



File No. J-11011/191/2007-IA-II (I)
Government of India
Ministry of Environment, Forest & Climate Change
Impact Assessment Division

Indira Paryavaran Bhawan,
Jal Wing, 3rd Floor, Aliganj,
Jor Bagh Road, New Delhi-110 003

Dated: 09th April, 2021

To,

M/s Godavari Biorefineries Ltd. located,
Madabhai Village, post Sameerwadi, Tal: Mudhol,
Dist: Bagalkot, Karnataka-587316

Sub: Proposed expansion of distillery for production of ethanol capacity from 400 KLPD to 600 KLPD using sugarcane syrup by expanding the sugarcane crushing from 15000 TCD to 20000 by M/s Godavari Biorefineries Ltd. located at Sy. No. 13, 14, 15, 16, 19, 21, 28, 29, 40 of Saidapur Village, Sy. No. 49, 50, 53 of Bisnal Village, Sy. No. 69, 72, 73, & 74 of Madabhai Village at post Sameerwadi, Tal: Mudhol, Dist: Bagalkot, Karnataka-587316 - Consideration of Environment Clearance regarding.

Sir,

This has reference to your online proposal No. IA/KA/IND2/198268/2021, dated 19th February, 2021 for environmental clearance to the above mentioned project.

2. The Ministry of Environment, Forest and Climate Change has examined the proposal for environmental clearance to the project for Proposed expansion of distillery for production of ethanol capacity from 400 KLPD to 600 KLPD using sugarcane syrup by expanding the sugarcane crushing from 15000 TCD to 20000 by M/s Godavari Biorefineries Ltd. located at Sy. No. 13, 14, 15, 16, 19, 21, 28, 29, 40 of Saidapur Village, Sy. No. 49, 50, 53 of Bisnal Village, Sy. No. 69, 72, 73, & 74 of Madabhai Village at post Sameerwadi, Tal: Mudhol, Dist: Bagalkot, Karnataka-587316.

- a. It is a proposed expansion of Distillery for production of Ethanol from 400 KLPD to 600 KLPD using sugarcane syrup by expanding the sugarcane crushing from 15000 TCD to 20000 TCD to augment the requirement of sugarcane syrup/juice as raw material during sugarcane crushing season.
- b. During sugarcane crushing off season the production will be restricted to 320 KLPD RS/ETHNOL using C heavy molasses or Extra Neutral Alcohol of 260 KLPD; or 400 KLPD RS/380 KLPD Ethanol using B heavy molasses as raw material.
- c. The distillery configuration will be as under:

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Sl. No.	Product details	Existing quantity	Proposed quantity	Total quantity
A. During sugarcane crushing season using 100 % Sugarcane syrup/sugarcane juice as raw material. Capacity in KLD				
	Rectified Spirit or	400	200	600
	Ethanol or	380	190	570
	ENA	260	-	260
B. During sugarcane crushing off season using C –Heavy Molasses / B Heavy Molasses as raw material				
	Rectified Spirit or	400	-	400
	Ethanol or	380	-	380
	ENA	260	-	260

3. All Distilleries and Sugar Industry projects are listed at S. No.5 (g) & 5(j) of Schedule of Environment Impact Assessment (EIA) and as per MoEF&CC vide Notification no. S.O. 345(E) dated 17th January 2019 & extension of notification S.O. 750 (E) dated 17th February 2020 the proposal is to be appraised as B2 category.

4. Public Hearing for the proposed project is not conducted as the proposal is appraised as per category B2 projects in line with Notification issued by MoEF&CC vide. S. O. 345(E) dated 17th January 2019. There is no Litigation Pending against the proposal.

5. SEIAA Karnataka, had issued EC earlier vide letter vide no. SEIAA:1: IND: 2007 dated 18.11.2009 to the existing project Sugar & Cogeneration Plant (Sugar Plant 15000 TCD, Cogeneration plant 46 M) and Ministry of Environment & Forest had issued prior Environment Clearance vide letter no. J-11011/191/2007-IA-II(I) dated 9th April 2020 to the existing Distillery unit for 400 KLPD capacity and captive power plant 5.5 MW capacity.

