

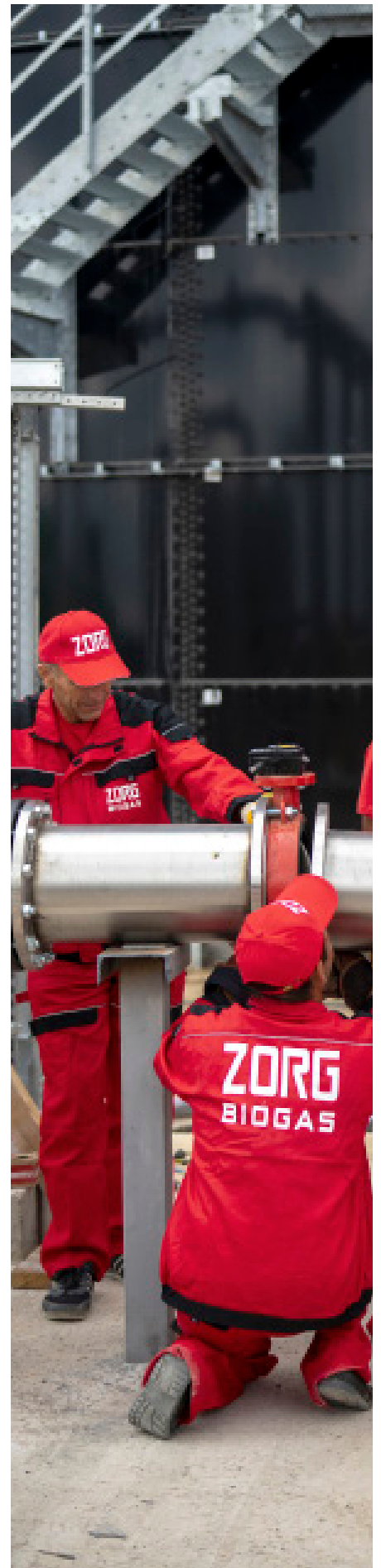
# Proposal

BioCNG plant 20 tpd using Napier grass



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## OVERVIEW

We offer a solution to process napier grass into biogas in the single high-load reactor (HLR). The proposed HLR technology is superior to the conventional CSTR . HLR is 3 times smaller and cheaper than CSTR. For 20 tonnes methane a day capacity just 2 HLR is enough.

Zorg makes the detailed engineering, supplies equipment and provides supervision during construction as well as training and start-up.

The construction and installation are done by Customer under Zorg' supervision and quality control. The construction costs are already included in the total budget.

The amount of Napier grass and the volume of the reactors depend on the quality of the grass and the harvesting age.

For a grass with 33% total solid, that is harvested in 120 days, it's enough 240 tonnes grass a day and reactors  $V=4245 \text{ m}^3 \times 2$  units.

For the grass 27% TS, harvested in 80 days, the amount of grass is 293 tonnes a day and reactors  $V=5281 \text{ m}^3 \times 2$  units are required.

If you are not sure about the quality of the grass you may chose bigger reactors  $V=5281 \text{ m}^3 \times 2$

Note, that if you opt with the bigger reactors, but the grass will be of a better quality, you may get up to 25-27 tpd bioCNG from the same plant. 20 tpd bioCNG is the the guaranteed minimum.

**Raw material potential from the Napier grass 33% total solid (ca. 120 day-harvest)**

Substrate	Quantity (tonnes/day)	Quantity (tonnes/year)	TS content: (%)	VS content (%)	TS quantity (tonne s/ day)	VS quantity (tonnes / day)	Biogas yield (m <sup>3</sup> / tonneVS)	Biogas (m <sup>3</sup> /day)	Methane content (%)	Biomethane (m <sup>3</sup> / day)
Napier grass	240	87 600	33	96	79.20	76.03	690	52 462	52	27 445

**Raw material potential from the Napier grass 27% total solid (ca. 80 day-harvest)**

Substrate	Quantity (tonnes/day)	Quantity (tonnes/year)	TS content: (%)	VS content (%)	TS quantity (tonne s/ day)	VS quantity (tonnes / day)	Biogas yield (m <sup>3</sup> / tonneVS)	Biogas (m <sup>3</sup> /day)	Methane content (%)	Biomethane (m <sup>3</sup> / day)
Napier grass	293.3	107 065	27	96	79.20	76.03	690	52 462	52	27 445

## Biogas plant characteristics

Characteristics	Values	Figures
Number of reactors	units	2
Reactor Napier grass 33% total solid		
a) volume:		
Work	m <sup>3</sup>	3979
Overall	m <sup>3</sup>	4245
b) Organic load	kgODM/ m <sup>3</sup>	9.55
c) Hydraulic retention time (gross)	days	35/33
d) Overall dimensions of the reactor (diameter / height)	m	26.0/8.0
e) Temperature	°C	+52
Reactor Napier grass 27% total solid		
a) volume:		
Work	m <sup>3</sup>	4951
Overall	m <sup>3</sup>	5281
b) Organic load	kgODM/ m <sup>3</sup>	7.68
c) Hydraulic retention time (gross)	days	36/34
d) Overall dimensions of the reactor (diameter / height)	m	29.0/8.0
e) Temperature	°C	+52
Gasholder (external)		
a) Volume	m <sup>3</sup>	1500
b) Number of gasholders	units	1
c) Dimensions of the gasholder (diameter / height)	m	15.4/11.8

## Number of personnel

	Shift 1	Shift 2	Shift 3
Director	1	-	-
Operator	1	1	1
Driver	1	-	-
Electrician	1	-	-
Mechanic	2	-	-
Total	7		



## Biogas plant working principle

The technology is based on the biochemical conversion of organic materials from high molecular weight compounds to low molecular weight compounds. The first stage of this process is hydrolysis. Hydrolysis produces organic acids and alcohols. Organic compounds + H<sub>2</sub>O → C<sub>5</sub>H<sub>7</sub>N<sub>2</sub>O<sub>2</sub> + H<sub>2</sub>CO<sub>3</sub>.

Further conversion of obtained dissolved compounds like organic acids and alcohols (C<sub>5</sub>H<sub>7</sub>N<sub>2</sub>O<sub>2</sub>, H<sub>2</sub>CO<sub>3</sub>) into gases - CH<sub>4</sub>, CO<sub>2</sub>. C<sub>5</sub>H<sub>7</sub>N<sub>2</sub>O<sub>2</sub> + H<sub>2</sub>CO<sub>3</sub> + H<sub>2</sub>O → CH<sub>4</sub> + CO<sub>2</sub> + NH<sub>4</sub>.

Biological process of consecutive (phasic) conversion of organic compounds take place in anaerobic environment i.e. in oxygen-free tank (biological reactor). At the first stage of fermentation, substrate hydrolysis take place under acidogenic bacteria influence. At the second stage, elementary organic compounds come through hydrolysis oxidation by means of hetero-acidogenic bacteria with production of acetate, carbon dioxide, and free hydrogen. The other part of the organic

compound including acetate forms C<sub>1</sub> compounds (elementary organic acids). Produced substances are the feedstock for methanogenic bacteria of the third type. This stage flows in two processes of A and B type the character which depends on caused by different bacteria type. These two types of bacteria convert the compound obtained during the first and second stages into methane CH<sub>4</sub>, water H<sub>2</sub>O and carbon dioxide CO<sub>2</sub>. Methanogenic bacteria are more sensitive to the living environment compared to acidogenic bacteria. They require a complete anaerobic environment and a longer reproduction period. The speed and scale of anaerobic fermentation depends on bacteria metabolic activity. That is why the biogas plant chemical process includes hydrolysis stage, oxidation, and methanization stage. For that kind of substrate, these processes take place in the same reactor

## Technological process of biogas production

Napier grass is transported to a biogas plant area and discharged into loaders. The loaders input substrates by portion to reactors using augers. In the reactors the substrate is brought up to a temperature of +52°C. Constant temperature is sustained for the entire digesting period. To prevent a rise in temperature (for example, in summer), the biogas station is equipped with a coolers (dry cooling). The reactors operating regime is thermophilic. The heated substrate in the reactors is blended periodically. Mixing is performed by vertical agitators. The average time of processing in the reactors is 33 days. After the reactors, the substrate is fed by pump to a separator area where it is separated into solid and liquid bio-fertilizer. Solid bio-fertilizer is discharged to the separation area and transported for storage; liquid filtrate is directed to a liquid residue storage tank. Biogas goes up under overlap and delivered into an external gas holder through pipeline.

