



**CII – ENVIRONMENTAL BEST PRACTICES
AWARD - 2023**

**GREEN SUPPLIER DEVELOPMENT PROGRAM
(GSDP)**

**Rialto Enterprises Private Limited,
Chennai**

21st June 2023

GREEN SUPPLIER DEVELOPMENT PROGRAM (GSDP)



***Phase – 1
Mar'22 – Feb'23***

What is Green Supplier Development Program (GSDP)?

Being an environmentally conscious & GreenCo platinum-rated company, We started to

- Handhold all its supplier partners toward Green Journey
- Which focuses on Energy & Water Conservation, Greenhouse Gas Emission Reduction, Material Conservation & Waste management

OVERALL INTENT

- To evaluate the environmental performance of Supply Partners
- Support them to further improve their performance
- Support them in evaluating their Emissions
- To make sure that the stakeholder fulfills all the legal regulation
- To recognize the best supplier, encouraging by giving the “**Green Supplier Award**”

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GSDP – “PHASE 1”

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SUPPLIER

Rialto launched the GSDP Phase – 1 on March 2022, to support its identified “7 Selected Supply Partners”, which is having a major environmental impact



FIRST REVIEW VISITS

Rialto handholds each supply partner by

1. Training Program with best case studies
2. Site Visit - Baseline development in each area like energy, water, etc.,
3. GHG Assessment
4. Strengthen the compliance
5. Implementation Phase
6. Review Visit
7. Final site assessment

SL NO.	SUPPLIER	1ST ROUND OF REVIEW*
1	SSF Plastics, Hosur	1-06-2022
2	Bright Brothers, Pondy	28-05-2022
3	Excel Plast, Coimbatore	31-05-2022
4	Panoply Packaging, Chennai	26-05-2022
5	Breech Oral care, Vadodara	3-06-2022
6	Ecoplast Industry, Faridabad	4-05-2022
7	Suba Plastics, Coimbatore	30-05-2022

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HANDHOLDING VISITS

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Suba Plastics, Coimbatore



SSF Plastics, Hosur



Bright Brothers, Pondy



Panoply Packaging, Chennai



Excel Plast, Coimbatore



Breach Oral Care, Vadodara

Focus on Energy Conservation, Renewable energy addition, GHG Mitigation, Waste reduction, etc.,

GREEN SUPPLIER DEVELOPMENT PROGRAM

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AUDIT RECOMMENDATIONS

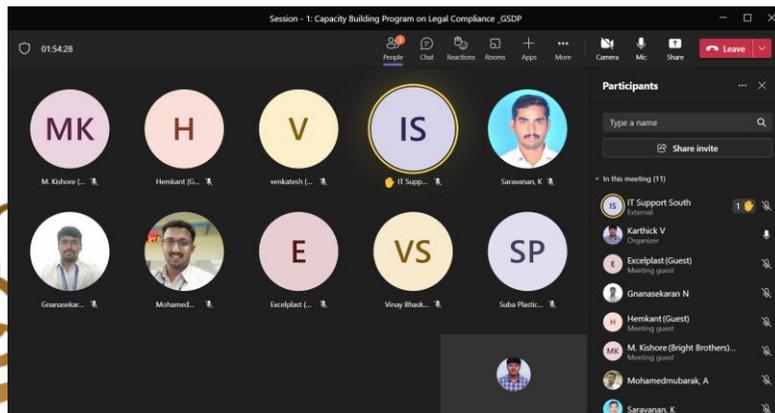
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S.No	Improvement Points
Energy Efficiency	
Compressor	
1	Provide duct to the ELGI 18 Compressor to send out the hot air out of the compressor room. Hot air intake to the compressor increases the power consumption of the compressor
2	Study the performance of the compressor by conducting a FAD test, also check the VFD performance as well
3	Conduct periodic leakage test (once a fortnight) and keep the air leak below 5%.
4	It is recommended to modify the existing concealed/underground airlines to ring main system with aluminium pipes
Motors & Heaters	
5	Plan to replace the remaining ceramic heaters with Infrared Heaters/Induction heaters in a phased manner
6	Inventorise the old EFF2/IE2 motor and replace it to IE3/IE4 motor in a phased manner. Cooling pump motors, power pack motor, etc.,
7	Conduct a feasibility study for installing VFD to the cooling water main circulation pump
8	Similarly, an interlock can be provided for the cooling tower fan. The fan should run only if the temperature difference(inlet & outlet) is more than 2 deg Celcius
9	Explore energy efficient IE3/IE4 motors for cooling pumps (Hot well & Cold well pump)
Metering System	
10	Metering of all major energy consumers like compressors, Moulding machines, AHU units, etc., (meters should be compatible with RS 485 port to connect it with online monitoring)
11	Explore online monitoring of Energy Consumption for all major energy consumers
12	While purchasing new Injection Moulding machines and for plant expansions considers only "All-Electric Injection Moulding Machines", It consumes less power when compared to conventional Induction machines/Servo Machines
13	Replace the conventional air circulators (almonard fan) with BLDC air circulators. Consumes 30% less power than conventional fans
Renewable Energy	
14	Set targets to increase the Renewable energy share of the facility. Plan to cover 100% of the roof area with Solar PV

