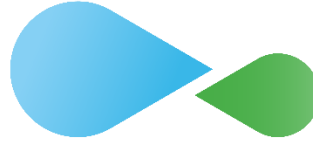
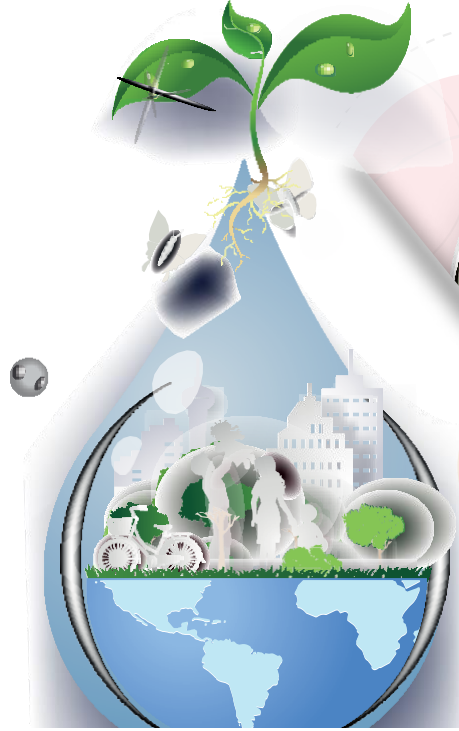




T.R.  
MINISTRY OF AGRICULTURE AND FORESTRY  
GENERAL DIRECTORATE OF WATER MANAGEMENT



Water Efficiency  
Campaign



**Water Efficiency  
Guidance Document Series**

**COLD ROLLING OF  
NARROW STRIPS**

**NACE CODE: 24.32**

**ANKARA 2023**

Prepared by the Ministry of  
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# Abbreviations

WTP	Wastewater Treatment Plant
EU	Europe Union
SSM	Suspended Solid Matter
BREF	Best Available Techniques Reference Document
EMS	Environment Management The system
MoEUCC	Republic of Turkey Ministry of Environment, Urbanization and Climate Change
NOM	Natural Organic Article
EMAS	Eco Management and Audit Program Directive
EPA	United States Environmental Protection Agency
IPPC	Industrial Pollution Prevention And Control
ISO	International Standardization for Organization
BAT	Best Available Techniques
NACE	Statistical Classification of Economic Activities
GSWM	General Directorate of Water Management
RO	Reverse Osmosis
MAF	Ministry of Agriculture and Forestry of the Republic of Turkey
TurkStat	Turkish Statistical Institute
NF	Nanofiltration
MF	Microfiltration
UF	Ultrafiltration
GW	Ground Water
SW	Surface Water

# 1 Introduction

Our country is located in the Mediterranean basin, where the effects of global climate change are felt intensely, and is considered to be among the regions that will be most affected by the negative effects of climate change. Projections on how our water resources in our basins will be affected in the future due to climate change show that our water resources may decrease by up to 25 percent in the next hundred years.

For the year 2022, the annual amount of water available per capita in Turkey is 1,313 m<sup>3</sup>, and it is expected that the annual amount of water available per capita will fall below 1,000 cubic meters after 2030 due to human pressures and the effects of climate change. If the necessary measures are not taken, it is obvious that Turkey will become a water scarce country in the very near future and will bring many negative social and economic consequences. As it can be understood from the results of future projections, the risk of drought and water scarcity awaiting our country necessitates the efficient and sustainable use of our existing water resources.

The concept of water efficiency can be defined as "*using the least amount of water in the production of a product or service*". The water efficiency approach is based on the rational, sharing, equitable, efficient and effective use of water in all sectors, especially in drinking water, agriculture, industry and household use, in a way that protects water in terms of quantity and quality and takes into account not only the needs of humans but also the needs of all living things with ecosystem sensitivity.

With the increasing demand for water resources, changes in precipitation and temperature regimes as a result of climate change, increasing population, urbanization and pollution, the fair and balanced distribution of usable water resources among users is becoming more and more important every day. Therefore, it has become imperative to create a road map based on efficiency and optimization in order to conserve and use limited water resources through sustainable management practices.

In the vision of sustainable development set by the United Nations, *Goal 7: Ensuring Environmental Sustainability* from the Millennium Development Goals, *Goal 9: Industry, Innovation and Infrastructure* from the Sustainable Development Goals and *Goal 12: Responsible Production and Consumption* from the Sustainable Development Goals include issues such as efficient, fair and sustainable use of resources, especially water, environmentally friendly production and consumption with concern for future generations.

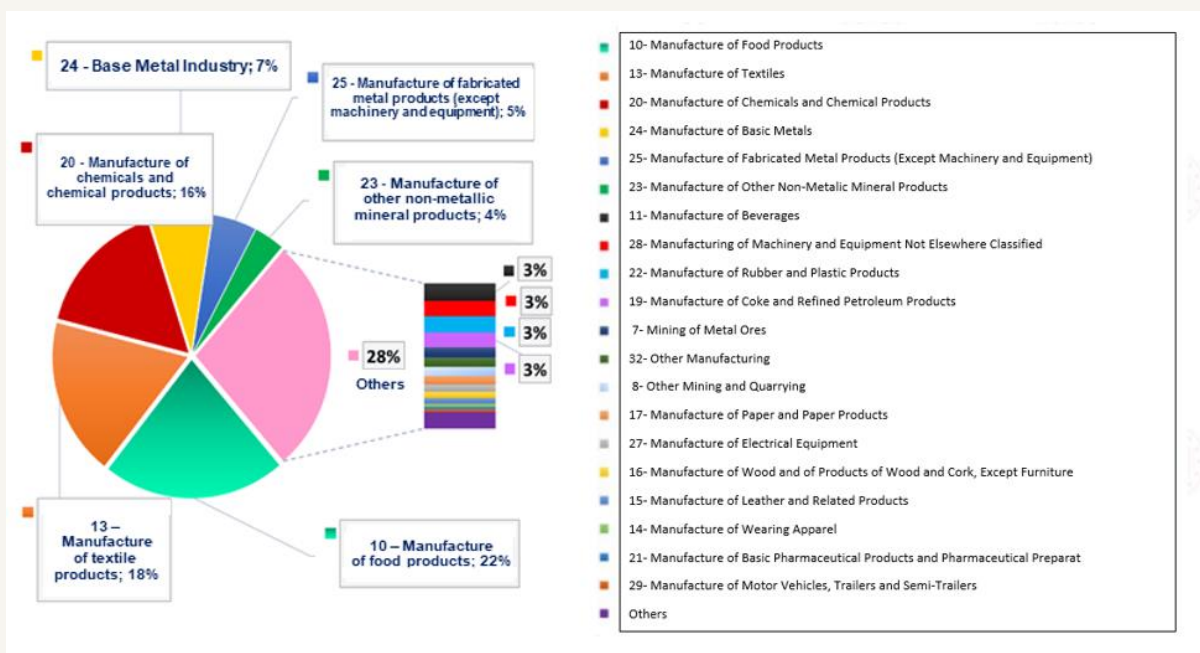
Within the scope of the European Green Deal, where member countries have agreed on goals such as implementing a clean, circular economy model with a carbon neutral target, expanding the efficient use of resources and reducing environmental impacts, actions emphasizing water and resource efficiency in production and consumption in various fields, especially in industry, have been determined in the European Green Deal Action Plan prepared by our country.

