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THE RAMCO CEMENTS LIMITED

(Formerly known as Madras Cements Ltd.)

RCL/MoEF&CC/21/2017-18

30th May 2017

The Addl. Principal Chief Conservator of Forests,
Ministry of Environment and Forests,
Regional Office (Southern Zone),
No. 34, Cathedral Garden Road,
Nungambakkam,
CHENNAI – 600 034.

Dear Sir,

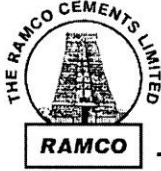
- Sub: Submission of half yearly Compliance Report for Environmental Clearances for the period October 2016 to March 2017 - Reg.
- Ref: 1. EC for Cement Plant - 2.50 million TPA Clinker & 2.60 million TPA Cement Capacity vide Lr. No. J-11011/403/2006-IA-II (I) dated 07.02.2007.
2. EC for Cement Plant - 2.80 million TPA Clinker & 3.65 million TPA Cement Capacity vide Lr. No. J-11011/403/2006-IA II (I) dated 09.06.2009.
3. EC for Cement Plant – 3.185 million TPA Clinker & 3.65 million TPA Cement Capacity vide Lr. No. J-11011/403/2006-IA-II (I) dated 29.09.2016.

We herewith submit the half yearly Compliance Reports for the above cited Environmental Clearance letters issued for our Cement Plant & Thermal Power Plant for the period October 2016 to March 2017 along with relevant enclosures.

This is to submit that third cited Environmental Clearance for Increase of Clinker Production from 2.80 MTPA to 3.185 MTPA by Upgradation of Line – I & Optimum Utilization of Line – II and Installation of 6 MW Turbo Generator project is issued on 29.09.2016. The Consent for Operation (CFO) order for the project is issued on 04.04.2017.

Name, designation and contact details of person in-charge of environmental division are:

T. Sridhar Reddy,
Asst. Vice President (Works),
Phone No. 08654 – 224400,
Fax No. 08654 – 222532,
e-mail: mcijpm@ramcocements.co.in.



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Certified Company

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THE RAMCO CEMENTS LIMITED

(Formerly known as Madras Cements Ltd.)

This is for your kind information and perusal please.

Thanking you,

Yours faithfully,
for The Ramco Cements Limited,

T. Sridhar Reddy,
Asst. Vice President (Works)

Encl: As above.

**THE RAMCO CEMENTS LIMITED, KSR NAGAR
COMPLIANCE REPORT – ENVIRONMENTAL CLEARANCE -
CEMENT PLANT – 2.80 MILLION TPA CLINKER, 3.65 MILLION TPA CEMENT &
THERMAL POWER PLANT – 36 MW**

EC Lr. No. : J-11011/403/2006-IA II (I) dated 09th June 2009
Period : October 2016 to March 2017

A. Specific Conditions:

- i. *Continuous stack monitoring facilities to monitor gaseous emissions from all the stacks shall be provided. After expansion, limit of SPM shall be controlled within 50 mg/Nm³ by installing adequate air pollution control system viz. Electrostatic precipitators, bag house, bag filters etc. Data on ambient air, fugitive and stack emissions shall be submitted to the Ministry's Regional Office at Bangalore, AP Pollution Control Board (APPCB) and CPCB regularly.*

Complied. 10 Nos. of on-line stack monitors are installed to monitor particulate emissions. Modifications / replacements in the pollution control equipment are made with the designed emission level of 30 mg/Nm³ from all the stacks of cement plant. Data on ambient air and stack emissions is being regularly submitted to APPCB on monthly basis & half-yearly basis. Compiled data of ambient air and stack monitoring data collected by MoEF&CC approved external laboratory on monthly basis for the period October 2016 to March 2017 is enclosed as Annexure – I & II respectively. Online data on ambient air quality and stack monitoring is linked up with APPCB & CPCB websites.

- ii. *Possibilities shall be explored for the proper and full utilization of gases generated from the kiln in waste heat recovery boiler (WHRB) and a feasibility report shall be prepared and submitted to the Ministry and its Regional Office at Bangalore within 3 months from the date of issue of the letter.*

Explored and will be implemented. The available hot gases are utilized for drying of raw materials in Vertical Roller Mills. Gas temperature after the mills is about 90°C and as such waste heat recovery system is not viable. Nevertheless obtained Techno - Commercial quotes from M/s Thermax Ltd (Power Division) and it is cost prohibitive. Submitted letter to MoEF&CC regarding the same vide Lr. No. MCL/MoEF/5442/2010 dated 19th July 2010 (Annexure – XIV).