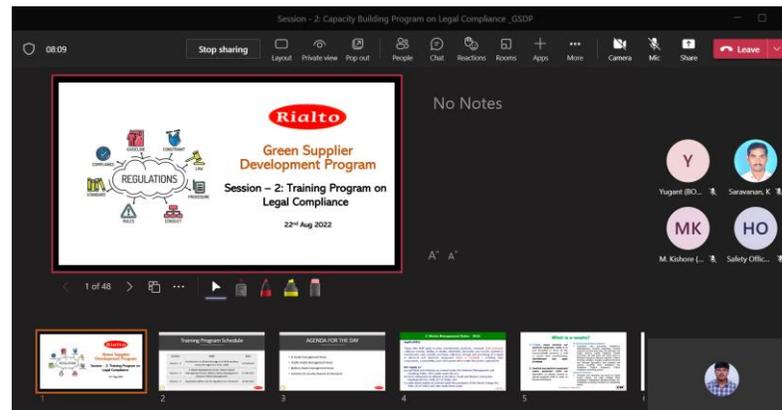
S.No	Improvement Points
Water & Wastewater treatment	
15	Arrive at the detailed water balance diagram of the facility
16	Install low flow taps/Aerators in the canteen washing area and washrooms
17	Explore reusing the treated water back for urinal flushing operations - this will reduce the freshwater consumption
18	Study the performance of the STP plant. 1. Check the capacity of sewage generated/day and STP capacity 2. Install EMF meter and maintain the STP treated water discharge details
19	Connect all the rainwater harvesting lines from the roof area to sump through filter, to store and reuse the water back for other applications. It can also be diverted to the raw water sump as well(near cooling tower)
20	Calculate the Rainwater Harvesting Potential - quantity of rainwater collected every year
21	It is recommended to install water meters and monitor the water consumption of the facility, like - Process water consumers like chilled water, cooling tower makeup, etc., - Domestic Water consumption – Canteen, Washrooms, Handwash, etc., - Gardening water Consumption - lit/sqm/day STP outlet should have a EMF meter
22	Consider installing a dishwasher machine for plate washing application to reduce the water consumption of the facility
23	Use drip Irrigation instead of open-end hose for gardening to save water
Waste Management	
24	Hazardous waste area should be covered on all 4 sides, and should have primary & secondary containment - Display form 3 in front of the Hazardous waste yard
25	Ensure disposal of hazardous waste once in 90 days and E waste in 180 days as per compliance
26	Provide source segregation bins inside & outside the shop floor to segregate the waste at source
Material Handling	
27	It is recommended to make a rack arrangement system in stores FG (handles), raw materials separately
Certifications & Other	
28	Renew the expired ISO 9001 QMS certification
29	Display the policy in the local language at prominent locations inside the factory
30	Increase the display poster about the conservation of Energy, Water, Source segregation of Waste, etc.,
31	Purchase Green Chemicals instead of conventional chemicals, for floor cleaning, washroom cleaning, etc., Similarly for paints as well
32	A separate fire hydrant sump should be available along with the DG operated fire pump for back up.

TRAINING & CAPACITY BUILDING PROGRAM

Session	Topic	Date
Session - 1	Energy Efficiency, Renewable Energy, Water Conservation & Best Practices	17.05.2023
Session - 2	GHG Accounting	17.05.2023
Session - 3	Introduction to Waste Management & Hazardous waste Management Rules 2016	17.08.2022
Session - 4	E-Waste Management Rules, Plastic Waste Management Rules, Biomedical Waste, Liquid & Gaseous Waste Management	22.08.2022
Session - 5	Applicable safety rules & regulation for Industries	26.08.2022



On Waste Management – Hazardous waste and Best Practices



On E-Waste, Battery, Plastic Waste Management



On Legal Compliance

The logo for Rialto, consisting of the word "Rialto" in white serif font inside a red oval.

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IMPLEMENTATION PHASE

1. BREECH ORAL CARE, VADODARA

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Greenco Silver



ISO 9001, 14001 Certified



Installed STP Plant – 30 KLD



100% LED lighting replaced



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VFD For Cooling Tower



Retrofitted Infrared Heater – 4 No's On Pilot Basis



Replaced conventional pump with EE IE3 pump – 7.5 kW



Replaced conventional Exhaust fans EE Exhaust fans- - 4 No's



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1. BREECH ORAL CARE, VADODARA

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Installed Piezometer to monitor the Ground water level



Installed Online monitoring system for Water Consumption – 5 No's



Installed Occupancy Sensor in office



Installed Solar Street Lights



Solar Plant – 200 kWp



Source Segregation of Waste



Reusable boxes for backer card movement



Other Green Initiatives:

- Servo Retrofit for Injection Moulding
- Energy Efficient IE4 Compressors
- GHG Inventorisation
- Signed agreement for Open Axes solar power purchase for the new factory

Summary of the environmental benefits achieved

Electrical energy savings	264896	kWh
Thermal energy savings	3.1	kL of fuel
GHG emission mitigation	216.5	MT of CO2 eq.
Water conservation	6160	kL of water
Total investment made	37.64	Rs Lakhs
Monetary savings	25.76	Rs Lakhs