The gas holder's weather protective film protects the gasholder from precipitation and damage by foreign objects. The weather protective film is fixed firmly by a special system. To protect the gas-

holder from overpressure, digesters are equipped with safety valves, which start working at a pressure of 5 mbars and bleeds biogas to the atmosphere.

Then accumulated in gasholders biogas goes through a gas pipeline to a biogas cooler with a condensate discharge unit and then to a compressor, where the pressure is raised up to 80-150 mbar to meet engine requirements. After the compressor, biogas is fed to activated coal filters to remove hydrogen sulfide (H<sub>2</sub>S). After filters, biogas goes to biogas upgrading plant where raw biogas treats through the removal of CO<sub>2</sub> and other soluble gases to produce primarily methane gas (~99%) which is clean and dry.

All technological processes are controlled and operated by an automatic system. Biogas plant work is monitored at the central control room monitor. The control room is equipped with a central control unit, which allows the switching of any biogas plant module into automatic or manual mode with local or remote control.

# MAIN EQUIPMENT







## Solid feeder (SF-01, SF-02)

Solid feeder machines have been proven in various situations. Solid feeder has the solid design, which guarantees a maximum functionality and less maintenance, combined to a low energy consumption. Because of the vertically oriented walls, there is no change for the material to get stuck or build bridges. The conveyor chains and the milling-unit allow continuous dosing by various types of materials. Furthermore, the material is loosened by this dosing process. The user is able to control the material flow up to 20m<sup>3</sup>/h or more, regarding to the own consumption of electrical power by the machine. In addition, the corrosion protection, wear resistance and high quality allow customers to use our product for a long period of time.

## Specifications

Length:	6.7 m
Width:	3.6 m
Height:	3.4 m
Volume:	30 m <sup>3</sup>
Quantity:	2 pcs.



## Receiving tank (RT-01) and filtrate tank (FT-01)

Reinforced concrete reservoir for reception of liquid kinds of raw materials. The reservoirs are equipped with level sensors and submersible agitators for mixing substrate.

### Specifications

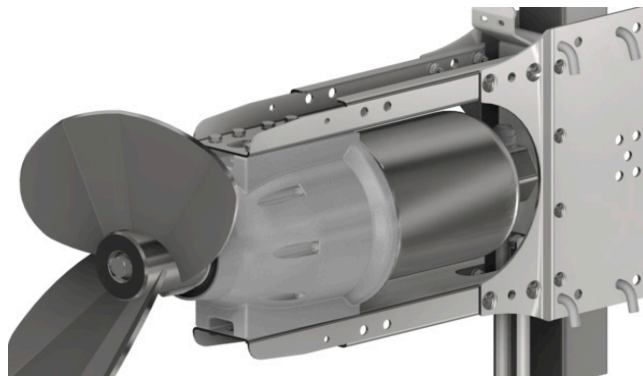
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#### Receiving tank (RT-01)

Diameter:	8.0 m
Height	2.5 m
Total volume:	125 m <sup>3</sup>
Quantity:	1 pcs

#### Filtrate tank (FT-01)

Diameter:	8.0 m
Height	2.5 m
Total volume:	125 m <sup>3</sup>
Quantity:	1 pcs



## Submersible agitator (AG-15, AG-16)

The submersible motor agitator serves for mixing renewable raw materials (RRM), liquid substrate as manure and similar substrates. The electro-motor driven submersible agitator is designed for submersion operations in potentially explosive environments of Ex zone 2 and complies with Directive 94/9 EC. The submersible agitator can be attached to most sliding masts by means of the motor support. A mounting option for a hauling cable is provided on the motor support for height adjustment purposes.

Due to the 4-roller guidance of the motor support, the agitator can be lifted and lowered without friction and the square mast, even if the pull of the hauling cable is slightly angular. The motor support is designed for a 100 x 100 mm square sliding mast as standard, but can also be used for an 80 x 80 mm sliding mast by changing the

rollers. The strain relief of the connecting cable can be positioned in the extension of the motor or towards the top on the motor support, depending on the requirements. This enables universal utilization with the most various installation kits.

The geared motor is made of spheroidal graphite iron (GGG40) and painted, the propeller is galvanized and the motor support is made of stainless steel. The submersible motor agitator is designed as a water pressure-tight monoblock unit for driving the three-vane propeller. The submersible agitator is of modular design, submersible electro-motor with flange-mounted planetary gear and bearing flange for holding the propeller. The conical shaft in the bearing flange is mounted in the oil bath by two angular roller bearings and sealed off from the agitating substrate with a mechanical seal.

## Specifications

### Submersible agitator of the receiving tank (AG-15)

**Nominal power**

N=3.0 kW

**Quantity:**

1 pcs

### Submersible agitator of the filtrate tank (AG-16)

**Nominal power**

N=3.0 kW

**Quantity:**

1 pcs



## Reactor (R-01, R-02)

Reactor is a tank of cylindrical form (for better mixing during the fermentation). It is built of cast-in-situ reinforced concrete based on sulphate-resistant cement with thickness of walls and bottom - 0,25m. In the center of the reactor there is a column with chapter. Overlap of digester is reinforce concrete plate. On the tank's wall and in the bottom there is to be installed pipelines for heating, intended for assurance and maintenance of the optimal fermentation process temperature at thermophilic conditions. For heat conservation and reduction of heat energy con-

sumption, the reactor walls, overlap and bottom are insulated outside with 100 mm slabs of extruded polystyrene foam. Over the heater, the substructure walls and bottom are insulated with roll damp proofing. Superstructure and substructure heat insulation is protected by shaped sheet from the outside mechanical damages and rodents. The reactor bottom has a slope 1%.

### Specifications for the Napier grass 33% total solid

Height :	8,0 m
Diameter :	26,0 m
The total volume :	4245 m <sup>3</sup>
The substrate volume :	3979 m <sup>3</sup>
Quantity:	2 pcs

### Specifications for the Napier grass 27% total solid

Height :	8,0 m
Diameter :	29,0 m
The total volume :	5284 m <sup>3</sup>
The substrate volume :	4951 m <sup>3</sup>
Quantity:	2 pcs



## Reactor vertical agitator (AG-01 ... AG-14)

Mixers are designed and engineered to guarantee high energy efficiency. We use gear units and motors from respected European manufacturers. This guarantees the long life of our mixers. All motors and gear units are available with ATEX certifications.

Agitators are designed for mixing substrates with a high solids content of 13-18%. The blades of the mixers are set at an optimum angle, and the external motor of the mixer is mounted on a special support.

