

EXECUTIVE SUMMARY

For

Proposed Expansion of Sugar capacity from 2500 TCD to 7500 TCD, Cogen power 12 MW to 32 MW and 120 KLPD new Distillery plant with 4 MW captive cogen power plant

By

**M/s. Khatav Man Taluka Agro Processing Ltd
Village : Padal, Tal. Khatav, Dist: Satara, State : Maharashtra**

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1.0 Introduction :

Khatav Man Taluka Agro Processing Ltd. (KMTAPL) is incorporated as public limited company mainly by Gharge, Ghorpade & Salunkhe family on 18/03/2011 vide CIN No. U01122PN2011PLC138910.

The company has installed 2500 TCD sugar plant and 12 MW cogen power plant at village Padal, Tal. Khatav, Dist. Satara. The plant is supplied by M/s ISGEC Heavy Engineering Ltd., Noida. KMTAPL has undertaken 1st trial crushing season in 2018-19 and crushed about 33044 MT of cane and produced 32630 Qtl. of sugar with an average recovery of 9.87% on cane. The Company has total land of 19.56 Ha at Padal Village which sufficient for sugar and cogen expansion as well as for setting up 120 KLPD distillery / ethanol plant. Company has constructed underground water storage tank and temporary water supply scheme. Company is in process to construct permanent water supply scheme from Yeralwadi Dam, which is about 8 Km from the site. The said dam has gross storage capacity of 32.80 Million Cum.

KMTAPL is now planning to increase the cane crushing capacity from present 2500 TCD to 7500 TCD (net addition of 5000 TCD). The company also proposes to increase its cogen power capacity from existing 12 MW to 32 MW for export of surplus power to grid and set up 120 KLPD Distillery /Ethanol plant with 4 MW captive cogen power plant.

2.0 Introduction of the project

2.1 Promoter's Background & Profile:-

Mr. Prabhakar D. Gharge, Director : He is in the field of cooperative banking for more than 22 years and now he is the Director of Satara DCC Bank Ltd. He is well known for experiments in agriculture & is chief promoter of plant. He is also in the real estate business and also set up Preeti Hotel at Satara. He was Director of Pratapgad Sahakari Sakhar Karkhana Ltd., Dist Satara. He has represented Satara and Sangli constituency as Member of Legislative Council through which is conversant with agriculture to processing of sugar cane.

2.2 Brief description of the project

The proposed scheme envisages for enhancing the sugarcane crushing capacity by addition of 5000 TCD to its 2500 TCD sugar plant (total capacity of 7500 TCD)

considering the huge potential raw material available from the nearby villages of KMTAPL. The cogen power plant will be expanded from its existing capacity of 12 MW to 32 MW.

This expansion program shall be met by addition of equipments in milling and boiling house sections and addition of equipment in cogen power plant.

The company also proposes to set up 120 KLPD distillery / ethanol plant along with captive cogen power plant.

The proposed distillery / ethanol plant of 120 KLPD capacity will employ state of art technology for production of fuel ethanol i.e. fermentation, multi pressure distillation system, integrated and standalone evaporation section and spent wash fired incineration based cogen power plant. Sugar factory will supply B-heavy molasses, while the incineration boilers and turbines will supply steam and power to the proposed ethanol plant. It will employ high pressure boiler of 25 TPH & 4 MW back pressure steam turbine.

KMTAPL has already applied for amendment in IEMs for 7500 TCD sugar. KMTAPL has already received IEMs for 36 MW cogen power plant and 120 KLPD distillery / ethanol plant from the Ministry of Commerce & Industry, Govt. of India.

Existing land is sufficient for the proposed expansion project including 120 KLPD distillery / ethanol plant.

The current policies for manufacture of fuel ethanol are getting progressively conducive at the Centre & also in the State of Maharashtra. The Government of India has recently approved the purchase price at Rs. 45.69 / litre of fuel ethanol from C-molasses, Rs.57.61/Litre from B-heavy molasses and Rs.62.65/Litre from juice / syrup, excluding GST and transport.

2.3 PROJECT DESCRIPTION :

SALIENT FEATURES OF THE PROJECT

Sr. No	PARTICULAR	DETAILS
1	Name of the Company & Regd. Office Address	M/s Khatav Man Taluka Agro Processing Ltd. Priya Agencies, Plot No. B-52/3, Ganesh Chowk, Old MIDC, Satara – 415 003, Maharashtra.
2	Factory Site	At Padal, Tal. Khatav, Dist. Satara 415 507, Maharashtra
3	Constitution & Type	Public Limited Company
4	Products & By Products	1. Sugar 2. Cogeneration power 3. Ethanol
5	Existing Capacity of the Project	Sugar Plant: 2500 TCD Cogen Power Plant (12 MW: BEP type)
6	Proposed Expansion Capacities of the Project	Expansion Sugar Plant: 5000 TCD Total installed capacity: 7500 TCD Expansion Cogen Power : 20 MW Total installed capacity: 32 MW Distillery / Ethanol Plant : 120 KLPD
7	Commercial Operation Date- (C.O.D)	January, 2022
8	Working Days	160 days of sugar plant 160 days of cogen plant (Season)

