

F. No. J-11011/342/2011-IA-II (I)
Government of India
Ministry of Environment and Forests
(I.A. Division)

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Dated: 11th March, 2013

To,

M/s Orient Cement
(A unit of Orient Paper & Industries Limited)
7-1-33/3, First Floor, Leela Nagar, KK Zone,
Ameerpet, Hyderabad - 500 016,
Andhra Pradesh

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Sub: Proposed Cement Plant (Clinker- 2 MTPA; Cement 3.0 MTPA) and Captive Power Plant (50 MW) at Villages Itgi & Digaon in Taluk Chittapur, District Gulbarga in Karnataka by **M/s Orient Cement (A unit of Orient paper & Industries Limited) - regarding Environmental Clearance**

Sir,

This has reference to your letter no. ORCEM:PROJ:0268 dated 14.08.2012 along with copies of EIA/EMP report seeking environment clearance under the provisions of EIA Notification, 2006.

2. The Ministry of Environment and Forests has examined the application for the above project. It is noted that M/s Orient Cement have proposed for Cement Plant (Clinker-2 MTPA; Cement-3.0 MTPA) and CPP (50 MW) at Villages Itgi & Digaon. The limestone requirement will be met from the Captive Limestone Mines (602.054 Ha area) at Itgi & Mogla Villages, Taluk Chittapur, District Gulbarga in Karnataka. The project area is 266 ha and green belt will be developed in 85.28 ha. of area. There is no National Park/Wildlife Sanctuary/Biosphere Reserve within 10 km radius of the project site. River Kagna flows at a distance of 6.2 km in NW. The total project cost is Rs.1,500 Crores. The capital cost towards EMP will be about Rs 135 Crores and the recurring cost will be about Rs 8 crores annually.

3. Following are the details of proposed facilities and products:

Facility	Products & Quantities
Cement Plant	Clinker – 2.0 MTPA Cement – 3.0 MTPA
Captive Power Plant	Power : 50 MW

4. Limestone, Bauxite/laterite, Iron Ore, Gypsum, Coal and fly ash are the raw materials that will be used. Coal required for the cement plant and power plant is envisaged to be sourced from coal fields of Singareni Collieries Company Limited (SCCL) and through E-auction. Power will be met from the Captive Power Plant.

5. It is noted that the Bag house for raw mill/ Kiln, ESP for Cooler, Bag filter for Coal Mill and Cement Mill will be installed. The pollution control equipment will have efficiency of 99.9% and the outlet emission will be restricted to less than 50 mg/Nm³.

6. The total fresh water requirement of 3,500 m³/day will be sourced from Kagna River. The total wastewater generated will be about 1,058m³/day. Rain water harvesting is also proposed. The cooling tower blow down, boiler feed, filter backwash and service water will be diluted in common basin and used in cement plant, dust suppression and workshop. The DM plant water will also be used similarly after neutralization. The wastewater from workshop will be used for greenbelt development after the removal of oil and grease. Sewage will be treated in STP and used for greenbelt development.

7. The solid waste in the form of dust collected in the air pollution control equipment in the cement plant will be recycled back to the process. Refractory are one of the solid wastes generated from the kiln section and will be disposed to outside agencies due to high recycling value. Solid waste generated from colony and sewage treatment plant will be disposed after segregating the waste into bio-degradable and non-degradable. Bio degradable waste will be composted and non-degradable waste will be land filled at identified areas. Fly ash generated in the power plant will be consumed in the cement plant totally.

8. All the Cement Plants (≥ 1.0 MTPA) are listed at S.No. 3(b) under Category 'A' of the schedule of EIA Notification, 2006 and appraised by the Expert Appraisal Committee (Industry) of MoEF.

9. The proposal was considered by the Reconstituted Expert Appraisal Committee (Industry) in its 2nd meeting held during 29-31st October, 2012. The Committee recommended the proposal for environmental clearance subject to stipulation of specific conditions along with other environmental conditions. Public Hearing / Public Consultation meeting was conducted by the Karnataka State Pollution Control Board on 18th July, 2012.