### Specifications Napier grass 33% total solid

Engine power:	N=15 kW
Quantity per digester:	5 pcs
Quantity total:	10 pcs

### Specifications Napier grass 27% total solid

Engine power:	N=15 kW
Quantity per digester:	7 pcs
Quantity total:	14 pcs



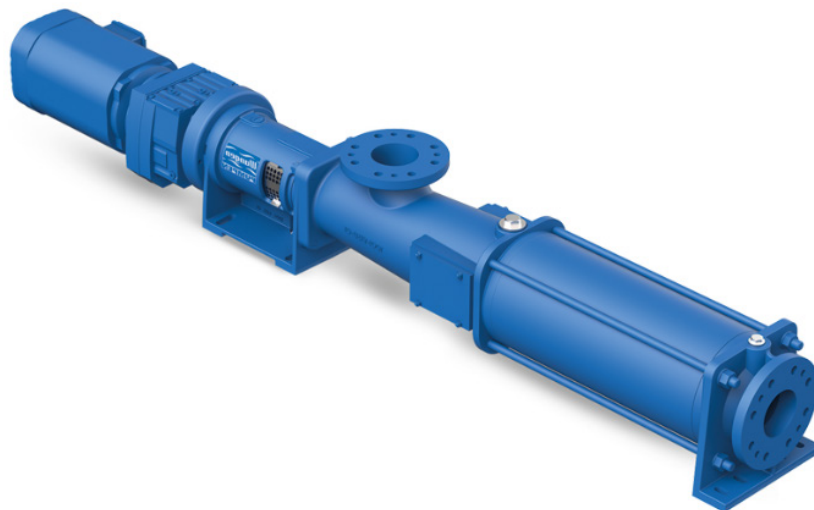
## Window with spotlight (SG-01, SG-02)

Inspection windows are designed for visual control of processes inside the fermenter. Spotlights were made in explosion-proof with automatic disconnection. Inspection windows are equipped with a cleaning washing system.

### Specifications

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Inspection windows Ø300  
Spotlight VISULUX UL50 -G -H  
230V, 50W, IP65



## Pump equipment (PU-01, PU-02, PU-03, PU-04)

Pumps are used to transport substrate to the equipment and facilities in the biogas plant and away. Biogas plant design allows to access easily to all pumps. Pumps are driven by helical geared motor. Stator has hopper inlet for optimum filling of the pumping chamber, wear-protected, robust universal joint with feeding screw, robust bearing pedestal with close-coupled drive and self-centering of the drive shaft. Pumps have modular design for high flexibility, low life-cycle-costs.

### Specifications

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#### Substrate pump to separator (PU-01, PU-02)

Flow rate:	30 m3/hour
Engine power:	7,5 kW
Pressure:	4 bar
Quantity:	2 pcs

#### Liquid substrate pump (PU-03)

Flow rate:	30 m3/hour
Engine power:	7,5 kW
Pressure:	4 bar
Quantity:	1 pcs

#### Filtrate pump (PU-04)

Flow rate:	30 m3/hour
Engine power:	7,5 kW
Pressure:	4 bar
Quantity:	1 pcs





## Separator (SR-01, SR-02)

The Press Screw Separator covers a broad spectrum of applications, from agriculture to biogas and bioethanol plants. The innovative technology separates substrates in its solid and liquid elements. The secret of the versatility of the press screw separator is that it can adjust to different dry matter contents and Thick liquids (20% dry matter content). Slotted screens have different assortment and width of table cells and give possibility work with small solids and fiber contents. In the slotted screen, the solids are screened out from the liquid. The solids build up a layer which also acts as a filter to separate finer particles from the liquid. The auger flights convey this layer to the solids outlet. The screen surface is cleaned and a new filter layer is formed. The design of the screens is not conducive to plugging. The pressure in the first part of the screen is low but increases with the solid consistency to the solid output. The consistence of the gained solid can be varied with the help of a output regulator by the amount and position of counter weights. This way the required consistency of the final product for either further storage, use as fertilizer or the basis for compost can be reached. The liquid phase can easily be drained through a pipe or hose system.

## Specifications

Engine power	5.5 kW
Flow rate	5-12 m <sup>3</sup> / h
Quantity	2 pcs
Equipment	
Frame	
Screw	
Sieve for the filtration	
Counterweights	
The design of the protective room	





## Gasholder (GH-01)

The gasholder provides for biogas storage and for equalizing pressure and biogas composition. The gasholder system has a two-layer construction. The external material consists of a weather-proof film of PVC-coated polyester fabrics with UV protection. Both sides are finished with an external N/5cm, internal membrane PELD (gasholder) membrane.

The gasholder has a methane permeation maximum of  $260 \text{ cm}^3/\text{m}^2 \cdot 1 \text{ bar}$  biogas resistance. The gasholder film temperature range allows operation from  $-30^\circ\text{C}$  to  $+60^\circ\text{C}$ .

The internal film is stretched under normal biogas pressure. Air is blown into the space between the external and internal membranes to pressurize the internal membrane and form the shape of the external membrane.

The biogas pressure in the gasholder is 2-5 mbar. The membranes are designed and cut out on NC machines. Welding is executed by high frequency currents. These steps yield substantial improvements for quality and service life compared to hand-made membranes welded by standard welding equipment.

To prevent damage to the gasholder as a result of overpressure conditions, a safety valve is installed. To survey the internal membrane, an inspection window is installed on the external membrane.

## Specifications

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Height :	11.8 m
Diameter :	15.4 m
The total/working volume :	1500 m <sup>3</sup>
Quantity:	1 pcs



## Biogas dryer and cooling (CHL-01)

Biogas dryer and cooling are provided with special equipment as GAS COOLER and AIR-COOLED LIQUID CHILLER. Biogas plants thanks to an extensive range of dedicated Biogas solutions, low pressure heat exchangers, a comprehensive range of water chillers and RWD Dry Coolers. Designed as one-way shell-and-tube heat exchanger. Process gas inside of the tubes; cooling water in the shell. All parts in contact with the process gas made of stainless steel 316Ti or 316L; heat exchanger shell made of stainless steel/ Designed with gas outlet chamber outlet connection radial; inspection opening axial Official acceptance according to PED 2014/68/EU in accordance with ADMerkblätter and factory pressure test.

### Specifications

Gas volume flow	2200 m <sup>3</sup> / h
Gas inlet temperature	+50 C
Gas outlet temperature	+20 C
Cooling power	200 kW
Engine power	54 kW



## Biogas compressor (BC-01, BC-02)

Biogas blower is a device used to move gas and increase pressure thanks to a rotating impeller within a toroidal channel, so there is a progressive increase of energy.

Blower is used to transporting biogas from gasholder storage to consumer (biogas upgrading plant in our case).

### Specifications

Flow rate:	2200 m <sup>3</sup> /h
Pressure:	150 mbar
Engine power:	26 kW
Quantity:	2 pcs



## Desulphurization system

The desulphurization system is a 3-step system. Stage 1 is adding Ferrum Hydroxide. Stage 2 - biological. Adding a certain portion of air to the fermenter. Air by special bacteria, converting  $H_2S$  into S. After 1 and 2 steps the sulphur concentration is 80 ppm. Stage 3 - activated charcoal filtration, as activated charcoal has the capability to absorb sulfur. After passing through activated charcoal filters, the sulfur concentration is reduced to 0 ppm.

### Specifications

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Air compressor	5 m <sup>3</sup> /h
The volume of charcoal (CF-01, CF02)	300 kg
Numbers of charcoal columns	2 pcs



## Flare

Flare is designed for the temporary or periodical complete combustion of the biogas produced by biogas plants without the possibility of its use as an energy source. The burn system consists of a burner and additional equipment. The burner is designed on the principle of injection and consists of a combustion nozzle with an injector with an air supply control system, flame protection tube, fitting and burner control system. The biogas combustion system is made of stainless steel.

The supporting structure holds the burner and vertically mounted socket. The burn control system is installed in a case, which is mounted on the supporting structure of the combustion system and contains all the elements for monitoring and controlling ignition and flame.

