



## **2021 Award for Excellence** in environmental, health, safety and security

### **Emery Oleochemicals**

Lima, Ohio

In 2020, a high priority ISO 14001 Environmental Management Plan for Emery Oleochemicals was to reduce the impact waste water has on the local POTW's treatment plant. Projects were initiated to reduce both the waste water volume and its organic waste concentration. An average of 2018 and 2019 data was used as the benchmark. Compared to the benchmarks, in 2020 the facility reduced their waste water volume by 14% and organic waste concentration by 25%. To accomplish this, multiple projects were addressed.

#### Waste water volume reduction projects:

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- Replacement of aged infrastructure.
- Project to increase cooling tower cycles of concentration which reduces blowdown to the sewer.
- Projects to capture condensate that had been discharged to the sewer.
- Projects to reuse sewer water for additional purposes, for example as scrubber feed water.

- Project to reuse contaminated condensate in applications where “pure” water is not a requirement. Prior to this, poor quality condensate was discharged to the sewer.
  - Isolation of high strength organic waste from esterification processes for alternative disposal to off-site biodigesters. This process breaks down the organics to generate bio-gas as an alternative energy source.
  - Spill and leak prevention awareness including incentives in the manufacturing operation’s Team Profit Incentive program. As a side benefit, all reduction of waste water discharge helps minimize the discharge of polluted waters to creeks and rivers in the Cincinnati area occurring through Combined Sewer Outfalls.
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*The Ohio Chemistry Technology Council recently announced the recipients of their Annual Awards for Excellence which recognizes Ohio chemical companies who have demonstrated exceptional performance in environmental, health, safety and security over the previous year. Awards were presented to 17 facilities from around Ohio, all of which had significant contributions and achievements in 2020.*