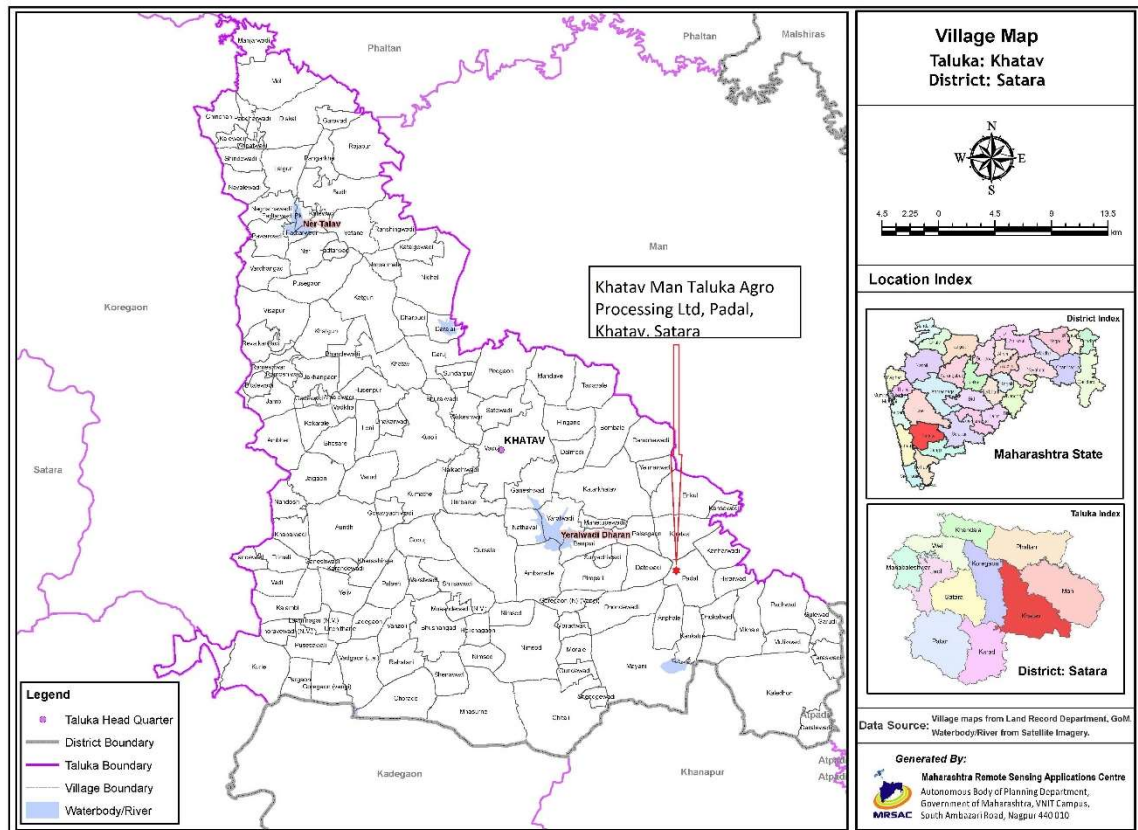
		88 days of cogen plant (Off-Season) 330 days of Distillery / ethanol plant
9	Basic Raw material requirement per annum	12.00 lakh MT of Sugarcane
10	Bagasse, Molasses & Press mud Available from sugarcane crushing	Bagasse - 336000 MT per Annum Diversion of Juice – 1600 TCD to Ethanol plant B-Heavy Molasses – 56640 MT/Annum + 9312 Procured Press mud – 36000 MT / Annum