## Specifications

**Flow rate**

2200 m<sup>3</sup>/h

**Quantity:**

1 pcs

# Water supplying and sewerage system

Water supplying system provides biogas plant feed water, water for network circuits, the domestic water and fire safety systems. As used centrifugal single stage pumps as main pumping elements. These pumps are designed for pumping waste water, household / domestic water and sewage. Pressure Boosting Systems are designed for pure water pressure boosting in industrial plants. The booster comprises 2 to 3 (connected in parallel pumps) installed on a common base frame, and provided with all the necessary fittings.

## Specifications

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Drain pump  
Pressure 4m  
Flow 2-3 m<sup>3</sup> / h  
Engine 0,24 kW

Equipment  
Pump case control  
Stove-base  
gauges  
Check valves  
Float switches  
Brackets  
Valves



## Heating system

Heating equipment is used for biogas plant heating and for sustaining constant temperature in the fermenter. Heating equipment includes circulation pumps, heat exchanger, heating manifold and pipes. The heat from the boiler is transferred to the biogas plant by using heat exchanger, and then is pumped through of biogas plant by circulation pumps. A heat carrier prepares water with an additive of ethylene glycol. Inlet temperature in the fermenter is 60C, the outlet is 40C.

## Specifications

Circulating pump feeding heat carrier heating

Flow	30 m <sup>3</sup> / h;
Pressure	1 bar

Circulating pump feeding heat carrier to the digester

Flow	18 m <sup>3</sup> / h;
Pressure	1.1 bar

The pumping station feeding propylene glycol

Flow	0.8 m <sup>3</sup> / h;
Pressure	4 bar





## Dry cooler (cooling substrate system)

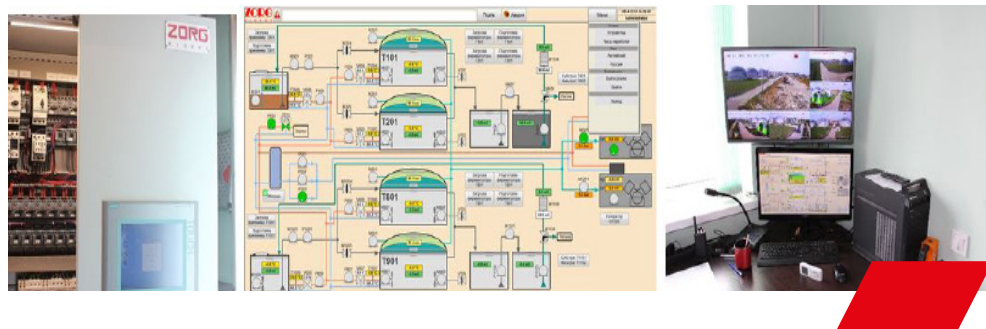
Device is designed to cool the substrate to working temperature according to technological regime. When use high temperature substrate, there is a chance of uncontrolled heating. The cooler is connected to the heating pipes, heat exchangers and it will be activated if it is need.

### Specifications

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<b>Power (cooling)</b>	100 kW
<b>Length:</b>	3,0 m
<b>Width:</b>	2,5 m
<b>Height:</b>	1,5 m
<b>Power electrical</b>	4 kW
<b>Quantity:</b>	2 pcs





## Automation and electrical equipment

Process control equipment is used for supervision and regulation operation of the plant and for the limitation of damage. In case of emergency (for example, breakdown of the electrical power supply) the biogas plant is automatically transferred to safe operating conditions by the process instrumentation. Critical electrically driven devices are supplied with emergency power. An automatic system allows the supervision of the plant in real time and to recognize and correct aberrations immediately; to run the plant at its optimum saving resources and costs; and to record for the electronic database operation parameters. The automatic system consists of a control cabinet and sensors for parameter control of technological processes and execution devices.

The control cabinet is designed based on the industrial controller Siemens CPU315-DP2, using periphery distributing system Simatic ET200S, and operator panel OP277 Touch with touch-sensitive controls. Communications is executed by PROFIBUS and MPI with physical interface RS-485. The control program is designed based on the Simatic Step7. The control cabinet is a modular design. The upper part has a power box with central and front-end processor. The periphery distributing system, Simatic ET200S, is installed with input - output units. The lower part with interface relay and clips is installed for connecting execution devices. The entire plant is controlled by a single operator.

## Specifications

**Incoming control case with automatic set ASE-1, 2, 3**

**Base Siemens CPU315-DP2 controller**

**Peripherals Simatic ET200S**

**Control panel OP277 touchscreen**

**Communication PROFIBUS and MPI**

**Interface RS-485**

**Control system Simatic Step7**



## Sensors set

Sensors are used to measure physical quantities (temperature, pressure, level of moisture) data collection.  
installation kits

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Conductometric sensor  
Pressure Sensor / level  
Ultrasonic sensor  
Gas Pressure Sensor  
Temperature converters with protective sleeves  
The moisture sensor and the gas temperature



## Laboratory

Monitoring and control of parameters of raw materials and fermentation processes is important for the efficient operation of a biogas plant. The laboratory allows you to assess the content of dry matter in the input raw materials, fermented mass, determine the ratio of volatile organic acids to total inorganic carbon (FOS/TAC parameter), determine the degree of substrate fermentation in fermenters, the level of biogas output, and evaluate the efficiency of separator.

## Equipment

- Analytical scales
- Moisture analyzer
- Automatic titrator
- Laboratory pH meter
- Centrifuge
- A set of flasks

# EQUIPMENT SPECIFICATION LIST



Nº	Equipment	Characteristic	Quantity
<b>1</b>	<b>Solid feeder</b>	<b>V=30 m3</b>	<b>2</b>
1.1	Container bunker		2
1.2	Feeding screws	set.	2
<b>2</b>	<b>Submersible mixer</b>	<b>N=3.0kW</b>	<b>1</b>
2.1	Airtight motor gearbox		1
2.2	Hydraulic screw (wear-resistant steel)		1
2.3	Mixer control mechanism		1
2.4	Electric motor mount		1
2.5	Set of fasteners		1
<b>3</b>	<b>Reactor vertical agitator</b>	<b>N=15 kW</b>	<b>10,14</b>
3.1	Airtight motor gearbox		10,14
3.2	Hydraulic screw (wear-resistant steel)		10,14
3.3	Shaft (adapted to the height of the fermenter)		10,14
3.4	Blade		10,14
3.5	Frequency converter		10,14
3.6	Mounting bracket to bottom of the mixer		10,14
<b>4</b>	<b>Safety valve of reactors</b>		<b>2</b>
<b>5</b>	<b>Window with a searchlight</b>	<b>set</b>	<b>2</b>
5.1	Inspection window RD300 (mounts and sealant included)	Ø300	4
5.2	Spotlight (mount system bundled) VISULUX UL50 -G -H	230V, 50W, IP65	2
<b>6</b>	<b>Substrate digested pump</b>	<b>30 m3/hour N=7.5 kW</b>	<b>2</b>

Nº	Equipment	Characteristic	Quantity
<b>7</b>	<b>Separator</b>	<b>N=5.5 kW, Q=8-12m3/h</b>	<b>2</b>
7.1	Body		2
7.2	Substrate Supply Pipe 4 ''		2
7.3	Engine - Gearbox	N=5,5 kW	2
7.4	Frame		2
7.5	Screw		2
7.6	Sieve for filtration		2
<b>8</b>	<b>Filtrate pump</b>	<b>30 m3/hour N=7.5kW</b>	<b>1</b>
<b>9</b>	<b>Submersible mixer</b>	<b>N=3.0kW</b>	<b>1</b>
<b>10</b>	<b>PVC external gas holder</b>	<b>Ø15.4m</b>	<b>1</b>
10.1	Weather protection film	Ø15.4m	1
10.2	Gasholder film PELD methane permeation max.260 cm3/m2*d*1 bar, 650 N/5cm bio- gas resistant		1
10.3	Air blower	16A, 0,5kW	1
10.4	Excess and minimum pressure valve		1
10.5	Dome level sensor		1
10.6	Mounting system		1
10.7	Accessories		1
10.8	Safety valve		1
<b>11</b>	<b>Biogas Cooling System</b>	<b>2200 m3/h</b>	<b>1</b>
11.1	Chiller		1
11.2	Heat exchanger		1
11.3	Polypropylene glycol tank		1
<b>12</b>	<b>Desulphurization system</b>		<b>1</b>
12.1	Numbers of charcoal columns	<b>300 kg</b>	2

