

ORCEM/DVP/ENV/ 75
21st May 2024

To,
Inspector General of Forests (C),
Integrated Regional Office (IRO) - Hyderabad,
Ministry of Environment, Forests and Climate Change,
6th Floor, Aranya Bhawan, Opp. RBI,
Saifabad – 500004, Hyderabad, Telangana.
Iro.hyderabad-mefcc@gov.in

Sub: Six-Monthly Compliance Status Report for Environmental Clearance of Expansion of Cement Plant (Cement 3,600 to 8,900 TPD and Clinker 5,550 to 10,600 TPD) and installation of Captive Power Plant (50 MW) by M/s Orient Cement Limited at Devapur (V), Kasipet (M), Mancherial (Dist.,) Telangana state for the period of October 2023 to March 2024 - Reg.

Ref: Environment Clearance F. No. J-11011/266/2007-IA.II(I) Dated 06th September, 2007.

Dear Sir,

Reference with the Environmental Clearance cited above, we are herewith attached six monthly compliance status report for the period of October 2023 to March 2024 which was uploaded in PARIVESH 2.0 for our Expansion of Cement Plant (Cement 3,600 to 8,900 TPD and Clinker 5,550 to 10,600 TPD) and installation of Captive Power Plant (50 MW) at Devapur (V), Mancherial (Dist.,) Telangana State.

This is for your information & records please.

Thanking you,

Yours faithfully

For Orient Cement Limited


MP Joshi
Sr. Vice President (Works) & Unit Head

Encl: A/a 

Copy:

1. The Regional Director, Central Pollution Control Board, Regional Directorate (South), Nisarga Bhawan, 1st Floor, 7th D Cross, Thimmaiah Road, Shivanagar, Bengaluru - 560079, Karnataka.
2. Environmental Engineer, Telangana State Pollution Control Board, Regional Office, H. No. 6-2-166/A, 1st Floor, Subhash Nagar, Nizamabad – 503002, Telangana.

Orient Cement Limited

Devapur Plant : PO Devapur Cement Works, Adilabad (District), Telangana 504218, India.

+91 8736 240709 Fax : +91 8736 240522

Registered Office : Unit VIII, Plot No.7, Bhoingar, Bhubaneshwar, Odisha 751012, India www.orientcement.com

CIN No : L26940OR2011PLC013933

Your (**Environment Clearance**) application has been **Submitted** with following details

Proposal No	ORCEM/9,17.03.2007
Compliance ID	68706361
Compliance Number(For Tracking)	EC/M/COMPLIANCE/68706361/2024
Reporting Year	2024
Reporting Period	01 Jun(01 Oct - 31 Mar)
Submission Date	24-05-2024
IRO Name	V Geroge Jenner
IRO Email	tr025@ifs.nic.in
State	TELANGANA
IRO Office Address	Integrated Regional Offices, Hyderabad
Note:- SMS and E-Mail has been sent to V Geroge Jenner, TELANGANA with Notification to Project Proponent.	

**Half Yearly Compliance Report
2024
01 Jun(01 Oct - 31 Mar)**

Acknowledgment

Proposal Name	Expansion of Cement Plant (Cement 3600 to 8900 TPD and Clinker 5550 to 10600 TPD) and Installation of Captive Power Plant (50 MW) at Devapur Village, Kasipet Mandal, Mancherial District.		
Name of Entity / Corporate Office	Orient Cement Limited		
Village(s)	N/A		
District	MANCHERIAL		
Proposal No.	ORCEM/9,17.03.2007	Category	Industrial Projects - 1
Plot / Survey / Khasra No.	N/A	Sub-District	N/A
State	TELANGANA	Entity's PAN	NA
MoEF File No.	J-11011/266/2007-IA II (I)	Entity name as per PAN	NA

Compliance Reporting Details

Reporting Year	2024
Remarks (if any)	Existing Project. Status: Operational.
Reporting Period	01 Jun(01 Oct - 31 Mar)

Details of Production and Project Area

Name of Entity / Corporate Office Orient Cement Limited

	Project Area as per EC Granted	Annual Project Area in Possession
Private	425.89	425.89
Revenue Land	0	0
Forest	0	0
Others	0	0
Total	425.89	425.89

Production Capacity

Sr. no	Product Name	units	Valid Upto	Capacity	Production last year	Capacity as per CTO
1	Clinker	Million Tons per Annum (MTPA)	30/06/2027	3.5	2.58754	3.5
2	Cement	Million Tons per Annum (MTPA)	30/06/2027	3.07	2.07847	3.07
3	Electricity	MW	30/06/2027	50	214039	50

Conditions

Specific Conditions

Sr.No.	Condition Type	Condition Details
1	AIR QUALITY MONITORING AND PRESERVATION	On-line continuous stack monitoring facilities for all the stacks and adequate air pollution control systems shall be provided to keep emission levels below 50 mg/Nm ³ and data submitted to the APPCB and CPCB regularly. ESP to kiln / raw mill, clinker and CPP shall be provided to control air emissions.
<p>PPs Submission: Complied</p> <p>On-line Continuous Stack Monitoring facilities (CEMS) were provided for all stacks attached to Raw Mills & Kilns, Coolers, Coal Mills, Cement Mills and Captive Power Plant. All the CEMS parameters are connected to TSPCB and CPCB servers. Particulate Matter emissions from all the stacks of Cement Plant & CPP are well within the prescribed standards of 30 & 50 mg/Nm³ respectively. Air Pollution Control Devices were provided to all the process stacks to control PM emissions well below the standards.</p>		Date: 17/05/2024
2	WATER QUALITY MONITORING AND PRESERVATION	Total Water requirement from the reservoir of abandoned mine pit shall not exceed 1,895 m ³ /day. No water from other surface or ground water sources shall be used. All the treated wastewater shall be recycled and reused in the process and/or for ash quenching, dust suppression, green belt development and other plant related activities etc. No process wastewater shall be discharged outside the factory premises and 'zero' discharge shall be adopted. Treated domestic effluent shall be used for green belt development within the plant premises.
<p>PPs Submission: Complied</p> <p>This EC is for capacity expansion of Clinker from 5500 TPD to 10600 TPD and Cement from 3600 TPD to 8900 TPD. Thus, the water requirement indicated in the condition is for the expansion part of the project. The same was explicitly mentioned in the EIA report. As advised in the condition, we are meeting this additional water requirement through the mine pit only. Water consumed from Mines pit for the CPP & Plant operations is between 1600-1800 m³/day. The plant is a modern dry process unit and CPP with air cooled condensers (ACC). Zero liquid discharge is adopted. Domestic wastewater from colony is being treated in STP and utilized completely for greenbelt development. Effluent generated from captive power plant is treated and used for dust suppression within the premises.</p>		Date: 17/05/2024
3	WASTE MANAGEMENT	The fly ash from the power plant shall be stored in silos and pneumatically transferred to the cement plant and used in the process itself for manufacturing Pozollona Portland Cement (PPC). Bottom ash shall be disposed off in abandoned mines or utilized in road making or given to brick kiln manufacturers. All the cement dust collected from pollution control devices shall be recycled and reused

