

INDUSTRIAL CASE STUDY

Recovered Furnace-Ready Glass Cullet Production from Contaminated Post-Consumer Cullet

Continuous Industrial-Scale Thermal Beneficiation System — 2 Tonnes Per Hour Capacity

Designed, Engineered & Validated by KERONE Engineering Solutions Limited

2 TPH

PLANT CAPACITY

Cullet Input

500 degC

PROCESS TEMP.

Oxidising Atmosphere

45 min

RESIDENCE TIME

Optimal Hold

0.42 %

LOI ACHIEVED

Loss on Ignition

91 %

ORGANIC REMOVAL

Mass Basis

90 %+

CULLET SUBSTITUTION

Furnace-Ready Grade

~2.2 Yrs

PAYBACK PERIOD

At Market Premium

2-2.5x

PRICE PREMIUM

Furnace-Ready Grade

Project Reference Detail

Field	Detail
Client Organisation	Vitrum Glass Recycling Pvt. Ltd. — Leading Indian post-consumer glass cullet processor
KERONE Reference	KRDC/ICS/GlassCullet/2026-01 Based on KRDC Lab Report 52/KRDC/LAB/22
Technology	Continuous Rotary Thermal Beneficiation Furnace with Oxidising Atmosphere & Forced-Air Cooling
Feedstock	Mixed-Colour Post-Consumer Glass Cullet — 3.80% Loss on Ignition (as-received)
Product Output	Furnace-Ready Glass Cullet — 0.42% Loss on Ignition, <0.50% Organic Contamination
Plant Location	Client facility (glass cullet beneficiation plant) — Inline with existing sorting line
Document Date	July 2026 Validated on KRDC Lab Data — June 2026

Glass Recycling | Cullet Beneficiation | Circular Economy | Thermal Processing | Industrial Sustainability | Ceramics & Glass

Executive Summary

Vitrum Glass Recycling Pvt. Ltd., a leading Indian processor of post-consumer glass cullet, faced a commercially significant challenge: its collection and sorting operations generate large volumes of mixed-colour glass cullet that, in its raw state, carries 3.80% Loss on Ignition (LOI) from organic residues — labels, adhesives, plastic caps and closures, and residual liquids — which restricts furnace acceptance and caps cullet substitution at 40% in most container-glass melting operations.

KERONE Engineering Solutions Limited was engaged to design, validate, and specify an industrial-scale continuous thermal beneficiation system capable of upgrading this contaminated cullet to furnace-ready quality suitable for high-substitution glass melting and ceramic frit applications — at a throughput of 2 Tonnes Per Hour (2 TPH).

Following rigorous laboratory validation at KRDC (Kerone Research & Development Centre) using a controlled thermal treatment furnace at 500 degrees C across multiple hold times (20 min, 45 min, 90 min), the optimal industrial process parameters were established. The KERONE continuous rotary thermal beneficiation furnace — operating at 500 degrees C with a 45-minute material residence time under a controlled oxidising (forced-air) atmosphere — delivers LOI reduction from 3.80% to below 0.50%, and organic/plastic contamination reduction from 4.20% to below 0.50%.

CHALLENGE	KERONE SOLUTION	OUTCOME ACHIEVED
Contaminated mixed cullet with 3.80% LOI and 4.20% organic content — capped at 40% furnace substitution, realising INR 3,500-5,500/tonne.	Continuous 2 TPH rotary thermal beneficiation furnace at 500 degrees C, oxidising atmosphere, 45-min residence — validated from KRDC lab trials.	Furnace-ready cullet with 0.42% LOI, <0.50% organics — enabling 90%+ substitution and commanding INR 9,000-12,000/tonne.

Key Performance Summary

KPI	Raw Feedstock (Baseline)	After KERONE Processing (2 TPH Plant)	Improvement
Loss on Ignition (LOI)	3.80%	< 0.50%	92% reduction
Organic / Plastic Contamination	4.20%	< 0.50%	91% reduction
Cullet Substitution Ratio Achievable	~40%	90%+	2.25x increase
Ceramic-Stone-Porcelain (CSP) Content	120 ppm	< 60 ppm	50% reduction
Market Value (Furnace-Ready Grade)	INR 3,500-5,500/t	INR 9,000-12,000/t	2-2.5x price premium
Product Classification	Contaminated / low-grade cullet	Furnace-ready premium cullet	Grade uplift
Annual Revenue Potential	INR 5.0-7.9 Cr/yr	INR 12-14 Cr/yr	at 7,200 hr/yr operation

Industry Context & The Business Challenge

India generates an estimated 1.0 million tonnes of post-consumer glass waste annually (bottles, jars, and containers), of which only 25-30% is recycled back into new glass melting due to contamination limiting furnace acceptance. Mixed cullet streams — sourced from municipal collection, kabadiwalas, and bottling returns — typically carry 3-5% Loss on Ignition from labels, adhesives, plastic caps, and residual liquids.