Nº	Equipment	Characteristic	Quantity
13	Biogas compressor	Q=2200m³/h H=150mBar N=26kW	2
14	Biogas analyzer (CH <sub>4</sub> , CO <sub>2</sub> , H <sub>2</sub> S, O <sub>2</sub> )		1
15	Electromagnetic flow meter		1
16	Flare	2200 m3/h	1
17	Gas equipment included	set	1
17.1	Drainage pump with float	DN=50 Q=1 m³/h H=13 m	2
18	The heat supply system	set	1
18.1	Diaphragm expansion tank	V=1000 l P=6Bar T=120°C	1
18.2	Circulating pump for supplying heat carrier	Q=30 m³/h H=1bar	1
18.3	Propylene glycol feed pump station heating systems	Q=1,0 m³/h, H=4 bar	1
18.4	Circulation pump for supplying heat carrier to the digester	Q=18 m3/h, H=1.1 bar	1
19	Water supply and sewerage system, complete, disassembled	set	1
20	Automation with electrical equipment complete, disassembled	set	1
20.1	Incoming distribution cabinet with a set of automation DB-1		1
20.2	Incoming distribution cabinet with a set of automation DB-2		1
21	Sensors, set		1
21.1	Gas pressure sensor 0,025Bar		2
21.2	Gas pressure sensor 0,4Bar		2
21.3	Pressure sensor(substrate level) 1,0Bar		3
21.4	Pressure sensor (substrate pressure) 2,5bar		3

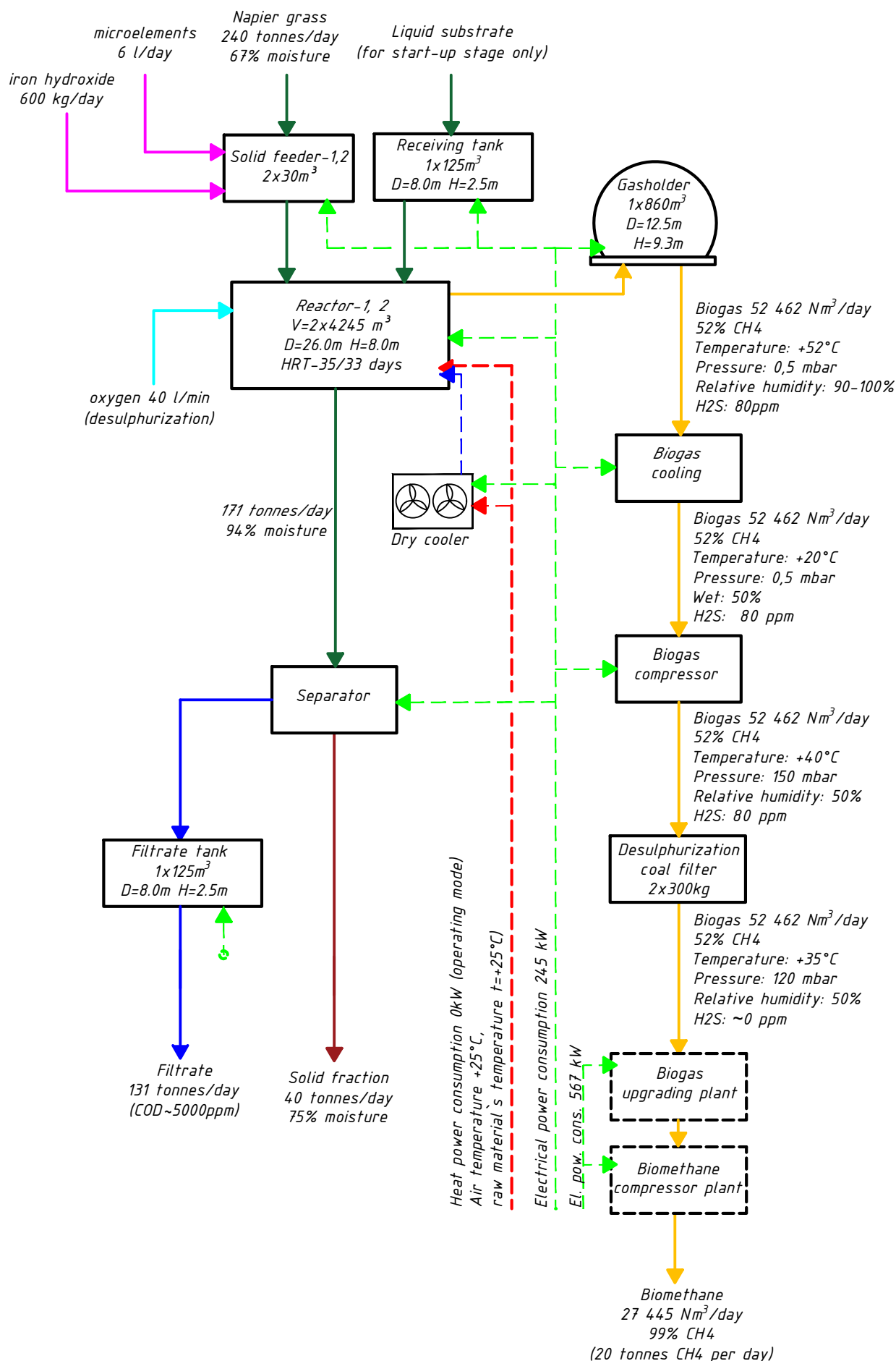
Nº	Equipment	Characteristic	Quantity
21.5	Resistive thermometer (gas temperature)		3
21.6	Resistive thermometer with thermo well (fermenter substrate temperature)		3
21.7	Resistive thermometer with thermo-well (digester tank substrate temperature)		3
21.7	Resistive thermometer (heat conductor temperature)		3
21.9	Conductometric sensor of maximum level		2
21.10	Conductometric sensor of water level		4
21.11	Dome position sensor		1
21.12	Coolant pressure sensor	SEN 3276 B065 G1/2 6Bar	2
21.13	Humidity and gas temperature sensor	ESFTF-I	2
<b>22</b>	<b>Dry cooler 100kW heat pow.</b>		<b>2</b>
<b>23</b>	<b>Laboratory</b>		<b>1</b>



