

भारत सरकार  
पर्यावरण एवं वन मंत्रालय  
GOVERNMENT OF INDIA  
MINISTRY OF ENVIRONMENT & FORESTS **BY SPEED POST**

Telefax: 011-24360488

Email: sansomj@gmail.com  
sansom\_2859@yahoo.co.in

File No- J-11011/383/2006-IA-II (I) (T)

Date: 16<sup>th</sup> May 2007

To,

Shri P. K. Goyenka  
President  
Vasavadatta Cement  
Post Sedam, Gulbarga  
Karnataka

Subject: Environmental Clearance to Expansion Project for Clinker Production from 3.30 MMTPA to 6.0 MMTPA and Cement production from 4.10 MMTPA to 9.0 MMTPA along with Expansion of Captive Power Plant from 43.2 MW to 73.2 MW at Sedam, Gulbarga, Karnataka by M/s Vasavadatta Cement.

Sir,

This is with reference to your communication no. VC:WS:E&I:ENV:CKJ:06:009A 2853 dated 9<sup>th</sup> October 2006 seeking environmental clearance for the above-mentioned project.

2. The Ministry of Environment and Forests has examined the proposal and additional information submitted by you vide your letter no VC:WS:JPEPP:ENV:CKJ:07:001 dated 2<sup>nd</sup> March 2007. It is noted that the company intends to augment Clinker production capacity from 3.30 MMTPA to 6.0 MMTPA and of Cement from 4.10 MMTPA to 9.0 MMTPA accompanied by expansion of the coal based Captive Thermal Power Plant of 43.2 MW to 73.2 MW at Sedam, Gulbarga in Karnataka State. The cost of the project is Rs. 575.00 Crores out of which Rs. 28.00 Crores is for environment protection, of which about Rs. 04.20 Crores will be recur annually. Capacity of the existing units will be optimized and a new unit as Unit IV of 1.75 MMTPA capacity will be added along with addition of 100 TPH slag grinding unit. Additional residential accommodation of 25 houses will be complete the project. Existing plant area is 227 ha land, of which 160.2 ha is for cement plant and 66.3 ha for colony. 94.69 ha has already been covered as green belt and another 5.25 ha is

Contd.

  
जहाँ है हरियाली।  
वहाँ है खुशहाली।।

पर्यावरण भवन, सी.जी.ओ. कॉम्प्लेक्स, लोदी रोड, नई दिल्ली - 110 003  
PARYAVARAN BHAWAN, C.G.O. COMPLEX, LODHI ROAD, NEW DELHI - 110 003

proposed for the same. No additional land is needed for the expansion. No forest, agriculture land, eco sensitive zones or R & R is involved in the project site. No endangered species of plants and animals in the area reportedly exist. Kamalavathi Nala abuts the Plant boundary and river Kagina is 9 Km away. Requirement of limestone will increase from 4.5 MMTPA to 9 MMTPA on commissioning Unit-III and it will be sourced from Injepalli captive Mines located 3 km away. Environment clearance for the same has been obtained. 0.2580 MMTPA of Laterite, 2.080 MMTPA of Fly ash, 0.42 MMTPA of Gypsum, 0.5 MMTPA of Shale, 0.0855 MMTPA of Bauxite and 0.260 MMTPA of Slag will be required finally. Total coal demand is 1,550 MMTPA and will be met by Singareni. CPP will consume 1414 TPD. Coal will have 25-40% of ash and 0.5% of Sulphur and will be transported by rail. The plant will be based on "Dry Process and Precalcinator Technology". The boiler for CPP will be Atmospheric Fluidized Bed Combustion (AFBC). Possibility of air cooled condensers for cooling towers will be explored. Power will be catered to by the CPP, KPTCL meeting the shortfall. Three standby D.G. Sets of 4 MW capacity will be as standby. Water required for all the units is 12,095 m<sup>3</sup>/d, diminishing to 10,869 m<sup>3</sup>/d after recycling and will be sourced from Kagina River, Kamalavath Barrage and water harvesting at the mine pit. Permission for additional water of 2,825m<sup>3</sup>/d from River Kagina has been applied for. Approval for withdrawal of 4903 m<sup>3</sup>/d from Kagina River and 3182 m<sup>3</sup>/d from Kamalavathi Barrage exists. The overall water generation from the project after the expansion will be about 1,726 m<sup>3</sup>/d, of which 590 m<sup>3</sup> will be recycled and 1105 m<sup>3</sup> utilised. No waste water will be discharged from the Plant. Total Ash generation from all the Units will be 0.226 Mill.MT/Y and will be used in cement production which will use 2.08 MMTPA of fly ash. Extra fly ash shall be procured from RTPS. Spent oil and automobile batteries will be sold off to authorize recyclers. Public Hearing was conducted on 12.12.2006 and 17.12.2006. The Commitment to fulfill the vouches during the Public Hearing has been submitted to the Ministry. It has been confirmed that no wild life Sanctuary exists in 10 km area of the site.