2.4 Site Connectivity and environmental Sensitivity

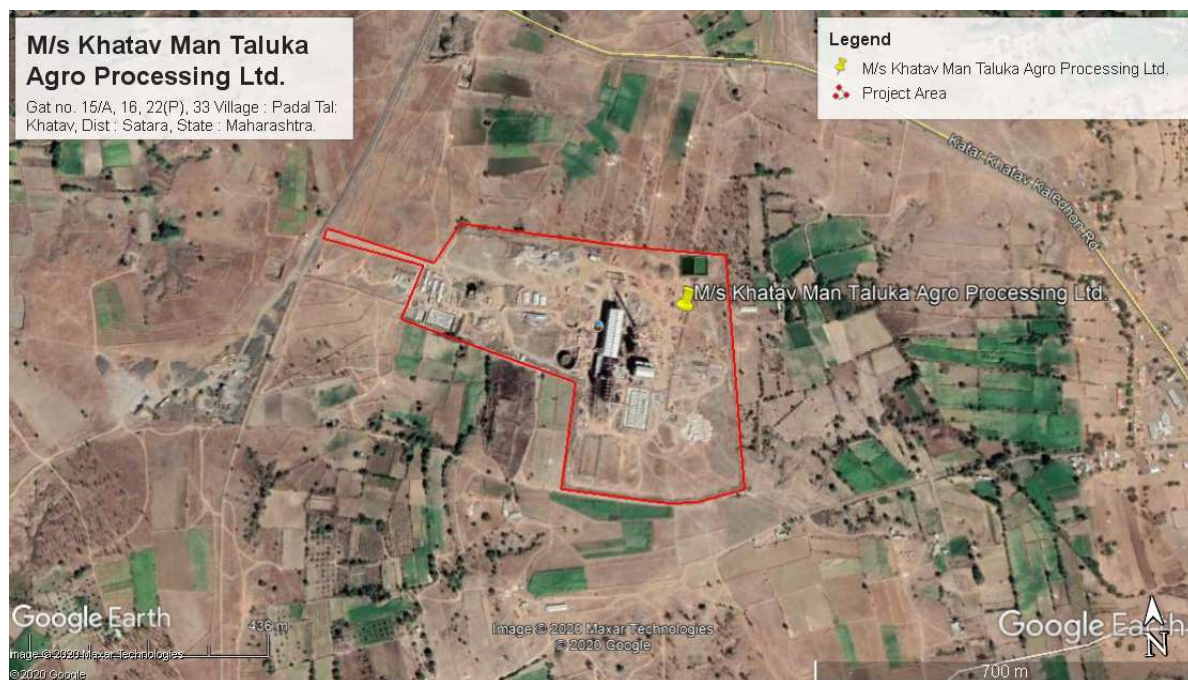
The site is well connected by the roads for transportation of sugarcane within the area of operation.

Sr. no	Particular	Details
1	Nearest Village	Padal which is 620 meter from project site
2	Nearest Town / City	Mayani city which is 6 km away from project site
3	State Highway	State Highway no. 145 is 3.07 km
4	Nearest National Highway	National Highway no.4 is 49.12
5	Nearest Railway station	Karad Railway Station 43.48 km
6	Nearest Airport	Pune Airport 137.33 km away from project site.
7	National Parks, Reserved Forests (RF) / Protected Forests (PF), Wildlife Sanctuaries, Biosphere Reserves, Tiger/ Elephant Reserves, Wildlife Corridors etc. within 10 km Radius	Reserve forest South West direction 4.56 km, reserved forest south direction 6.29 km.

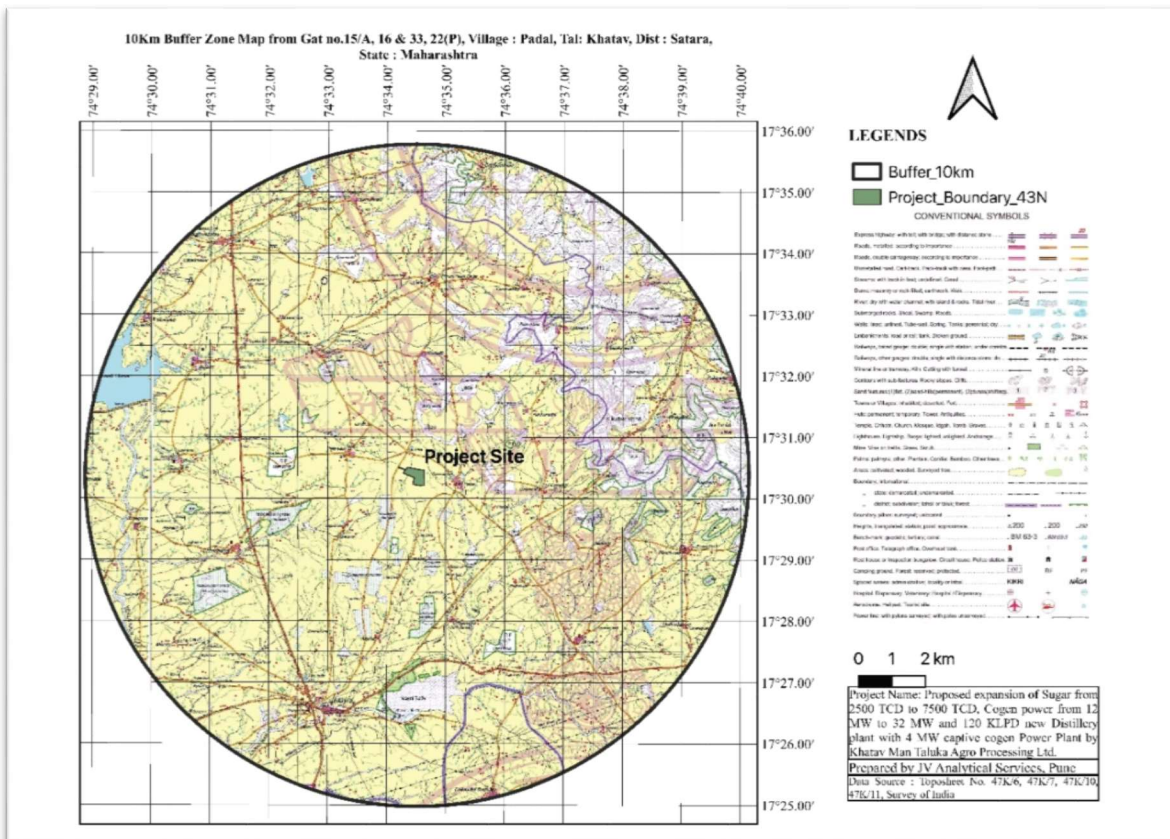
Site Location:



Google Image of the Project



Toposheet of 10 Km radius of Project site



2.6 Land and site development

The Company has total land of 21.34 Ha at Padal Village which sufficient for sugar and cogen expansion as well as for setting up 120 KLPD distillery / ethanol plant. Necessary facilities like roads, street lighting and green belt etc. are also being established.

Proposed Infrastructure:

Area Statement:

Sr. No	Particular	Area In Sq.M
1	Total area of land	213400
2	Total Built up area	34095
3	Total area under road	14050
4	Total area under green belt	69500
5	The cane Marshall & bagasse yard	22500
6	Total Open area	73255

Details of the alternate sites

No alternate sites have been examined, as proposed project will be located in existing factory Premises.

2.7 Raw Material and its Sustainability

Sugar Plant

The command area of the KMTAPL has excellent irrigation facilities and potential for ensured raw material supply for the sugar factory.

Company has reported that they have registered cane from farmers of about 12000 Ha. The average per ha cane yield in the operational area is about 100 MT/ha. Therefore, based on the registered cane with the factory, the company is expected to get cane . to farmers through bank loans, by issuing suitable guarantees for recovery of bank loan

It is recommended that KMTAPL should also sponsor cane development schemes on its own and / or with the help the farmers in its command area, for availing financial assistance. This will help KMTAPL in ensuring assured availability of cane, on a long-term basis.

KMTAPL has already appointed skilled & experienced personnel within Agronomy Department. With these sustained efforts, KMTAPL is sure of getting the required sugarcane for its expanded capacity, by the time plant is commissioned.

Cogen Power Plant

Bagasse is the main source of fuel that will be available from the sugarcane crushing of 12.00 lakh MT after expansion. This is purely green source of fuel and will not pose any pollution to environment.

The cogen plant will be operated for 160 days to cater steam to sugar process during season. The sugar plant will generate about 3,36,000 MT of bagasse. Cogen power plant after expanding it to 32 MW, will use around 266573 MT of bagasse during season & balance bagasse around 69427 MT will be used in off-season for 88 days.

Ethanol Plant

The generation of B-heavy molasses of 56640 MT, considering the crushing of 12.00

lakh MT will be available. Further, cane juice of 1600 TCD/day will be diverted to distillery / ethanol plant. For operation of fuel ethanol plant for 330 days at 100% capacity utilization, additional C-molasses of 9312 MT will be met out through procurement through nearby sugar factories / traders.

Hence, the company will not face any difficulty for its operation of distillery / ethanol plant for 330 days.