		in the process and used for cement manufacturing. Sludge from domestic sources shall be used as manure for green belt development. Waste oil shall be sold to authorized recyclers/re-processors only.	
		<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> • Fly ash from the Power Plant is being conveyed pneumatically to cement plant and utilized for manufacturing of PPC grade cement. • Bottom ash is being utilized in filling of low laying areas and internal road making. • Dust collected from Air Pollution Control Equipment's viz. RABH, Bag House, ESP's, Bag Filter etc., are being recycled back into the process. • Sludge from STP is used as manure for plantation in colony. • Used oil is being disposed to authorized recyclers/re-processors only. 	Date: 17/05/2024
4	WASTE MANAGEMENT	High calorific value hazardous waste shall be utilized in the cement kiln from Ranga Reddy, Medak and Patancheru Districts.	
		<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> • High calorific value hazardous waste and non-hazardous wastes (Rice husk, Cotton stalk, Black carbon, etc.) sourced from Telangana and other states are being co-processed in our cement kilns. • Hazardous waste about 3005.7 MT was co-processed for the period April 2023 to March 2024. 	Date: 17/05/2024
5	GREENBELT	Out of total 425.89 acre, green belt shall be developed in 216.09 acres (51%) as per the CPCB guidelines to mitigate the effects of air emissions in consultation with local DFO.	
		<p>PPs Submission: Complied</p> <p>Greenbelt developed about 57.7% of the total area. Local and native species are being planted for better growth. The Local Plant Species are: • Kanuga (Pongamia pinnata), • Nidra Ganneru, Dirisena (Samanea saman), • Neem, Vepa (Azadirachta indica), • Gulmohar (Delonix regia), • Subabul (Leucaena leucocephala), • Mango (Mangifera indica), • Burugu (Bombax ceiba), • Chinduga (Albizia chinensis), • Neeruddi (Dolichandrone atrovirens), • Devakanchanam (Bauhinia variegata).</p>	Date: 17/05/2024
6	Human Health Environment	Regular annual medical examination of all the employees shall be carried out from the occupational health point of view and records should be maintained.	
		<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> • Periodical Medical Examination is being carried out for all the employees as well as contract workmen at our Occupational Health Centre (OHC). Medical examinations were conducted from 04/03/2024 to 16/03/2024. • Records of the medical examinations are being maintained at our OHC. 	Date: 17/05/2024
General Conditions			
Sr.No.	Condition Type	Condition Details	
1	Statutory compliance	The project authority shall adhere to the stipulations made by A.P. Pollution Control Board (APPCB) and State Government.	
		<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> • Obtained Consent for Establishment (CFE) in 2007 from Telangana State Pollution Control Board (SPCB). • Obtained Consent for Operation and Hazardous Waste Authorization (CFO&HWA) from TSPCB in 2022 from TSPCB. • Conditions stipulated in the above orders are being complied with and followed. 	Date: 17/05/2024
2	Statutory compliance	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.	

<p>PPs Submission: Complied Six monthly compliance reports and the monitored data are being uploaded to PARIVESH portal and are being submitted to MOEFCC IRO at Hyderabad, CPCB RD at Bangalore & TSPCB RO at Nizamabad. Latest half yearly compliance report for the period April 2023 to September 2023 was submitted/uploaded in the month of November 2023. Director from IRO Hyderabad (SRO) was monitored the compliance status of the conditions on 27th and 28th of March 2024. Full cooperation was extended to the inspection officers.</p>		Date: 17/05/2024
3	Statutory compliance	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.
<p>PPs Submission: Complied The project work was completed in the month of August 2010 and the plant has been under operation since 2010. Details of the same are being submitted in EC compliance report.</p>		Date: 17/05/2024
4	Statutory compliance	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 A.P. Pollution Control Board / Committee and may also be seen at Website of the Ministry of Environment and Forests at http://envfor.nic.in . This should 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.
<p>PPs Submission: Complied An advertisement has been published in the following two local newspapers on 11.09.2007. 1. Deccan Chronical - English 2. Eenadu - Telugu</p>		Date: 17/05/2024
5	Statutory compliance	No further expansion or modification of the plant shall be carried out without prior approval of this Ministry.
<p>PPs Submission: Agreed to Comply Agreed to Comply. No further expansion or modification of the plant will be carried out without prior approval of this Ministry.</p>		Date: 17/05/2024
6	AIR QUALITY MONITORING AND PRESERVATION	The gaseous and particulate matter emissions from various units shall conform to the standards prescribed by the A.P. 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 shut down automatically.
<p>PPs Submission: Complied • Installed adequate Air Pollution Control equipment like RABH, High Efficiency Bag filters and ESP to control and achieve the particulate matter emission standards prescribed by TSPCB. • Gaseous emissions (SO₂ & NO_x) are well below the prescribed standards by TSPCB. • Interlocking facility was provided to Pollution Control Equipment so that in the event of failure of Pollution Control Equipment, the respective equipment (s) will be shutdown/feed cut automatically.</p>		Date: 17/05/2024
7	AIR QUALITY MONITORING AND PRESERVATION	One Ambient Air Quality Monitoring Station shall be installed in downwind direction. 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 TSPCB quarterly and to the Ministry's