2. SSF PLASTICS, HOSUR

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Installation of low flow taps – 35 No's

Mutiplast Machine servo Retrofit 4 M/c. on a pilot basis

100% LED Lights

Lighting System

Timer Switch for Street lights

Occupancy Sensor



Induction Heaters for Moulding Machine



4 No's AC Energy Saver – 21% saving

Solar & Wind power purchases to 85% in 2022-23 (Earlier it was 6%)

2. SSF PLASTICS, HOSUR

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VFD to the Hydraulic Motor



Compressors- line isolation in B4 and B3 based on the Pressure requirements



Centralised compressor for B3 & B4



GreenPro Certified - House Keeping Chemicals

EV for Company transportation



Sprinklers for Garden



EMF Meters for Water monitoring



Construction of Sludge Bed for STP

2. SSF PLASTICS, HOSUR

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5 Ply to 3 Ply Carton Box

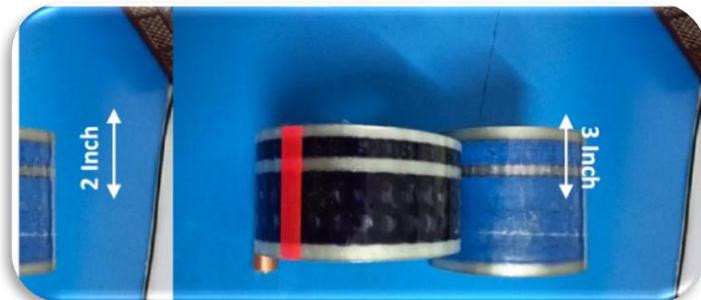
Bopp Tape 3 inch to 2 inch

BEFORE

AFTER

BEFORE

AFTER



STB BOX NEW PACKING STANDARD

TOP OLD PS

TOP NEW

BOTTOM OLD PS

BOTTOM NEW



Before

After

Before

After

Qty. Per Box 99No's (33*3)
2 Separator and 13 set of Partition

Qty. Per Box 120 No's (40*3)
2 Separator and No's Partition

Qty. Per Box 198No's (66*3)
2 Separator and 13 set of Partition

Qty. Per Box 224 No's (112*2)
2 Separator and 2 No's Partition

25% of unit quantity increased per truck MOQ

Awareness creation to Employees



2. SSF PLASTICS, HOSUR



Miyawaki Forest of 300 saplings, 53 species in 4100 sqft on Environment Day celebration on June 5th 2022.

Other Initiatives

1. Cooling tower fan PID
2. In-house merging conveyor production of EBM machine
3. GHG Inventorisation

Summary of the environmental benefits achieved		
Electrical energy savings	821703	kWh
GHG emission mitigation	2944.3	MT of CO2 eq.
Water conservation	4200	kL of water
Resource conservation	234	MT of material
Renewable energy addition	2000	kWp of RE
Waste Reduction	8900	kgs of waste
Total investment made	48.6	Rs Lakhs
Monetary savings	69.8	Rs Lakhs

3. SUBA PLASTICS, COIMBATORE

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Construction of Waste Management Yard



Source Segregation of different waste



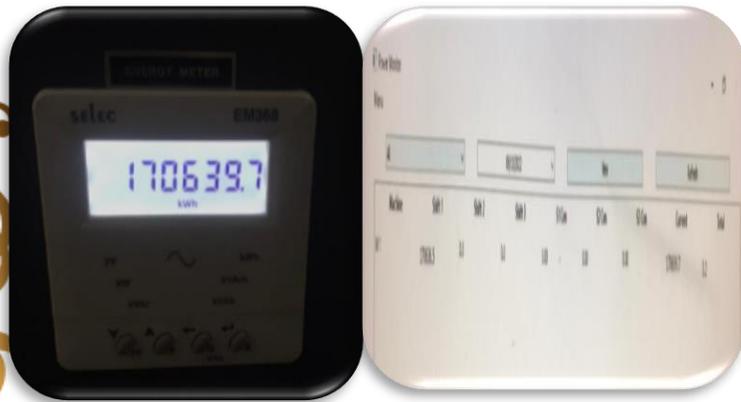
ISO 9001, 14001 & 45001 Certified



Installation of Water Meters for major locations



Online Monitoring System



Solar PV – 11 kWp



Bio Composting Bins for Food Waste



3. SUBA PLASTICS, COIMBATORE

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Roof Area



Paved Area

Installed 250 kWp Solar Roof Top plant – 100% roof covered



Rainwater Harvesting system to capture the roof and non-roof area



Avoid running DG by switching monthly shutdown with weekly off – saving 9020 KL/month



Installed BIO STP plant to Treat the Sewage waste

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3. SUBA PLASTICS, COIMBATORE

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Mass Tree Plantation
drive along with
Forest Department
5th June 2022



Other Green initiatives

1. Timer switch for Street lights
2. GHG Inventorisation
3. Awareness Program to Employees
4. Purchase of Green Certified Chemicals