3. The Project falls in 3 (b) "A" Category in the Schedule of EIA Notification 2006 however was considered as per the EIA Notification 1994 in the light of Para 2.2.1 (i) (a) of the Interim Operational Guidelines of 13<sup>th</sup> October, 2006 issued by the Ministry under Para 12 of the EIA Notification 2006.

4. Based on the information submitted by you, the Ministry of Environment and Forests hereby accords environmental clearance to above project under the provisions of EIA Notification, 2006 subject to the compliance of the following Specific and General conditions:




Contd



A. SPECIFIC CONDITIONS:

- i. The gaseous emissions from various units shall conform to the standards prescribed by the concerned State Pollution Control Board (SPCB) or by the Ministry, whichever is stringent. Bag filter system shall be provided for flue gas instead of conditioning towers. SPM emission from all the stacks, including CPP will be  $<50 \text{ mg/m}^3$ . The CPP will be based on AFBC technology and will preferably have Air Cooled Condenser System for cooling of water for CPP.
- ii. The unit shall use the high calorific hazardous waste in their kiln. The relevant designed factors shall be incorporated at the inception stage itself.
- iii. The predicted values for  $\text{SO}_2$  seems low and will further decrease if the actual sulphur content of 0.4 to 0.5% is considered. These may be rechecked and submitted to the Ministry with in fifteen days of issue of this letter.
- iv. The height of stack with Unit -IV AFBC will be 88 m, of raw mill, 90 m, of coal mill 100 m, while other stacks will be 30-40 m and for CPP, it will be 110 m. Bag house will be installed at all other emission points except the cooler exhaust. Bag filters will be provided at all material handling and transfer locations. Low  $\text{NO}_x$  burners shall be installed to control  $\text{NO}_x$  emissions and lime injection shall be carried out to reduce  $\text{SO}_2$  emissions, if required.
- v. Continuous On-line monitors for particulate emissions,  $\text{SO}_2$  and  $\text{NO}_x$  in Raw Mill /Kiln, clinker cooler, coal mill, cement mill etc. shall be provided and shall make necessary arrangements for submission of On-line real time emission data to CPCB website. Interlocking facility shall be provided between pollution control equipment and the process operation so that in the event of the pollution control equipment not working, the respective unit (s) is shut down automatically.
- vi. Regular Ambient Air Quality Monitoring shall be carried out. The location of the monitoring stations will be reviewed in consultation with the State Pollution Control Board and additional stations will be installed, if required. It will be ensured that at least one monitoring station is set up in up-wind & in down-wind direction along with those in other directions. On-line data for air emissions shall be transferred to the CPCB and APPCB regularly. The instruments used for ambient air quality monitoring shall be calibrated regularly.
- vii. Fugitive emission shall be  $<500 \text{ mg/m}^3$ . Bag filters shall be provided for all stacks except CPP Boiler and Cooler where ESP shall be provided. The regular monitoring of fugitive emission shall be carried out by the unit as per the CPCB guidelines.

Contd.



- viii. Raw material will be stored in covered yards and clinker in Silos/covered tanks to control fugitive emissions. Fugitive emissions from cement mill, packing area and coal yard shall also be controlled.
- ix. Vacuum dust cleaning system will be provided to evacuate dust on floors. All roads will be swept with sweeping machines. Material will be transported in tippers, covered trucks, covered containers, covered rail wagons etc. Dust collectors and extraction system (suction apparatus) shall be installed to control fugitive dust emissions at coal and lime stone unloading points, at all the transfer points, stockpiles to arrest free release of dust.
- x. Windbreakers will be installed to restrict fugitive dust.
- xi. Water sprinkling arrangement should be made in the raw material stock yard and suction system for cement bag loading areas. Regular water sprinkling shall be carried out at all areas where fugitive dust can be generated.
- xii. The proposed cooling system for CPP may be decided and submitted along with a detailed water balance resubmitted.
- xiii. Acoustic enclosures will be provided at all high noise equipment and place to limit the noise levels below 85 dBA.
- xiv. Copy of water withdrawal permission from the relevant authority shall be submitted before starting the project.
- xv. Note on source wise water withdrawal and status of permissions on this account is needed.
- xvi. Water requirement will not exceed from 10,869 m<sup>3</sup>/d. No wastewater will be generated in cement manufacture. The wastewater from CPP and domestic activities shall be treated in Effluent Treatment Plant (ETP) and Sewage Water Reclamation Plant (SWRP) respectively and recycled/reused in cement plant for make-up, in CPP for cooling, dust suppression, other plant related activities and green belt development. No wastewater will be released outside the premises. 'Zero' discharge shall be strictly adopted. During monsoon, the waste water will be stored in the mine pit. Separate storm water drains will be provided and storm water from CPP area will be stored in a settling tank before discharging into the nallah.