		Regional Office at Bangalore half-yearly.
	<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> Manual or fixed ambient air quality monitoring is being carried out at 4 no's of locations on a monthly basis through third party M/s Lawn Enviro Associates, Hyderabad. Data of the same is being submitted to TSPCB on monthly basis and MOEFCC (PARIVESH uploading) on six monthly along with compliance report. Continuous ambient air quality monitoring stations (CAAQMS) installed and connected to TSPCB server. 	Date: 17/05/2024
8	AIR QUALITY MONITORING AND PRESERVATION	<p>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. Asphalted/concreting of road and water spray all around the stockyard and loading / unloading areas shall be carried out to control fugitive emissions. Covered sheds for storage of raw materials and pneumatic conveying system for fly ash and bed ash for conveying ash from boiler shall be provided. Coal, cement, fly ash and clinker shall be stored in silos.</p>
	<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> Installed adequate dust collection and extraction systems to control fugitive emissions. About 115 plus no's of bag filters (De-Dusting System) were installed at various material transfer points, silo tops, raw material un loading area and packing plant area. Cement Concrete roads are laid and regular water sprinkling and Road sweeping machine with in-built vacuum cleaner is being engaged to control fugitive emissions. All the raw materials are being stored and handled under covered sheds. Fly ash handling through pneumatic system. All material transfer conveyors are covered with GI sheets. Cement & fly ash is being stored in Silo's and Clinker is stored in CSP and Silos to avoid the fugitive dust generation. A dedicated water tanker has been deployed for spraying water on roads to control fugitive dust. Fugitive emission monitoring data is being submitted to MOEFCC IRO at Hyderabad on a half yearly basis along with compliance report. 	Date: 17/05/2024
9	AIR QUALITY MONITORING AND PRESERVATION	Secondary fugitive emissions shall be controlled and regularly monitored as per guidelines issued by the CPCB.
	<p>PPs Submission: Complied</p> <p>Secondary fugitive emissions are being controlled and monitored as per the CPCB guidelines. The following are fugitive control measures adopted.</p> <ul style="list-style-type: none"> All transfer points and storage silos are provided with dust collection and extraction systems for effective control of fugitive emissions. Closed Sheds are constructed for all the raw materials storage and handling. Fly ash is being handled through a pneumatic system. Road sweeping machines are deployed and ensure good housekeeping for controlling secondary fugitive dust emissions. Regular water spray is being carried out. Fugitive emission monitoring data is being submitted to MOEFCC IRO at Hyderabad on a half yearly basis along with compliance report. 	Date: 17/05/2024
10	WATER QUALITY MONITORING AND PRESERVATION	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.
	<p>PPs Submission: Complied</p> <ul style="list-style-type: none"> Rainwater is stored in mines abandoned reservoir, and it is utilized for various activities in the plant thus reducing the consumption of fresh water. The rooftop rainwater harvesting system developed in the colony, small bunds and check dam have been constructed to harvest the rainwater to improve the ground water levels. 	Date: 17/05/2024
11	Corporate Environmental Responsibility	The company shall undertake eco-development measures including community welfare measures in the project area.
	<p>PPs Submission: Complied</p>	Date:

Various eco development and community welfare schemes are being adopted for the development of the surrounding village people & area under CSR. Education: Running DAV school and providing quality education to local people. Health: Providing free healthcare facilities to the surrounding people at our OHC with qualified doctors. Ambulance and medicine facilities are also provided. Infrastructure Development – Roads, bus shelters and drinking water supply.		17/05/2024
12	Noise Monitoring & Prevention	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) 70 dBA (night time).
PPs Submission: Complied • Overall noise levels in and around the plant area are maintained well below the prescribed standards by providing acoustic enclosures and hoods to various noise generating areas such as compressors, mills, and fans. • Ambient noise levels are being monitored and the noise levels are below 75 dB (A) daytime and 70 dB(A) nighttime. • Work zone and ambient noise levels are being monitored through third party on monthly basis.		Date: 17/05/2024
13	Corporate Environmental Responsibility	All recommendations made in the ‘Corporate Responsibility for Environment Protection (CREP) for cement plants shall be implemented.
PPs Submission: Complied Recommendations made in the Corporate Responsibility for Environment Protection (CREP) for cement plant are being implemented.		Date: 17/05/2024
14	Human Health Environment	Proper housekeeping and adequate occupational health programmes shall be taken up.
PPs Submission: Complied • Good Housekeeping is being maintained at all areas of the plant. Dust bins provided at all the areas for source segregation of waste. Adequate road sweeping machines are being used for cleaning roads. Dedicated water tankers have been deployed for water sprinkling on the road to control fugitive dust. • The Occupational Health Surveillance Programme is conducted on a regular basis & records maintained. The Programme includes a lung function & sputum analysis test once a year.		Date: 17/05/2024
15	Human Health Environment	A separate environmental management cell to carry out various management and monitoring functions shall be set up under the control of Senior Executive.
PPs Submission: Complied Environmental management cell is in place with qualified personnel to carry out various environmental management and monitoring activities under the control of senior executive. 1. Mr. Satyabrata Sharma, (President Manufacturing) – Head Office 2. Mr. MP Joshi, (Sr. VP & Unit Head) 3. Mr. Srinivasa Raju, (VP Sustainability & EHS) – Head Office 4. Mr. T Shekar Reddy, (Dy. Manager, Environment) 5. Mr. MVN Chary, (Officer, Environment).		Date: 17/05/2024
16	MISCELLANEOUS	As proposed in EIA/EMP, Rs.24.50 Crores and Rs.1.86 Crores earmarked towards the capital cost and recurring cost/annum for environmental pollution control measures shall be suitably used to implement the conditions stipulated by the Ministry of Environment and Forests as well as the State Government. The funds so provided shall not be diverted for any other purpose.
PPs Submission: Complied Funds earmarked towards environmental pollution control measures and to implementation of the conditions stipulated by the MOEFCC are incurred without diverting to any other purposes.		Date: 17/05/2024

Visit Remarks

Last Site Visit Report Date:

27/03/2024

Additional Remarks:

It is an existing project. All the conditions are being complied & fulfilled. EC was monitored by Director, MOEFCC IRO Hyderabad on 27th and 28th March 2024.

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherla District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024

Details of Installed Air Pollution Control Devices with stacks and CEMS

Sl. No.	Process Equipment	APCD
1	Kiln & Raw Mill - I	ESP
2	Clinker Cooler - I	ESP
3	Coal Mill (Ball Mill) - I	Bag House
4	Coal Mill (VRM) - I	Bag House
5	Kiln & Raw Mill - II	ESP
6	Clinker Cooler - II	ESP
7	Coal Mill (Ball Mill) - II	Bag House
8	Kiln & Raw Mill - III	RABH
9	Clinker Cooler - III	ESP
10	Coal Mill (Ball Mill) - III	Bag House
11	Cement Mill - 1	Bag House
12	Cement Mill – 2	Bag House
13	CPP Boilers	ESP



ESPs for Kiln, Raw Mill-1



Bag House for Coal Mill VRM – Line1



RABH for Kiln & Raw Mill -3



ESP for Clinker Cooler-3

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherla District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024