6. The details of products and capacity are as under: -

Sl. No.	Product details	Existing quantity	Proposed quantity	Total quantity
1	Sugar cane crushing capacity, TCD	15000	5000	20000
2	Co-generation power plant, MW	46	-	46
3	Distillery KLD with Captive power plant MW	400 5.5	200 -	600 5.5

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	During sugarcane crushing season 100 % sugarcane syrup/sugarcane juice only			
1	Rectified Spirit (KLPD)	400	200	600
2	Ethanol (KLPD)	380	190	570
3	ENA (KLPD)	260	-	260
	During off season using C Heavy/ B Heavy Molasses			
	RS (KLPD)	400	-	400
	ENA (KLPD)	260	-	260
	Ethanol (KLPD)	380	-	380

7. Existing land area of Sugar, Cogeneration & Distillery complex is 154.62 Hectares out of which 48.56 Hectares is of distillery plant area and remaining 106.06 Hectares is of Sugar Cogeneration plant area & proposed expansion will be within the existing industries premises. Industry has already developed greenbelt in an area of 33 % i.e., 51.02 Hectares or 510200 m² out of total area of the project. The estimated project cost is Rs. 760.859 Crores including existing investment of Rs. 630.299 Crores. Total capital cost earmarked towards environmental pollution control measures is Rs. 96.175 Crores and the Recurring cost (operation and maintenance) will be about Rs. 5.43 Crores per annum. Total Employment will be 1195 persons, out of this the direct employment is 1165 persons & indirect is 30 persons after expansion. Industry proposes to allocate Rs.2.5 Crores towards Corporate Social Responsibility.

8. There are no national parks, wildlife sanctuaries, Biosphere Reserves, Tiger/Elephant Reserves, Wildlife Corridors etc. within 10 km distance from the project site. River Ghataprabha is flowing at a distance of 6.5 km in South of the industry.

9. Baseline ambient air quality monitoring is not carried out since the project is to be appraised as B2 category as per the Notification of MoEF&CC no. 345 (E) dated 17th January 2019. However, ambient air quality monitoring is carried out by the industry as per the conditions of the Consent issued by KSPCB. The monitoring data during December 2020 indicate PM₁₀ (75µg/m³), PM_{2.5} (29 µg/m³), SO₂ (12 µg/m³) and NO_x (14 µg/m³).

10. Total water requirement is as under;

- Sugar & co-gen - (1825 + 2204 = 4029) KLD of which fresh water requirement is (575+1004) KLD. The condensate water generated from sugar plant is treated and reused for sugar plant requirement and cooling tower. There is no increase in fresh water for Co-generation plant as it will not be expanded.
- Distillery water requirement is as in the table below;

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Sl. No.	Particulars	Existing (KLD)			Proposed scenario after expansion (KLD)			
		C Heavy	B Heavy	Cane syrup	C Heavy	B Heavy	Cane syrup	Cane syrup
	Feed stock (any one of the raw materials will be used at given time)	320	400	400	320	400	400	600
1	Fresh water for process	1172	1248	869	1172	1248	869	1654
	Fresh water for boiler	160	160	160	160	160	160	160
	Domestic water requirement	25	25	25	25	25	25	25
	Total Fresh water quantity	1357	1433	1054	1357	1433	1054	1839
2	Reuse from distillery CPU	1856	1856	2054	1856	1856	2054	1866
3	Total water requirement	2688	2731	3185	2688	2731	3185	3520

Fresh water will be met from Ghataprabha River located at about 6.5 km in southern direction from project site. (Permission to draw 97.70 MCFT per year, this amounts to 7689 m³/day is obtained from Karnataka Neeravari Nigama Limited).

A. Effluent from the sugar plant is 1825 KLD and from the co-generation plant is 485 KLD. Effluent will be treated through Biological Treatment Plant of total capacity 2500 KL and used on land for irrigation.