Contd



- xvii. Solid waste generated shall be 100 % recycled and reutilized in the process and no solid waste shall be disposed off outside the plant premises. The solid waste will be dumped in the low lying areas and the area thus filled up/reclaimed shall be used for tree plantation.
- xviii. Vermi Compositing shall be adopted for disposing off bio-degradable waste from the domestic sources.
- xix. 0.226 MMTPA of fly ash generated from CPP will be transported pneumatically to the cement plant fly ash silos and shall be 100% utilized in Portland Pozzolana Cement production. Bottom ash shall also be used in Cement plant or used for land filling. Treated STP sludge shall be used as manure for green belt development. Waste oil sludge shall be reused in the plant and finally burnt in the kiln or sold to authorized recyclers/ re-processors.
- xx. The company shall strictly follow all the recommendations mentioned in the Charter on Corporate Responsibility for Environmental Protection (CREP).
- xxi. An additional area of 5.25 ha shall be developed as green belt.
- xxii. The company must harvest surface as well as rainwater from the rooftops of the buildings proposed in the expansion project 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.
- xxiii. Studies on noise dosimetry and audiometry to assess the noise induced hearing loss in case of exposed employees will be carried out and appropriate ameliorative measures will be taken, wherever necessary.

**B. GENERAL CONDITIONS:**

- i. The project authorities must strictly adhere to the stipulations made by the State Pollution Control Board (SPCB) 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. Adequate number of influent and effluent quality monitoring stations shall be set up in consultation with the SPCB. Regular monitoring shall be carried out for relevant parameters.



Contd

- iv. The project proponent shall also comply with all the environmental protection measures and safeguards recommended in the EIA/EMP report.
- v. Industrial wastewater shall be properly collected and treated so as to conform to the standards prescribed under GSR 422 (E) dated 19<sup>th</sup> May 1993 and 31<sup>st</sup> December, 1993 or as amended from time to time. The treated wastewater shall be utilized for plantation purpose.
- vi. The overall noise levels in and around the plant area shall be limited within the prescribed standards (85 dBA) by providing noise control measures including acoustic hoods, silencers, enclosures etc. on all sources of noise generation.
- vii. Proper House keeping and adequate occupational health programs shall be taken up. Regular Occupational Health Surveillance Programme shall be carried and records shall be maintained properly for at least 30-40 years. The programme shall include lung function and sputum tests once in six months. Sufficient preventive measures shall be adopted to avoid direct exposure to dust etc.
- viii. A separate environment management cell with full fledge laboratory facilities to carry out various management and monitoring functions shall be set up under the control of a Senior Executive.
- ix. As proposed in the EIA/EMP, Rs. 28.00 Crores and Rs. 04.20 Crores/annum earmarked to meet the capital and recurring cost/annum respectively for the environmental protection measures shall be used judiciously 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.
- x. The concerned Regional Office of this Ministry / State Pollution Control Board / Central Pollution Control Board shall monitor the implementation of the stipulated conditions. Six monthly compliance status report and monitoring data along with statistical interpretation shall be submitted to them regularly.
- xi. The Project Proponent should advertise in at least two local newspapers widely circulated in the region around the project, one of which shall be in the vernacular language of the locality concerned informing that the project has been accorded environmental clearance by the Ministry and copies of the clearance letter are available with the State Pollution Control Board / Committee and may also be seen at Website of the Ministry and Forests at <http://envfor.nic.in> . The advertisement should be made within 7 days from the date of issue of the clearance letter and a copy of the same should be forwarded to the Ministry's Regional Office at Bangalore.

Contd.



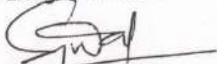


xii. The Project Authorities shall inform the Regional Office as well as the Ministry the date of financial closure and final approval of the project by the concerned authorities and the date of start of land development work.

5. The Ministry may revoke or suspend the clearance, if implementation of any of the above conditions is not satisfactory.

6. The Ministry reserves the right to stipulate additional conditions if found necessary. The company will implement these conditions in a time bound manner.

7. The above conditions will 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, the Public Liability Insurance Act, 1991, Hazardous Waste (Management & Handling) Rules, 1989 and Manufacture, Storage and Import of Hazardous Chemicals Rules, 1989 along with their amendments and rules.

  
(Sanchita Jindal)  
Additional Director

Copy to:

1. The Secretary, Department of Forests, Ecology & Environment, Government of Karnataka, R.No. 404, 4<sup>th</sup> Floor, II Stage, Multi Storyed Building, Bangalore-560001, Karnataka.
2. The Chief Conservator of Forests, Regional Office ( Southern Zone) , Ministry of Environment & Forests, Kendriya Sadan ,4<sup>th</sup> Floor , C& F Wing, 17 Main Road, II Block , Kormangla, Bangalore- 560 034, Karnataka.
3. The Chairman, Central Pollution Control Board Parivesh Bhavan, CBD-cum-Office Complex, East Arjun Nagar, New Delhi - 110 032.
4. The Chairman, A.P. Pollution Control Board, Paryavaran Bhawan, A-3, Industrial Estate, Sanath Nagar, Hyderabad- 500 018, A.P.
5. Joint Secretary (CC-I), Ministry of Environment and Forests, Paryavaran Bhavan, CGO Complex, Lodhi Road, New Delhi.
6. Monitoring Cell, Ministry of Environment and Forests, Paryavaran Bhavan, CGO Complex, New Delhi.
7. Guard File/Monitoring File/Record File

(Sanchita Jindal)  
Additional Director