The "Industrial Emissions Directive (EED)", which is one of the most important components of the European Union environmental legislation in terms of industry, includes measures to be taken for the control, prevention or reduction of discharges/emissions from industrial activities to the receiving environment, including air, water and soil, with an integrated approach. In the Directive, Best Available Techniques (BAT) are presented in order to systematize the applicability of cleaner production processes and to eliminate difficulties in implementation. BATs are the most effective implementation techniques for a high level of environmental protection, taking into account their costs and benefits. In accordance with the Directive, Reference Documents (BAT-BREF) have been prepared for each sector detailing BATs. In the BREF documents, BATs are presented in a general framework such as good management practices, techniques as general measures, chemical use and management, techniques for various production processes, wastewater management, emission management and waste management.

The Ministry of Agriculture and Forestry, General Directorate of Water Management carries out activities aimed at disseminating efficient practices in urban, agricultural, industrial and individual water use and raising social awareness. Water efficiency action plans addressing all sectors and stakeholders were prepared within the scope of ***the "Water Efficiency Strategy Document and Action Plan (2023-2033) within the Framework of Adaptation to a Changing Climate"***, which entered into force with the Presidential Circular No. 2023/9. In the Industrial Water Efficiency Action Plan, a total of 12 actions have been determined for the 2023-2033 period and responsible and relevant institutions have been assigned for these actions. Within the scope of the Action Plan, the General Directorate of Water Management has been assigned the responsibility of conducting studies to determine specific water use ranges and quality requirements on the basis of sub-sectors in industry, organizing technical training programs and workshops on sectoral basis and preparing water efficiency guidance documents.

On the other hand, with the ***"Industrial Water Use Efficiency Project by NACE Codes"*** carried out by the General Directorate of Water Management of the Ministry of Agriculture and Forestry, the best sectoral techniques specific to our country were determined within the scope of studies on improving water efficiency in industry. As a result of the study, sectoral guidance documents and action plans classified by NACE codes, which include measures recommended for improving water use efficiency in sectors with high water consumption operating in our country, were prepared.

As in the world, the sectors with the highest share in water consumption in our country are food, textile, chemical and basic metal sectors. Within the scope of the studies, field visits were carried out in enterprises representing 152 sub-sectors in 35 main sectors, mainly food, textile, chemical and basic metal industries, representing production areas with different capacities and diversity within the scope of NACE Codes operating in our country and with high water consumption, and data on water supply, sectoral water use, wastewater generation, recycling were obtained and information was provided on best available techniques (BAT) and sectoral reference documents (BREF) published by the European Union, water efficiency, clean production, water footprint, etc.



Distribution of water usage in industry sector in Türkiye

As a result of the studies, specific water consumption and potential savings rates for the processes of enterprises for 152 different 4-digit NACE codes with high water consumption were determined, and water efficiency guidance documents were prepared by taking into account the EU best available techniques (BAT) and other cleaner production techniques. The guidelines include 500 techniques (BATs) for water efficiency;

(i) Good Management Practices, (ii) General Measures, (iii) Measures Related to Auxiliary Processes and (iv) Sector Specific Measures.

Within the scope of the project, environmental benefits, operational data, technical specifications-requirements and applicability criteria were taken into consideration in the determination of BATs for each sector. In the identification of BATs, not only BREF documents were not limited, but also different data sources such as current literature data on a global scale, real case studies, innovative practices, reports of sector representatives were examined in detail and sectoral BAT lists were created. In order to evaluate the suitability of the BAT lists created for the local industrial infrastructure and capacity of our country, the BAT lists prepared specifically for each NACE code were prioritized by the enterprises by scoring them on the criteria of water saving, economic savings, environmental benefit, applicability, cross-media impact and the final BAT lists were determined using the scoring results. Water and wastewater data of the facilities visited within the scope of the project and the final BAT lists prioritized by sectoral stakeholders and taking into account the local dynamics specific to our country were used to create sectoral water efficiency guides based on NACE codes.



## 2 Scope of the Study

The guidance documents prepared within the scope of water efficiency measures in the industry include the following main sectors:

- Crop and animal production, hunting and related service activities (including sub-production areas represented by 6 four-digit NACE Codes )
- Fisheries and aquaculture (including 1 sub-production area represented by a four-digit NACE Code )
- Extraction of coal and lignite (including 2 sub-production areas represented by a four-digit NACE Code)
- Service activities in support of mining (including 1 sub-production area represented by a four-digit NACE Code )
- Metal ore mining (including 2 sub-production areas represented by a four-digit NACE Code)
- Other mining and quarrying (including 2 sub-production areas represented by a four-digit NACE Code)
- Manufacture of food products (including 22 sub-production areas represented by a four-digit NACE Code)
- Manufacture of beverages (including 4 sub-production areas represented by a four-digit NACE Code)
- Manufacture of MAFacco products (including 1 sub-production area represented by a four-digit NACE Code)
- Manufacture of textiles (including 9 sub-production areas represented by a four-digit NACE Code)
- Manufacture of apparel (including 1 sub-production area represented by a four-digit NACE Code)
- Manufacture of leather and related products (including 3 sub-production areas represented by a four-digit NACE Code)
- Manufacture of wood, wood products and cork products (except furniture); manufacture of articles made by knitting from reeds, straw and similar materials (including 5 sub-production areas represented by a four-digit NACE Code)
- Manufacture of paper and paper products (including 3 sub-production areas represented by a four-digit NACE Code)
- Manufacture of coke and refined petroleum products (including 1 sub-production area represented by a four-digit NACE Code )
- Manufacture of chemicals and chemical products (including 13 sub-production areas represented by a four-digit NACE Code )
- Manufacture of basic pharmaceutical products and pharmaceutical materials (including 1 sub-production area represented by a four-digit NACE Code )
- Manufacture of rubber and plastic products (including 6 sub-production areas represented by a four-digit NACE Code )
- Manufacture of other non-metallic mineral products (including 12 sub-production areas represented by a four-digit NACE Code )
- Base metal industry (including 11 sub-production areas represented by a four-digit NACE Code)
- Manufacture of fabricated metal products (excluding machinery and equipment) (including 12 sub-production areas represented by a four-digit NACE Code )
- Manufacture of computers, electronic and optical products (including sub-production area represented by 2 four-digit NACE Codes )
- Manufacture of electrical equipment (including 7 sub-production areas represented by a four-digit NACE Code)
- Manufacture of machinery and equipment, n.e.c. (including 8 sub-production areas represented by a four-digit NACE Code )
- Manufacture of motor vehicles, trailers and semi-trailers (including 3 sub-production areas represented by a four-digit NACE Code)
- Manufacture of other means of transport (including 2 sub-production areas represented by a four-digit NACE Code)
- Other productions (including 2 sub-production areas represented by a four-digit NACE Code)
- Installation and repair of machinery and equipment (including 2 sub-production areas represented by a four-digit NACE Code )
- Electricity, gas, steam and ventilation system production and distribution (including 2 sub-production areas represented by a four-digit NACE Code)
- Waste collection, remediation and disposal activities; recovery of materials (including 1 sub-production area represented by a four-digit NACE Code)
- Construction of non-building structures (including 1 sub-production area represented by a four-digit NACE Code)
- Storage and supporting activities for transportation (including 1 sub-production area represented by a four-digit NACE Code)



- Accommodation (including 1 sub-production area represented by a four-digit NACE Code)
- Educational Activities (Higher Education Campuses) (including 1 sub-production area represented by a four-digit NACE Code)
- Sports, entertainment and recreational activities (including 1 sub-production area represented by a four-digit NACE Code )

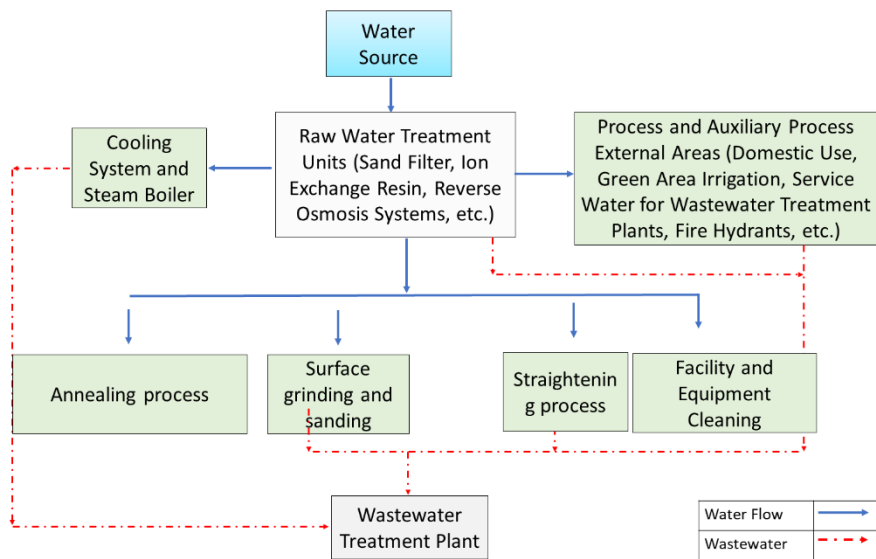
"Basic metal industry" and "Manufacture of fabricated metal products (except machinery and equipment)"

The sub-production branches for which guidance documents were prepared under the "Basic metal industry" and "Manufacture of fabricated metal products (except machinery and equipment)" sectors are as follows

24.10	Manufacture of basic iron and steel products and ferroalloys
24.20	Manufacture of steel tubes, pipes, hollow profiles and similar fittings
24.31	Cold withdrawal of bars
24.32	Cold rolling of narrow strips
24.34	Cold pulling of wires
24.41	Precious metal production
24.42	Aluminum production
24.51	Iron casting
24.52	Steel casting
24.53	Casting of light metals
24.54	Casting of other non-ferrous metals
25.12	Manufacture of metal doors and windows
25.21	Manufacture of central heating radiators (except electric radiators) and hot water boilers (boilers)
25.30	Manufacture of steam generators, except central heating hot water boilers (boilers) Forging, pressing, stamping and rolling of metals; powder metallurgy
25.50	
25.61	Processing and coating of metals
25.62	Machining and shaping of metals
25.71	Manufacture of cutlery and other cutting tools
25.73	Manufacture of hand tools, machine tool bits, saw blades, etc.
25.92	Manufacture of lightweight packaging materials from metal
25.93	Manufacture of wire products, chains and springs
25.94	Manufacture of fastening materials and screw machine products
25.99	Manufacture of other fabricated metal products not elsewhere classified

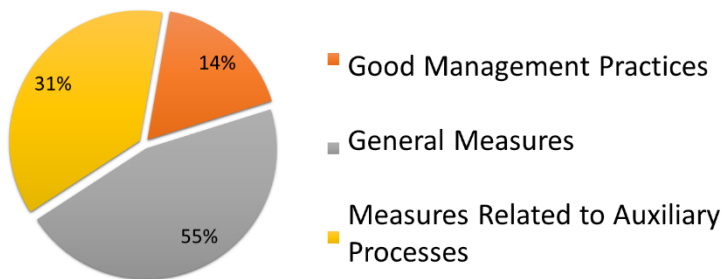
# 2.1 Cold Rolling of Narrow Strips (NACE 24.32)

Water Flow Diagram For The Cold Rolling Of Narrow Strips



	Minimum	Maximum
Specific Water Consumption of Facilities Visited in the Project (L/unit of product)	0,16	
Reference Specific Water Consumption (L/kg of product)	3	5

Percentage Distribution of Water Efficiency Practices



In the rolling process, the metal strip is pressed by two or more rollers to obtain a standard thickness. There are two types of rolling: hot rolling and cold rolling. If the metal strip is rolled after being heated above the crystallization temperature, this process is called hot rolling. If it is done at room temperature, it is called cold rolled. Cold rolled steel is actually hot rolled steel that has undergone further processing.