B. waste water generated from the distillery is as in the table below;

Sl. No.	Particulars	Existing			After expansion			
		C Heavy Molasses 320 KLD	B Heavy Molasses 400KLD	Sugarcane Syrup 400 KLD	C Heavy 320 KLD	B Heavy 400 KLD	Sugar cane Syrup 400 KLD	Sugarcane syrup 600 KLD
1	Raw spent wash	1931	1789	1792	1931	1789	1792	1700
2	Concentrated spent wash	401	295	173	401	295	173	159
3	Spent lees	443	497	564	443	497	564	452
4	Total Condensate	1530	1490	1618	1530	1490	1618	1541
5	Boiler blow down	10	10	10	10	10	10	10
6	Cooling tower	30	30	30	30	30	30	30

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The spent wash from the distillery with respect to per KL of ethanol produced is as in the table below;

SI No	Description	Raw spent wash generation		Conc. Spent wash	
		KLD	KL/KL ethanol	KLD	KL/KL ethanol
1	320 KLPD using C heavy Molasses	1931	6.034	401	1.25
2	400 KLPD using B Heavy Molasses	1789	4.47	295	0.73
3	400 KLPD using sugarcane syrup	1792	4.48	173	0.43
4	600 KLPD using sugarcane syrup	1700	2.83	159	0.26

Mode of treatment of distillery spent wash, spent leese & other utility effluents are as under:

- The first stream of spent wash concentrated in MEE and the concentrate will be incinerated.
- The MEE condensate along with process condensate and spent lees treated in BTP/CPU. Treated effluent is used in cooling tower makeup.
- The second stream of spent wash will be treated in bio-methanization plant, concentrated in stand-alone MEE and the concentrate will be composted. The condensate from MEE will be treated in stripper column and re-used mixing it with treated BTP/CPU effluent and reused in cooling tower.
- The distillery plant will be based on Zero Liquid discharge system.

11. Power requirement after expansion will be 28.5 MW including existing sugar cogeneration plant and Distillery power requirement and will be met from sugar Cogeneration plant of 46 MW and for distillery plant from distillery captive power plant of 5.5 MW capacity. Existing sugar and cogeneration plant has 1No. 625 kVA & 2 No. X 1010 kVA DG sets & distillery Plant has 320 kVA capacity DG set.

Existing unit has boilers as under;

- Sugar plant – existing 2 x 37.5 TPH, bagasse fired boiler with independent chimney of 42 m AGL and wet scrubber as APC equipment respectively.
- Sugar Co-generation plant – existing 1 x 130 TPH and 1 X 120 TPH bagasse fired boiler with independent chimney of 70 m height and ESP as APC equipment respectively.
- Distillery – Existing distillery has 40 TPH incinerator boiler with fuel as concentrated spent wash supported with coal (65:35). ESP with stack of 81 m height is installed for controlling the particulate emissions within the

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statutory limit of 115 mg/Nm³ for the proposed boilers. No boiler is proposed during expansion.

12. Details of Process emissions generation and its management:

During fermentation 442 TPD of CO₂ is estimated to be released. The company is conducting research for value addition for making better use of CO₂. As and when the technology is developed the same will be implemented.

13. Details of Solid waste/Hazardous waste generation and its management:

Sl. No.	Type of solid waste	Quantity generated after expansion MT/month	Disposal
Distillery Plant			
1.	Yeast sludge	1800	By composting
2.	Bottom ash	1350	Sold to brick manufacturers and also mixed with bio-organic manure.
3.	Fly ash	1350	Sold to brick manufacturers and also mixed with bio-organic manure.
Sugar Plant and Co-gen plant			
1.	Wet & dry ash from sugar Boilers	480	Given to brick manufacturers
2.	Cogeneration boiler fly ash	1260	Given to brick manufacturers
3.	Press mud	24000	Used as filler in converting spent wash to compost

Hazardous waste generation and its management

Waste category	Hazardous waste generated	Quantity	Method of handling
Sugar Unit			
5.1	Used Oil	1.25 KL/A	Stored in leak proof containers in secure manner and handed over to KSPCB authorized reprocessors/incinerator
5.2	Wastes Residues Containing Oil	0.100 MT	Stored in leak proof containers in secure manner and handed over to KSPCB authorized reprocessors/incinerator

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Distillery unit			
5.1	Used Oil	0.1 KL/A	Stored in leak proof containers in secure manner and handed over to KSPCB authorized reprocessors/incinerator
5.2	Wastes Residues Containing Oil	0.01 MT/A	Stored in leak proof containers in secure manner and handed over to KSPCB authorized reprocessors/incinerator

14. Certified compliance report is issued by RO, MoEF&CC. Regional Office, Bangalore and visit was conducted on 20.01.2021. Bangalore RO, MoEF& CC has issued certified compliance report for the project vide File No. EP/1201/633/KAR/207 & EP/1201/633/KAR/208 dated 11.02.2021. Status of compliance is 'Satisfactory'.