Summary of the environmental benefits achieved

Electrical energy savings	96028.0	kWh
Thermal energy savings	32.4	kL of fuel
GHG emission mitigation	161.5	MT of CO2 eq.
Water conservation	54.0	kL of water
Renewable energy addition	250	kWp of RE
Waste Reduction	743	kgs of waste
Total investment made	5.1	Rs Lakhs
Monetary savings	23.7	Rs Lakhs

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4. BRIGHT BROTHERS LIMITED, PONDICHERRY

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**Environmental
Policy**



**13 nos - 2LPM Aerator type
tap replaced**



**ISO 9001, 14001 & 45001
Certified**



**Installed 8 no's
EMF Meter**



Compressed air transportation

**Replaced underground GI Pipes with over-the-
surface PPR Pipes**



**12 No's Energy Efficient Infrared
Heaters – 25% savings**



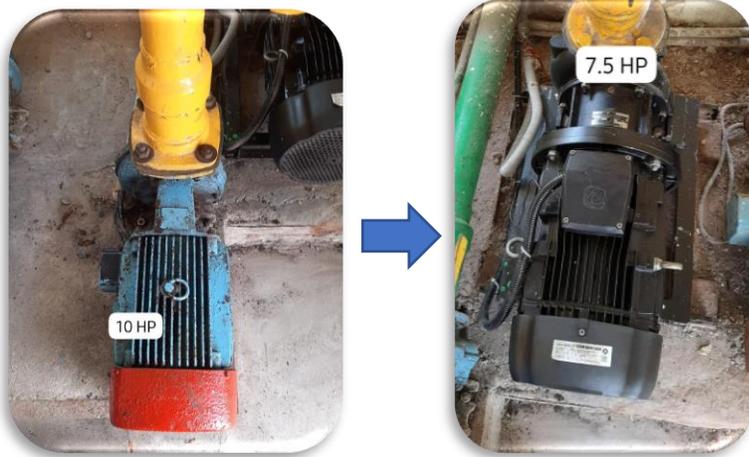
**Source Segregation of
different waste**



4. BRIGHT BROTHERS LIMITED, PONDICHERRY



Downsized the water circulation pump



Units savings per day	85
Units savings per month	2550
Units savings per year	30,600

VFD for Water Circulation pump – Avoided Recirculation



Unit savings per day	65
Unit savings per month	1950
Unit savings per year	23400

Installed VFD for Compressor & Power pack



4. BRIGHT BROTHERS LIMITED, PONDICHERRY



Modified the existing Waste management Yard as per PCB compliance



Installed Solar Street Lights



Other Green initiatives

1. Screw Barrel Size reduction
2. GHG incentivisation
3. Awareness Program to Employees
4. Tree Plantation Drive

Summary of the environmental benefits achieved		
Electrical energy savings	158502	kWh
GHG emission mitigation	82.6	MT of CO2 eq.
Resource conservation	7.123	MT of material
Total investment made	17	Rs Lakhs
Monetary savings	16	Rs Lakhs

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5. EXCEL PLAST, COIMBATORE

GREEN SUPPLIER

Environmental Policy

EXCEL PLAST ENVIRONMENT AND SUSTAINABILITY POLICY

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Polycarbonate sheet to avoid daytime power consumption



Installed Energy meters to account the Energy consumption



Installed BLDC Fans – 6 Nos



Low flow Water fixtures



Installed Bio-Septic tank to treat sewage



Rainwater Harvesting at the facility



Energy Savers for AC's



5. EXCEL PLAST, COIMBATORE



Constructed Hazardous waste storage yard



Purchased Electric bike for company internal movements



Summary of the environmental benefits achieved

Electrical energy savings	1278	kWh
Water conservation	3759	kL of water
Total investment made	3.5	Rs Lakhs
Monetary savings	0.30	Rs Lakhs

Other Green initiatives

1. GHG inventorisation
2. Tree Plantation Drive
3. Source Segregation of waste

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6. PANOPLY PACKAGING, CHENNAI



Construction of Waste Management Yard



Water Saving aerators



Installed BLDC Fans – 16 No's



More than 80% of Renewable Energy Share



Water meters installed for major areas



FSC certified

Installed 400 kWp of solar Roof Top

Use of Briquette (Renewable energy) as a Boiler Fuel

6. PANOPLY PACKAGING, CHENNAI



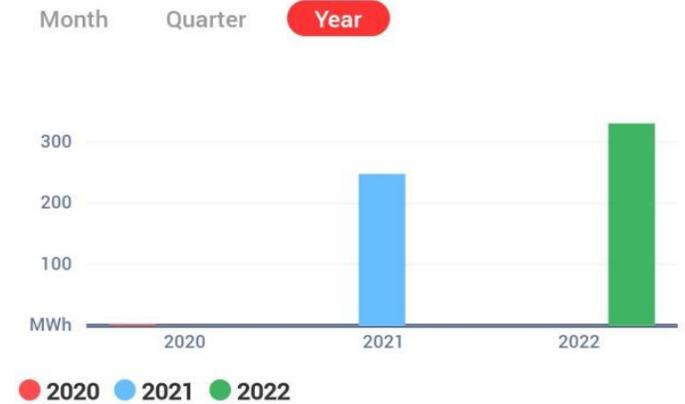
Installed Online Monitoring software for Energy Monitoring



