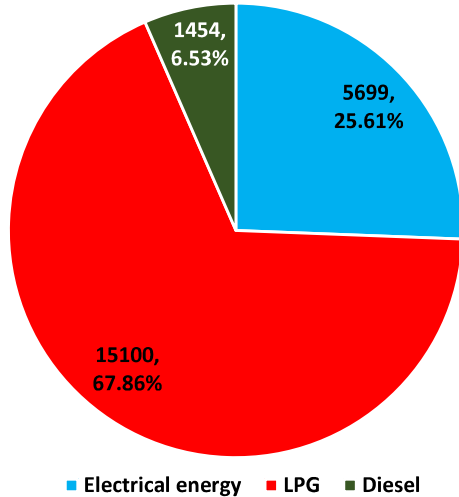
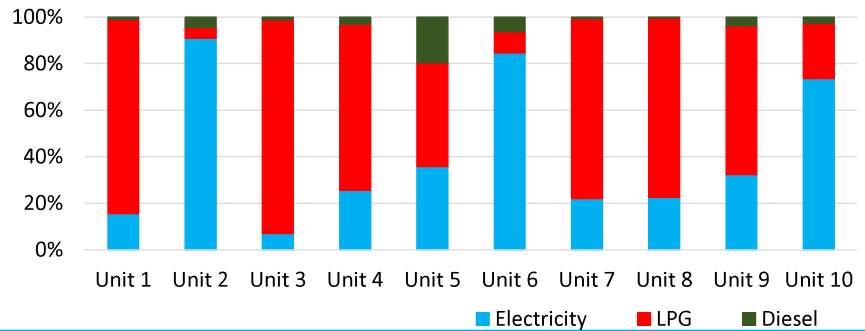


The bakery industry in India is the largest of the food processing segments with an estimated annual turnover of about 7.60 billion \$ by 2020. In Kerala, where each Panchayat has an estimated 25-40 bakery units and random estimates suggests that there are **22,000** bakery product manufacturing units in the state of Kerala. Energy optimization Study was conducted at selected 10 major baking units in Ernakulam district during December 2021. Energy savings to a tune of **84222 kWh** and an anticipated Monetary savings of **7.13 Lakh INR** is envisaged.

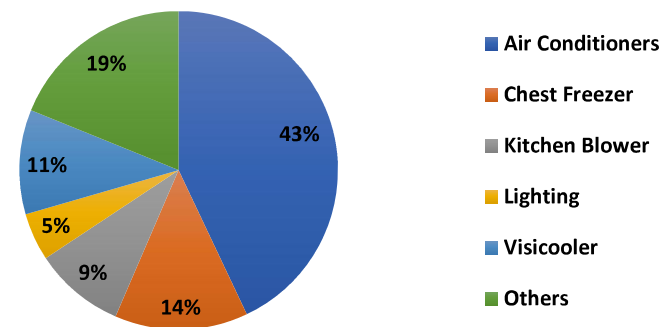
Energy Breakup by Source (kWh)



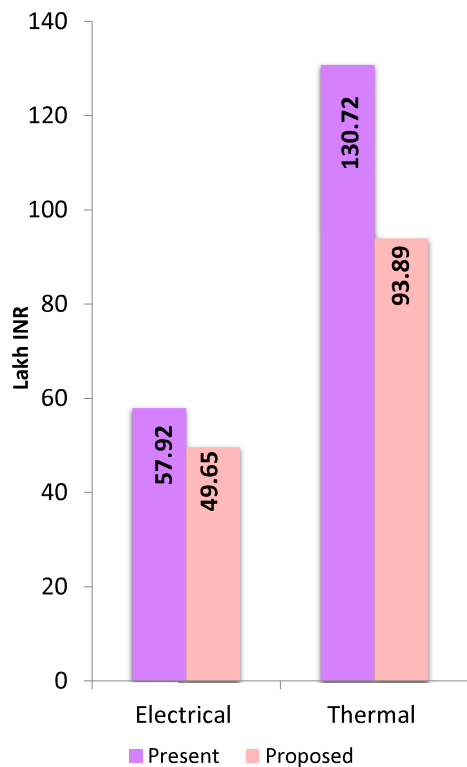
Monthly Energy Share for 10 Baking Units (kWh)



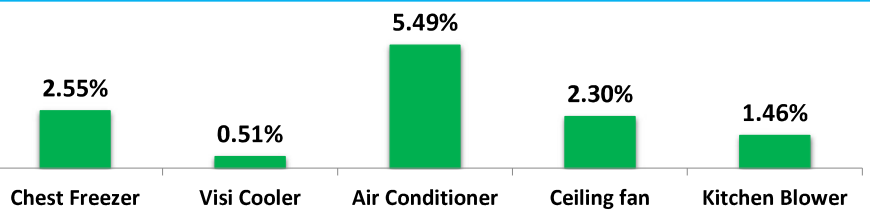
Monthly Energy Breakup for 10 Baking Units (kWh)



Monetary Savings Potential



Energy Saving Potential in various areas



Best Practices

- Ensure to buy BEE star labelled energy efficient chest freezers and energy efficient Visi coolers having low rated power consumption whenever replacement is due.
- Replace the inefficient Air conditioners (AC) with BEE 5 star labelled inverter type having ISEER of 5.75 or more.
- Set your AC temperature at 25°C. Lowering the temperature by each 1°C will increase energy consumption by 3%
- Switch to BLDC ceiling fans and save energy upto 50% - 60%
- Avoid stacking of outdoor units of air conditioners. Ensure proper Insulation of refrigerant copper pipes of AC units.
- Provide sufficient space clearance for the freezers and visi coolers for effective heat transfer which will result improved operational efficiency.