15. The proposal was considered by the EAC in its 31st meeting held on 03rd March, 2021 in the Ministry, wherein the project proponent and their consultant M/s. Samrakshan, presented the EIA/EMP report. The Committee recommended the project for grant of environmental clearance.

16. During deliberations, EAC desired additional information/commitments related to establishment of carbon dioxide recovery plant, spent wash disposal and commitment to switch from bio-composting to incineration/drier technology within 3 years, traffic management details, CER activities to be undertaken in the field of school development after consultation from Principal/management. PP has submitted the desired commitments in compliance to above.

17. The EAC, constituted under the provision of the EIA Notification, 2006 and comprising of Experts Members/domain experts in various fields, have examined the proposal submitted by the Project Proponent in desired form along with EIA/EMP report prepared and submitted by the Consultant accredited by the QCI/NABET on behalf of the Project Proponent. The EAC noted that the Project Proponent has given undertaking that the data and information given in the application and enclosures are true to the best of his knowledge and belief and no information has been suppressed in the EIA/EMP report. If any part of data/information submitted is found to be false/ misleading at any stage, the project will be rejected and Environmental Clearance given, if any, will be revoked at the risk and cost of the project proponent.

18. The Committee noted that the compliance report to be satisfactory, reflecting the present environmental concerns and the projected scenario for all the environmental components. The Committee has also deliberated on the CER plan and found to be addressing the issues in the study area. The EAC has deliberated the proposal and has made due diligence in the process as notified under the provisions of the EIA Notification, 2006, as amended from time to time and accordingly made the recommendations to the proposal. The Experts Members of the EAC have found the proposal in order and have **recommended** for grant of environmental clearance.

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19. The environmental clearance granted to the project/activity is strictly under the provisions of the EIA Notification 2006 and its amendments. It does not tantamount/construe to approvals/consent/ permissions etc. required to be obtained or standards/conditions to be followed under any other Acts/ Rules/ Subordinate legislations, etc., as may be applicable to the project. The project proponent shall obtain necessary permission as mandated under the Water (Prevention and Control of Pollution) Act, 1974 and the Air (Prevention and Control of Pollution) Act, 1981, as applicable from time to time, from the State Pollution Control Board, prior to construction & operation of the project.

20. Based on the proposal submitted by the project proponent and recommendations of the EAC (Industry-2), Ministry of Environment, Forest and Climate Change hereby accords environmental clearance to the project for **Proposed expansion of distillery for production of ethanol capacity from 400 KLPD to 600 KLPD using sugarcane syrup by expanding the sugarcane crushing from 15000 TCD to 20000 by M/s Godavari Biorefineries Ltd. located at Sy. No. 13, 14, 15, 16, 19, 21, 28, 29, 40 of Saidapur Village, Sy. No. 49, 50, 53 of Bisnal Village, Sy. No. 69, 72, 73, & 74 of Madabhai Village at post Sameerwadi, Tal: Mudhol, Dist: Bagalkot, Karnataka-587316**, under the provisions of the EIA Notification, 2006, and the amendments therein, subject to compliance of the terms and conditions as under:-