In the cold rolling of narrow strips sector, water is used in annealing, stretching - straightening, surface grinding and sanding processes. In raw water preparation units such as sand filter, ion exchange resin, reverse osmosis, which are used to produce soft water for use in production processes, significant water consumption is also realized for filter washing, resin regeneration and membrane cleaning processes. Water consumption also occurs in auxiliary processes such as cooling system and steam boiler.

The reference specific water consumption in the narrow strip cold rolling sector is in the range of 3 - 5 L/kg. The specific water consumption of the production line analyzed in the study is 0.16 L/kg. With the implementation of good management practices, general measures and measures related to auxiliary processes, it is possible to achieve water savings of 18 - 26% in the sector.



[https://www.steelwarehouse.com/assets/images/content/coldmill\\_2.jpg](https://www.steelwarehouse.com/assets/images/content/coldmill_2.jpg)  
Cold Rolling Process

24.32 Cold Rolling of Narrow Strips Prioritized water efficiency implementation techniques recommended under the NACE code are presented in the table below.

NACE Code	NACE Code Description	Sectoral Prioritized Best Available
24.32	Cold rolling of narrow strips	<p><b>Good Management Practices</b></p>
		<p>1. Use integrated wastewater management and treatment strategy to reduce wastewater quantity and pollutant load</p>
		<p>2. Establishment of environmental management system</p>
		<p>3. Preparing a water efficiency action plan to reduce water use and prevent water pollution</p>
		<p>4. Good production planning to optimize water consumption</p>
		<p><b>Measures in the nature of General Measures</b></p>
		<p>1. Recovering water from rinsing solutions and reusing the recovered water in processes appropriate to the quality of the recovered water Shower/toilet etc. will provide water savings at water usage points</p>
		<p>2. the use of automated hardware and equipment (sensors, smart hand washing systems, etc.)</p>
		<p>3. Reducing water consumption by reusing filter wash water in filtration processes, reusing relatively clean cleaning water in production processes and using clean-in-place systems (CIP)</p>
		<p>4. Avoiding the use of drinking water in production lines</p>
		<p>5. Identification and reduction of water losses</p>
		<p>6. Use of automatic control-close valves to optimize water use Reuse of pressurized filtration backwash water prior to water softening at appropriate points</p>
		<p>7. Optimizing the frequency and duration of regeneration (including rinses) in water softening systems</p>
		<p>9. Transportation of toxic or hazardous chemicals for the aquatic environment Construction of a closed storage and impermeable waste/scrap site to prevent</p>
	<p>10. Substances that pose a risk in the aquatic environment (oils, emulsions, binders) storage, storage and prevention of mixing with wastewater after use</p>	
	<p>11. Preventing the mixing of clean water streams with dirty water streams Preventing the quantity and quality of wastewater at all wastewater generation points</p>	
	<p>12. characterization of wastewater streams that can be reused with or without treatment</p>	
	<p>13. Untreated reuse of relatively clean wastewater from washing, rinsing and equipment cleaning in production processes Scope</p>	
	<p>14. of reuse of washing and rinsing water Determination of</p>	

NACE Kodu	NACE Code Description	Sectoral Prioritized Best Available Techniques
24.32	Cold rolling of narrow strips	<p>Separate collection and treatment of gray water and high water quality</p> <ol style="list-style-type: none"> <li>15. use in areas that do not require (green area irrigation, floor washing, etc.)</li> <li>16. Implementing time optimization in production and organizing all processes to be completed as soon as possible</li> <li>17. Collecting rainwater and utilizing it as an alternative water source for facility cleaning or in suitable areas</li> <li>18. Nanofiltration (NF) or reverse osmosis (RO) concentrates reuse with or without treatment depending on the characterization</li> </ol> <p><b>Precautions for Auxiliary Processes</b></p> <ol style="list-style-type: none"> <li>1. Saving water by reusing steam boiler condensate</li> <li>Water saving with insulation of steam and water lines (hot and cold)</li> <li>2. ensuring the prevention of water and steam losses in pipes, valves and connection points in the lines and monitoring them with a computer system</li> <li>3. Reducing water consumption in closed loop cooling systems by increasing the number of cycles and improving the quality of make-up water Corrosion and scale inhibitors in systems with closed water cycles</li> <li>4. increasing the number of cycles using inhibitors</li> <li>5. Prevention of flash steam losses due to boiler unloading</li> <li>6. Use of closed loop cooling system to reduce water usage</li> <li>7. Collecting the water generated by surface runoff with a separate collection system and using it for cooling water, process water, etc.</li> <li>8. Minimization of boiler discharge water (blowdown) in steam boilers</li> <li>9. Reuse of energy generated from the steam condenser</li> </ol>

A total of 31 techniques have been proposed in this sector.

#### For Cold Rolling of Narrow Strips NACE Code;

- (i) Good Management Practices,
- (ii) General Precautions and
- (iii) Measures for auxiliary processes are given under separate headings.



## 2.1.1 Good Management Practice

### • **Establishment of an environmental management system**

Environmental Management Systems (EMS) include the organizational structure, responsibilities, procedures and resources necessary to develop, implement and monitor the environmental policies of industrial organizations. The establishment of an environmental management system improves the decision-making processes of organizations between raw materials, water and wastewater infrastructure, planned production process and different treatment techniques. Environmental management organizes how resource supply and waste discharge demands can be managed with the highest economic efficiency, without compromising product quality and with the least possible impact on the environment.

The most widely used Environmental Management Standard is ISO 14001. Alternatives include the Eco Management and Audit Scheme Directive (EMAS) (761/2001). It was developed to assess, improve and report on the environmental performance of businesses. It is one of the leading practices within the scope of eco-efficiency (cleaner production) in EU legislation and voluntary participation is provided (TUBITAK MAM, 2016; TOB, 2021). The benefits of establishing and implementing an Environmental Management System are as follows:

- Economic benefits can be achieved by improving business performance (Christopher, 1998).
- International Organization for Standardization (ISO) standards are adopted, ensuring greater compliance with global legal and regulatory requirements (Christopher, 1998).
- While minimizing the risks of penalties associated with environmental responsibilities, the amount of waste, resource consumption and operating costs are reduced (Delmas, 2009).
- The use of internationally recognized environmental standards eliminates the need for multiple registrations and certifications for businesses operating in different locations around the world (Hutchens Jr., 2017).
- Especially in recent years, the improvement of companies' internal control processes has also been emphasized by consumers. The implementation of environmental management systems provides a competitive advantage against companies that do not adopt the standard. It also contributes to the better position of organizations in international areas / markets (Potoski & Prakash, 2005).