The global container glass industry is increasingly mandating higher recycled-content targets, with major manufacturers (Owens-Illinois, Saint-Gobain, AGI Glaspac) targeting 60-90% cullet incorporation to reduce furnace energy consumption — each 10% increase in cullet substitution cuts furnace energy demand by roughly 2-3% and lowers CO2 emissions correspondingly. However, contaminated cullet causes redox defects, seed and bubble formation, and accelerated refractory corrosion, forcing Indian glass manufacturers to restrict cullet use to 40-50% unless feedstock quality is upgraded.

The Commercial Problem — Why Contaminated Cullet Has Low Value

Quality Parameter	Raw Cullet (Vitrum)	Market Requirement (Furnace-Ready Grade)	Gap
Loss on Ignition (LOI)	3.80%	< 0.50%	FAIL — 7.6x over limit
Organic / Plastic Contamination	4.20%	< 0.50%	FAIL — 8.4x over limit
Ceramic-Stone-Porcelain (CSP)	120 ppm	< 50 ppm	FAIL — insufficient purity
Market Price Realised	INR 3,500-5,500/t	INR 9,000-12,000/t	2-2.5x revenue gap

Table 1: Raw glass cullet quality parameters vs market specification for furnace-ready grade | Source: KRDC Analysis & ASTM C1866 Cullet Grade Requirements

Revenue Opportunity — Upgrading Existing Waste Stream

At 2 TPH throughput operating 300 days/year (7,200 hours), the annual feedstock volume is approximately 14,400 tonnes of contaminated cullet. At current raw cullet prices of INR 4,500/tonne, this generates INR 6.48 Cr/year. Post-processing with KERONE's system, the resulting ~13,464 tonnes/year of furnace-ready cullet at INR 10,500/tonne generates INR 14.14 Cr/year — a revenue increase of over INR 7.6 Cr annually, from an existing waste stream.

About Vitrum Glass Recycling Pvt. Ltd.

Vitrum Glass Recycling Pvt. Ltd. is one of India's established post-consumer glass cullet processors, with annual collection and sorting capacity exceeding 40,000 tonnes. Its operations span colour sortation, crushing, and cullet supply to container-glass furnaces and ceramic frit manufacturers — positioning it as an ideal anchor client for KERONE's cullet beneficiation technology. The KRDC trial was conducted on Vitrum's actual mixed-colour cullet (25 kg sample, dispatched 12 June 2026) to ensure industrial relevance of all process parameters.

Process Validation — From KRDC Lab to Industrial Scale

KERONE's engineering approach mandates laboratory-scale validation before any industrial system specification. The KRDC (Kerone Research & Development Centre) conducted a structured experimental programme on Vitrum's actual mixed-colour cullet over 5 days (8-12 June 2026), using a precision thermal treatment furnace to establish the process envelope that informs the 2 TPH industrial plant design.

KRDC Experimental Programme — Key Findings

Test Condition	Hold Time	Mass Reduction	Loss on Ignition	Assessment
Control (no hold)	0 min	< 0.3%	3.80%	Baseline — raw cullet
Short hold	20 min	~1.6%	1.85%	Insufficient — rejects grade spec
OPTIMAL	45 min	3.6%	0.42%	Optimal for furnace-ready grade
Extended hold	90 min	~3.9%	0.18%	Premium ultra-low-LOI grade

Table 2: KRDC Laboratory Results — 500 degrees C thermal treatment trials on Vitrum mixed-colour cullet | KRDC Test Report 52/KRDC/LAB/22 | Loss on Ignition per ASTM C114 at 950 degrees C

Scale-Up Methodology — Lab to 2 TPH

KERONE's scale-up process follows a structured engineering framework where laboratory parameters are translated to industrial equipment specifications using validated thermal engineering models. The key translation factors for this project are:

Parameter	KRDC Lab (Muffle/Tube Furnace)	Industrial Plant (2 TPH Rotary Furnace)	Scale-Up Factor
Treatment Temperature	500 degrees C	500 degrees C	1:1 (direct)
Optimal Hold Time	45 min	45 min residence	1:1 (direct)
Throughput	~15 g/run	2,000 kg/hr	~133,000:1
Atmosphere	Air / O2-enriched (selectable)	Continuous forced-air draft	Direct
Ramp Rate	5 degrees C/min	Zone-controlled (3 zones)	Adapted
Heating Mode	Batch (static)	Continuous rotary drum	Configuration change
Cooling	Natural (in-furnace)	Forced-air cascade cooler	Enhanced
Feed System	Manual loading	Vibratory feeder + auto control	Automated

Industrial Plant Design — 2 TPH Continuous Processing System

Process Flow Overview

Feedstock Intake → Feed Preparation (Screening & Magnetic Separation) → Rotary Thermal Beneficiation Furnace → Forced-Air Cascade Cooling → Quality Analysis → Furnace-Ready Cullet Storage & Dispatch

System Architecture — Major Process Units

Unit / Section	Equipment	Design Parameters	Function
U-01: Feed Preparation	Vibro Screen + Magnetic Separator	8-40 mm mesh 2,200 kg/hr rated	Remove oversize/undersize fines and ferrous metal; uniform feed
U-02: Pre-drying (if reqd.)	Indirect Hot-Air Dryer (optional bypass)	150 degrees C Reduce surface moisture to <1%	Minimise steam generation inside furnace; improve thermal efficiency
U-03: Rotary Thermal Furnace (Primary Process Unit)	KERONE Continuous Rotary Thermal Beneficiation Furnace	2,200 kg/hr capacity 500 degrees C 45 min residence L/D = 10:1 oxidising atmosphere 3-zone heating	Core thermal processing — organic burnout, LOI reduction
U-04: Combustion Air System	Forced-Draft Blower + Air Preheater	Ambient air up to 30% O2 enrichment optional 250 Nm3/hr	Sustain oxidation of organics; control furnace atmosphere
U-05: Volatile Collection	After-burner / Thermal Oxidiser + Scrubber	850 degrees C afterburner 2-sec residence wet scrubber for acid gases	Combust VOC-laden off-gas from furnace; meet emission norms (CPCB)
U-06: Cooling Zone	Forced-Air Cascade Cooler	Inlet: 500 degrees C Outlet: <60 degrees C 2,000 kg/hr	Cool cullet before handling; prevent thermal-shock cracking
U-07: Product Handling	Belt Conveyor + Big Bag Filler / Silo Loading	Load cell-based auto filling	Transfer treated cullet to storage; prevent recontamination
U-08: Emission Control	Pulse-jet Bag Filter + Induced Draft Fan	Efficiency: >99.9% PM < 30 mg/Nm3 Compliant: CPCB Stack Norms	Capture fine glass/silica dust; zero visible emissions
U-09: Process Control	PLC/SCADA Control Panel	Siemens S7 / Allen Bradley Remote monitoring capable	Automated temperature, flow, residence time control; data logging

Core Equipment Specification — KERONE Rotary Thermal Furnace

The KERONE Continuous Rotary Thermal Beneficiation Furnace is the heart of the cullet upgrading system. Designed and manufactured in-house at KERONE's Ambarnath facility, it directly scales the validated laboratory parameters from KRDC trial 52/KRDC/LAB/22 to industrial throughput while maintaining the identical thermal profile, residence time, and atmosphere control that produced the 0.42% LOI result.

ROTARY THERMAL FURNACE — CORE SPECIFICATIONS	Value
Design Throughput	2,200 kg/hr (cullet input)
Operating Temperature	500 degrees C (max design: 800 degrees C)
Residence Time	45 min (adjustable 20-90 min via RPM)
Drum Dimensions	ID 800 mm x L 9,000 mm (alloy steel)
Heating Zones	3 independent zones (electric with gas-assist)
Atmosphere	Forced-air draft O ₂ 18-21%
Drive System	VFD-controlled 11 kW gear motor
Installed Power	~175 kW (total connected load)
Shell Material	MS with high-temperature ceramic lining
Insulation	Ceramic fibre blanket — 180 mm
Sealing	Labyrinth + carbon-ring seals (dust-tight)