A. Specific Condition:

- (i). The capacity addition under the instant EC i.e. 200 KLPD, shall be utilized fully for contributing to Ethanol Blending Programme (EBP).
- (ii). The company shall comply with all the environmental protection measures and safeguards proposed in the documents submitted to the Ministry. All the recommendations made in the EIA/EMP in respect of environmental management, and risk mitigation measures relating to the project shall be implemented.
- (iii). The project proponent will treat and reuse the treated water within the factory and no waste or treated water shall be discharged outside the premises.
- (iv). Total fresh water requirement for the proposed project will be 3418 KLPD which will be met from Ghataprabha River. Prior permission shall be obtained from the concerned regulatory authority/CGWA in this regard, and renewed from time to time. No ground water recharge shall be permitted within the premises. Ground water monitoring shall be done regularly and report is to be submitted to concerned authorities regularly.
- (v). The spent wash/other concentrates shall be incinerated and bio-composting shall be switched to incineration/drier technology within 03 years as committed. Spent wash shall be stored maximum for 05 days only in spent wash storage lagoon. Ash/manure shall be packed in 25 kg



bags and transported via covered trolleys and installation of briquetting plant shall be explored for disposal of ash.

- (vi). CO₂ generated from the process shall be bottled/made solid ice and utilized/sold to authorized vendors.
- (vii). Occupational health centre for surveillance of the worker's health shall be set up. The health data shall be used in deploying the duties of the workers. All workers & employees shall be provided with required safety kits/mask for personal protection.
- (viii). Training shall be imparted to all employees on safety and health aspects of chemicals handling. Safety and visual reality training shall be provided to employees.
- (ix). The unit shall make the arrangement for protection of possible fire hazards during manufacturing process in material handling. Fire fighting system shall be as per the norms.
- (x). Process organic residue and spent carbon, if any, shall be sent to Cement other suitable industries for its incinerations. ETP sludge, process inorganic & evaporation salt shall be disposed of to the TSDF.
- (xi). The company shall undertake waste minimization measures as below (a) Metering and control of quantities of active ingredients to minimize waste; (b) Reuse of by-products from the process as raw materials or as raw material substitutes in other processes. (c) Use of automated filling to minimize spillage. (d) Use of Close Feed system into batch reactors. (e) Venting equipment through vapour recovery system. (f) Use of high pressure hoses for equipment clearing to reduce wastewater generation.
- (xii). The green belt of at least 5-10 m width shall be developed in nearly 33% of the total project area, mainly along the plant periphery. Selection of plant species shall be as per the CPCB guidelines in consultation with the State Forest Department. Records of tree canopy shall be monitored through remote sensing map.
- (xiii). As per the Ministry's OM dated 30.09.2020 superseding the OM dated 01.05.2018 regarding the Corporate Environmental Responsibility, and as per the action plan proposed by the project proponent to address the socio-economic and environmental issues in the study area, the project proponent, as committed, shall provide education funds in technical training centers/ support in nearby village's schools, support in health care facilities, drinking water supply and funds for miscellaneous activities like solar street lights, battery, solar panel etc., in the nearby villages. The action plan shall be completed within time as proposed.

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- (xiv). There shall be adequate space inside the plant premises earmarked for parking of vehicles for raw materials and finished products, and no parking to be allowed outside on public places.
- (xv). Storage of raw materials shall be either stored in silos or in covered areas to prevent dust pollution and other fugitive emissions.
- (xvi). Continuous online (24x7) monitoring system for stack emissions shall be installed for measurement of flue gas discharge and the pollutants concentration, and the data to be transmitted to the CPCB and SPCB server. For online continuous monitoring of effluent, the unit shall install web camera with night vision capability and flow meters in the channel/drain carrying effluent within the premises.
- (xvii). A separate Environmental Management Cell (having qualified person with Environmental Science/Environmental Engineering/specialization in the project area) equipped with full-fledged laboratory facilities shall be set up to carry out the Environmental Management and Monitoring functions.

B. General Condition:

- (i) No further expansion or modifications in the plant, other than mentioned in the EIA Notification, 2006 and its amendments, shall be carried out without prior approval of the Ministry of Environment, Forest and Climate Change/SEIAA, as applicable. In case of deviations or alterations in the project proposal from those submitted to this Ministry for clearance, a fresh reference shall be made to the Ministry/SEIAA, as applicable, to assess the adequacy of conditions imposed and to add additional environmental protection measures required, if any.
- (ii) The energy source for lighting purpose shall be preferably LED based, or advanced having preference in energy conservation and environment betterment.
- (iii) The overall noise levels in and around the plant area shall be kept well within the standards 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 the Environment (Protection) Act, 1986 Rules, 1989 viz. 75 dBA (day time) and 70 dBA (night time).
- (iv) The company shall undertake all relevant measures for improving the socio-economic conditions of the surrounding area. CER activities shall be undertaken by involving local villages and administration and shall be implemented. The company shall undertake eco-developmental measures including community welfare measures in the project area for the overall improvement of the environment.