Kiln-3 RABH & Cooler-1 ESP stack



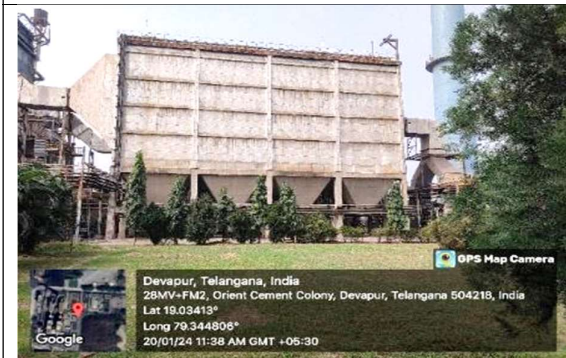
Stack of 2X25 MW CPP



Coal Mill -1 VRM Baghouse



ESP for with stack Clinker Cooler – Line2



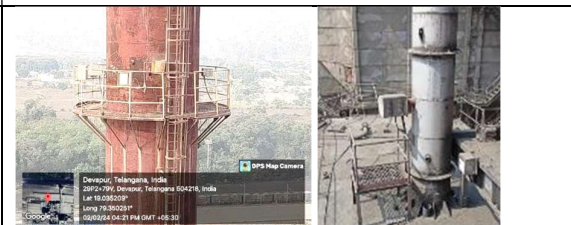
ESP for 2X25 MW CPP



CEMS at Kiln-1



CEMS at Kiln-3 Stack & CEMS at Coal Mill-1 Stack



CEMS at Cooler-3 & Coal Mill Stack

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherla District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024

Stack Emission Monitoring Data

October 2023 to March 2024

Month	KILN-1			KILN-2			KILN-3			CPP		
	PM	SO ₂	NO _x	PM	SO ₂	NO _x	PM	SO ₂	NO _x	PM	SO ₂	NO _x
Oct-23	19.5	0	310.7	Not in Operation			16.9	0.0	295.1	34.1	280.9	80.5
Nov-23	21.7	6.8	287.4				15.9	0	270.8	30.9	255.1	108.5
Dec-23	23.2	0	304				16.6	5.8	250.8	32.4	279.5	70.1
Jan-24	22.2	0	320.8				15.5	0	286.7	30.1	242.6	85.8
Feb-24	20.5	0	290.5				18.2	0	260.6	33.5	220.4	75.1
Mar-24	18.3	7	310.5				14.2	8.5	328	33.0	232.5	90.3
Limits	30	100	1000				30	100	800	50	600	450

Month	Cooler-Line-1	Cooler-Line-2	Cooler-Line-3	Coal Mill-1	Coal Mill-2	Coal Mill-3	Coal Mill-1 VRM	Cement Mill-1	Cement Mill-2	Limestone Crusher		
	PM	PM	PM	PM	PM	PM	PM	PM	PM	PM		
Oct-23	16.4	Not in Operation		17.5	14.6	Not in Operation		15.8	15.1	18.9	16.7	20.0
Nov-23	18.3			16.3	16.4			17.5	17.2	19.3	20.2	18.5
Dec-23	15.7			15.9	15.0			13.5	16.3	15.4	17.1	21.1
Jan-24	19.2			18	12.5			15.1	14.3	16.4	18.6	19.5
Feb-24	18.4			17.5	15.8			14.3	17.2	18.7	16.8	20.1
Mar-24	17.7			17.1	13.0			12.6	14.9	15.3	16.1	22.6
Limits	30			30	30			30	30	30	30	30

Month	Packer-1	Packer-2	Packer-3	Packer-4	Packer-5	Packer-6
	PM	PM	PM	PM	PM	PM
Oct-23	22.1	20.4	19.1	20.9	23.8	17.5
Nov-23	19.9	18.7	18.4	22.1	19.3	18.6
Dec-23	17.7	15.8	22.4	17.3	18.5	15.9
Jan-24	19.4	17.7	17.4	20.0	16.9	18.3
Feb-24	20.2	16.5	19.5	18.4	17.6	16.7
Mar-24	18.4	20.2	18.7	19.8	18.0	17.1
Limits	30	30	30	30	30	30

Note: All the value are expressed in mg/Nm³

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherial District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024

Emission Monitoring During Co-Processing of Hazardous Waste

Vimta Labs Limited
 Registered Office
 142, IDA Phase II, Cherlapally
 Hyderabad-500 051, Telangana, India
 T : +91 40 2726 4141
 F : +91 40 2726 3657



ISSUED TO:
 M/s. ORIENT CEMENT LIMITED,
 DEVAPUR CEMENT WORKS,
 DEVAPUR VILLAGE, KASIPET MANDAL,
 MANCHERIAL DISTRICT-504218,
 TELANGANA, INDIA.

Report Number : VLL/VLS/24/00593/003
 Issued Date : 2024.04.18
 P.O. Number : 8040029035
 P.O. Date : 20.03.2023

Page 1 of 2

Sample particulars : Stack Connected to Raw Mill KILN-III During Co Processing of Hazardous waste.

Sample Registration Date : 2024.03.29 Sample Collection Date : 2024.03.26
 Analysis Starting Date : 2024.03.30 Analysis Completion Date : 2024.04.18
 Test Required : PM, SO₂, NO_x, HCl, HF, CO, CO₂, O₂ and TOC.
 Sample collected by Vimta Labs Ltd.

TEST REPORT

Sr. No.	Parameters	UoM	Method of Testing	Results	Limits as per Notification GSR 497(E)
1	Diameter of stack	m	-	3.5	--
2	Flue gas temperature	°C	-	185	--
3	Oxygen as O ₂	%	Flue Gas Analyzer	10.9	--
4	Velocity	m/sec	USEPA method-2	12.32	--
5	Volumetric flow rate	Nm ³ /Sec	USEPA method-2	76.7	--
6	Particulate Matter	mg/Nm ³	USEPA method-5	19.9	<30.0
7	Sulphur Dioxide as SO ₂	mg/Nm ³	USEPA method -06	20.0	<100.0
8	Oxides of Nitrogen, NO _x as NO ₂	mg/Nm ³	USEPA method -07	453.04	<1000.0
9	Hydrogen Chloride as HCl	mg/Nm ³	USEPA method -26	4.7	<10.0
10	Hydrogen Fluoride as HF	mg/Nm ³	USEPA method -13	<0.1	<1.0
11	Carbon Monoxide as CO	mg/Nm ³	Flue Gas Analyzer	55.3	--
12	Total Organic Compounds as TOC	mg/nm ³	USEPA method -40 & MM5(10)	2.4	<10.0

All the Values are represented at 10% O₂

Dr. Subba Reddy Mallampati
 Manager-Environment

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 T : +91 40 6740 4040 E : mdoffice@vimta.com URL : www.vimta.com

CIN : L24110TG1990PLC011977

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherial District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024

Vimta Labs Limited

Registered Office
142, IDA Phase II, Cherlapally
Hyderabad-500 051, Telangana, India
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ISSUED TO:

M/s. ORIENT CEMENT LIMITED,
DEVAPUR CEMENT WORKS,
DEVAPUR VILLAGE, KASIPET MANDAL,
MANCHERIAL DISTRICT-504218,
TELANGANA, INDIA.