- iii. *As proposed, Electrostatic precipitators (ESPs) to clinker, bag house to kiln / raw mill, coal mill and pulse jet bag filters to cement mill and slag mill shall be provided to control gaseous emissions within 50 mg/Nm³. Bag filters shall also be provided at transfer points. Water sprinklers shall be provided to control dust emissions in cement plant and mine area.*

Complied. Modifications / replacements in the pollution control equipment are made with the designed emission level of 50 mg/Nm³ from all the stacks.

- Kiln – I ESP, Coal Mill – I ESP and Cement Mill ESP are replaced with Bag Houses.
- Slag Mill bag house upgraded.

- High efficiency bag filters are provided for LS crusher and additive crusher.
- All material transfer points are connected with bag filters.
- Agglomerative Dust Suppression systems (water fogging) are installed at raw material hopper area, coal handling area and additive handling area.
- Water fogging system is installed at limestone crusher hopper.
- Total 88 Nos. of Air Pollution Control Equipments (APCEs) in cement plant & 9 Nos. of APCEs in TPP are in operation (Annexure – III).
- Permanent water sprinkling system installed at mines haul road.
- In addition to this, water sprinkling is being done with truck mounted sprinklers on roads of cement plant and mines internal haul roads.

iv. *Ambient air monitoring shall be carried out in and around the project site and efforts shall be made to control and minimize the particulate matters to bare minimum. One ambient air quality monitoring station shall be installed in downwind direction. It shall be ensured that the ambient air quality parameters conform to the norms prescribed by the CPCB in this regard.*

Being complied. Ambient air monitoring is being carried out by MoEF&CC approved external laboratory and efforts are being made that the ambient air quality parameters conform to the norms prescribed by the CPCB. Installed 2 Nos. of Continuous Ambient Air Quality Monitoring Stations at Time Office & at Mines Office respectively (one station is installed in downwind direction) and online data is being transmitted to APPCB & CPCB websites. Compiled data of ambient air quality monitoring data collected by MoEF&CC approved external laboratory on monthly basis for the period October 2016 to March 2017 is enclosed as Annexure - I.

v. *The company shall install adequate dust collection and extraction system to control fugitive dust emissions at various transfer points, raw mill handling (unloading, conveying, transporting, stacking), vehicular movement, bagging and packing areas etc. Crusher shall be operated with high efficiency bag filters. All conveyers shall be covered with GI sheets. Covered sheds for storage of raw materials and fully covered conveyers for transportation of materials shall be provided besides coal, cement, fly ash and clinker shall be stored in silos. Pneumatic system shall be used for fly ash handling. Regular water sprinkling shall be carried out in critical areas prone to air pollution and having high levels of SPM and RPM particularly in mine area and other vulnerable areas.*

Complied. Total 88 Nos. of APCE in cement plant and 9 Nos. of APCE are in operation in TPP (Annexure – III).

- All material transfer points are equipped with dust collection systems to control fugitive dust emissions.
- High efficiency bag filters are provided for LS crusher and additive crusher.
- The dust collected from APCE is being totally recycled to the respective process / storage facility.
- All conveyers are covered with GI sheets. All packing machines are fitted with bag filters.
- To control fugitive emissions, dust extraction system with bag filter facility is provided at truck loading area.
- Closed sheds are provided for additive stacker & reclaimer, coal stacker & reclaimer and for gypsum storage.