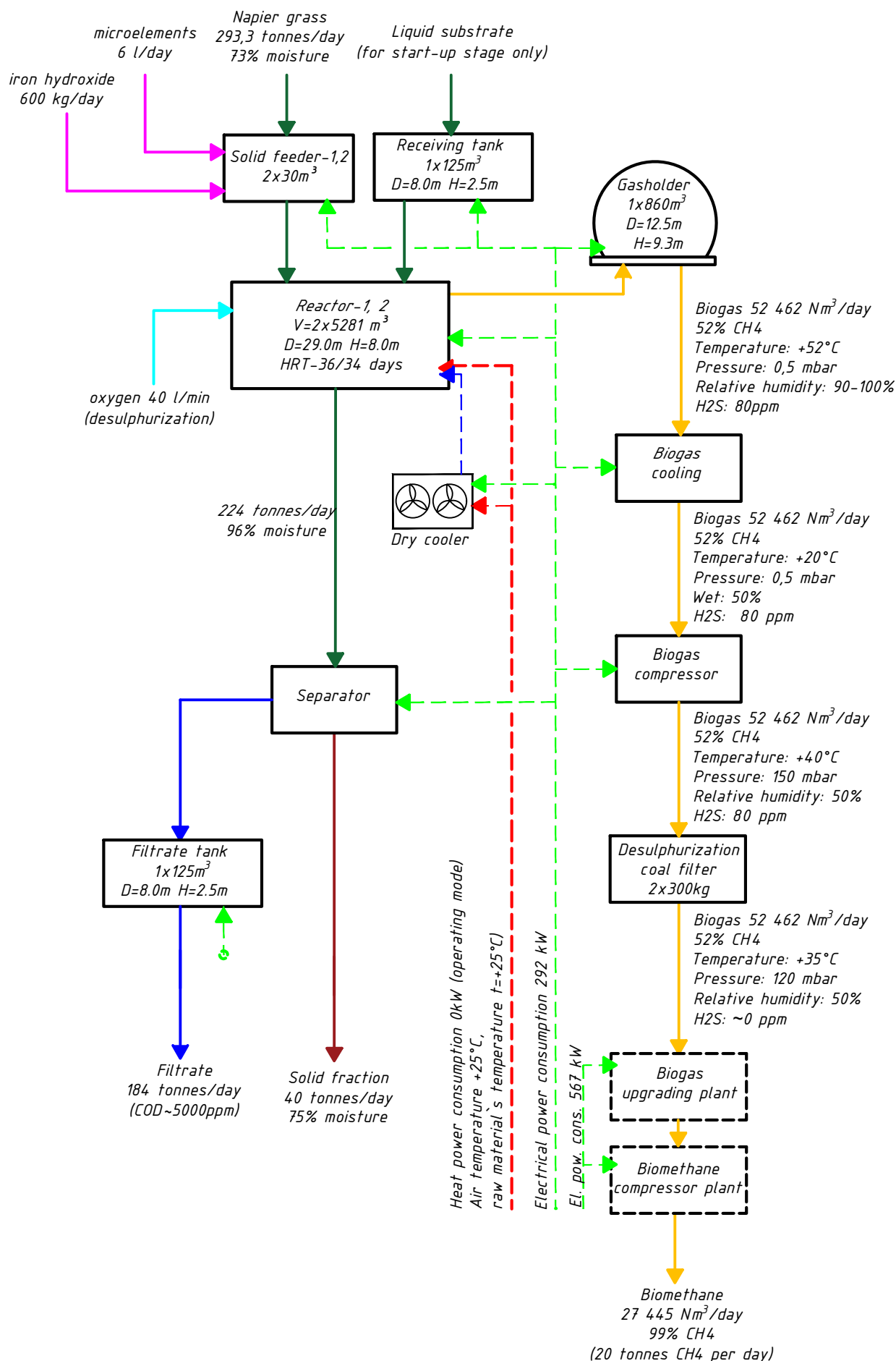
# APPENDICES



# Material flow diagram (Napier gras 33% TS)



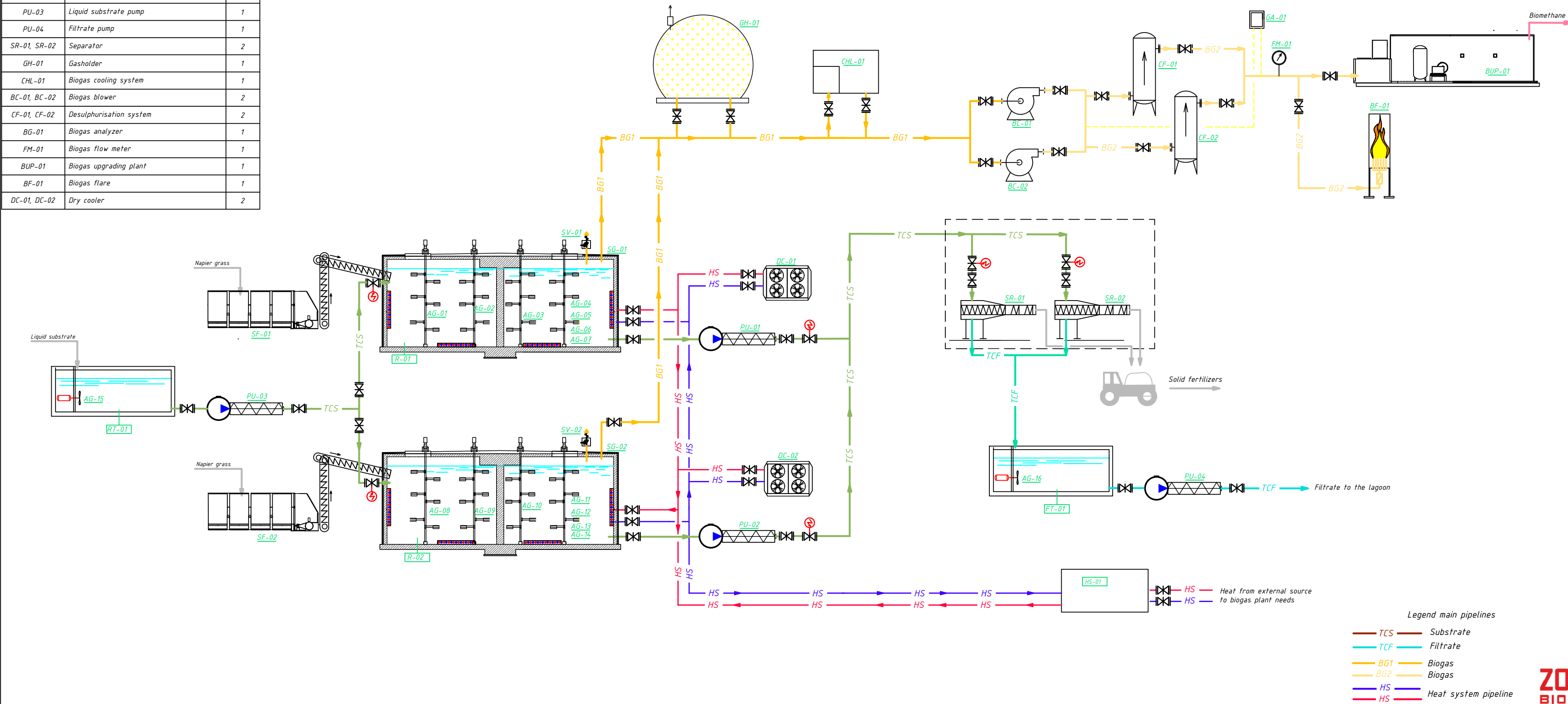
# Material flow diagram (Napier gras 27% TS)