Utilities & Ancillary Requirements

Utility	Specification	Consumption (at 2 TPH)	Source
Electrical Power	415V, 3-phase, 50Hz	~175 kW connected ~135 kW avg demand	Site utility
Combustion Air	Ambient, forced draft	250 Nm ³ /hr	Blower package
Cooling Water (scrubber)	25 degrees C supply closed loop	8 m ³ /hr 32 degrees C return	Cooling tower
Compressed Air	6 bar dry instrument grade	18 Nm ³ /hr	Air compressor (site)
Space Requirement	Building / covered area	L 35m x W 14m x H 8m	New shed or existing bay

Emission Compliance

Emission Point	Pollutant	Expected Level	CPCB / MoEF Limit	Status
Furnace off-gas (after afterburner)	PM10	< 20 mg/Nm ³	50 mg/Nm ³	COMPLIANT
Furnace off-gas	VOC / TOC	< 10 mg/Nm ³	20 mg/Nm ³	COMPLIANT
Cooling + handling (bag filter outlet)	Glass/Silica Dust	< 25 mg/Nm ³	50 mg/Nm ³	COMPLIANT

Mass Balance & Energy Analysis — 2 TPH Operation

Detailed Mass Balance — Per Hour at Full Load

Stream	Material	Flow Rate (kg/hr)	Notes
Feed (IN)	Raw mixed-colour cullet (as-received)	2,000	3.80% LOI, 0.9% moisture, Vitrum quality
Volatile / Organic Loss	Organic residues + residual moisture	~76	~3.8% of feed at 45-min hold; passed to afterburner
Moisture (pre-drying)	Surface moisture removal	~18	Removed in pre-dryer if feed moisture >2%
Product (OUT)	Furnace-ready cullet	~1,870	< 0.5% LOI; 0.42% typical; bagged / bulk loaded
Fines (recycled)	Bag filter fines	~36	Collected from U-08; recycled to product or waste stream
Combustion products	CO ₂ , H ₂ O, trace SO ₂	Stack	Post-afterburner stack; meets CPCB emission limits

Table 4: Mass balance — 2 TPH continuous glass cullet processing plant | Based on validated KRDC lab data scaled to industrial throughput

Energy Consumption Estimates

Energy Category	Equipment / Unit	Power (kW)	Load Factor	Consumption (kWh/tonne product)
Furnace Heating (Ramp + Hold)	Electric resistance heaters (3-zone, 130 kW total)	130	72%	~100
Drive Systems	Rotary drum drive + conveyor drives	18	80%	~14
Cooling System	Forced-air cascade cooler fans	12	85%	~9
Afterburner	Thermal oxidiser (burner fuel: LPG)	LPG: 3.5 kg/hr	100%	~40 kWh eq.
Emission Control	ID fan + bag filter + scrubber pump	16	85%	~13
Utilities & Controls	Combustion air blower + SCADA + lighting + misc	11	60%	~4
TOTAL		~187 kW		~180 kWh/tonne

Product Quality Specification & Market Applications

Expected Product Specification — KERONE Processed Cullet

Parameter	Test Method	Raw Cullet (Input)	Processed (20-min hold)	Processed (45-min hold)	Furnace-Ready Spec
Moisture Content	IS 2086	0.90%	< 0.5%	< 0.3%	< 0.5%
Loss on Ignition (LOI)	ASTM C114	3.80%	1.85%	0.42%	< 0.50%
Organic / Plastic Contamination	Gravimetric	4.20%	1.10%	0.30%	< 0.50%
Ceramic-Stone-Porcelain (CSP)	ASTM C1866	120 ppm	~95 ppm	~60 ppm	< 50 ppm
Colour Sortation Purity	Visual sort	~92%	~94%	~96%	> 95%
Product Grade	Classification	Contaminated cullet	Standard furnace cullet	Premium furnace-ready cullet	Furnace-ready spec

Table 6: Product quality specification — raw cullet vs processed cullet vs furnace-ready specification | 45-min processed column highlighted = recommended for high-value applications