- Fly ash and clinker being stored in closed silos and fly ash is unloaded / conveyed through pneumatic system. Fly ash from TPP is transported through pneumatic system to cement plant.
- Cement is stored in closed silos.
- Agglomerative dust suppression systems (water fogging) are installed at raw material hopper area, coal handling area and additive handling area.
- Water spray system is arranged around the coal stacker & reclaimers.
- Water fogging system is installed at limestone crusher hopper.
- Permanent water sprinkling system installed at mines haul road.
- In addition to this, water sprinkling is being done with truck mounted sprinklers on roads of cement plant and mines internal haul roads.

vi. *Data on ambient air quality, stack emissions and fugitive emissions shall be regularly submitted on-line to the Ministry's Regional Office at Bangalore, Central Pollution Control Board (CPCB) and AP Pollution Control Board (APPCB) as well as hard copy once in six months. Data on SPM, SO₂ and NO_x shall also be displayed outside the premises at the appropriate place for the general public.*

Being complied. Compiled data of ambient air and stack monitoring data collected by MoEF&CC approved external laboratory on monthly basis for the period October 2016 to March 2017 is enclosed as Annexure – I & II respectively. Online data on ambient air quality and stack monitoring is linked up with APPCB & CPCB websites. Data on PM, SO₂ & NO_x for the stacks and PM₁₀, PM_{2.5}, SO₂ & NO_x data for ambient air quality respectively displayed outside the premises for the general public.

vii. *Asphalting / concreting of roads and water spray all around the critical areas prone to air pollution and having high levels of SPM and RPM shall be ensured.*

Complied. All major roads of the plant are paved with concrete. Water sprinkling is being done with truck mounted sprinklers on critical roads of cement plant.

viii. *Secondary fugitive emissions shall be controlled and shall be within the prescribed limits and regularly monitored. Guidelines / Code of Practice issued by the CPCB in this regard shall be followed.*

Being complied. All the material transfer points are equipped with dust collection systems to control secondary fugitive emissions. Total 88 Nos. of APCE in cement plant and 9 Nos. of APCE in TPP are in operation. Water fogging system is installed at limestone crusher hopper. Agglomerative Dust Suppression systems (water fogging) are installed at raw material hopper area, coal handling area and additive handling area. Guidelines / code of practice issued by the CPCB in this regard are being followed accordingly.

ix. *Efforts shall be made to reduce impact of the transport of the raw materials and end products on the surrounding environment including agricultural land. All the raw materials including fly ash shall be transported in the closed containers only and shall not be overloaded. Vehicular emissions shall be regularly monitored.*

Being complied. Major portion of raw materials, clinker (intermediate product) and cement (end product) are being transported through closed wagons to control dust on surrounding agricultural lands. Fly ash is being transported in the closed containers only. Pneumatic system is used to convey the fly ash within the premises. All the raw material containers are not being overloaded. It is ensured that vehicular emissions are being regularly monitored by respective transporters.

- x. *Total water requirement for cement plant from bore wells / mine pit water shall not exceed 6,630 m³/day. The wastewater from boiler blow down, DM plant regeneration waste water, UF & RO rejects shall be neutralized in neutralization tank and mixed with cooling tower blow down in a Central Monitoring Basin (CMB) and used for greenbelt development. All the treated wastewater shall be recycled and reused in the process and / or for dust suppression and greenbelt development and other plant related activities etc. No process waste water shall be discharged outside the factory premises and 'zero' discharge shall be adopted.*

Being complied. Total water requirement for cement plant, power plant and domestic usages from mine pit water / bore well is 6,260 m³/day, after replacing the GCT & ESP of Kiln – I with Bag House, after execution of this project. Cement manufacturing will not generate process effluents. TPP effluent is being treated in effluent treatment plant. The wastewater from boiler blow down, DM plant regeneration waste water, UF & RO rejects and cooling tower blowdown of TPP are being neutralized in neutralization tank and being used for greenbelt. Sewage treatment plant is in operation to treat domestic sewage from colony. Auto garage wash water is being treated at Oil & Grease Trap. Compiled data of STP, TPP ETP and Oil & Grease outlet samples analysis carried out by MoEF&CC approved agency on monthly basis being for the period October 2016 to March 2017 is enclosed as Annexure – V, VI & VII respectively. These treated effluents are used for greenbelt, water sprinkling & partially for process activities and being maintaining 'zero discharge'. The excess treated waste water, if any, is being passed to pond in our own lands to uplift the water table nearby area.

- xi. *'Permission' for the drawl of 6,630 m³/day ground water / mine pit water shall be obtained from the Central Ground Water Authority / State Ground Water Board (GGWA / SGWB) and a copy of the letter shall be submitted to the Ministry's Regional Office at Bangalore within 3 months of issue of the environment clearance.*

Complied. Permission obtained from SGWB for 7000 m³/day vide Lr. No. 11/Hg/MC/2006 dated 29.03.2007 (enclosed as Annexure - IV).