Report Number : VLL/VLS/24/00593/003
Issued Date : 2024.04.18
P.O. Number : 8040029035
P.O. Date : 20.03.2023

Page 2 of 2

Sample particulars : Stack Connected to Raw Mill KILN-III During Co Processing of Hazardous waste.

Sample Registration Date	: 2024.03.29	Sample Collection Date	: 2024.03.26
Analysis Starting Date	: 2024.03.30	Analysis Completion Date	: 2024.04.18
Test Required	: Hg & its compounds, Cd + Tl its compounds, Sb+ As+ Pb+ Co+ Cr+ Cu+ Mn+ Ni+ V+ Their compounds		
Sample collected by Vimta Labs Ltd.			

TEST REPORT

Sr. No.	Parameters	UoM	Method of Testing	Results	Limits as per Notification GSR 497(E)
1	Mercury as Hg + their Compound	mg/Nm ³	USEPA method -29	<0.001	<0.05
2	Cadmium + Thallium (Cd + Tl) + their Compounds			<0.001	<0.05
3	Chromium as Cr + their Compounds			0.008	--
	Manganese as Mn + their Compounds			0.026	
	Arsenic as As + their Compounds			0.014	
	Antimony as Sb + their Compounds			0.008	
	Lead as Pb + their Compounds			0.007	
	Cobalt as Co + their Compounds			0.015	
	Copper as Cu + their Compounds			0.012	
	Nickel as Ni + their Compound			0.007	
	Vanadium as V + their Compound			0.005	
	Sb+ As+ Pb+ Co+ Cr+ Cu+ Mn+ Ni+ V+ Their compounds			0.101	

All the values are represented at 10% O₂

Dr. Subba Reddy Mallampati
Manager-Environment

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Sample Registration Date : 2024.03.29 Sample Collection Date : 2024.03.26
Analysis Starting Date : 2024.03.30 Analysis Completion Date : 2024.04.18
Test Required : PCDD & PCDFs as per USEPA 23 A & 8290
Sample collected by Vimta Labs Ltd.

TEST REPORT

Sr.No.	Parameters	UoM	Results
Physical Parameters			
1	Diameter of the Stack	m	3.5
2	Temperature	°C	185
3	Velocity	m/sec	12.32
4	Volumetric flow rate	Nm ³ /Sec	76.7
Congeners of Dioxin & Furans			
1	2,3,7,8-TCDF	ng/Nm ³ , TEQ	0.0005
2	1,2,3,7,8-PeCDF		0.0008
3	2,3,4,7,8-PeCDF		0.0002
4	1,2,3,4,7,8-HxCDF		0.0000
5	1,2,3,6,7,8-HxCDF		0.0000
6	2,3,4,6,7,8-HxCDF		0.0002
7	1,2,3,7,8,9-HxCDF		0.0000
8	1,2,3,4,6,7,8-HpCDF		0.0000
9	1,2,3,4,7,8,9-HpCDF		0.0000
10	OCDF		0.0001
11	2,3,7,8-TCDD		0.0000
12	1,2,3,7,8-PeCDD		0.0001
13	1,2,3,4,7,8-HxCDD		0.0001
14	1,2,3,6,7,8-HxCDD		0.0001
15	1,2,3,7,8,9-HxCDD		0.0001
16	1,2,3,4,6,7,8-HpCDD		0.0001
17	OCDD		0.0000
Total Furans & Dioxins		ng/Nm ³ , TEQ Corrected to 10% O ₂ Concentration	0.0024
Limits as per MoE, F&CC Notification GSR 497(E)			<0.1

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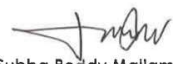
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Analysis Starting Date	: 2024.03.30	Analysis Completion Date	: 2024.04.18
Test Required	: PM, SO ₂ , NO _x , HCl, HF, CO, CO ₂ , O ₂ and TOC.		
Sample collected by Vimta Labs Ltd.			

TEST REPORT

Sr. No.	Parameters	UoM	Method of Testing	Results	Limits as per Notification GSR 497(E)
1	Diameter of stack	m	-	3.5	--
2	Flue gas temperature	°C	-	185	--
3	Oxygen as O ₂	%	Flue Gas Analyzer	10.9	--
4	Velocity	m/sec	USEPA method-2	12.32	--
5	Volumetric flow rate	Nm ³ /Sec	USEPA method-2	76.7	--
6	Particulate Matter	mg/Nm ³	USEPA method-5	19.9	<30.0
7	Sulphur Dioxide as SO ₂	mg/Nm ³	USEPA method -06	20.0	<100.0
8	Oxides of Nitrogen, NO _x as NO ₂	mg/Nm ³	USEPA method -07	453.04	<1000.0
9	Hydrogen Chloride as HCl	mg/Nm ³	USEPA method -26	4.7	<10.0
10	Hydrogen Fluoride as HF	mg/Nm ³	USEPA method -13	<0.1	<1.0
11	Carbon Monoxide as CO	mg/Nm ³	Flue Gas Analyzer	55.3	--
12	Total Organic Compounds as TOC	mg/nm ³	USEPA method -40 & MM5(10)	2.4	<10.0

All the Values are represented at 10% O₂


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Sample collected by Vimta Labs Ltd.			

TEST REPORT

Sr. No.	Parameters	UoM	Method of Testing	Results	Limits as per Notification GSR 497(E)
1	Mercury as Hg + their Compound	mg/Nm ³	USEPA method -29	<0.001	<0.05
2	Cadmium + Thallium (Cd + Tl) + their Compounds			<0.001	<0.05
3	Chromium as Cr + their Compounds			0.008	--
	Manganese as Mn + their Compounds			0.026	
	Arsenic as As + their Compounds			0.014	
	Antimony as Sb + their Compounds			0.008	
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	Cobalt as Co + their Compounds			0.015	
	Copper as Cu + their Compounds			0.012	
	Nickel as Ni + their Compound			0.007	
	Vanadium as V + their Compound			0.005	
	Sb+ As+ Pb+ Co+ Cr+ Cu+ Mn+ Ni+ V+ Their compounds	0.101	< 0.5		

All the values are represented at 10% O₂

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2	1,2,3,7,8-PeCDF		0.0008
3	2,3,4,7,8-PeCDF		0.0002
4	1,2,3,4,7,8-HxCDF		0.0000
5	1,2,3,6,7,8-HxCDF		0.0000
6	2,3,4,6,7,8-HxCDF		0.0002
7	1,2,3,7,8,9-HxCDF		0.0000
8	1,2,3,4,6,7,8-HpCDF		0.0000
9	1,2,3,4,7,8,9-HpCDF		0.0000
10	OCDF		0.0001
11	2,3,7,8-TCDD		0.0000
12	1,2,3,7,8-PeCDD		0.0001
13	1,2,3,4,7,8-HxCDD		0.0001
14	1,2,3,6,7,8-HxCDD		0.0001
15	1,2,3,7,8,9-HxCDD		0.0001
16	1,2,3,4,6,7,8-HpCDD		0.0001
17	OCDD		0.0000
Total Furans & Dioxins		ng/Nm ³ , TEQ Corrected to 10% O ₂ Concentration	0.0024
Limits as per MoE,F&CC Notification GSR 497(E)			<0.1