- (v) The company shall earmark sufficient funds towards capital cost and recurring cost per annum to implement the conditions stipulated by the Ministry of Environment, Forest and Climate Change as well as the State Government along with the implementation schedule for all the conditions stipulated herein. The funds so earmarked for environment management/ pollution control measures shall not be diverted for any other purpose.
- (vi) A copy of the clearance letter shall be sent by the project proponent to concerned Panchayat, Zilla Parishad/Municipal Corporation, Urban local Body and the local NGO, if any, from whom suggestions/ representations, if any, were received while processing the proposal.
- (vii) The project proponent shall also submit six monthly reports on the status of compliance of the stipulated Environmental Clearance conditions including results of monitored data (both in hard copies as well as by e-mail) to the respective Regional Office of MoEF&CC, the respective Zonal Office of CPCB and SPCB. A copy of Environmental Clearance and six monthly compliance status report shall be posted on the website of the company.
- (viii) The environmental statement for each financial year ending 31st March in Form-V as is mandated shall be submitted 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 clearance conditions and shall also be sent to the respective Regional Offices of MoEF&CC by e-mail.
- (ix) 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/Committee and may also be seen at Website of the Ministry and at <https://parivesh.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 shall be forwarded to the concerned Regional Office of the Ministry.
- (x) 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 the project.
- (xi) This Environmental clearance is granted subject to final outcome of Hon'ble Supreme Court of India, Hon'ble High Court, Hon'ble NGT and any other Court of Law, if any, as may be applicable to this project.

21. The Ministry reserves the right to stipulate additional conditions, if found necessary at subsequent stages and the project proponent shall implement all the said conditions in a time bound manner. The Ministry may revoke or suspend the

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environmental clearance, if implementation of any of the above conditions is not found satisfactory.

22. Concealing factual data or submission of false/fabricated data and failure to comply with any of the conditions mentioned above may result in withdrawal of this clearance and attract action under the provisions of Environment (Protection) Act, 1986.

23. Any appeal against this environmental clearance shall lie with the National Green Tribunal, if preferred, within a period of 30 days as prescribed under Section 16 of the National Green Tribunal Act, 2010.

24. 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 Hazardous Waste (Management, Handling and Transboundary Movement) Rules, 2016 and the Public Liability Insurance Act, 1991 read with subsequent amendments therein.

25. This issues with the approval of the competent authority.

Ashok Kr. Pateshwary
09/04/2021

(Ashok Kr. Pateshwary)
Director

Copy to: -

1. The Secretary, Department of Forest, Environment & Ecology, Government of Karnataka, Room No. 708, Gate 2, Multi Storey Building, Dr. Ambedkar Veedhi, Bangalore - 1
2. The Deputy DGF (C), MoEF&CC Regional Office (SZ), Kendriya Sadan, 4th Floor, E&F Wings, 17th Main Road, Koramangala II Block, Bangalore - 34
3. The Member Secretary, Central Pollution Control Board, Parivesh Bhawan, CBD-cum-Office Complex East Arjun Nagar, Delhi - 32
4. The Member Secretary, Karnataka State Pollution Control Board, Parisara Bhavan, #49, 4th& 5th Floor, Church Street, Bangalore -1
5. Monitoring Cell, Ministry of Environment, Forest and Climate Change, Indira Paryavaran Bhawan, Jor Bagh Road, New Delhi
6. The District Collector, District Bagalkot, Karnataka
7. Guard File/Monitoring File/Parivesh portal/Record File

Ashok Kr. Pateshwary
09/04/2021

(Ashok Kr. Pateshwary)
Director

E-mail: ak.pateshwary@gov.in
Tel. No. 24695290