- xii. *All the bag filter dust, raw meal dust, coal dust, clinker dust and cement dust from air pollution control devices shall be recycled and reused in the process and used for cement manufacturing. The sludge from sewage treatment plant (STP) shall be used as manure for greenbelt development. Organic wastes shall be subjected to vermin composting and used as manure for greenbelt. Inorganic wastes (papers and other wastes) shall be properly disposed off or sold to rag pickers / scrap dealers. Used oil and batteries shall be used in kiln as an alternate fuel and / or sold to authorized recyclers / reprocessors only.*

Being complied.

- All the bag filter dust, raw meal dust, coal dust, clinker dust and cement dust from air pollution control devices are being recycled totally in the respective section and reused in the cement manufacturing process.
- The sludge from sewage treatment plant (STP) is being used as manure for greenbelt development.
- Organic wastes is subjected to vermin composting and used as manure for greenbelt.
- Inorganic wastes (papers and other wastes) are properly disposed off.
- Waste oil along with fresh fuel is being used for kiln firing while light up & for reclaimer lubrication and sold to APPCB authorized agents.
- Used lead acid batteries are sold to APPCB authorized agents.
- Waste lead acid batteries are being stored in closed shed and waste oil is stored in a tank of capacity 3.5 kL, till their disposal.

xiii. An effort shall be made to use of high calorific hazardous waste in the cement kiln and necessary provision shall be made accordingly.

Being complied. Hazardous Waste Authorization for handling various high calorific hazardous wastes obtained from APPCB and applied for regular permission from CPCB. CPCB has rejected our proposal for the specified list of materials.

xiv. Efforts shall be made to use low-grade lime, more fly ash and solid waste in the cement manufacturing.

Being complied. About 15% low grade limestone is being used by blending activity. For production capacity of 3.65 million TPA cement, the total fly ash requirement is 1.11 million TPA and slag requirement is 0.287 million TPA respectively.

xv. All the fly ash shall be utilized as per Fly Ash Notification, 1999 subsequently amended in 2003. Efforts shall be made to use fly ash and slag maximum in making Pozollona Portland Cement (PPC) and Portland Slag Cement (PSC).

Being complied. Fly ash collected from TPP is being totally reused in the production of PPC. For production capacity of 3.65 million TPA cement, the total fly ash requirement is 1.11 million TPA and total slag requirement is 0.287 million TPA respectively.

xvi. As proposed, greenbelt shall be developed in 172.75 ha (69.63%), out of total 248.08 ha area in and around the cement plant as per the CPCB guidelines to mitigate the effects of air emissions in consultation with local DFO.

Greenbelt is developed in an area of 130.24 ha by March 2017. This condition is modified in the latest Environmental Clearance issued for Cement Plant expansion project [No. J-11011/403/2006-IA-II (I) dated 29th September, 2016], as point No. vi of specific conditions:

- A greenbelt of 130.24 ha (52.5 % of 248.08 ha) as on 30.11.2014 has been developed, which should be maintained as it is.

Copy of the EC is enclosed herewith as Annexure – IX. Emphasis is being made to maintain 130.24 ha greenbelt area in and around plant premises in consultation with local DFO to mitigate the effects of air emissions.

xvii. *Permission and recommendations of the State Forest Department regarding impact of proposed plant on surrounding reserve forests viz. Jaggayapeta Extension RF (0.2-10.5 km, E-S), Budavada RF (3.2-10.5 km, W), Ballusupadu RF (6-11 km, WNW), Gandrayi RF (8.5-11 km, NNW) and Kuntimaddi RF (8 km, SSE) shall be obtained and implemented. Further, Conservation Plan for the conservation of wild fauna in consultation with the State Forest Department shall be prepared and implemented.*

Complied. District Forest Officer, Vijayawada has accorded 'No Objection Certificate' for the modernization project, vide Lr. No. 712/2000-V6 dated 13.05.2009.