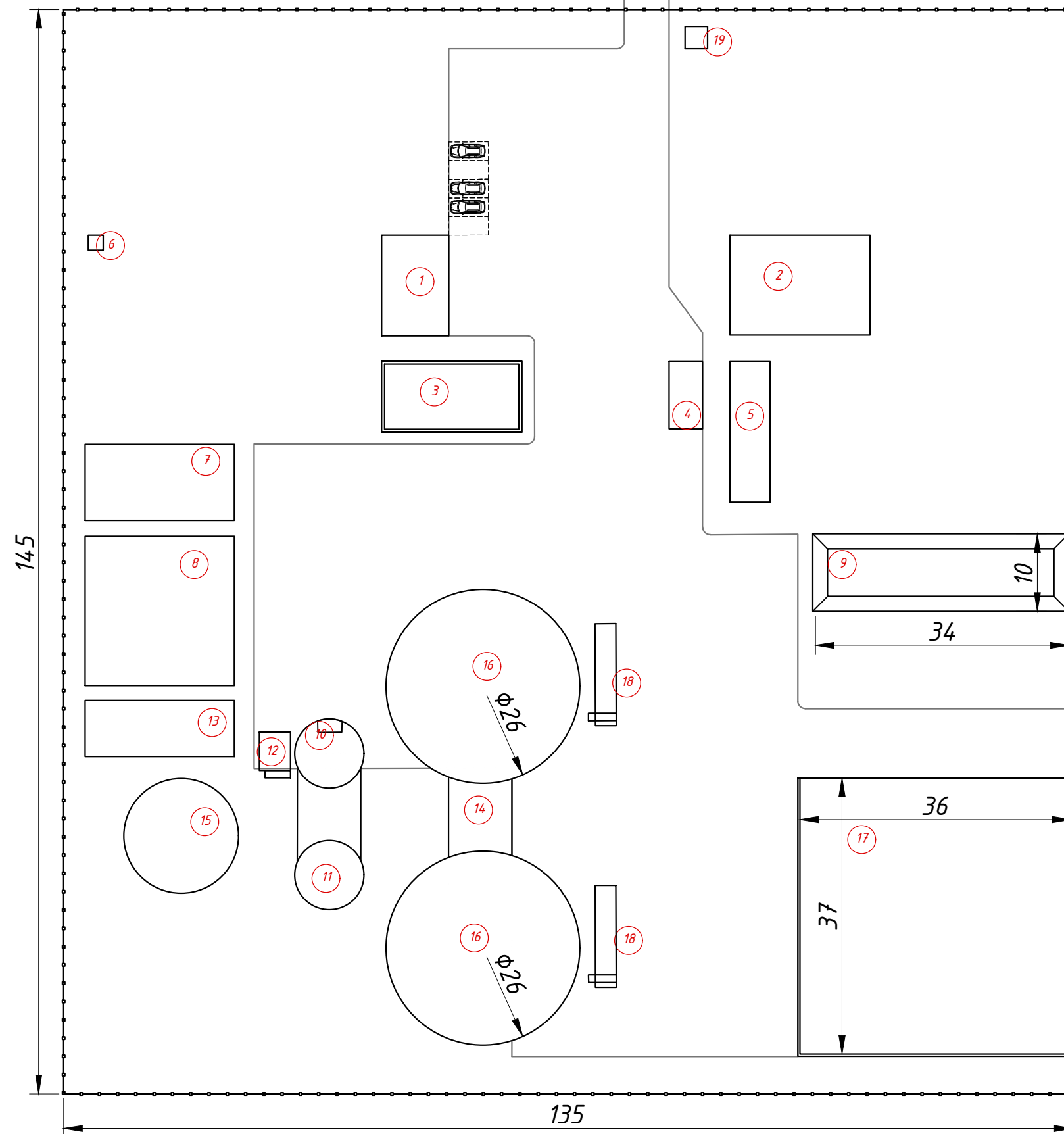
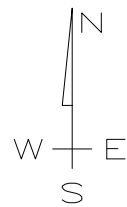


Explication		
N/Nº	Name	Quantity
SF-01, SF-02	Solid feeder	2
SV-01, SF-02	Safety valve	2
SG-01, SG-03	Inspection windows	2
AG-01 .... AG-14	Vertical Paddle agitator of Reactor-1,2	2x5 or 2x7
AG-15	Submersible agitator of the receiving tank	1
AG-16	Submersible agitator of the filtrate tank	1
PU-01, PU-02	Substrate pump from Digesters tos eparator	2
PU-03	Liquid substrate pump	1
PU-04	Filtrate pump	1
SR-01, SR-02	Separator	2
GH-01	Gasholder	1
CHL-01	Biogas cooling system	1
BC-01, BC-02	Biogas blower	2
CF-01, CF-02	Desulphurisation system	2
BG-01	Biogas analyzer	1
FM-01	Biogas flow meter	1
BUP-01	Biogas upgrading plant	1
BF-01	Biogas flare	1
DC-01, DC-02	Dry cooler	2

Structure		
N/Nº	Name	Quantity
R-01 R-02	Reactor - 1,2	2
RT-01	Receiving tank	1
FT-01	Filtrate tank	1
HS-01	Heat sub-station	1

Basic diagram





### Explication

N/Nº	Name	Note
1	Warehouse	
2	Fire tank	
3	Operators room	
4	Weigh bridge	
5	Stormwater treatment	
6	Biogas flare	
7	Methane filling station	
8	Biomethane module	
9	Lagoon	
10	Receiving tank	
11	Filtrate tank	
12	Separator area	
13	Gas preparation	
14	Technological room	
15	Gasholder	
16	Reactor	
17	Storage of raw materials	
18	Solid loader	
19	Security	

## Appendix 4.1

Biogas plant (Napier grass 33% total solid)					
Name equipment	Instal. Pow. (kW)	Quantity (pcs)	Total installed power (kW)	Working hours per day	Consumption kWh per day
Loader V=30 m <sup>3</sup>	20,0	2	40,0	8,0	320,0
Screw set.	18,5	2	37,0	8,0	296,0
Reactor Vertical agitator	15,0	10	150,0	18,0	2700,0
Submersible agitator in receiving tank	5,0	1	5,0	12,0	60,0
Submersible agitator in filtrate tank	3,0	1	3,0	12,0	36,0
Biogas cooling system	56,0	1	56,0	24,0	1344,0
Biogas compressor	26,0	2	52,0	12,0	624,0
Separator	5,5	2	8,0	8,0	64,0
Substrate pump to separator	7,5	2	8,0	8,0	64,0
Liquid substrate pump	7,5	1	4,0	2,0	8,0
Filtrate pump	7,5	1	4,0	2,0	8,0
Air compressor for gasholder lock	1,5	1	1,5	1,0	1,5
Air blower for double membrane	1,0	1	1,0	24,0	24,0
Digester cooling system	4,0	2	8,0	24,0	192,0
Circulation pump for supplying heat carrier to the digester	0,8	2	1,5	24,0	36,0
Circulation pump for supplying heat carrier to the digester cooling system	2,0	2	4,0	24,0	96,0
Circulating pump feeding hot water at technical building	0,1	1	0,1	24,0	1,9
Propylene glycol pump station	0,8	1	0,8	0,5	0,4
Drinage pump	1,0	2	2,0	0,5	1,0
Lighting of the biogas plant territory	1,0	1	1,0	8,0	8,0
Spot light for digesters inspection windows	0,1	1	0,1	0,5	0,0
Working lighting of switchboard	0,1	1	0,1	0,5	0,1
Total installed power, kW			<b>387</b>		
Total consumed electric energy, kWh per day					<b>5885</b>
Total consumed power, kW					<b>245</b>

Biogas upgrading plant					
Name equipment	Instal. Pow. (kW)	Quantity (pcs)	Total installed power (kW)	Working hours per day	Consumption kWh per day
Biogas upgrading plant	349,7	1	349,7	24,0	8393,9
Biomethane compressor plant	217,3	1	217,3	24,0	5214,7
Total installed power, kW			<b>349,7</b>		
Total consumed electric energy, kWh per day					<b>13609</b>
Average consumed electric power, kW					<b>567</b>

Total average consumed electric power, kW					<b>812</b>
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## Appendix 4.2