Process Description of sugar plant

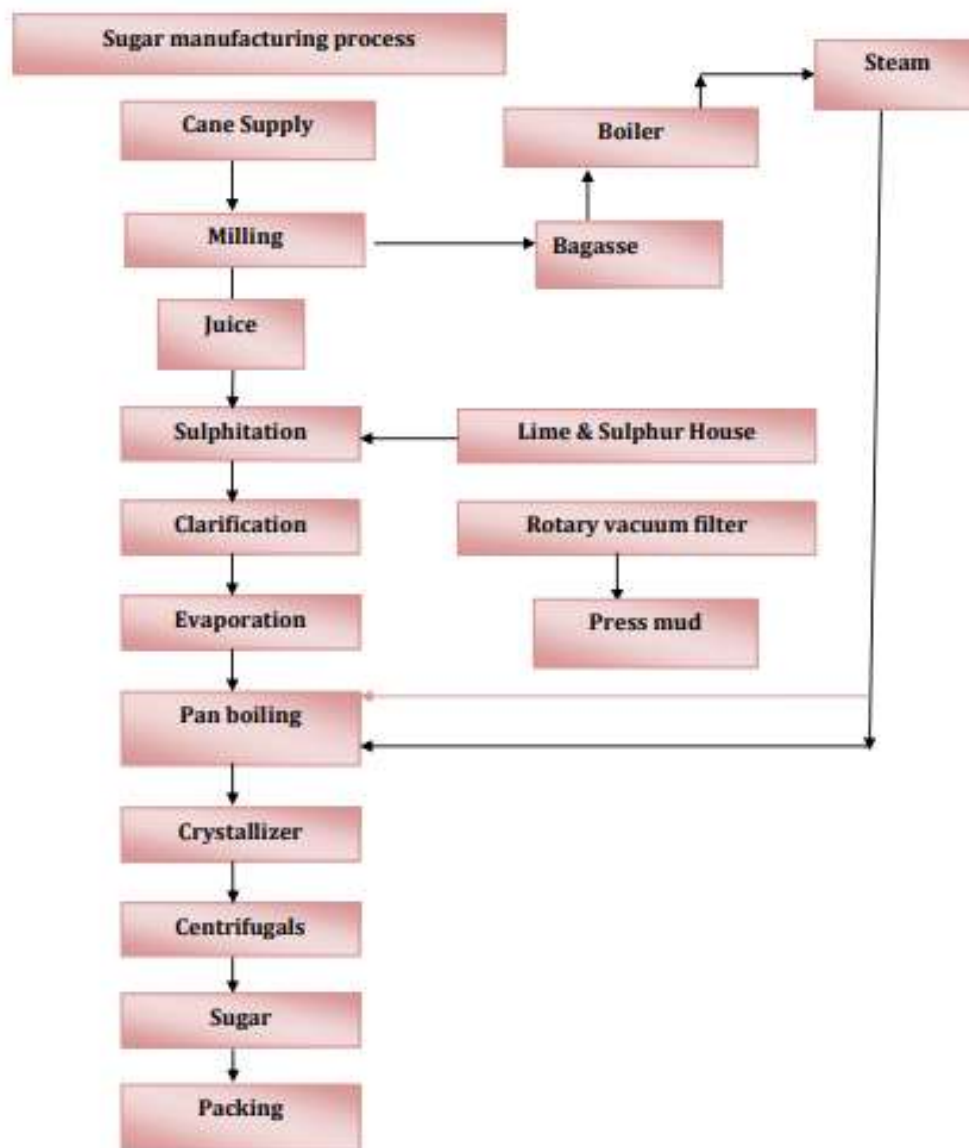


Fig : Flow diagram of sugar manufacturing process

Fig : Flow diagram of Cogeneration power

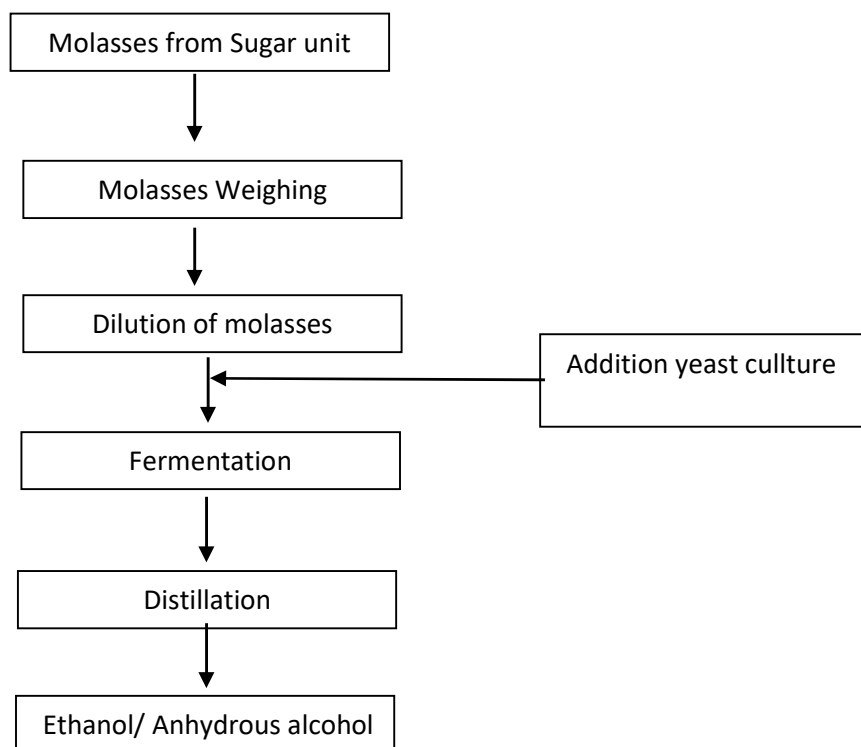


Fig : Ethanol production process flow chart

Production details

Particulars	2018-19	2019-20
Sugar Cane Crushed (Lakh MT)	0.33	3.28
Bagasse (MT)	8931	92856
Molasses (MT)	13752	1864
Sugar Produced (Lakh Qtl)	0.33	3.64
Sugar Recovery (%)	9.87	11.10
Molasses (% on cane)	5.64	4.20
Bagasse (% on cane)	27.03	28.33

Performance Details

Particulars	2018-19	2019-20
Gross Season Days	31.27	133.58
Net Season Days	29	123
Mill Extraction	93.08	95.29
Reduced Mill Extraction	92.71	95.68
Boiling House Extraction	81.31	88.36
Reduced Boiling House Extraction	83.69	88.92
Overall Extraction	75.69	84.20
Reduced Overall Extraction	77.78	85.08
Total sugar losses	3.17	2.08
Crushing capacity achieved		
- Including Stoppages	1152.75	2849.95
- Excluding Stoppages	1152.75	2676.37

2.8 Water Requirement:

Company has constructed underground water storage tank and temporary water supply scheme. Company is in process to construct permanent water supply scheme from Yeralwadi Dam, which is about 8 Km from the site. The said dam has gross storage capacity of 32.80 Million Cum.