16 No's – Energy Meters installed

Monitoring of Solar Generation

Comparative Production



Other Green initiatives

1. Energy-Efficient IE4 Screw Compressors
2. Condensate Recovery from Steam and reusing for pre heating
3. GHG Inventorisation
4. Reuse of the Captured Rainwater for day-to-day consumption

Summary of the environmental benefits achieved

Electrical energy savings	25920	kWh
GHG emission mitigation	319.89	MT of CO2 eq.
Water conservation	200	kL of water
Renewable energy addition	400	kWp of RE
Total investment made	139.7	Rs Lakhs
Monetary savings	34.4	Rs Lakhs

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7. ECO PLAST INDUSTRY, HARYANA

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Installed Energy Meters for all major consumers



Installed High Density Heaters for Machines



Replaced Reciprocating compressor with Screw Compressor



Replaced Diesel forklift to Electric



Installed Energy Efficient IE3 motors for Machines



Daylighting Arrangement made at shop floor



Push Taps replaced to save water



7. ECO PLAST INDUSTRY, HARYANA



Captured Rainwater is stored and reused back for day-to-day activities



Storage Tank

Hazardous waste storage Yard



Switch to CNG vehicle for transportation



Other Green initiatives

1. Purchasing Green Housing chemicals
2. Awareness creation to employees
3. Packaging material Reduction Initiatives

Summary of the environmental benefits achieved

Electrical energy savings	13806	kWh
GHG emission mitigation	14.6	MT of CO2 eq.
Water conservation	9300	kL of water
Resource conservation	0.4	MT of material
Waste Reduction	3050	kgs of waste
Total investment made	80.3	Rs Lakhs
Monetary savings	9.9	Rs Lakhs

The best practices of one supplier are circulated to others by monthly bulletins

Bulletin #1
The CATALYST
GO GREEN
Simple solutions for Sustainability
11th July 2022

Importance of Green Products

Did you know that air pollution can also happen indoors?

Yes, 2 to 5 times indoors has more pollutants than outdoor. Carpets, cleaning agents (like phenols, acids), furniture & even the paint we use give off air pollutants such as volatile organic compounds (VOCs). They can cause physical reactions to your body in many ways, and you can reduce your exposure to them by opting for low-emitting materials.

Volatile Organic Compounds (VOCs) such as formaldehyde, are found in many building supplies and household products

Airborne particles From dust, pollen, mold, smoke, and other sources	Indoor formaldehyde From building materials, furniture, carpets, and smoking	Household odors & gases From activities such as painting, cooking, and smoking	Ozone From outdoor air (reacts to sunlight to form smog)	Carbon Dioxide From people, vehicles, and cooking
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Exposure to high levels of formaldehyde and other VOCs causes physical reactions like

Most people can alleviate these symptoms by minimizing exposure and increasing air ventilation and circulation in their homes

We can also do our part by using products that are free from such pollutants

Use of Low VOC Paints – lead & chrome free paints
Use Green Housekeeping material
Indoor Gardening helps to absorb these VOCs

"At Rialto, we use Low/Ultra-low VOC paints and Green Certified Housekeeping Chemicals"

Look for **GreenPro (or) Green Seal** certified products for Paints & housekeeping chemicals

1. Importance of Green Products

Bulletin #2
The CATALYST
GO GREEN
Simple solutions for Sustainability
18th Aug 2022

Plastic Injection Moulding Technologies

The major energy-consuming equipment in the plastic manufacturing process is Injection moulding machines. Today's plastic injection moulding machine technology is far more energy efficient. Injection Moulding machines are classified primarily by the type of driving systems they use, including (a) Hydraulic injection moulding machines, (b) Servo Hydraulic injection moulding machines (c) Electric injection moulding machines (d) Hybrid injection moulding machines.

Technology	Share in the market (%)
Hydraulic Plastic Injection Moulding	50-60
Servo Hydraulic Plastic Injection Moulding	30-40
Electric Plastic Injection Moulding	>10; Very low penetration in the Indian market
Hybrid Technology	Marginal/no penetration in India market, available only in the European market.

All-Electric Injection Moulding Machine

% Share at operation in Indian Market

Energy performance has been one of the important parameters for shortlisting the technology for plastic production. The specific energy consumption (kWh/ton of product) vary from process to process because of variation in multiple parameters. Different injection moulding machines consume vastly different amounts of energy, based on the size of their clamping mechanisms, screw, heater, and pumps.

Technology	kWh/kg *
Hydraulic Plastic Injection Moulding	0.60-0.70
Servo Hydraulic Plastic Injection Moulding	0.40-0.48
Electric Plastic Injection Moulding	0.25-0.30

However, based on the survey made by a Not-for-Profit organization (NPO) along with various stakeholders like consultants, Machine Manufacturers, Plastic product manufacturers, and various case studies from the energy audit of NPO, the estimated specific energy consumption of injection moulding technologies is given in the table.