10. Based on the information submitted by you, presentation made by you and consultant, M/s. B.S Envitech (P) Ltd., Hyderabad, the Ministry of Environment and Forests hereby accords environmental clearance to the above project under the provisions of EIA Notification dated 14th September 2006 subject to strict compliance of the following Specific and General conditions:

A. SPECIFIC CONDITIONS :

- i. Continuous stack monitoring facilities to monitor gaseous emissions from the process stacks shall be provided. After expansion, limit of PM shall be controlled within 50 mg/Nm³ by installing adequate air pollution control system. Electrostatic precipitators to clinker cooler, bag house to raw mill/kiln and bag filters to coal mill and cement mill. Low NO_x burners should be provided to control NO_x emissions.
- 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.

- iii. The National Ambient Air Quality Standards issued by the Ministry vide G.S.R. No. 826(E) dated 16th November, 2009 shall be followed.
- iv. 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 should be followed.
- v. As and Hg shall be monitored in emissions, ambient air and water.
- vi. The coal yard shall be lined and covered.
- vii. 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 should be transported in the closed containers only and shall not be overloaded. The company shall have separate truck parking area. Vehicular emissions should be regularly monitored.
- viii. Total fresh water requirement for cement and captive power plant shall not exceed 3,500 m³/day. Efforts shall be made to further reduce water consumption by using air cooled condensers. All the treated wastewater shall be recycled and reused in the process and/or for dust suppression and green belt development and other plant related activities etc. No process wastewater shall be discharged outside the factory premises and 'zero' discharge should be adopted.
- ix. Efforts shall be made to make use of rain water harvested. If needed, capacity of the reservoir should be enhanced to meet the maximum water requirement. Only balance water requirement shall be met from other sources.
- x. Regular monitoring of influent and effluent surface, sub-surface and ground water should be ensured and treated wastewater should meet the norms prescribed by the State Pollution Control Board or described under the Environment (Protection) Act, 1986 whichever are more stringent. Leachate study for the effluent generated and analysis should also be regularly carried out and report submitted to the Ministry's Regional Office at Bangalore, SPCB and CPCB.
- xi. All the bag filter dust, raw mill dust, coal dust, clinker dust and cement dust from pollution control devices should be recycled and reused in the process and used for cement manufacturing. Spent oil and batteries shall be sold to authorized recyclers / reprocessors only.
- xii. All the fly ash shall be utilized as per Fly ash Notification, 1999 subsequently amended in 2003 and 2009. Efforts should be made to use fly ash maximum in making Pozollona Portland Cement (PPC).
- xiii. Efforts shall be made to use low-grade lime, more fly ash and solid waste in the cement manufacturing.
- xiv. An effort shall be made to use of high calorific hazardous waste in the cement kiln and necessary provision should be made accordingly.
- xv. As proposed, green belt shall be developed in at least 33 % area in and around the cement plant as per the CPCB guidelines to mitigate the effects of air emissions in consultation with local DFO.

- xvi. All the recommendations made in the Charter on Corporate Responsibility for Environment Protection (CREP) for the Cement plants should be implemented.
- xvii. All the commitments made to the public during the Public Hearing / Public Consultation meeting held on 18th July, 2012 shall be satisfactorily implemented and a separate budget for implementing the same shall be allocated and information submitted to the Ministry's Regional Office at Bangalore.
- xviii. At least 5 % of the total cost of the project shall be earmarked towards the Enterprise Social Commitment based on Public Hearing Issues and item-wise details along with time bound action plan shall be prepared and submitted to the Ministry's Regional Office at Bangalore. Implementation of such program shall be ensured accordingly in a time bound manner.
- 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 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.

B. GENERAL CONDITIONS:

- i. The project authorities must strictly adhere to the stipulations made by the Karnataka State Pollution Control Board and the State Government.
- ii. No further expansion or modifications in the plant shall be carried out without prior approval of the Ministry of Environment and Forests.
- iii. At least four ambient air quality monitoring stations should be established in the downward direction as well as where maximum ground level concentration of PM₁₀, SO₂ and NO_x are anticipated in consultation with the SPCB. Data on ambient air quality and stack emission shall be regularly submitted to this Ministry including its Regional Office at Bangalore and the SPCB/CPCB once in six months.
- iv. Industrial wastewater shall be properly collected, treated so as to conform to the standards prescribed under GSR 422 (E) dated 19th May, 1993 and 31st December, 1993 or as amended from time to time. The treated wastewater shall be utilized for plantation purpose.
- v. 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 should conform to the standards prescribed under EPA Rules, 1989 viz. 75 dBA (daytime) and 70 dBA (nighttime).
- vi. Occupational health surveillance of the workers shall be done on a regular basis and records maintained as per the Factories Act.
- vii. The company shall develop rain water harvesting structures to harvest the rain water for utilization in the lean season besides recharging the ground water table.
- viii. The project proponent shall also comply with all the environmental protection measures and safeguards recommended in the EIA/EMP report. Further, the company must undertake socio-economic development activities in the