Total process and cooling water requirement for the proposed project after recycling and reuse is estimated at 1650 m³/day.

The water for distillery and allied projects to be met from existing water supply of the sugar mill. However, the process water will be treated separately in the water treatment

plant to be provided in the distillery project.

2.9 Power Requirement

Company has proposed to install separate incineration boiler of 25 TPH and back pressure turbine of 4 MW

3.0 Baseline Environment

3.1 Ambient Air Quality

Ambient air quality of the study area has been assessed during study period January 2021 to March 2021, through a network of Nine ambient air quality stations within an area of 10 km region around the project site.

Based on the established selection criteria the locations of ambient air quality monitoring (AAQM) stations have been identified. The concentrations of PM₁₀, PM_{2.5}, SO₂ and NO_x samples were collected as 24 hourly average by drawing air at the rate of 1.0 -1.5 m³/min through glass fibre filter paper and analyzing by the gravimetric method.

Table 3.1 Ambient Air Monitoring Locations

Sr No	Locations	Geocodes	Direction	Distance from Project site in Km
1	Project site	17°30'20.54"N 74°34'29.80"E	-	0
2	Kanharwadi	17°31'24.90"N 74°36'27.16"E	NE	3.60
3	Hivarwadi	17°30'7.36"N 74°36'36.33"E	SEE	3.72
4	Dhondewadi	17°29'8.18"N 74°31'23.74"E	W	5.47
5	Padal	17°30'10.29"N 74°35'9.12"E	SE	0.67
6	Mayani	17°26'40.67"N 74°32'50.29"E	SW	6.88
7	Yaralwadi	17°32'53.22"N 74°30'4.61"E	NW	8.49
8	Pasalgaon	17°32'15.30"N 74°32'56.62"E	NNW	4.08

3.2 NOISE LEVEL

Noise level measurements were carried out using Sound Level Meter of Pulsecho Systems (Bombay) private Limited make in nearby villages to establish their background levels.

Noise levels monitored at Project Site, Kanharwadi, Hivarwadi, Dhondewadi, Padal, Mayani, Yaralwadi and Palasgaon villages were analysed in terms of Residual, Medium, Peak, Equivalent, Daytime and Night Time Noise Levels

3.3 WATER ENVIRONMENT

3.3.1 Ground water Quality

Ground water samples from bore well or dug well were collected from Project Site, Kanharwadi, Hivarwadi, Dhondewadi, Padal, Mayani, Yaralwadi and Palasgaon villages and analyzed.

3.3.2 Surface Water Quality

The surface water sample at Yaralwadi dam and at Kadamwadi village has been collected and analysed.

3.4 Biological Environment

Biodiversity encompasses the variety and variability of life on Earth. It refers to the differences within and between all living organisms at this different level of biological Organization

	Botanical Name	Common Name	Family
<i>Trees</i>			
1.	*Acacia catechu	Khair	Fabaceae
2.	*Acacia Arabica	Babhul	Fabaceae
3.	*Abitulon indicum	Sweet neem	
4.	Annona squamosal	Sitaphal	Annonaceae
5.	Artocarpus hirsutus	Wild Jack	Moraceae

6.	*Azadirachta Indica	Neem	Meliaceae
7.	*Bauhinia racemosa	Apta	Fabaceae
8.	*Butea monosperma	Palas	Fabaceae
9.	Cordia dichotoma	Bhokar	Boraginaceae
10.	Dalbergia sissoo	Shisu	Fabaceae
11.	Erythrina indica	Pangara	Fabaceae

List of Dominant Fauna Observed in Study Area

S.No.	Name	Scientific Name	Conservation status
<i>Mammals</i>			
1	Common mongoose	Herpestes edwardsi	Least concern
2	Indian hare	Lepus nigricollis	Least concern
3	Indian porcupine	Hystrix indica	Least concern
4	Jackal (gidar)	Canis aureus	Least concern
5	Indian fox	Vulpes bengalensis	Least concern
6	*Plam Squirrel	Funambulus pennati	Least concern
7	Sheep	Ovis	Least concern

4.0 Anticipated Environment Impact and Mitigation measures

Identification of impacts and mitigation measures of the same in Environmental Impact Assessment study helps in quantification and evaluation of impacts.