The above-mentioned benefits depend on many factors such as the production process, management practices, resource utilization and potential environmental impacts (TOB, 2021). Practices such as preparing annual inventory reports with similar content to an environmental management system and monitoring the quantity and quality of inputs and outputs in production processes can save 3-5% of water consumption (Öztürk, 2014). The total duration of the development and implementation phases of an EMS takes an estimated 8-12 months (ISO 14001 User Manual, 2015).

Industrial organizations also carry out studies within the scope of ISO 14046 Water Footprint Standard, an international standard that defines the requirements and guidelines for assessing and reporting water footprint. The implementation of the relevant standard aims to reduce the use of fresh water required for production and environmental impacts. In addition, the ISO 46001 Water Efficiency Management Systems Standard, which helps industrial organizations save water and reduce operating costs, helps organizations develop water efficiency policies by conducting monitoring, benchmarking and review studies.

- ***Use integrated wastewater management and treatment strategy to reduce wastewater quantity and pollutant load***

Wastewater management should be based on a holistic approach from wastewater generation to final disposal, and includes functional elements such as composition, collection, treatment including sludge disposal, and reuse. The selection of the appropriate treatment technology for industrial wastewater depends on integrated factors such as land availability, desired treated water quality, and compliance with national and local regulations (Abbassi & Al Baz, 2008).

On-site reuse of treated wastewater not only improves the quality of water bodies, but also reduces the demand for freshwater. It is therefore crucial to identify appropriate treatment strategies for different reuse objectives.

In integrated industrial wastewater treatment, different aspects such as wastewater collection system, treatment process and reuse target are considered together (Naghedi et al., 2020). For industrial wastewater recovery, methods such as SWOT method (strengths, weaknesses, opportunities and threats), PESTEL method (political, economic, social, technological, environmental and legal factors), decision tree can be combined with expert opinions to determine the integrated wastewater management framework (Naghedi et al., 2020). Integrating Analytic Hierarchy Process (AHP) and CoCoSo techniques can be used to set priorities for industrial wastewater management processes based on multiple criteria (Adar et al., 2021).

The implementation of integrated wastewater management strategies can reduce water consumption, wastewater quantity and pollution loads of wastewater by up to 25% on average. The potential payback period of implementation varies between 1-10 years (MoAF, 2021).





- ***Good production planning to optimize water consumption***

In industrial production processes, planning by using the least amount of process from raw material to product is an effective practice to reduce labor costs, resource utilization costs and environmental impacts and to ensure efficiency (TUBITAK MAM, 2016; TOB, 2021). Production planning in industrial plants, taking into account the water efficiency factor, reduces water consumption and wastewater amount. Modifying production processes or combining some processes in industrial plants provides significant benefits in terms of water efficiency and time planning (TOB, 2021).

- ***Preparing a water efficiency action plan to reduce water use and prevent water pollution***

It is important for water efficiency to prepare an action plan that includes short, medium and long term actions to be taken in order to reduce water-wastewater quantities and prevent water pollution in industrial facilities. At this point, determination of water needs throughout the facility and in production processes, determination of quality requirements at water use points, wastewater generation points and wastewater characterization should be carried out (TOB, 2021). At the same time, measures to be implemented to reduce water consumption, wastewater generation and pollution loads should be determined, feasibility should be made and action plans should be prepared for the short-medium-long term. In this way, water efficiency and sustainable water use in facilities are ensured (MoAF, 2021).

## 2.1.2 Measures in the nature of General Measures

- **Identification and reduction of water losses**

Water losses occur in equipment, pumps and pipelines in industrial production processes. First of all, water losses should be identified and equipment, pumps and pipelines should be regularly maintained and kept in good condition to prevent leaks (IPPC BREF, 2003). Regular maintenance procedures should be established, paying particular attention to

- Adding pumps, valves, level switches, pressure and flow regulators to the maintenance checklist,
- Inspections not only of the water system, but also, in particular, of heat transfer and chemical distribution systems, broken and leaking pipes, drums, pumps and valves,
- Regular cleaning of filters and pipelines,
- Calibrate, routinely check and monitor measurement equipment such as chemical measuring and dispensing devices, thermometers, etc. (IPPC BREF, 2003).

With effective maintenance-repair, cleaning and loss control practices, savings ranging from 1-6% in water consumption can be achieved (Öztürk, 2014).

- **Untreated reuse of relatively clean wastewater from washing, rinsing and equipment cleaning in production processes**

In industrial plants, relatively clean wastewaters such as washing-final rinse wastewaters and filter backwash wastewaters can be reused without treatment in floor washing and garden irrigation processes that do not require high water quality, saving between 1-5% in raw water consumption. The initial investment costs required for the application are the installation of new pipelines and reserve tanks (Öztürk, 2014).

- **Prevention of mixing of clean water flows with polluted water flows**

By identifying wastewater generation points in industrial facilities and characterizing wastewater, wastewater with high pollution load and relatively clean wastewater can be collected in separate lines (TUBITAK MAM, 2016; TOB, 2021). In this way, wastewater streams with appropriate quality can be reused with or without treatment. By separating wastewater streams, water pollution is reduced, treatment performances are improved, energy consumption can be reduced in relation to the reduction of treatment needs, and emissions are reduced through wastewater recovery and recovery of valuable materials. It is also possible to recover heat from separated hot wastewater streams (TUBITAK MAM, 2016; TOB, 2021). Separation of wastewater streams generally requires high investment costs, which can be reduced where it is possible to recover large amounts of wastewater and energy (IPPC BREF, 2006).

- ***Determination of wastewater flows that can be reused with or without treatment by characterizing wastewater quantities and qualities at all wastewater generation points***

By identifying and characterizing wastewater generation points in industrial facilities, it is possible to reuse various wastewater streams with or without treatment (Öztürk, 2014; TUBİTAK MAM, 2016; TOB, 2021). In this context, filter backwash waters, TO concentrates, blowdown waters, condensate waters, relatively clean washing and rinsing waters can be reused without treatment in the same/different processes and in areas that do not require high water quality (such as facility and equipment cleaning). In addition, wastewater streams that cannot be directly reused can be reused in production processes after treatment using appropriate treatment technologies.

Membrane filtration processes are an integral part of many wastewater reuse systems. Nanofiltration (NF) and Reverse osmosis (RO) filtration systems are used for industrial wastewater recovery. Microfiltration (MF) and ultrafiltration (UF) are generally used for pre-treatment of water before it goes to NF or TO (Singh et al., 2014).