Wild life conservation plan is not required as no wild life and schedule -1 species are present in the area as per the DFO Krishna Division, Vijayawada through Letter No. Rc. No.712/95-V6 date 29.08.2008.

xviii. *All the recommendations made in the Charter on Corporate Responsibility for Environment Protection (CREP) for the Cement plants shall be implemented.*

Being implemented. The compliance report for CREP guidelines for cement plant is enclosed as Annexure - XI.

xix. *The company shall provide housing for construction labour within the site with all necessary infrastructure and facilities such as fuel for cooking, mobile toilets, mobile STP, safe drinking water, medical health care, crèche etc. The housing may be in the form of temporary structures to be removed after the completion of the project.*

Complied. Separate colony with permanent structures is constructed for contract workmen with all necessary infrastructure facilities such as toilets connected with septic tanks, safe drinking water, medical health care, etc.

Potability certificates for RO plant inlet and outlet samples for the period October 2016 to March 2017 are enclosed as Annexure - XV.

B. General Conditions:

i. *The project authority shall adhere to the stipulations made by Andhra Pradesh Pollution Control Board (APPCB) and State Government.*

Being complied as per the CFO Order No. APPCB/HO/UH-IV/CFO:VJA/Auto Renewal-9/2016 dated 08.12.2016, which is valid up to 31st January 2022.

ii. *No further expansion or modification of the plant shall be carried out without prior approval of this Ministry.*

Noted. EC is issued by Ministry vide Lr. No. J-11011/403/2006-IA-II (I) dated 29th September, 2016 to increase the clinker production from 2.80 million TPA to 3.185 million TPA clinker in Cement Plant and installation of 6 MW Turbo Generator in Thermal Power Plant (of present capacity 2 x 18 MW).

iii. *The gaseous and particulate matter emissions from various units shall conform to the standards prescribed by the AP Pollution Control Board. At no*

time, the particulate emissions from the cement plant shall exceed APPCB limit. Interlocking facility shall be provided in the pollution control equipment so that in the event of the pollution control equipment not working, the respective unit(s) is shutdown automatically.

Complied. Efforts are being made to adhere to the gaseous and particulate matter emissions from various units to the standards prescribed by the APPCB. In the event of pollution control equipment not working, the respective unit(s) gets stopped automatically in phased manner with associated interlocks.

iv. *Ambient air quality including ambient noise levels shall not exceed the standards stipulated under EPA or by the State authorities. Monitoring of ambient air quality and stack emissions shall be carried out regularly in consultation with APPCB and report submitted to the APPCB quarterly and to the Ministry's Regional Office at Bangalore half-yearly.*

Being complied. Ambient air quality monitoring and stack monitoring are being carried out with MoEF&CC approved external laboratory. Data on ambient air and stack emissions is being regularly submitted to APPCB on monthly basis & half yearly basis and half-yearly basis to MoEF&CC, Regional Office. Compiled data of ambient air quality monitoring data collected by MoEF&CC approved external laboratory on monthly basis for the period October 2016 to March 2017 is enclosed as Annexure - I. Efforts are being made to achieve noise levels within norms.

v. *The company must harvest the rainwater from the rooftops and storm water drains to recharge the ground water and use the same water for the various activities of the project to conserve fresh water.*

Being complied. 48 Nos. of rain water harvesting structures are made to recharge the ground water in the colony by March 2017. 3 Nos. of rain water harvesting structure are made to recharge the ground water in the plant by March 2017 (Annexure – VIII). Water collected in mine pits is only being used for cement plant, thermal power plant and for domestic purposes. Treated waste water from STP, ETP and Oil & Grease Trap is used for greenbelt and water sprinkling activities.

vi. *The company shall undertake eco-development measures including community welfare measures in the project area.*

Being complied. Spent about Rs. 85.60 lakh in the financial year 2016-17 for various socio-economic activities for the surrounding villages as part of corporate social responsibility. Details of CSR expenditure is being submitted along with half-yearly compliance reports regularly to MoEF&CC regularly.