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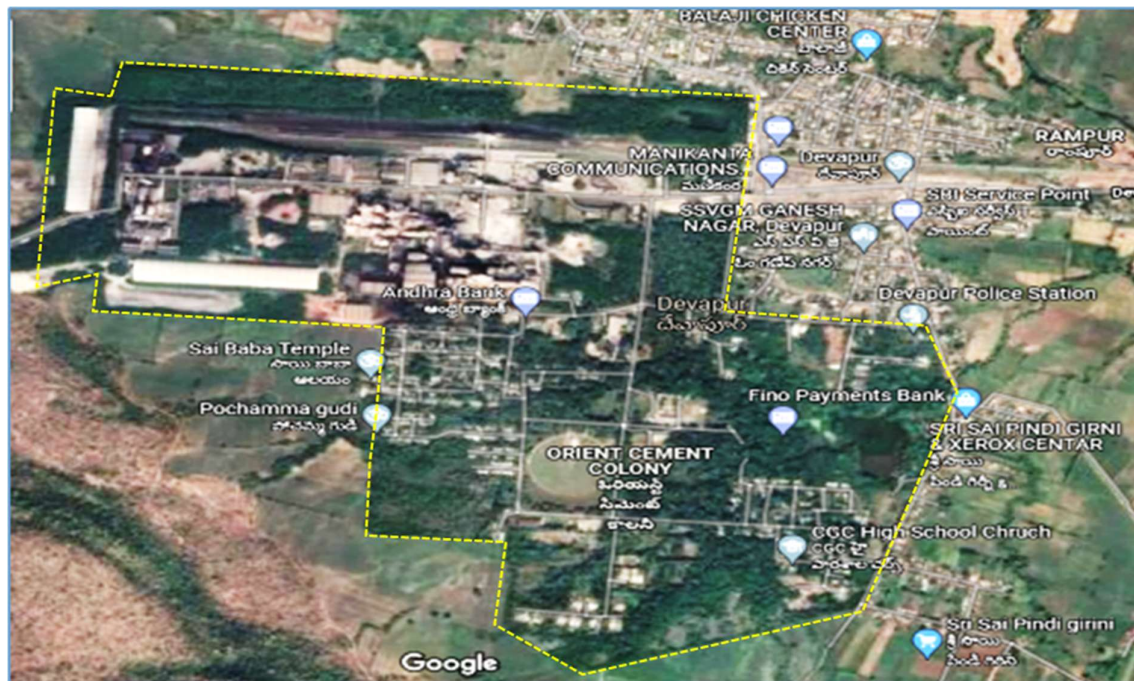
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Greenbelt Development Details

	Area, Ac	Saplings Planted (Plant & Colony)	Survival Rate%
Plant & Colony Area, Ac		425.91	
Built-Up Area, Ac		85.72	
Greenbelt Up to 2016-17	244.3	158795	80
2017-18	0.370	126	85
2018-19	0.000	0	85
2019-20	0.000	0	85
2020-21	0.660	1000	90
2021-22	0.463	300	95
2022-23	0.390	250	95
2023-24	0.080	50	100
Total	246.26	160521	89
Green Cover (%)	57.82		



Plant Layout & Arial view showing greenery in the plant & colony.

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Photographs showing plantation in the plant and colony.

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Photographs of Annual Medical Checkup



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Ambient Air Quality Monitoring

- Manual/fixed ambient air quality monitoring is being carried out at 4 no's of locations on monthly basis through third party M/s Lawn Enviro Associates, Hyderabad.
- Continuous ambient air quality monitoring stations (CAAQMS) installed and connected to TSPCB server. Data of AAQ, ambient noise and stack emissions are being submitted to the MOEFCC IRO at Hyderabad on half yearly & TSPCB on monthly basis.

AAQ Monitoring Data

October 2023 to March 2024

Parameters	NAAQM Standards	Near Time office			Near Mines office		
		Min	Max	Avg	Min	Max	Avg
PM10 (µg/m ³)	100	56	62	58.8	57	67	62.3
PM2.5 (µg/m ³)	60	19	24	21.3	20	25	23.2
SO ₂ (µg/m ³)	80	7	12	9.7	6	11	8.5
NO ₂ (µg/m ³)	80	16	24	20.0	16	23	19.7
Lead (Pb) (µg/m ³)	1.0	0.08			0.04		
Carbon Monoxide (mg/m ³)	2.0	BDL			BDL		
Ammonia (NH ₃) (µg/m ³)	400	BDL			BDL		
Ozone (O ₃) (µg/m ³)	100	6			9		
Benzene (C ₆ H ₆) (µg/m ³)	5.0	<0.02			<0.02		
Arsenic (As) (ng/m ³)	6.0	ND			ND		
Nickle (Ni) (ng/m ³)	20	ND			ND		
Benzo Pyrene (Bap) (ng/m ³)	1.0	ND			ND		

Parameters	NAAQM Standards	NORTH, Stores			SOUTH, Guest House		
		Min	Max	Avg.	Max	Min	Avg.
PM10 (µg/m ³)	100	60	72	65.8	50	59	53.0
PM2.5 (µg/m ³)	60	23	29	25.8	16	21	18.5
SO ₂ (µg/m ³)	80	10	13	11.5	5	9	6.8
NO ₂ (µg/m ³)	80	21	25	23.3	15	20	17.0
Lead (Pb) (µg/m ³)	1.0	0.09			0.02		
Carbon Monoxide (mg/m ³)	2.0	BDL			BDL		
Ammonia (NH ₃) (µg/m ³)	400	BDL			BDL		
Ozone (O ₃) (µg/m ³)	100	11			4		
Benzene (C ₆ H ₆) (µg/m ³)	5.0	<0.02			<0.02		
Arsenic (As) (ng/m ³)	6.0	ND			ND		
Nickle (Ni) (ng/m ³)	20	ND			ND		
Benzo Pyrene (Bap) (ng/m ³)	1.0	ND			ND		

Note:

All the values are expressed in µg/m³ except mentioned.

BDL – Below Detectable Limits.

ND – non-detectable.