* Specific Energy Consumption of different Injection moulding machines

2. Plastic Injection Moulding Technologies

Bulletin #3
The CATALYST
GO GREEN
Simple solutions for Sustainability
24th Sep 2022

Tips to Reduce Your Energy Bill

With the recent tariff revision from the Tamilnadu Electricity Regulation Commission (TNERC), the monthly electricity bill for the industries has increased. Industries were trying to reduce their electricity bill by taking several initiatives like switching to energy-efficient equipment, avoiding idle running of machines, avoiding losses, etc., to reduce the monthly electricity bill.

Details	Normal Hour Consumption	Peak Hour Consumption	Night Hour Consumption
Period of the day	10 AM TO 6 PM, 5 AM TO 6 AM	6 AM TO 10 AM, 6 PM TO 10 PM	10 PM TO 5 AM
Tariff	Normal Tariff	25% Extra	5% rebate
Electricity Charges (Rupees)	6.75	8.44	6.41
Demand Charges	INR 550 / KVA		

Revised TNERC tariff from for HT Consumers w.e.f Sep 2022

There are several ways that you can take to lower your electricity cost. While electricity bills are dependent on many factors, one major part is the amount of electricity consumed and when it is being consumed. Below are some of the simple ways to reduce the electricity bill without reducing the overall electricity consumption.

Any planned machine stoppage/ Schedule maintenance can be taken during the peak hours, during 6 – 10 AM & 6 – 10 PM

Maximum utilization of machine during the night & non-peak hours

Transfer your load to non-peak hours - Fixed load can be run during the night or non-peak hours. Eg. Filling the water sumps, Fire Sumps, use of Housekeeping machines, etc.

Power purchase from 3rd party through IEX

Ensure the maximum recorded demand is close to the contract demand with the Electricity board – Install a Demand controller to control reaching the maximum demand

Maintain Power factor close to unity. If required install the APFC unit

Holiday can be declared during the EB Monthly shutdown, instead same week Sunday can be made a working day to reduce the Diesel consumption in DG

Switch to renewable sources of energy – daytime consumption can be offset

3. Tips to Reduce Your Energy Bill

GSDP
PHAS -1 OUTCOMES

After the GSDP Phase – 1 Program, Supply partner performance were improved

- ***Energy Efficiency***
- ***Water Conservation***
- ***Waste Management & Material Conservation***
- ***Strengthen the Compliance***
- ***Capacity build the team***



ASSESSMENT PROCESS FOR
“GREEN SUPPLIER AWARDS”

ASSESSMENT PROCESS FOR GREEN CHAMPION AWARDS



- How companies proactively take action to mitigate the environmental impacts
- GreenCo Lite checklist (500 Points)
- Supply partners were evaluated based on the 500-point scale around 8 parameters

S.No	Evaluation Criteria	Score Distribution
1	Basic Environmental Certifications - ISO, FSC, GreenCo, others	155
2	Energy Efficiency - Improvement activities	50
3	Water Conservation activities	35
4	Waste Management Initiatives	55
5	Greenhouse Gas Management	70
6	Material Conservation	50
7	Compliance to Statutory requirements	35
8	Community Impact - CSR, Tree Plantation, etc.,	50
Total Score for Supplier Evaluation		500

GREEN SUPPLIER DEVELOPMENT PROGRAM (GSDP)