Biogas plant (Napier grass 27% total solid)					
Name equipment	Instal. Pow. (kW)	Quantity (pcs)	Total installed power (kW)	Working hours per day	Consumption kWh per day
Loader V=30 m <sup>3</sup>	20,0	2	40,0	8,5	340,0
Screw set.	18,5	2	37,0	8,5	314,5
Reactor Vertical agitator	15,0	14	210,0	18,0	3780,0
Submersible agitator in receiving tank	5,0	1	5,0	12,0	60,0
Submersible agitator in filtrate tank	3,0	1	3,0	12,0	36,0
Biogas cooling system	56,0	1	56,0	24,0	1344,0
Biogas compressor	26,0	2	52,0	12,0	624,0
Separator	5,5	2	8,0	8,5	68,0
Substrate pump to separator	7,5	2	8,0	8,5	68,0
Liquid substrate pump	7,5	1	4,0	2,0	8,0
Filtrate pump	7,5	1	4,0	2,0	8,0
Air compressor for gasholder lock	1,5	1	1,5	1,0	1,5
Air blower for double membrane	1,0	1	1,0	24,0	24,0
Digester cooling system	4,0	2	8,0	24,0	192,0
Circulation pump for supplying heat carrier to the digester	0,8	2	1,5	24,0	36,0
Circulation pump for supplying heat carrier to the digester cooling system	2,0	2	4,0	24,0	96,0
Circulating pump feeding hot water at technical building	0,1	1	0,1	24,0	1,9
Propylene glycol pump station	0,8	1	0,8	0,5	0,4
Drinage pump	1,0	2	2,0	0,5	1,0
Lighting of the biogas plant territory	1,0	1	1,0	8,0	8,0
Spot light for digesters inspection windows	0,1	1	0,1	0,5	0,0
Working lighting of switchboard	0,1	1	0,1	0,5	0,1
Total installed power, kW			<b>447</b>		
Total consumed electric energy, kWh per day					<b>7011</b>
Total consumed power, kW					<b>292</b>

Biogas upgrading plant					
Name equipment	Instal. Pow. (kW)	Quantity (pcs)	Total installed power (kW)	Working hours per day	Consumption kWh per day
Biogas upgrading plant	349,7	1	349,7	24,0	8393,9
Biomethane compressor plant	217,3	1	217,3	24,0	5214,7
Total installed power, kW			<b>349,7</b>		
Total consumed electric energy, kWh per day					<b>13609</b>
Average consumed electric power, kW					<b>567</b>

Total average consumed electric power, kW					<b>859</b>
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## Prices for quipment and services for 20 tpd bioCNG plant

Pos	Name	Number of units	Unit price, EUR	Discounts *	Discounted unit price, EUR	Discounted price sub-total, EUR
1	Project documentation	1	95 000	0%	95 000	95 000
2	Supervision	1	40 000	0%	40 000	40 000
3	Startup and training	1	40 000	0%	40 000	40 000
4	Living and travel expences	1	45 000	0%	45 000	45 000
5	Delivery of the equipment	8	10 000	0%	10 000	80 000
6	Laboratory	1	27 000	0%	27 000	27 000
7	Solid feeder (dosing buffer machine)	2	105 000	0%	105 000	210 000
8	Screw conveyor	2	114 000	0%	114 000	228 000
9	Digester vertical agitator	12	78 000	0%	78 000	936 000
10	Frame for Digester vertical agitator pos 3	12	6 000	0%	6 000	72 000
11	Substrate pump	1	31 000	0%	31 000	31 000
12	Digested substrate pump	2	31 000	0%	31 000	62 000
13	Filtrate supply pump	2	31 000	0%	31 000	62 000
14	Substrate separation unit	2	56 000	0%	56 000	112 000
15	Submersible agitator for receiving tank	1	10 000	0%	10 000	10 000
16	Submersible agitator for filtrate tank	1	10 000	0%	10 000	10 000
17	Over- and under pressure safeguard	2	7 000	0%	7 000	14 000
18	Sight glasses/viewing windows with projector	2	6 000	0%	6 000	12 000
19	Water supply and canalization system	1	48 000	0%	48 000	48 000
20	Heat supply station	1	47 000	0%	47 000	47 000
21	Dry-cooler cooling system for reactors	2	36 000	0%	36 000	72 000
22	Automation and electric cabinet	1	290 000	0%	290 000	290 000
23	Sensors (set)	4	25 000	0%	25 000	100 000
24	Gasholder	1	89 000	0%	89 000	89 000
25	Biogas chiller (Biogas cooling system)	1	118 000	0%	118 000	118 000
26	Biogas blower	2	38 000	0%	38 000	76 000
27	Desulphurization column with active coal	2	35 000	0%	35 000	70 000
28	Biogas burner	1	128 000	0%	128 000	128 000
29	Gas analyzer	1	27 000	0%	27 000	27 000
30	Gas conditioning unit	1	41 000	0%	41 000	41 000
				TOTAL by ZORG, EUR*		3 192 000
				(equivalent in Crores) by Zorg		<b>29</b>
	<b>Client' responsibility</b>					
31	Cascades (40 each)	44	22 000	0%	22 000	968 000
32	Oxygen generator	1	60 000	0%	60 000	60 000
33	Biomethane upgrading plant	1	1 400 000	0%	1 400 000	1 400 000
34	Biomethane compressor plant	1	270 000	0%	270 000	270 000
35	Gas chromatograph	1	80 000	0%	80 000	80 000
36	Construction	1	1 600 000	0%	1 600 000	1 600 000
37	Filtrate Storage	1	40 000	0%	40 000	40 000
38	Weight control (truck scale)	1	35 000	0%	35 000	35 000
				TOTAL by Client, EUR		4 453 000
				(equivalent in Crores) by Client		<b>41</b>

SUM Zorg + **Client**, crores

70

\* Customs duties are zero. Biogas plant is an equipment for renewables. You need to apply for customs duties waiving to the Ministry of Renewable Energy of India yourself

Implementation terms and payment

Months	1	2	3	4	5	6	7	8	9	10	11	12	13	14
Project documentation	50%			50%										
Approvals and permits														
Equipment supply	50%		20%	20%		10%								
Biogas upgrading plant	30%					70%								
Construction														
Supervision	50%					50%								
Plant start-up											50%		50%	

Contracts

Project implementation is executed simultaneously under several contracts

- Engineering contract
- Equipment supply contract
- Supervision contract
- Start-up and training contract



### List of exclusions for a 20 tpd bioCNG plant:

- 1) Import taxes and local duties in India. The importer needs to apply the Ministry of Economy of India. To get waiving of the import duties. Biogas plant is a plant for renewables.
- 2) Project report, civil permits and authorizations, adaptation of the project documentation by a licensed local engineering organisation for the permit purposes. Namely the organisation puts their stamp and acts act the face of the project. The design documentation is not changed in fact. 10 000 – 15 000 EUR
- 3) Topographic and geological surveys 3000-7000 EUR
- 4) Electric transformer and the external electric line 250 kW for start-up, for construction period and 900 kW for normal operation.
- 5) External roads,
- 6) Temporary water supply during the construction and the hydraulic test of reactors at least 500 m<sup>3</sup> water per day. It can be a technical quality water from a river, lake, well. Not salty.
- 7) Bacterial seed for the start-up. It can be biomass from another biogas plant. Possibly also cow manure, any kind of manure, sludge from city sewage treatment plant. Customer needs to bring the seed one-time during a 1-2 week period and to fill with it at least 15-20% of the reactor volume 600-800 m<sup>3</sup>. The rest is filled with the water item 7 above.
- 8) Machinery to transport Napier grass to and from silage storage to the solid feeders (a truck, a frontal loader, a tractor)
- 9) Machinery to transport filtrate and the digested mass from the biogas plant to the agricultural fields (a truck, a frontal loader, a tractor)
- 10) Activated carbon 0,6 tonne per year x 4800 EUR/tonne = 2880 EUR
- 11) Fe(OH)<sub>3</sub>, Fe(OH)<sub>2</sub> – 219 tonnes per year x 80 EUR/tonne = 17 520 EUR
- 12) Anti-foam reagent 7 tonnes annually (all kinds of vegetable oil, for example, palm oil or rapeseed oil)
- 13) Microelements 1430 l per year total x 25 EUR/l = 35 750 EUR
- 14) PVC foil for the silage storage to cover grass 1400 m<sup>2</sup>
- 15) Demineralized water to the heating system 3 tonnes,
- 16) Spare parts for two years 180 000 EURO



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