CSR activities for the nearby villages are being carried out as per the need basis of the local people, subjected to the budget availability. The expenditure details regarding the same for the year 2016-17 are enclosed as Annexure – X.

vii. *The overall noise levels in and around the plant area shall be kept well within the standards (85 dBA) by providing noise control measures including acoustic hoods, silencers, enclosures etc. on all sources of noise generation. The ambient noise levels shall conform to the standards prescribed under Environmental (Protection) Act, 1986 Rules, 1989 viz. 75 dBA (day time) and 70 dBA (night time).*

Being complied. Efforts are made to achieve noise levels within the standards.

viii. *All recommendations made in the Corporate Responsibility for Environment Protection (CREP) for cement plants shall be implemented.*

Being implemented. The compliance report for CREP guidelines for cement plant is enclosed as Annexure - XI.

ix. *Proper housekeeping shall be taken up. Regular annual medical examination of all the employees shall be carried out from the occupational health point of view and records maintained.*

Being complied. Proper housekeeping is maintained in the plant premises. 3 Nos. of mobile road sweepers and 1 No. of vacuum cleaner are being used for better housekeeping. Occupational health checkup is being carried for all the employees and records are being maintained.

x. *A separate environmental management cell to carry out various management and monitoring functions shall be set up under the control of Senior Executive.*

Complied. Separate environmental management cell is carrying out monitoring functions. The organization chart of environmental cell is enclosed as Annexure - XII.

xi. *Occupational health surveillance programme shall be done on a regular basis and records maintained. The programme must include lung function and sputum analysis tests once in six months.*

Being complied. Occupational health checkup is being carried for all the employees, covering lung function and sputum analysis tests also. Occupational Health Centre (with qualified Occupational Health Specialist) is established with the following facilities:

- X-ray
- ECG
- Spirometry (lung function test)
- Audiometry
- Semi-auto analyser to carryout bio-chemical tests
- Clinical lab for micro-biological tests (including sputum test)
- Checking colour blindness
- Dental chair
- Ambulance

xii. *As proposed, Rs. 2.00 Crores and Rs. 2.50 Crores shall be earmarked towards the total capital cost and recurring cost/annum for environmental pollution control measures and shall be suitably used to implement the conditions stipulated by the Ministry of Environment and Forests as well as the State Government. Rs. 25.00 Lakhs and Rs. 25.00 Lakhs earmarked towards EMP / greenbelt and occupational health per annum and Rs. 50.00 Lakhs earmarked for corporate social responsibility shall be judiciously utilized and regular report shall be submitted to the Regional Office of this Ministry at Bangalore. The funds so provided shall not be diverted for any other purpose.*

Being complied. Earmarked funds so provided are not being diverted for any other purposes.

- Rs. 218 lakh spent towards the total capital cost for environmental pollution control measures at the time of modernization.
- Rs. 4.31 crore spent on new air pollution control equipment in the financial year 2016-17 as part of the Line – I expansion project.
- Rs. 6.49 crore spent as recurring cost in the financial year 2016-17, for various environmental protection measures associated with plant.
- Greenbelt expenditure in the financial year 2016-17 is Rs. 81.42 lakh with respect to plant, colony, mining lease areas and nearby areas.
- The expenditure details for various environmental protection measures taken for the financial year 2016-17 are enclosed as Annexure - XIII. Total expenditure in the financial year 2016-17 towards environmental protection account is around Rs. 14.27 crore.
- Spent about Rs. 85.60 lakh in the financial year 2016-17 for various socio-economic activities for the surrounding villages as part of corporate social responsibility.

xiii. The Regional Office of this Ministry at Bangalore / CPCB / APPCB shall monitor the stipulated conditions. A six monthly compliance report and the monitored data along with statistical interpretation shall be submitted to them regularly.

This compliance report along with statistical interpretation of monitored data is submitted as per this stipulation.

xiv. The Project Authorities shall inform the Regional Office as well as the Ministry, the date of financial closure and final approval of the project by the concerned authorities and the date of commencing the land development work.

Noted. Date of financial closure for this project is not required as total funding for this project is from own funds.

xv. The Project proponent shall inform the public that the project has been accorded environmental clearance by the Ministry and copies of the clearance letter are available with the AP Pollution Control Board and may also be seen at Website of the Ministry of Environment and Forests at <http://envfor.nic.in>. This shall be advertised within seven days from the date of issue of the clearance letter at least in two local newspapers that are widely circulated in the region of which one shall be in the vernacular language of the locality concerned and a copy of the same shall be forwarded to the Regional office at Bangalore.

Complied. Published the same in 11.06.2009 Eenadu (Telugu) & The Hindu (English) newspapers and copy submitted to Regional Office, Ministry.