4.1 During Construction Phase

Land Environment

This is an existing operating sugar plant and adequate land is available within the premises for distillery unit. The area identified for the distillery unit is almost flat and not much of leveling work is expected.

Mitigation Measures

- All earth work will be completed in such a way so that the soil erosion and carryover of the materials in other areas are protected.
- The packaging materials which may consist of wooden boxes and jute wrappers will be stored at suitable place and disposed off suitably.
- Excavated soil will be used for green-belt development.

Water Environment

- Due to construction activities, the surface run-off during rainy season may contain more of
- eroded soil and other loose matter. With segregation of construction area and proper drainages, the water contamination is prevented

requirements for labour and staff onsite.

Mitigation Measures

- The earth work (cutting and filling) will be avoided during rainy season and will be Completed during the winter and summer seasons only
- Stone pitching on the slopes and construction of concrete drains for storm water to Minimize soil erosion in the area will be undertaken
- To strengthen the green belt in and around plant will be undertaken during the monsoon season

Air Environment

- The main sources for impact of air quality during construction period is due to movement of vehicles and construction equipment at site, dust emitted during leveling, foundation works, transportation of construction material etc.

Mitigation Measures:

Following measures would greatly reduce the impacts during the construction phase

- The approach roads will be paved or tarred and vehicles will be kept in good order to minimize the pollution due to vehicular traffic.
- It is necessary to control the dust emissions particularly during dry weather. This will be achieved by regular water sprinkling all over the exposed area, at least twice a day using truck-mounted sprinklers.

4.2 During Operation Phase

Operational phase activities may have impacts minor or major, positive or negative on environmental discipline such as soils, surface and ground water hydrology, micro meteorology, water use, water and air quality, ecology, socio economics & noise environment.

This phase includes following activities:

- Raw material storage
- Product manufacturing
- Product storage
- Transportation
- Gaseous emission
- Effluent discharge
- Solid waste generation
- Occasional equipment failure/ process upset and related problems

5.0 ENVIRONMENT MANAGEMENT PLAN

5.1 Objectives of Environmental Management Plan

The main objectives in formulating the environment management plan are

- ✓ To treat all the pollutants i.e. effluent, air emission, noise & solid waste, which contribute to the degradation of environment, with appropriate technology.

5.2 Wastewater Management

Sewerage system

Domestic waste water generated will be sent to septic tank and soak pit.

Waste Water and its Disposal

Waste water or liquid effluent is normally generated from the following

1. Water treatment plant
2. Boiler blow-down
3. Waste water from various places like toilets, laboratory, washing etc.

Total effluent by way of above and effluent generated from sugar mill will be around 500 m³/day after expansion.

Wastewater treatment will be based on discharges of the various waste water to ponds for clarification and filtration. Oily water, if any, will be treated separately to remove oil / grease, before discharge into the effluent pond. The oily water collection in the plant is basically due to floor cleaning, leaky oil filters, etc.

Oil and grease free effluent is transferred to a Neutralizing cum settling tank to settle out large suspended particles and the pH is also corrected if required by addition of acid or alkali. Coagulants, Chemical agents and polymers are added to condition finer & colloidal particles, to enable their settling. The effluent will be passed through a sand filter unit and will store in the treated water storage tank. The water will be used for maintaining the Green Belt.

Ethanol Plant

The spent wash treatment plant will use latest technologies to achieve zero discharge. The multistage evaporation system will be used to reduce the spent wash quantity. The details of spent wash generation is given below for use of juice/syrup, B heavy molasses and C molasses.

5.3 Air Pollution management

Main air polluting elements discharged from the proposed Cogen Project include dust particulate from fly ash, Nitrogen oxides and Sulphur-di-oxide in the flue gas

ESP is already installed to arrest the fly ash and same will be collected and sent to ash silo. ESP will be designed to maintain the particulate matter emission below 50 mg/Nm³.

Bagasse contains minor quantity of sulphur. Hence, the chimney height is calculated as per the designated formula the problem of Sulphur can be tackled. The temperatures encountered in the boiler while burning high moisture bagasse are lower enough to minimize the nitrogen-oxides production. Moreover, the tender specification for boiler will stipulate over fire air system with staged combustion, to ensure reduction in nitrogen-

oxide emission. Hence, no separate measures are taken to contain the nitrogen oxide pollutants.

5.4 Solid Waste Generation and Management Solids (Ash & its Disposal)

Solids are generated by way of ash by burning the bagasse. As bagasse is renewable fuel and creates less harm to the environment is considered as an environment friendly fuel as compared to coal. Ash generated from the bagasse is also very less as compared to the coal. Ash generated from bagasse is only around 2% against 35% by burning Indian coal and 10% by burning imported coal. While in distillery, ash will be generated 25 MT/day.

In this project only bagasse as fuel is considered and no coal will be used. Total bagasse utilized during season will be 266573 MT and 69427 MT bagasse will be used in off-season. Ash generated will be 5332 MT & 1389 MT. In distillery, the total ash will be generated about 16500 MT (total 23221 MT for integrated project).