- ***Determining the scope of reuse of washing and rinsing water***

In industrial plants, relatively clean wastewaters such as wash-final rinse wastewaters and filter backwash wastewaters can be reused without treatment in floor washing and garden irrigation processes that do not require high water quality (Öztürk, 2014). Thus, raw water consumption It is possible to save between 1-5% (MoAF, 2021).

- ***Use of automatic control-close valves to optimize water use***

Monitoring and controlling water consumption using flow control devices, meters and computer-aided monitoring systems provides significant technical, environmental and economic advantages (Öztürk, 2014). Monitoring the amount of water consumed in the plant and in various processes prevents water losses (TUBİTAK MAM, 2016). It is necessary to use flow meters and meters in the plant in general and in production processes in particular, to use automatic shut-off valves and valves in continuously operating machines, and to develop monitoring-control mechanisms according to water consumption and some determined quality parameters by using computer-aided systems (TUBİTAK MAM, 2016). With this practice, it is possible to save up to 20-30% of water consumption on a process basis (DEPA, 2002; LCPC, 2010; IPPC BREF, 2003). By monitoring and controlling water consumption on a process basis, 3-5% savings in process water consumption can be achieved (Öztürk, 2014).

- ***Avoiding the use of drinking water in production lines***

In different sub-sectors of the manufacturing industry, waters with different water quality can be used for production purposes. In industrial plants, raw water from groundwater sources is generally used in production processes after treatment. However, in some cases, although it is costly, drinking water can be used directly in production processes or raw water is disinfected with chlorinated compounds and then used in production processes. These waters containing residual chlorine can react with organic compounds (natural organic matter (DOM)) in water in production processes and form disinfectant by-products harmful to living metabolisms (Özdemir & Toröz, 2010; Oğur et al.) The use of drinking water containing residual chlorine compounds or raw water disinfected with chlorinated compounds should be avoided as much as possible. Highly oxidizing disinfection methods such as ultraviolet (UV), ultrasound (US) or ozone can be used instead of chlorine disinfection for disinfection of raw water. In order to increase the technical, economic and environmental benefits of the application, it helps to reduce unnecessary water supply and treatment costs by determining and using the water quality parameters required in each production process. With this application, it is possible to reduce water, energy and chemical costs (TUBITAK MAM, 2016).

- ***Collecting rainwater and utilizing it as an alternative water source in facility cleaning or in suitable areas***

Nowadays, when water resources are decreasing, rainwater harvesting is frequently preferred especially in regions with low rainfall. There are different technologies and systems for rainwater collection and distribution systems. Cistern systems, ground infiltration, surface collection and filter systems are used. Rainwater collected with special drainage systems can be used for production processes, garden irrigation, tank and equipment cleaning, surface cleaning, etc. if it meets the required quality requirements (Tanik et al., 2015).

In various examples, roof rainwater collected in industrial facilities was stored and then used inside the building and in landscape areas, resulting in 50% water savings in landscape irrigation (Yaman, 2009). Perforated stones and green areas can be preferred to increase the permeability of the ground and allow rainwater to pass through and be absorbed into the soil on site (Yaman, 2009). Rainwater collected on building roofs can be used for car washing and garden irrigation. It is possible to recover and reuse 95% of the collected water after use through biological treatment (Şahin, 2010).

- **Optimizing the frequency and duration of regeneration (including rinses) in water softening systems**

Cationic ion exchange resins, one of the most commonly used methods for softening raw water in industrial plants, are routinely regenerated. In regeneration, pre-washing of the resin using raw water, regeneration with salt water and final rinsing processes are carried out respectively. Regeneration periods are determined depending on the hardness of the water. If the hardness is high, regeneration should be performed more frequently in water softening systems.

In regeneration processes, washing, regeneration and rinsing wastewaters are usually removed directly. However, if the washing and final rinse water is of raw water quality, it can be sent to raw water storage or reused in processes that do not require high water quality such as facility cleaning and green area irrigation (TOB, 2021).

It is very important to determine the optimum regeneration frequency in regeneration systems. Although regeneration in water softening systems is adjusted according to the frequencies recommended by the supplier or depending on the flow rate and time entering the softening system, this frequency also varies depending on the calcium concentration in the raw water. For this reason, online hardness measurement is applied when determining the regeneration frequency. Thus, regeneration frequencies can be optimized and excessive washing rinsing or backwashing with brine can be prevented by using online hardness sensors.



Water Softening Systems

<https://www.youtube.com/watch?v=Deazp2Ukgio>



- **Reuse of pressurized filtration backwash water prior to water softening at appropriate points**

Many industrial processes require softened water with low calcium and magnesium concentrations. With water softening systems, calcium, magnesium and some other metal cations in hard water are removed from the water and soft water is obtained.

Savings are achieved by reusing pressurized filtration backwash water at appropriate points before water softening. This measure is similar in content to practices such as "Reuse of filter backwash water in filtration processes, reuse of relatively clean water in production processes, reduction of water consumption by using on-site cleaning systems".

- **Reuse of nanofiltration (NF) or reverse osmosis (RO) concentrates with or without treatment depending on their characterization**

Based on the wastewater characterization and appropriate point of use, the potential for reuse of other wastewater from membrane processes (backwashing without or with chemicals, CIP cleaning, module cleaning, cleaning of chemical tanks, etc.) should be assessed.

Nanofiltration is a membrane-based liquid separation technique with low energy consumption and low operating pressures suitable for the treatment of well water and surface water. Reverse osmosis is also a membrane-based liquid separation technique and can separate smaller substances than nanofiltration (Akgül, 2016).

Savings are achieved by reusing nanofiltration or reverse osmosis concentrates with or without treatment depending on their characterization. Measures should be taken to reduce water consumption by reusing clean water in the production processes of filter backwash water in filtration processes and using cleaning systems (TOB, 2021).