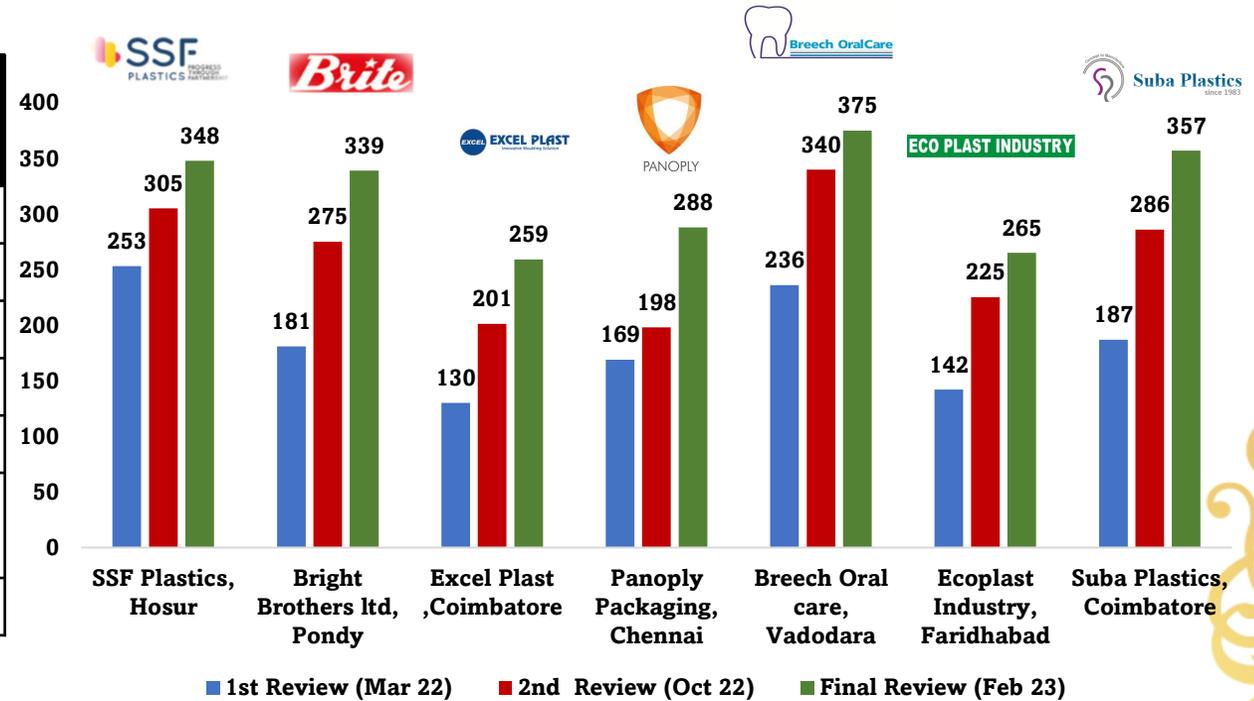
PHASE – 1 OUTCOMES



Scores Obtained by the Supplier



Supplier	1st Review (Mar 22)	2nd Review (Oct 22)	Final Review (Feb 23)
SSF Plastics, Hosur	253	305	348
Bright Brothers Ltd, Pondy	181	275	339
Excel Plast ,Coimbatore	130	201	259
Panoply Packaging, Chennai	169	198	288
Breech Oral care, Vadodara	236	340	375
Ecoplast Industry, Faridhabad	142	225	294
Suba Plastics, Coimbatore	187	286	357



