

F. No. J-11011/118/2007- IA II (I)  
**Government of India**  
**Ministry of Environment and Forests**  
**(I.A. Division)**

**Paryavaran Bhawan**  
**CGO Complex, Lodhi Road**  
**New Delhi – 110 003**

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Dated 25<sup>th</sup> August, 2008

To,

✓ M/s Dalmia Cement (Bharat) Ltd.  
Hansalaya 11<sup>th</sup> & 12<sup>th</sup> Floor  
15, Barakhamba Road, P.B. No. 364  
New Delhi – 110 001.

**E-mail : [kcnarang@dalmiacement.com](mailto:kcnarang@dalmiacement.com) / [lakshman.sainath@dalmiacement.com](mailto:lakshman.sainath@dalmiacement.com)**  
**Fax No. : 011-23313303**

**Subject : Cement Plant (4.0 MTPA) and Captive Power Plant (40 MW) at Village Kokanhalli-Hoshalli, Taluk Sedam, District Gulbarga, Karnataka by M/s Dalmia Cement (Bharat) Ltd. – Environment clearance reg.**

**Ref. : Your letter no. DCBL/MOEF/Gulbarga/07 dated 16<sup>th</sup> January, 2007 & 2<sup>nd</sup> July, 2007.**

Sir,

Kindly refer your letter no. DCBL/MOEF/Gulbarga/07 dated 16<sup>th</sup> January, 2007 alongwith project documents including Form-I, Pre-feasibility Report, draft Terms of References and EIA/EMP as per the EIA Notification, 2006 and subsequent clarifications furnished vide communications dated 22<sup>nd</sup> June, 2007, 2<sup>nd</sup> & 17<sup>th</sup> July, 2007, 6<sup>th</sup> August, 2007, 21<sup>st</sup> May, 2008 regarding above mentioned cement project.

2.0 The Ministry of Environment & Forests has examined the application. It is noted that M/s M/s Dalmia Cement Ltd. have proposed to set up a Cement Plant (4.0 MTPA) and Captive Power Plant (40 MW) at Village Kokanhalli-Hoshalli, Taluk Sedam, District Gulbarga, Karnataka. Total land acquired is 120 ha. No rehabilitation and resettlement (R & R) and forest land is involved. No reserve forest, national park and wildlife sanctuary is located within 10 km radius. Total cost of the project is Rs. 1,027.36 Crores.

3.0 Cement plant will be based on dry process and pre-calciner technology. Cement manufacturing will involve raw meal grinding, blending, pre-calcinating, clinker burning and cement grinding. The cement and clinker production will be 12,500 TPD and 8,000 TPD respectively. 42% of OPC and 58% of PSC will be produced. Limestone will be sourced from Alkali, Udgi villages of Seadam, Gulbarga and have applied for the approval for the mining lease but prospective licence is granted by the State Govt.

4.0 Electrostatic precipitator (ESP), bag house and bag filters will be provided to control air emissions within 50 mg/Nm<sup>3</sup>. Bag filters with ventilation system and water sprinkling will be provided to control fugitive emissions from the material handling areas. Total water requirement from Kagna river 2,500 m<sup>3</sup>/day and ground water source will be 100 m<sup>3</sup>/day. Captive Power Plant will be provided with air-cooled condensers to reduce the water demand to a greater

extent. No wastewater will be generated from the process since wastewater generated will be used for dust suppression and green belt development at the site. 'Zero' discharge will be adopted. Dust collected in various air pollution control equipments will be recycled back to the process. Fly ash will be transported pneumatically to cements plant and used in manufacturing PPC. Bed ash will be collected in ash cooler hoppers and then conveyed to a bed ash storage silo for further use as boiler bed material. ETP sludge and STP sludge will be composted and used as manure for green belt development. Waste oil and scrapped auto mobile batteries will be sold to recyclers.

