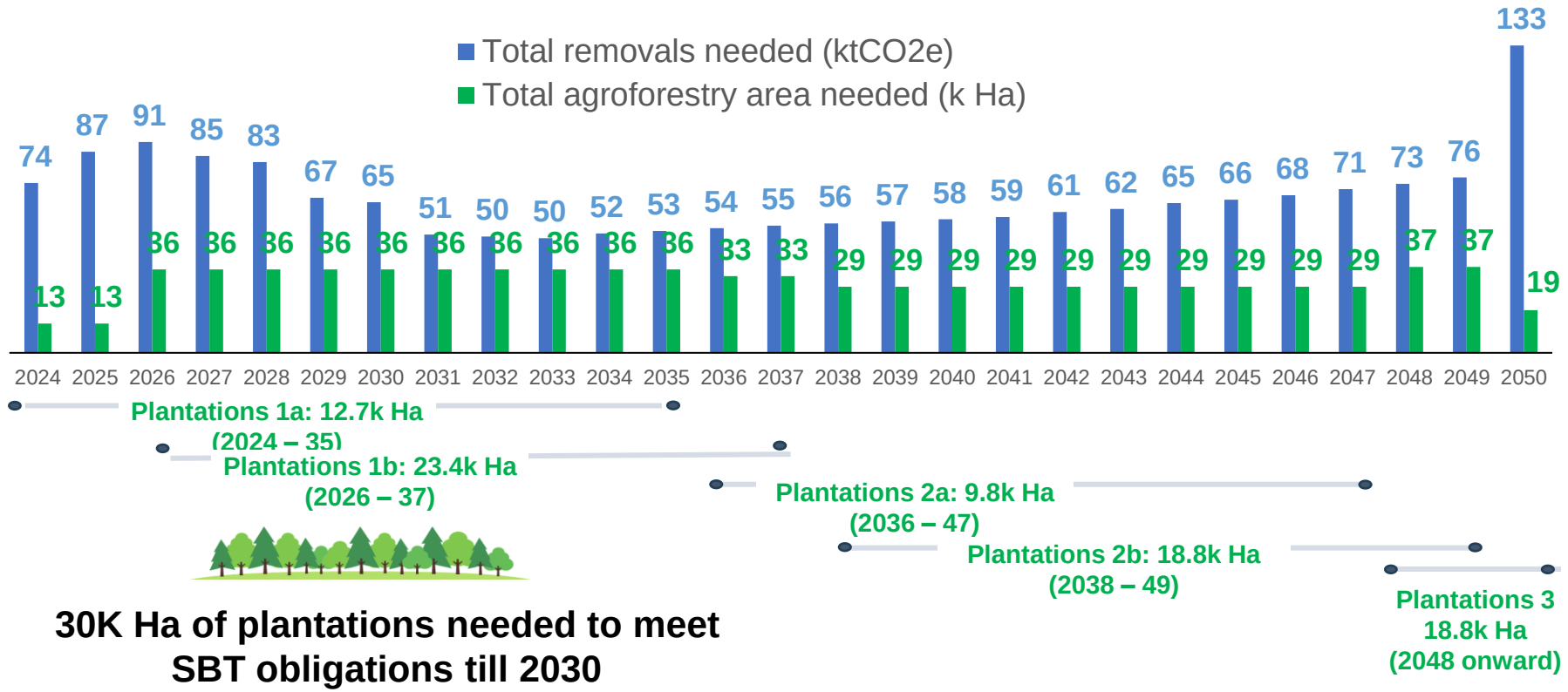
Balance 20% in Farm and 7% emissions will be removed through **removal process by enhancing agroforestry**

Removals needed = Gap between yearly SBT and emissions after abatement

Area based on CSP of plantations (Eucalyptus = 7 to 37 MT/Ha/Yr)

All cultivation cycles of 12 years with pruning every 4 years → Results in reversal of removals for previous years has been accounted

116 Cr is the net cumulative costs till 2030



30K Ha of plantations needed to meet SBT obligations till 2030

Awards and Accolades

ISO 9001
ISO 14001
ISO 45001

TC-5302

ISO 17025

Only GLT in the World to get Platinum Level - AWS certification 2023

ICQCC – Gold Award CAQ, China 2023

CII Energy Efficient Unit 2023

Best Performing Wind Farm IWPA 2023

CCQC – 2 Gold Awards 2023

3rd Place in ITC For Water Stewardship 2023

THANK YOU