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Noise Levels Monitoring Data

Ambient Noise Levels October 2023 to March 2024

Location	Noise Levels in Leq dB(A)			
	Day Time		Nighttime	
	Monitored Value	Limits	Monitored Value	Limits
East Side Boundary	63.5	75	58.3	70
West Side Boundary	65.5		60.8	
North Side Boundary	62.0		56.8	
South Side Boundary	61.2		56.9	

Workplace Noise Levels October 2023 to March 2024

Location	Monitored Values Noise Levels dB(A)	Limits, dB(A)
Kiln- 1 & 2	78.4	85
Raw Mill-1 & 2	81.4	
Compressors	83.9	
Cement Mill-1 & 2	75.5	
Crusher	80.2	
Kiln-3	79.7	
CPP	79.1	
Raw Mill-3	78.3	
Packing Plant	74.9	

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Details of activities carried out and amount incurred under CSR

Sl. No.	Activity	2023-24 (Rs)	Focus Area
1	School Running Expenses at Devapur	1,54,96,237.9	Promoting Education
2	Medical Expenses at Dispensary	25,98,788.5	Promoting Preventive health care
3	Vanavasi Kalyani Parishad	1,44,000.0	Eradicating hunger, poverty, and malnutrition
4	AMMA ANADHAN SHARA BELLAM CSR	4,46,689.9	Eradicating hunger, poverty, and malnutrition
5	RED CROSS SOY OLD AGE	9,81,450.0	Eradicating hunger, poverty, and malnutrition
6	Maintenance charges of Sulabh Complex	2,58,000.0	Promoting Sanitation
7	Distribution Mass meals arranged for adivasi community	1,09,812.5	Eradicating hunger, poverty, and malnutrition
8	Repair & Painting work at Dhyankendra - Devapur	1,28,522.9	Promoting Rural development projects, etc
9	Hiring Charges of Ambulance for Villagers	10,02,517.8	Promoting Preventive health care
10	Medical Camp at Nearby Villages	51,365.5	Promoting Preventive health care
11	Maintenance Work Nearby Villages	1,13,97,501.6	Promoting Rural development projects, etc
	TOTAL	3,26,14,886.6	

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Compliance Status of CREP Recommendations

Sl. No	Condition	Compliance Status
1	Cement Plants, which are not complying with notified standards, shall do the following to meet the standards; Augmentation of existing Air Pollution Control Devices - by July 2003 Replacement of existing Air Pollution Control Devices - by July 2004	Complying with the new emission standards for PM, SO ₂ & NO _x notified by MOEF&CC as per G.S.R 612 (E) dated 25.08.2014 and amendment thereof.
2	Cement Plants located in critically polluted or urban areas (including 5 km distance outside urban boundary) will meet 100 mg/ Nm ³ limit or particulate matter by December 2004 and continue working to reduce the emission of particulate matter to 50 mg/Nm ³ .	Not applicable – Our cement plant is not located in critically polluted or urban areas.
3	The new cement kilns to be accorded NOC/Environmental Clearance w.e.f 01.04.2003 will meet the limit of 50 mg/Nm ³ for particulate matter emissions.	Kiln emissions are control through ESP's and high efficient RABH to meet the standard of PM < 30 mg/Nm ³ .
4	CPCB will evolve load based standards by December 2003.	--
5	CPCB and NCBM will evolve SO ₂ and NO _x emission standards by June 2004.	Complying with the new emission standards for SO ₂ & NO _x notified by MOEF&CC as per G.S.R 612 (E) dated 25.08.2014
6	The Cement industries will control fugitive emissions from all the raw material and products storage and transfer points by December 2003. However, the feasibility for the control of fugitive emissions from limestone and coal storage areas will be decided by the National Task Force (NTF). The NTF shall submit its recommendations within three months.	CPCB Environmental Guidelines for Prevention and Control of Fugitive Emissions from Cement Plants are being followed. <ul style="list-style-type: none"> All transfer points and storage silos are provided with dust collection and extraction systems for effective control of fugitive emissions. The dust collected from the pollution control equipment is being recycled back into the process. Sheds constructed for all raw materials. All raw material transfer conveyors are covered with GI sheet. Truck mounted Vacuum Cleaner and Road sweeping machines are being deployed and good housekeeping is being maintained for controlling secondary fugitive dust emissions.
7	CPCB, NCBM, BIS and Oil refineries will jointly prepare the policy on use of petroleum cokes as fuel in cement kiln by July 2003.	-----

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Sl. No	Condition	Compliance Status
8	After performance evaluation of various types of continuous monitoring equipment and feedback from the industries and equipment manufacturers, NTF will decide feasible unit operations/ sections for installation of continuous monitoring equipment. The industry will install the continuous monitoring systems (CMS) by December 2003	<p>Continuous online emission monitoring system (CEMS) is available for 13 major stacks. Online data is connected to CPCB as well as TSPCB servers.</p> <p>Line-1: Kiln & Raw Mill: ESP Line-2: Kiln & Raw Mill: ESP Line-3: Kiln & Raw Mill: RABH Clinker Coolers for all 3 lines: ESPs Coal Mills for all 3 lines: Bag Filters Cement Mills – 2 Nos: Bag Filters Captive Power Plant: ESP</p>
9	Tripping in kiln ESP to be minimized by July 2003 as per the recommendations of NTF.	Complied.
10	Industries will submit the target date to enhance the utilization of waste material by April, 2003.	Waste materials like Fly ash, Gypsum, lime sludge, slag are being utilized in the process of Cement manufacturing. Hazardous Waste Materials are being fired as Alternative fuels to conserve fossil fuels.
11	NCCBM will carry out a study on hazardous waste utilization in cement kiln by December 2003.	Studies were conducted by NCCBM for usage of Hazardous Wastes in various cement industries and the same is being followed.
12	Cement industries will carry out feasibility study and submit target dates to CPCB for co-generation of power by July 2003.	Obtained Consent for Establishment (CFE) from T.S. PCB for Waste Heat Recovery Boiler Power Plant (Co-Generation) from waste heat gases from Cement Plant. Project activities are yet to be commenced.