- **Preventing substances that pose a risk to the aquatic environment (such as oils, emulsions, binders) from being mixed into wastewater as much as possible after storage, storage and use** In industrial facilities, substances that pose a risk to the aquatic environment such as oils, emulsions and binders dry cleaning techniques to prevent chemicals from mixing into wastewater streams can be used and leaks can be prevented. In this way, water resources can be protected (TUBITAK MAM, 2016).
- **Construction of closed storage and impermeable waste/scrap sites to prevent the transportation of toxic or hazardous chemicals for the aquatic environment** Closed and impermeable waste/scrap storage sites can be constructed in industrial facilities to prevent the transportation of toxic or hazardous chemicals for the aquatic environment to receiving environments. This practice is already being implemented in our country within the scope of existing environmental regulations. Within the scope of the field studies carried out, a separate collection channel can be built in the storage areas of toxic or hazardous substances in industrial facilities to collect the leachate separately and prevent it from mixing into natural water environments.
- **Recovery of water from rinsing solutions and reuse of recovered water in processes appropriate to its quality** Rinsing wastewater in industrial plants is relatively clean wastewater that can be reused without treatment in floor washing and garden irrigation processes that do not require high water quality (Öztürk, 2014). Raw water consumption can be reduced with the recovery of rinse water. Savings between 1-5% can be achieved.
- **Use of automatic hardware and equipment (sensors, smart hand washing systems, etc.) to save water at water usage points such as showers/toilets etc.** Water is very important in many sectors of the manufacturing industry, both for production processes and for personnel to maintain the necessary hygiene standards. Water consumption in the production processes of industrial facilities can be achieved in various ways, and water consumption can be saved by using equipment such as sensor faucets and smart hand washing systems in the water usage areas of personnel. Smart hand washing systems provide resource efficiency in addition to water savings while adjusting the water, soap and air mixture at the right ratio.
- **Separate collection and treatment of gray water in the facility and its use in areas that do not require high water quality (green area irrigation, floor washing, etc.)** Wastewater generated in industrial facilities is not only industrial wastewater from production processes, but also includes wastewater from showers, sinks, kitchens, etc. Wastewater from showers, sinks, kitchens, etc. is called gray water. Water savings can be achieved by treating this gray water with various treatment processes and using it in areas that do not require high water quality.



- ***Reducing water consumption by reusing filter wash water in filtration processes, reusing relatively clean cleaning water in production processes and using clean-in-place systems (CIP)***

Wastewater from backwashing of activated carbon filters and softeners often contains only high levels of suspended solids (TSS). Backwash water, which is one of the easiest types of wastewater to recover, can be recovered by filtration with ultrafiltration plants. In this way, water savings of up to 15% can be achieved (URL - 1, 2021).

Regeneration wastewater generated after the regeneration process is soft water with high salt content and accounts for approximately 5-10% of total water consumption. Regeneration wastewater is collected in a separate tank and utilized in processes with high salt requirements, plant cleaning and domestic use. This requires a reserve tank, plumbing and a pump. By reusing regeneration wastewater, water consumption, energy consumption, wastewater quantities and salt content of wastewater are reduced by approximately 5-10% (Öztürk, 2014). The payback period varies depending on whether the regeneration wastewater is consumed in production processes, plant cleaning or domestic use. The potential payback period is estimated to be less than one year if regeneration water is reused in production processes that require high salt content (since both water and salt will be recovered). For facility and equipment cleaning and domestic uses, the payback period is estimated to be over one year (MoAF, 2021).

In Turkey, reverse osmosis (RO) concentrates are combined with other wastewater streams and discharged to the wastewater treatment plant channel. The concentrates formed in TO systems used for additional hardness removal can be used in garden irrigation, in-plant and tank-equipment cleaning (TUBITAK MAM, 2016; TOB, 2021). In addition, with the structuring of raw water quality monitoring, it is possible to feed TO concentrates back into the raw water reservoirs and reuse them by mixing (TOB, 2021).

- ***Implementing time optimization in production and organizing all processes to be completed as soon as possible***

In industrial production processes, planning the process from raw material to product by using the minimum number of processes is an effective practice to reduce labor costs, resource utilization costs and environmental impacts and to ensure efficiency. In this context, it may be necessary to revise the production processes so that the minimum number of process steps is used (TUBITAK MAM, 2016). In cases where the desired product quality cannot be achieved due to some inadequacies, inefficiencies and design errors in basic production processes, production processes may need to be renewed. Therefore, in this case, the resource utilization and the amount of waste, emissions and solid waste generated in the production of a unit amount of product increases. Time optimization in production processes is an effective practice (TUBITAK MAM, 2016).

## 2.1.3 Precautions for Auxiliary Processes

### **BATs for steam generation**

- Ensuring water saving by insulation of steam and water lines (hot and cold) and preventing water and steam losses in pipes, valves and connection points in the lines and monitoring them with a computer system** Failure to design steam lines properly in the facilities, routine maintenance and maintenance of steam lines repairs, mechanical problems occurring on the lines, and inadequate maintenance of the lines. If steam lines and hot surfaces are not fully insulated and not operated properly, steam losses may occur. This situation affects both water consumption and energy consumption of the plant. Control systems with automatic control mechanisms should be used in order to ensure steam isolation and continuous monitoring of steam consumption. Depending on the reduction of steam losses, similar savings can be achieved in fuel consumption and additional soft water consumption in boilers. Since fuel consumption in steam boilers will decrease, waste gas emissions are expected to decrease at the same rate. Since the additional soft water used in steam boilers will be reduced with the application, the amount of regeneration water, the amount of salt used in regeneration and reverse osmosis concentrates will also be reduced. Full steam isolation application and automatic control mechanisms to minimize steam losses are used in many plants with high steam consumption. With the configuration of the application, fuel savings of 2-4% are achieved in steam boilers.

In order to prevent losses in production processes; adding the most important parts of the equipment such as pumps, valves, control knobs, pressure and flow regulators to the maintenance checklist, inspecting not only water systems but also heating and chemical dispensing systems, drums, pumps and valves, regular cleaning of filters and pipelines, regular calibration of measuring equipment (thermometers, chemical scales, dispensing/dosing systems, etc.) and inspection and cleaning of heat treatment units (including chimneys) at routinely determined periods, effective maintenance-repair, cleaning and loss control practices can reduce water consumption by %%. Regular calibration of measuring equipment (thermometers, chemical scales, dispensing/dosing systems, etc.), routine inspection and cleaning of heat treatment units (including chimneys) in specified periods, effective maintenance-repair, cleaning and loss control practices can save 1-6% in water consumption (Hasanbeigi, 2010; Öztürk, 2014; TOB, 2021).



[https://hohwatertechnology.com/wp-content/uploads/2021/03/boiler\\_175594851-1024x688.jpeg](https://hohwatertechnology.com/wp-content/uploads/2021/03/boiler_175594851-1024x688.jpeg)

Industrial Steam Boilers

- ***Saving water by reusing steam boiler condensate***

When steam indirect heating techniques are used to transfer thermal energy in production processes, recovery of condensed steam (condensate) is an effective practice to reduce water consumption (IPPC BREF, 2009). Condensate recovery can reduce water consumption by 5% on average (Greer et al., 2013). In addition, the potential payback period varies between 4-18 months (considering energy savings) (Öztürk, 2014; TÜBİTAK MAM, 2016).