Market Applications for Processed Cullet

- Container Glass Manufacturing (Furnace Cullet Feed)** — Bottle and jar manufacturers can use furnace-ready cullet at 60-90% substitution rates, replacing virgin raw materials (silica sand, soda ash, limestone) and cutting furnace energy demand. LOI-compliant cullet at <0.5% qualifies for high-substitution furnace charges.
- Fibre Glass & Insulation Wool Manufacturing** — Non-container glass applications accept furnace-ready cullet as a partial raw-material substitute, reducing melting energy and raw-material cost.
- Ceramic Glaze & Frit Formulations** — Low-organic, colour-sorted cullet is used as a flux and silica source in ceramic glaze and frit compounding. 45-min processed cullet with <0.5% LOI meets premium frit-grade requirements.
- Foam Glass & Lightweight Aggregate** — Crushed furnace-ready cullet is used as feedstock for foam glass insulation panels and lightweight construction aggregate; less colour-sensitive than container-glass applications.
- Glass Tile, Terrazzo & Decorative Aggregate** — Construction and décor segments use processed cullet as a coloured aggregate; suits 20-min processed material as an entry-level, less quality-sensitive market.

Financial Analysis & Return on Investment

Cumulative Cash Flow — 5-Year Projection

Year	Cumulative Cash Flow (INR Lakhs)	Note
Year 0 (CAPEX)	-62	Initial plant investment
Year 1	-20	Ramp-up phase
Year 2	18	Break-even reached ~2.2 years
Year 3	58	
Year 4	98	
Year 5	138	

Table 7: Cumulative cash flow — 2 TPH glass cullet processing plant, 5-year projection | Break-even ~2.2 years at assumed furnace-ready cullet price of INR 10,500/tonne

CAPEX Estimate — 2 TPH Plant

Cost Head	Scope	Estimated Cost (INR Lakhs)	Notes
Rotary Thermal Furnace (Primary Equipment)	KERONE supply, factory tested	22-27	FOT Ambernath; includes drive, seals, controls
Afterburner / Thermal Oxidiser	VOC destruction, LPG fired	7-9	850 degrees C, 2-sec residence, SS construction
Combustion Air System	Forced-draft blower + preheater	3-4	250 Nm3/hr capacity
Cooling System	Forced-air cascade cooler	3-4	Air-cooled, dust-tight enclosure
Emission Control (Bag filter + Scrubber)	CPCB-compliant stack system	4-5	Pulse-jet BF + ID fan + wet scrubber
Feed Handling & Product Packing	Vibro screen, conveyor, big bag filler	4-5	Load cell filling, magnetic separator
Electrical & Instrumentation	MCC panel, SCADA, cabling, transformer	6-7	PLC/SCADA by KERONE; site electrical by client
Civil & Structural	Foundation, shed, utilities connections	4-5	Client scope; KERONE to provide layout drawing
Commissioning, Training & Startup	KERONE commissioning team, 15-day site support	2-3	Includes operator training and performance test
TOTAL CAPEX		INR 58-72 Lakhs	Approx. range; detailed quote on enquiry

Revenue & OPEX Model — Annual Basis (7,200 hr/yr operation)

Item	Basis	INR/Year (Lakhs)	Remarks
REVENUE			
Furnace-Ready Cullet Sales	1,870 kg/hr x 7,200 hr x INR 10,500/t	INR 1,414 Lakhs	Conservative price; market range INR 9,000-12,000/t
OPERATING COSTS			
Electricity	180 kWh/t x 13,464 t/yr x INR 8/kWh	INR 194 Lakhs	Based on INR 8/kWh industrial tariff
LPG (afterburner)	3.5 kg/hr x 7,200 hr x INR 100/kg	INR 25 Lakhs	Afterburner fuel; can substitute with natural gas
Labour (Operations)	4 operators/shift x 3 shifts x 12 months	INR 24 Lakhs	At INR 25,000/operator/month CTC
Maintenance & Spares	3% of CAPEX per annum	INR 2 Lakhs	Annual maintenance provision
Miscellaneous & Overheads	QC testing, consumables, admin	INR 10 Lakhs	General provision
NET PROFIT BEFORE TAX		INR ~1,159 Lakhs/yr	Payback ~2.2 years on INR 65L CAPEX

Table 8: Revenue & OPEX model — 2 TPH plant at 7,200 hr/yr | Indicative figures; actual revenue depends on cullet market price and product grade achieved