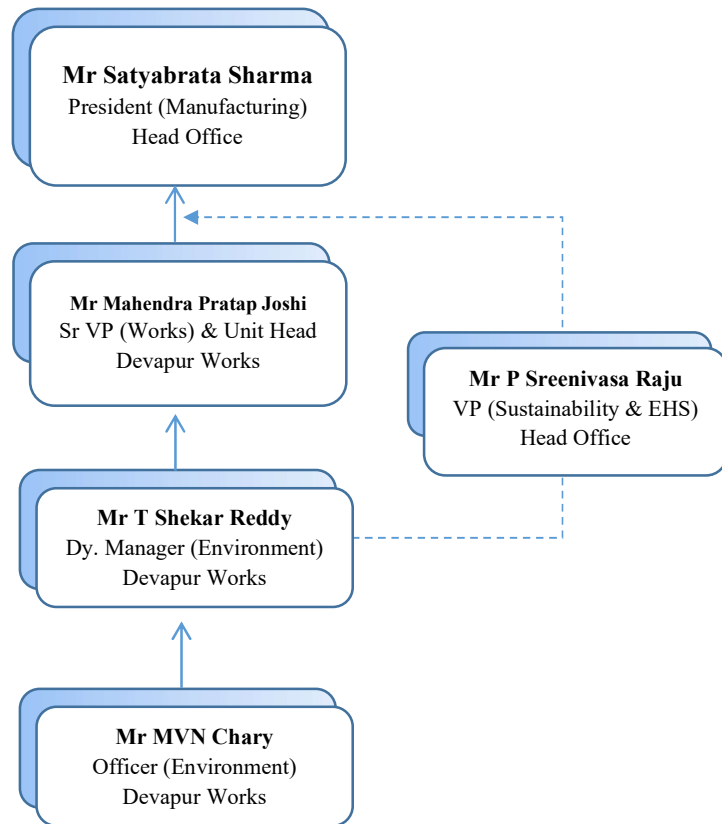
Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherial District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024

Organizational Structure for Environmental Management at Plant & Head office



Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherla District, Telangana – 504218

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Half Yearly Compliance Report for the period October 2023 to March 2024

Details of the expenditure (Revenue & Capital) for “Environmental Protection Measures” the period April 2023 to March 2024

Sl. No.	Nature of Capital Expenditure	Rs in Lakhs
1	Additional Bag filters at Cement Mill-1	6.57
2	Additional Bag filters at Kiln-1	7.89
3	Rehabilitation of CPP stack	223.94
	Total	238.40

Sl. No.	Nature of Recurring Expenditure	Rs in Lakhs
1	PCEs Operation & Maintenance	93.19
2	Environmental Monitoring	8.27
3	STP Operation & Maintenance	9.06
4	Bio Medical Waste Disposal	0.94
5	Ash Compliance Audit	0.50
6	Compliance of Plastic EPR Credits	3.31
7	Environmental Awareness & Training	0.46
8	O&M of CEMS, CAAQMS & CEQMS	20.56
9	Power Consumption cost for PCEs	1005.65
10	O&M Cost for road sweeping machines	31.04
	Total	1173.00

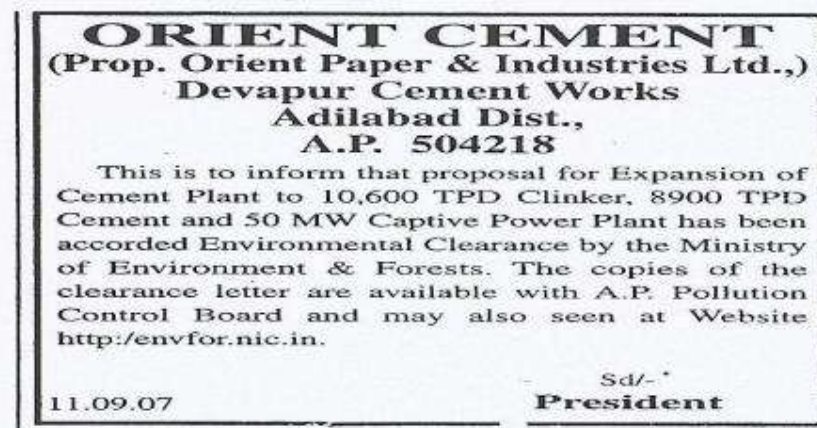
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Half Yearly Compliance Report for the period October 2023 to March 2024

News Paper Clippings of accord of Environmental Clearance



Deccan Chronical - English



Eenadu - Telugu

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherial District, Telangana – 504218

Environmental Clearance F. No. J -11011/266/2007-IA II (I) Dated: 06th September 2007

Half Yearly Compliance Report for the period October 2023 to March 2024

Fugitive Emission Control Measures

- We have installed adequate dust collection and extraction systems to control fugitive emissions. About 115 no's of bag filters were installed at various material transfer points, silo tops, raw material un loading area and packing plant area.
- Cement Concrete roads are laid and regular water sprinkling and Road sweeping machine with in-built vacuum cleaner is being engaged to control of fugitive emissions.
- All the raw materials are being stored and handled under covered sheds. Those details are as follows:

Material	Storage Capacity
Laterite	Total Sheds – 09 no' Each capacity is 4000 tons.
Gypsum	Total Sheds – 05 no's Each capacity is 4000 tons
Coal – Cement Plant	Total Sheds– 7 no's Each capacity is 5000 tons.
Limestone	Capacity 1,00,000 tons
Coal – CPP	Capacity 1,00,000 tons

- Fly ash handling through pneumatic system.
- All material transfer conveyors are covered with GI sheets.
- Cement & fly ash is being stored in Silo's and Clinker is stored in CSP and Silos to avoid the fugitive dust generation.
- A dedicated water tanker has been deployed for spraying water on roads to control fugitive dust.



Dedicated Water Spraying Tanker



Mechanical Water Sprinklers

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherla District, Telangana – 504218

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Half Yearly Compliance Report for the period October 2023 to March 2024



Internal CC Roads & Floorings



Water Spraying on internal roads



Road Sweeping Machine



Pneumatic handling of Flyash



Coal Storage Shed



Limestone Storage Shed

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Laterite Storage Shed



Gypsum Storage Shed



Clinker Silo



Flyash Silo



Closed Conveying System



Closed Conveying System

Orient Cement Limited

Devapur Village, Kasipet Mandal, Mancherial District, Telangana – 504218

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Half Yearly Compliance Report for the period October 2023 to March 2024



Bag filters at various material transfer points & silo top

Fugitive Emission Monitoring Data

October 2023 to March 2024

Sl. No.	Location	SPM µg/m ³
1	Bulk Loading Area	1512.6
2	Fly Ash Unloading Area	1585.0
3	Gypsum Yard	1372.7
4	Coal Yard-1 & 3	1704.8
5	Coal Yard-2	1819.4
6	Laterite-1 & 2	1502.1
7	Laterite-3	1555.4
8	Coal Yard- CPP	1829.8
9	Truck Loading Area	1640.9
10	Cement Mill 1 & 2 Area	1524.2

SPM Concentration Standard: 2000 µg/m³ for Coal Yard and 5000 µg/m³ Other than Coal Yard (ENVIRONMENTAL GUIDELINES FOR PREVENTION AND CONTROL OF FUGITIVE EMISSIONS FROM CEMENT PLANTS).