5.0 Public hearing / Public consultation meeting was held on 14<sup>th</sup> March, 2008.

6.0. The Ministry of Environment and Forests hereby accords environmental clearance to the above project under the provisions of EIA Notification dated 14<sup>th</sup> September, 2006, subject to strict compliance to the following specific and general conditions:

**A. SPECIFIC CONDITIONS:**

- i. Continuous stack monitoring facilities to monitor gaseous emissions from all the stacks shall be provided and limit of SPM shall be controlled within 50 mg/Nm<sup>3</sup> by installing adequate air pollution control system by installing adequate air pollution control system. Electrostatic precipitator (ESP) to clinker cooler and captive power plant, bag house to raw mill / kiln and bag filters to cement mill and coal mill shall be provided to control air emissions within 50 mg/Nm<sup>3</sup> and reports submitted to the Ministry's Regional Office at Bangalore, Central Pollution Control Board (CPCB) and Karnataka Pollution Control Board (KPCB).
- ii. Secondary fugitive emissions shall be controlled within the prescribed limits and regularly monitored. Guidelines / Code of Practice issued by the CPCB in this regard shall be followed. Bag filters with ventilation system shall be provided to raw material handling areas, clinker, cement & fly ash silos, clinker hoppers etc. to control fugitive emissions from the material handling areas. Closed clinker stockpile system shall be adopted and bag filters shall be provided to clinker hoppers. Water sprinkling arrangements shall be made in the material stockyards and cement bags loading areas. To eliminate fugitive emissions, transportation of the ash to the cement plant shall be in closed containers and pneumatic transfer of the ash into ash silos in cement plant.
- iii. Efforts shall be made to reduce impact of the transport of the raw materials and end products on the surrounding environment including agricultural land. Wagon and truck tippers for unloading and transportation shall be covered with tarpaulin. Internal roads shall be asphalted and sprinkled with water regularly.
- iv. As proposed, total water requirement from Kagna river and ground water source shall not exceed 2,500 m<sup>3</sup>/day and 100 m<sup>3</sup>/day respectively and prior 'Permission' for the drawl of water shall be obtained from concerned Department. The process effluent from captive power plant (CPP) shall be treated in effluent treatment plant (ETP) and treated wastewater shall be recycled and reused in the cement manufacturing process and/or for 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.
- v. 'Permission' for the drawl of 3,100 m<sup>3</sup>/day from River Ghataprabha shall be obtained from concerned Department. Captive Power Plant shall be provided with air-cooled condensers to reduce the water intake.



- vi. All the fly ash shall be utilized as per Fly ash Notification, 1999 subsequently amended in 2003. Efforts shall be made to use fly ash maximum in making Pozzollona Portland Cement (PPC).
- vii. Fly ash shall be transported pneumatically to cement plant and efforts shall be made to use fly ash generated from the power plant maximum in making Pozzolana Portland Cement (PPC). Bed ash shall be collected in ash cooler hoppers and then conveyed to a bed ash storage silo for further use as boiler bed material.
- viii. All the dust collected from pollution control equipments shall be recycled and reused in the process and used for cement manufacturing. Refractory bricks having high recycling values shall be sold to outside agencies or disposed off in environment-friendly manner. Domestic solid waste i.e. sludge shall be composted and used as organic manure for the green belt development within the plant and colony area. Used oil and scrapped auto mobile batteries shall be sold to authorized recyclers / reprocessors only.
- ix. An effort shall be made to use of high calorific hazardous waste in the cement kiln and necessary provision shall be made accordingly. An effort shall be made to use of high calorific hazardous waste viz. municipal solid waste, solvents, spent oil, agro waste, sludge from DG sets and used tyres etc. in the cement kiln and necessary provision shall be made accordingly.
- x. Efforts shall be made to use low grade lime, more fly ash and solid waste in the cement manufacturing.
- xi. As proposed, out of 120 ha., green belt shall be developed in 40 ha. (33%) in and around the plant as per the CPCB guidelines to mitigate the effects of air emissions in consultation with local DFO.
- xii. All the recommendations made in the Charter on Corporate Responsibility for Environment Protection (CREP) for the Cement plants shall be implemented.

**B. GENERAL CONDITIONS:**

- i. The project authority shall adhere to the stipulations made by Karnataka Pollution Control Board (KPCB) and State Government.
- ii. No further expansion or modification of the plant shall be carried out without prior approval of this Ministry.
- iii. The gaseous and particulate matter emissions from various units shall conform to the standards prescribed by the Karnataka Pollution Control Board. At no time, the particulate emissions from the cement plant shall exceed KPCB 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.
- iv. 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 KPCB and

report submitted to the KPCB quarterly and to the Ministry's Regional Office at Bangalore half-yearly.