surrounding villages like community development programmes, educational programmes, drinking water supply and health care etc.

- ix. Requisite funds shall be earmarked towards capital cost and recurring cost/annum for environment pollution control measures to implement the conditions stipulated by the Ministry of Environment and Forests as well as the State Government. An implementation schedule for implementing all the conditions stipulated herein shall be submitted to the Regional Office of the Ministry at Bangalore. The funds so provided shall not be diverted for any other purpose.
 - x. A copy of clearance letter shall be sent by the proponent to concerned Panchayat, Zila Parishad/Municipal Corporation, Urban Local Body and the local NGO, if any, from whom suggestions/representations, if any, were received while processing the proposal. The clearance letter shall also be put on the web site of the company by the proponent.
 - xi. The project proponent shall upload the status of compliance of the stipulated environment clearance conditions, including results of monitored data on their website and shall update the same periodically. It shall simultaneously be sent to the Regional Office of the MOEF at Bangalore. The respective Zonal Office of CPCB and the SPCB. The criteria pollutant levels namely; PM₁₀, SO₂, NO_x (ambient levels as well as stack emissions) or critical sectoral parameters, indicated for the projects shall be monitored and displayed at a convenient location near the main gate of the company in the public domain.
 - xii. The project proponent shall also submit six monthly reports on the status of the compliance of the stipulated environmental conditions including results of monitored data (both in hard copies as well as by e-mail) to the Regional Office of MOEF, the respective Zonal Office of CPCB and the SPCB. The Regional Office of this Ministry at Bangalore / CPCB / SPCB shall monitor the stipulated conditions.
 - xiii. The environmental statement for each financial year ending 31st March in Form-V as is mandated to be submitted by the project proponent to the concerned State Pollution Control Board as prescribed under the Environment (Protection) Rules, 1986, as amended subsequently, shall also be put on the website of the company along with the status of compliance of environmental conditions and shall also be sent to the respective Regional Office of the MOEF at Bangalore by e-mail.
 - xiv. 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 SPCB 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 should be forwarded to the Regional office at Bangalore.
 - xv. 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.
11. The Ministry may revoke or suspend the clearance, if implementation of any of the above conditions is not satisfactory.

12. The Ministry reserves the right to stipulate additional conditions if found necessary. The Company in a time bound manner shall implement these conditions.

13. The above conditions shall be enforced, inter-alia under the provisions of the Water (Prevention & Control of Pollution) Act, 1974, the Air (Prevention & Control of Pollution) Act, 1981, the Environment (Protection) Act, 1986, Hazardous Wastes (Management, Handling and Transboundary Movement) Rules, 2008 and the Public (Insurance) Liability Act, 1991 along with their amendments and rules.

(Dr.V.P.Upadhyay)
Director(S)

Copy to:-

1. The Secretary, Department of Environment & Ecology, Govt. of Karnataka, Room No. 708, Gate 2, Multi Storied Building, Dr. Ambedkar Veedhi, Bangalore - 560 001
2. The Chief Conservator of Forests, Regional Office (Southern Zone, Bangalore) Kendriya Sadan, 4th Floor, E&FWing, II Block Koramangala, Bangalore-560034.
3. The Chairman, Central Pollution Control Board Parivesh Bhavan, CBD-cum-Office Complex, East Arjun Nagar, New Delhi - 110 032.
4. The Chairman, Karnataka State Pollution Control Board, #49, Parisara Bhavana, Church Street, Bangalore-01 (Karnataka).
5. Monitoring Cell, Ministry of Environment and Forests, Paryavaran Bhavan, CGO Complex, New Delhi.
6. Guard File/Monitoring File/Record File.

(Dr.V.P.Upadhyay)
Director(S)