Project Execution & KERONE Scope of Supply

Implementation Timeline

Phase	Activity	Duration	KERONE Deliverable
Phase 0 — Pre-Order	Technical consultation, site visit, process design freeze, commercial negotiation	4-6 Weeks	Process Design Basis (PDB), GA drawing, utility list, commercial offer
Phase 1 — Engineering	Detailed engineering: mechanical, electrical, civil layout, P&ID; finalization	6-8 Weeks	Complete engineering package, vendor drawings, DFM approval
Phase 2 — Procurement	Long-lead items: furnace shell, alloy drum, refractory, drives, blower package	8-10 Weeks	Material test certificates, QC inspection reports, FAT invitation
Phase 3 — Fabrication	Rotary furnace fabrication, afterburner assembly, bag filter, SCADA panel	10-12 Weeks	Factory Acceptance Test (FAT) at KERONE Ambarnath; client witness invited
Phase 4 — Installation	Equipment erection at client site; piping, electrical, instrument hook-up	4-5 Weeks	KERONE site supervision; civil and electrical by client as per KERONE drawings
Phase 5 — Commissioning	Cold trials, hot trials with cullet, performance guarantee test, operator training	2-3 Weeks	Commissioning report, performance test certificate, O&M manual, training records
TOTAL PROJECT TIMELINE	Order to commercial production	~34-44 Weeks	From purchase order to first commercial output

KERONE Scope of Supply & Services

Category	KERONE Scope (INCLUDED)	Client Scope (EXCLUDED from KERONE supply)
Process Design	Process design basis, mass balance, heat & material balance, P&ID	Feedstock quality guarantee; plant operating schedule
Primary Equipment	Rotary thermal furnace (complete), afterburner, combustion air system, cascade cooler, product handling	Feed preparation (screening/sorting) if not included in enquiry scope
Emission Control	Pulse-jet bag filter, scrubber, ID fan (CPCB compliant)	Stack height design and consent-to-operate from CPCB/SPCB
Controls	PLC/SCADA, MCC panel, all instruments and field wiring	DG set, main power supply connection, transformer
Civil & Structural	Foundation load drawings, GA layout, anchor bolt drawings	All civil work, sheds, platforms, ladders, drains
Commissioning	FAT, site commissioning, performance test, operator training (15 days)	Consumables (LPG, power) for commissioning; feedstock for trials
Documentation	P&ID, GA drawings, O&M manual, spares list, test certificates	Client-side approvals, regulatory consents, insurance

Conclusions & Why KERONE

The KERONE-designed 2 TPH Continuous Glass Cullet Processing System represents a proven, commercially validated solution to one of the most significant value-unlock opportunities in India's glass recycling industry. The process is built on rigorous KRDC laboratory data — not theoretical projections — and the industrial design directly replicates the exact process conditions that produced measurable, certified results on Vitrum's actual production cullet.

- **Proven Technology** — Every process parameter in the 2 TPH plant — 500 degrees C, 45-minute residence, oxidising atmosphere — is directly derived from KRDC lab trial 52/KRDC/LAB/22 on client's actual feedstock. No extrapolation; no assumptions.
- **Quantified Outcome** — LOI reduction from 3.80% to below 0.50%, and organic contamination reduction from 4.20% to below 0.50%, are measurable, certified results — not marketing claims.
- **Commercial Clarity** — The financial model demonstrates a payback period of approximately 2.2 years at conservative furnace-ready cullet pricing, converting an existing waste stream into a INR 1,400+ Lakh/year revenue line.
- **Full Ownership** — KERONE designs, manufactures, supplies, installs, and commissions the complete plant from a single point of accountability — eliminating multi-vendor coordination risk.
- **Scalable Platform** — The rotary thermal furnace platform is scalable. A 2 TPH system validated at Vitrum Glass Recycling creates the reference installation for 4, 8, and 15 TPH systems for other glass and ceramics processors across India and internationally.
- **Compliance-Ready** — Emission control is integral to the KERONE supply scope — the system is designed to CPCB stack norms, not retrofitted for compliance after the fact.

Enquire About Your Glass & Ceramics Processing Project

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To initiate a project discussion, please share: feedstock quality report + daily/annual tonnage + site location + target cullet grade required

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DISCLAIMER: All financial projections are indicative and based on prevailing market conditions as of July 2026. Process performance figures are derived from KRDC laboratory data (Report 52/KRDC/LAB/22) conducted on Vitrum Glass Recycling Pvt. Ltd. feedstock. Actual industrial performance may vary. This document is intended for discussion purposes; a formal quotation will be issued following detailed enquiry.