SUPPLIER SHOWED AN AVERAGE IMPROVEMENT OF 42%

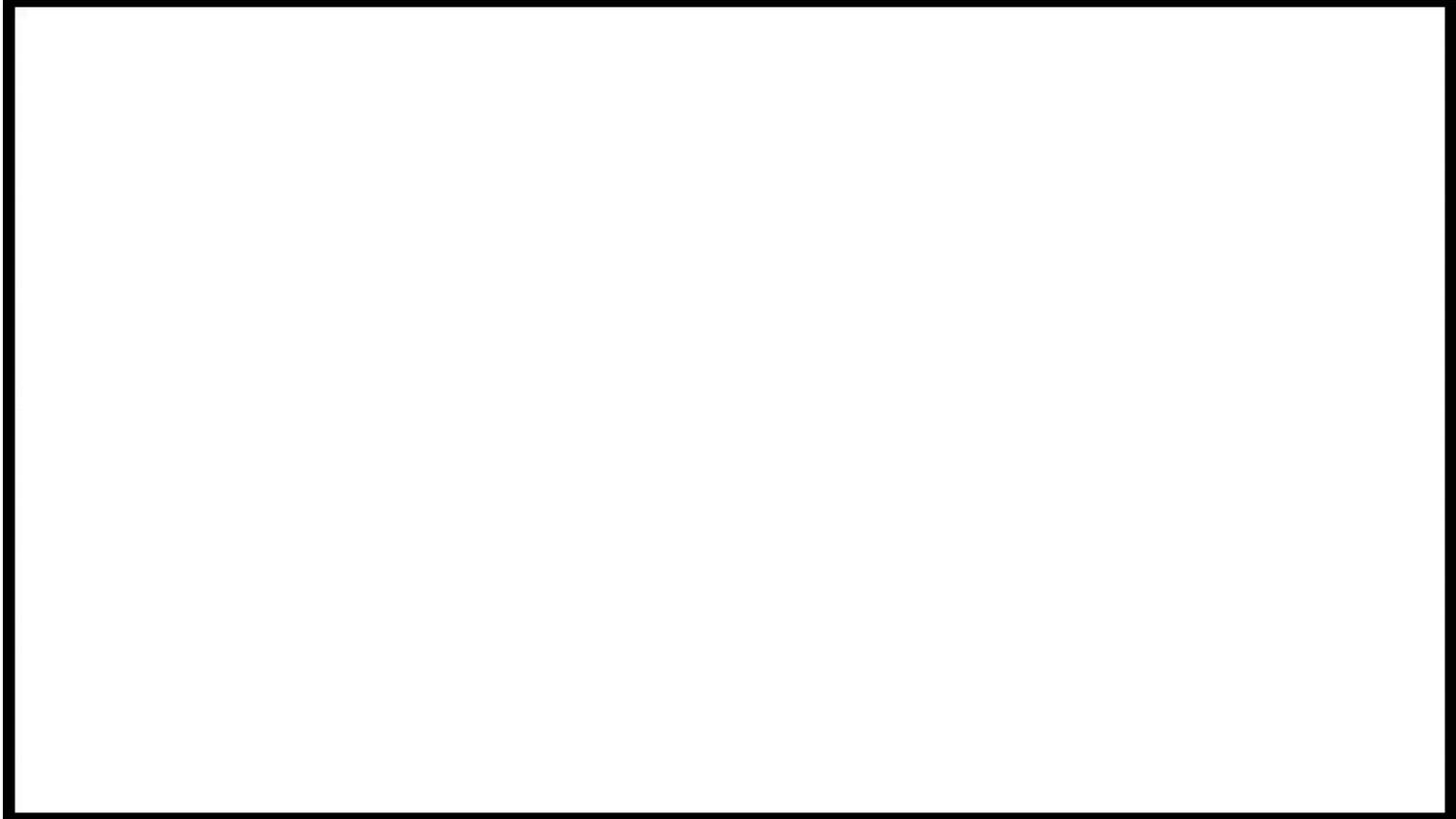
GSDP – Phase – 1: OUTCOMES

	Cumulative achieved	Achieved
Electrical energy savings	13,80,855	kWh
Thermal energy savings (Diesel & CNG)	35.5	kL of fuel
GHG emission mitigation	3739.4	MT of CO2 eq.
Renewable energy Addition	2411	kWp of RE
Water Conservation	19914	kL of water
Resource conservation	241.5	MT of material
Waste Reduction	12693	kgs of waste
Total investment made	340 (453 M\$)	Rs Lakhs
Monetary savings	175.6 (228 M\$)	Rs Lakhs
ROI	2	years



RECOGNITION - GSDP SUPPLIER AWARDS – 2023

GSDP
SUPPLIER
AWARDS -
2023



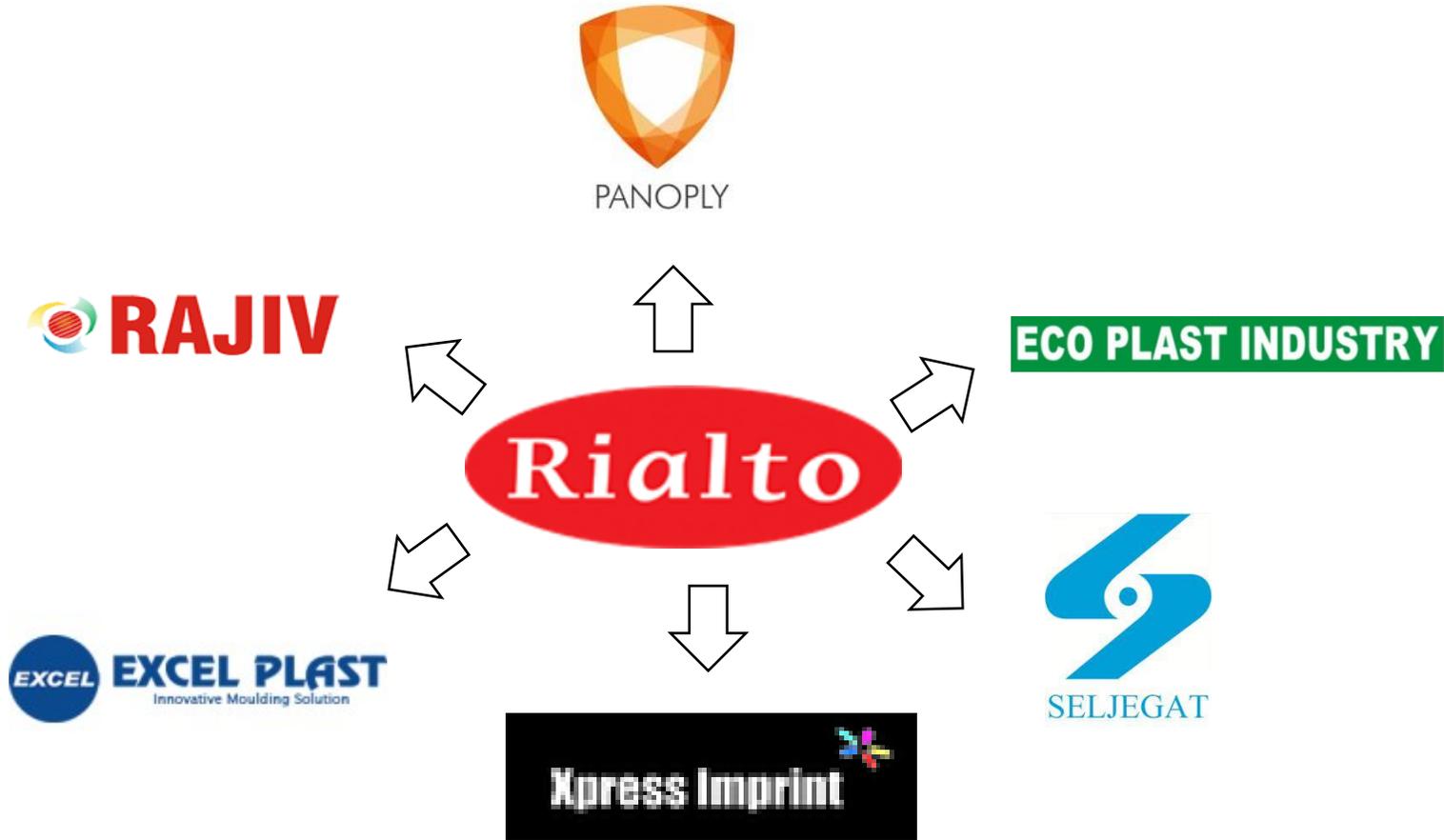
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GSDP – “PHASE 2”



Suppliers already identified for Phase – 2 Program



Period:
July 23 to
June 24



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OUR CONTINUOUS IMPROVEMENT
JOURNEY CONTINUES.....

Thank You