- ***Prevention of flash steam losses due to boiler unloading***

Steam boiler condensate is usually discharged from the system at atmospheric pressure through equipment outlets and steam traps. As the pressure decreases in condensate systems, some of the condensate re-evaporates and cools to the boiling point of water at atmospheric pressure. The re-evaporated condensate, called flash steam, is lost by being thrown into the atmosphere. In condensate return lines, which are usually quite long, cooling and therefore vaporization is inevitable. In order to prevent re-evaporation of condensate, savings can be achieved by keeping it in a flash tank under pressure until it returns to the boiler feed tank. As the pressure drops in the condensate taken into the tank, the vapor formed as the pressure drops collects on the tank and feeds the low pressure steam system from here. The remaining hot condensate is taken from the bottom of the tank to the boiler.

- ***Minimization of boiler discharge water (blowdown) in steam boilers***

Boiler blowdown refers to the water wasted from a boiler to prevent the condensation of pollutants during the continuous evaporation of steam. Boiler blowdown can be reduced by 50% through condensate recovery (IPPC BREF, 2009).

In automatic systems, blowdowns in the boilers are continuously monitored and the system is re-analyzed with the water taken after the blowdown. In the analysis, data such as dissolved and undissolved particles in the water and water density are processed. If the density for the boiler is above the system limits, the blowdown process is repeated. The system should be automated and the optimum blowdown frequency should be determined. When the blowdown frequency is reduced, the amount of wastewater decreases. Energy and cooling water used for cooling this wastewater is saved (IPPC BREF, 2009). By optimizing the steam boiler blowdown process, operating costs are reduced by saving on boiler water consumption, waste costs, treatment and heating.

- ***Reuse of energy generated from the steam condenser***

With a simple modification to the piping system, the water supplying the water resting/decarbonization unit can be obtained from the outlet of the turbine condenser unit. This water is of sufficient temperature for the recovery/decarbonization unit. It is therefore not necessary to heat this water by means of steam produced by the heat exchanger system. Significant steam recovery can be achieved through this operation. Cooling water consumption can also be reduced (CPRAC, 2021).

## ***BATs for cooling systems***

- ***Use of closed loop cooling system to reduce water usage***

Closed loop cooling systems significantly reduce water consumption compared to open loop systems, which are more water intensive. In closed loop systems, the same amount of water is recirculated within the system, usually requiring the addition of cooling water equal to the amount of water evaporated. By optimizing cooling systems, evaporation losses can also be reduced.

- ***Reducing water consumption by increasing the number of cycles in closed loop cooling systems and improving the quality of make-up water***

Water is used as a refrigerant in many processes such as production processes of the manufacturing industry and cooling of products. The water is recirculated through cooling tower or central cooling systems and cooling process is carried out. If an unwanted microbial growth occurs in the cooling water, it can be controlled by adding chemicals to the recirculated water (TUBITAK MAM, 2016). The number of cycles can be increased with good chemical conditioning in the recirculation process. In this way, the amount of fresh water fed to the system can be reduced and water savings can be achieved. In addition, good conditioning of the cooling make-up water can also increase the number of cycles (TOB, 2021).

- ***Increasing the number of cycles by using corrosion and scale inhibitors in systems with closed water cycles***

Cooling towers and evaporative condensers are efficient and low-cost systems that remove heat from air conditioning and industrial process cooling systems (IPPC BREF, 2001b; TOB, 2021). In these systems, more than 95% of the circulating water can be recovered (TUBITAK MAM, 2016). In cooling systems, impurities remain in the recirculated water due to the evaporation of a portion of the recirculated water, and impurity concentrations gradually increase with each cycle. Impurities that can enter the cooling system together with air can cause contamination in recirculation water (TUBITAK MAM, 2016). If impurities and contaminants are not effectively controlled, they can cause scaling and corrosion, unwanted biological growth and sludge accumulation. This can become a chronic problem leading to reduced efficiency of heat transfer surfaces and increased operating costs. In this case, it is necessary to implement a water treatment program specifically designed for the quality of the feed water supplied to the cooling system, the cooling water system construction material and the operating conditions. This may include blowdown control, control of biological growth, corrosion control, avoidance of hard water, use of sludge control chemicals, filtration and screening systems (TUBITAK MAM, 2016). Establishing and periodically implementing an effective cleaning procedure and program is also a good management practice for the protection of cooling systems. Corrosion is one of the most important problems in cooling systems. Dissolved solids (sulfate, chloride, carbonate, etc.) in the tower recirculation water, which cause corrosion as a result of the formation of limestone and deposits on the walls as the degree of hardness increases, will cause corrosion on the surface over time. In addition, the formation of deposits negatively affects heat transfer and reduces energy efficiency. In order to prevent these problems, a chemical treatment program to prevent scale and corrosion, disinfection with biological activation inhibitor biocide, chemical and mechanical cleaning of the cooling towers in use at least twice a year to remove deposits, hardness and conductivity values of the booster water should be as low as possible (IPPC BREF, 2001; Kayabek et al., 2005).



Treatment (conditioning) using an appropriate treatment system may be necessary to improve the quality of the makeup water. Undesirable microbial growth also needs to be controlled (IPPC BREF, 2001b; TOB, 2021). Blowdown occurs in cooling systems as well as in steam boilers due to micro-residues and deposits in the cooling water. The deliberate draining of the cooling system to compensate for the increased concentration of solids in the cooling system is called cooling blowdown. By pre-treatment of cooling water with appropriate methods and continuous monitoring of cooling water quality, biocide usage and blowdown amounts can be reduced (TUBITAK MAM, 2016). The investment cost depends on the scale of implementation, but the payback period for the expected investment costs varies between 3 and 4 years (IPPC BREF, 2001).

- ***Collecting the water generated by surface runoff with a separate collection system and using it for cooling water, process water, etc.***

Most industrial facilities generate wastewater from process or non-process areas. The wastewater generated can be treated and reused in appropriate places. Savings can be achieved at varying rates in various industrial plants by reusing the wastewater generated in the plant after treatment. Water generated by surface runoff can be collected with a separate collection system and used as cooling water (TOB, 2021).

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Reşitpaşa Mah Katar Cd.  
Anı Teknokent 1 2/5, D:12, 34469  
Sarıyer/Istanbul

(0212) 276 65 48

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