- v. The company shall install adequate dust collection and extraction system to control fugitive dust emissions at various transfer points, raw mill handling (unloading, conveying, transporting, stacking), vehicular movement, bagging and packing areas etc. Asphaltting/concreting of roads 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 fully covered conveyers for transportation of materials shall be provided besides coal, cement, fly ash and clinker shall be stored in silos.
- vi. The company shall 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.
- vii. The company shall undertake eco-development measures including community welfare measures in the project area.
- viii. The overall noise levels in and around the plant area shall be kept well within the standards (85 dBA) by providing noise control measures including acoustic hoods, silencers, enclosures etc. on all sources of noise generation. The ambient noise levels shall conform to the standards prescribed under Environmental (Protection) Act, 1986 Rules, 1989 viz. 75 dBA (day time) and 70 dBA (night time).
- ix. Proper house keeping and adequate occupational health programmes shall be taken up.
- x. A separate environmental management cell to carry out various management and monitoring functions shall be set up under the control of Senior Executive.
- xi. As proposed in EIA/EMP, Rs. 31.05 Crores and Rs. 4.28 Crores earmarked towards capital cost and recurring cost/annum respectively for the environmental pollution control measures shall be suitable 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.
- xii. The Regional Office of this Ministry at Bangalore / CPCB / KPCB shall monitor the stipulated conditions. A six monthly compliance report and the monitored data alongwith statistical interpretation shall be submitted to them regularly.
- xiii. 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.
- 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 Karnataka Pollution Control Board 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.

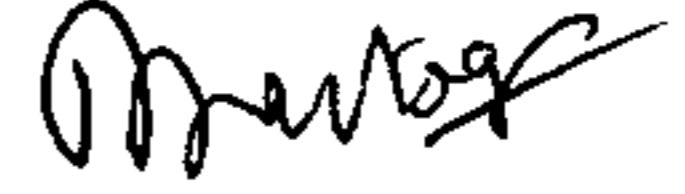
7.0 The Ministry or any other competent authority may stipulate any further condition(s) on receiving reports from the project authorities. The above conditions shall be monitored by the Regional Office of this Ministry located at Bangalore.

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

9.0 Any other conditions or alteration in the above conditions shall have to be implemented by the project authorities in a time bound manner.

10.0 Any appeal against this environmental clearance shall lie with the National Environment Appellate Authority, if preferred within a period of 30 days as prescribed under Section 11 of the National Environment Appellate Act, 1997.

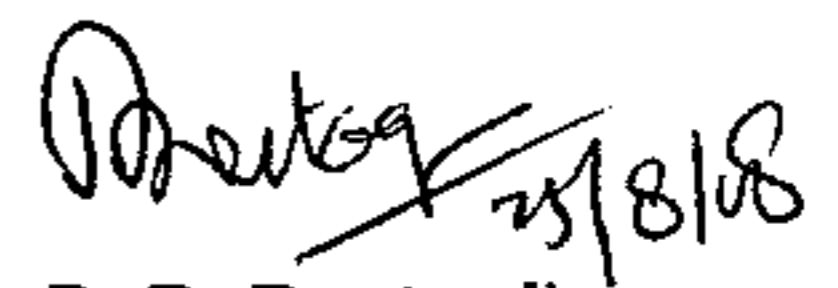
11.0 The above conditions shall be enforced, inter-alia under the provisions of the Water (Prevention and Control of Pollution) Act, 1974 the Air (Prevention and Control of Pollution) Act, 1981 the Environment (Protection) Act, 1986 and the Public Liability Insurance Act, 1991 along with their amendments and rules.



(Dr. P. B. Rastogi)  
Director

Copy to : -

1. The Chairman, Central Pollution Control Board, Parivesh Bhavan, CBD-cum-Office Complex, East Arjun Nagar, Delhi -110032.
2. The Chairman, Karnataka State Pollution Control Board, 6,7,8 & 9<sup>th</sup> Floor, (Public Utility Building), Subhas Chandra Bose Building, M.G. Road, Bangalore - 560001, Karnataka.
3. The Chief Conservator of Forests (Central), Regional Office (SZ), Kendriya Sadan, 4<sup>th</sup> Floor, E&F Wing, 17<sup>th</sup> Main Road, Koramangala, Bangalore-560034, Karnataka.
4. The Secretary, Department of Environment & Forests, Government of Karnataka Bangalore, Karnataka.
5. Adviser (IA-II), Ministry of Environment and Forests, Paryavaran Bhavan, CGO Complex, New Delhi- 110003.
6. Monitoring Cell, Ministry of Environment and Forests, Paryavaran Bhavan, CGO Complex, New Delhi- 110003.
7. Guard file.
8. Monitoring file.
9. Record file.



(Dr. P. B. Rastogi)  
Director