

Finishing Mill Potential Energy Savings (%)

(after implementing a professional energy management system)

Area	Burning Fuels	Water	Electricity
Insulation	1 – 2.5	–	–
Heat recovery	2 – 8	–	–
Boiler inefficiencies	0 – 4	0 – 1	–
Maintenance	1 – 7	0 – 3	–
Logistics	0 – 2	0 – 0.5	0 – 1
Compressed air system	–	–	1 – 4
Variable frequency drives	–	–	0 – 1
Water & condensate re-use	0.5 – 4	2 – 12	–
Total	4.5 – 27.5	2 – 16.5	1 – 6

Table 1