Total ash is generated as bottom ash which is collected at the bottom of the boiler below grate (travelling grate or dumping grate) and fly ash which fly along with exhaust gases.

ESP is already installed to arrest the fly ash and same will be collected and sent to ash silo. ESP will be designed to maintain the particulate matter emission below 50 mg/Nm³.

The ash generated will be initially stored in silos and suitably supplied to the brick manufactures through trucks and also can be used to mix in the farms. As the ash generated from the bagasse has high potash value, same can be used to mix with press mud and use for bio-compost production and then sell it to farmers as fertilizer.

5.5 Noise & vibration control

Relevant noise emitters at KMTAPL are noise-making equipment such as compressors, pumps, centrifuges, blowers, cranes, conveyor belts, boilers, turbo generator etc. All the equipment produce continuous noise. As deliberated in chapter -IV, noise level impacts of KMTAPL operations are significant only on the operators of machinery and are negligible within buffer zone.

5.6 Socio-economic benefits.

- Ample power will be available from local grid due to decentralization of power generation
- Power from grid on no charge basis or low charge basis can be available in this area.
- This can be an initiative for many units to start.
- Many sorts of direct as well as indirect job opportunities will be on the horizon due to expansion of sugar, co-generation and new distillery plant.

5.7 Green Belt Development

Company to be planted several trees around factory premises

No.	Scientific name of tree	Common Name
1	Azadirachta indica	Neem
2	Pongamia pinnata	Karanj
3	Magnifera indica	Mango
4	Ficus benghalensis	Banyan
5	Tamarindus indica. Linn	Chinch
6	Cocos nucifera	coconut tree
7	Hibiscus rosa-sinensis	Jaswand
8	Eucalyptus	Nilgiri
9	Terminalia catappa	Badam
10	Phyllanthus emblica	Awala
11	Casuarina equisetifolia	Suru
12	Ficus religiosa	Pimpal
13	Saraca asok	Ashok
14	Dalbergia sissoo	Shisam
15	Tectona grandis	Sag
16	Vitex negundo	Nirgudi
17	Limonia acidissima	kavath
18	Nerium oleander	Kanher
19	Annona squamosa	Sitafal
	Total	4250

5.8 Budget Provision For Environmental Management

Sl. No.	Particulars	Capital cost (Rs. Lakhs)	Recurring Cost (Rs. Lakh/annum)
1	Air Pollution Control; to co-gen boiler comprising of ESP, stack of 76 meter height	50	3.00
2	Water Pollution control; ETP Facility comprising of full-fledged ETP- Primary, Secondary treatment with online monitoring system	300	5.00
3	Noise pollution control Enclosures for DG set	4.00	0.45
4	Occupational health; annual health check up	5	0.50
5	Environment monitoring and management	0.50	2.00
6	Green Belt development	20	0.85
	Total	379.85	11.80

5.9 Land & Site Development:

The sugar factory has already in possession which is sufficient for the proposed expansion. Most of the land is plain with not much level difference and strata of the land are quite hard.

6.0 Rehabilitation and Resettlement

The project site is in possession over the years. This is a working factory since long. The present proposal is only for expansion Thus, no Rehabilitation or Resettlement issues are any more involved with no human settlement.

7.0 Project Schedule & Cost estimate

The promoters have planned to complete the proposed integrated expansion by January 2022.

Cost of the project

Sr. no	Description	Sugar	Cogen	Ethanol	Total in Lakhs
1	Land	0.00	0.00	0.00	0.00
2	Site Development	18.00	18.00	108.00	144.00
3	Civil Works	168.00	786.00	1356.00	2310.00
4	Plant and Machinery	3780.00	5298.00	9263.00	18341.00
5	Misc. Fixed Assets	295.00	230.00	1056.00	1581.00
6	Prelim. & Pre-op. Expenses	293.00	400.00	321.00	1014.00
7	Contingencies	46.00	68.00	121.00	235.00
8	Working capital margin	0.00	0.00	75.00	75.00
	Total Project Cost	4600.00	6800.00	12300.00	23700.00

8.0 Analysis of Proposal

With sustained raw material availability for the project on long term basis and best technologies available to produce excellent quality of various products, the project is technically feasible. The market for these products is excellent with very good price.

Financial viability of the project is worked out and shows excellent financial results. Assumptions made are on conservative side and any increase in the crushing of the sugar mills and increase in prices of the final product will enhance the viability further.

Hence, considering sustained availability of raw material, excellent market and price for finished products, flexibility of producing variety of different products with market and price trend makes this project extremely feasible.

All the measures are taken to protect the environment and all the latest instruments like ESP, evaporation and ETP, CPU are considered to achieve the zero emission from the project.

Hence, it is recommended to go ahead with the project. This project will be win-win situation for both promoters and financial institutions along with farmers in the area.