



BHORUKA EXTRUSIONS PVT. LTD.

ESG Status Report, 2023-24



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About the Report

Bhoruka Extrusions has established itself as a leader in India's aluminium industry, renowned for its dedication to innovation and advancement. We have continually increased our production capabilities and broadened our market reach, serving a variety of sectors including construction and industrial applications.

This report discloses our environmental and social performance for the reporting year 2023-24. It highlights our data analysis and interpretation, the sustainable initiatives we have implemented, and the advancements we have made over the years. It showcases our ESG goals and the significant progress we have made towards achieving them, demonstrating our steadfast dedication to sustainable practices.

Scope and Boundary

The report presents the data compilation and analysis for the reporting period from 1st April 2023 to 31st March 2024.

The environmental data disclosed in this report are for our Mysuru manufacturing plant only. Our sales offices exert minimal environmental footprint. However, energy consumption data has been reported solely for the Bengaluru sales office. The social data covers the entire organization, including the Mysuru plant and all sales offices.

For energy metrics, the baseline year is 2015-16, whereas for other indicators, it is 2019-20.





About the Organization

Established in 1979, Bhoruka Extrusions Private Limited has been a 100% subsidiary of YKK AP Inc., Japan since 2020. Bhoruka Extrusions specializes in offering a diverse range of aluminium extrusion products and associated services for customers worldwide. By leveraging advanced technology for value creation, the company continually strives to be the preferred supplier for its customers. In 2023, we have been honoured as one of the Top 10 Aluminium Product Manufacturers in India by the esteemed magazine, 'Industry Outlook'.

We are a 100% made-to-order aluminium extrusion company that primarily serves the building and construction sector with a comprehensive range of curtain wall systems, including unitised, semiunitised, stick glazing, and other glazing systems. Additionally, we have extensive expertise in creating custom-designed aluminium extrusions for other sectors such as automotive (including EVs), electrical and electronics, metro, railway, rolling stock, solar, renewables, and other specialized shapes.

In India, Bhoruka runs a state-of-the-art manufacturing facility in Mysuru, ensuring consistently high-quality production and efficient operations. It has established sales offices in major cities across India, including Bengaluru, Chennai, Mumbai, Coimbatore, Hyderabad, Cochin, Pune, and Delhi.

Bhoruka has a robust production capacity with a production capacity of 9,667.09 tonnes in the reporting period.

Vision

To be the extruder of choice for iconic projects by delivering products and services that reduce our customers' total cost of ownership.

We do this through innovative technology and a commitment to sustainability, customer satisfaction, and operational excellence.

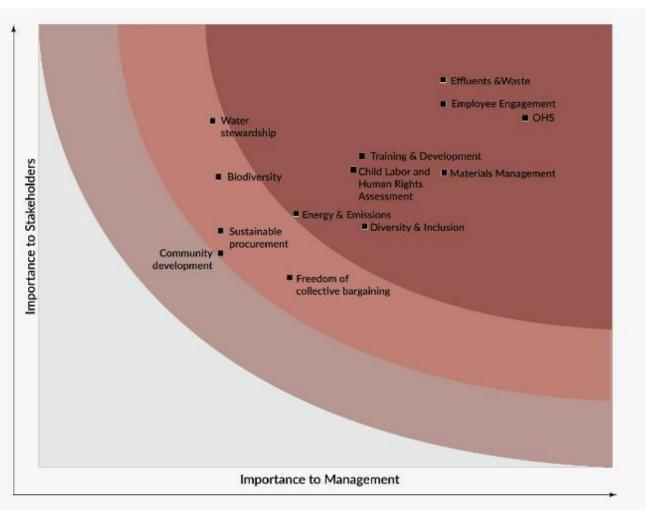




Stakeholder Engagement and Materiality

In 2020-21, we conducted a materiality assessment through an online survey focusing on all our stakeholders. Our long list for consultation encompassed topics on Environmental parameters: Energy & Emissions, Effluents & Waste, Biodiversity, Water Stewardship, and Materials Management; Social Indicators: Employment, Diversity & Inclusion, Occupational Health and Safety, Training & Development, Child Labour & Human Rights, Freedom of Collective Bargaining, Community Development, and Sustainable Procurement. The survey yielded responses from our employees, management, customers and suppliers.

Building on the robust foundation laid, we are continuing with the same material areas in the current reporting year. This continuity ensures consistency in our approach and allows us to monitor progress against established benchmarks.



ESG Goals Status

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S. No.	Goal Area	Objective	Target	Date	Status (2023-24)		
A. Envir	A. Environment						
Environ	mental Manager	ment Certification: ISO 14	001: Action initiated				
		& Being Circular – increasing recycled material input and achieving Zero Waste status	Reduction of packaging materials: 20% (2023) & 50% (2030)	2023	5% reduction in packing materials.		
1.	Materials & Waste		Biogas Facility	2023	Preparatory steps		
			Aluminium Recycling	2023	On- track: 98% aluminium recycling		
			Operational emission reduction - 80%	2025	On-track: Emission intensity		
2.	Energy & Emissions	Moving towards Carbon Neutrality	Operational emission reduction - 100%	2030	reduction of 76% compared to 2015-16.		
3.		Optimizing water usage and ZLD implementation	Treated water reuse & maximizing recycling potential of process water	2024-25	On-track: Reused/recycled water quantity increased by 4% from 2022-23.		
			ETP Sludge reduction	2024	ETP sludge increased by 23%.		

ESG Goals Status

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S. No.	Goal Area	Objective	Target	Date	Status (2023-24)	
B. Social						
4.	Employee Engagement	Employee retention & employee work-life balance	Improving work-life balance	2024	On-track: bi-annual get- together conducted.	
5.	Diversity & Inclusion	Equity for All	Women in management roles	2024	On-track: Overall gender diversity increased to 6%,	
6.	Occupational Health & Safety	ISO 45001 Certification	Aligning to ISO 45001 & best practices	2024-25*	Target date revised.	
7.	Training & Development	Improve skills and training with special exposure for women	Increase per employee training hours by 20%	2025	Training hours per employee 1.6 hours.	
8.	Human Rights & Child Labour	Creating awareness on human rights within the organization & supply chain	Regular due diligence for Human rights matters within the organization and progressing towards Human Rights assimilations and assessment in the supply chain	2024	On-track	





Environmental Data Review

Energy



In this section, we disclose our operational energy consumption.

- Bhoruka Extrusions monitors its energy utilisation and incorporates strategies to improve energy efficiency and reduce energy consumption.
- Energy consumption is monitored in the Mysuru manufacturing plant and Bengaluru sales office. Energy consumption from other sales offices is not included since it is negligible and is attributed to shared workspaces with limited dedicated energy consumption.
- Energy consumption of the Bengaluru sales office is negligible compared to the Mysuru plant.
- The overall energy consumption at the plant primarily comes from various fuels and electricity. The fuels used include diesel for DG sets, processes, and transport; LPG for processes and cooking. Furnace oil and PNG are also used for certain processes.
- The electricity sources include Karnataka State Grid, Off-site renewable energy sources and DG sets.

Details	Units	2022-23	2023-24			
Electricity Consumption						
State grid	MWh	2,206	1,497			
Offsite renewable source	MWh	9,545	8,545			
DG set	MWh	35	52			
Total Electricity Consumption	MWh	11,787	10,095			
Other Forms of Energy						
Diesel (DG Set Fuel & process)	Litres	3,81,161	2,04,306			
LPG (Process & cooking)	Litres	6,53,858	1,52,339			
Furnace Oil	Litres	4,42,142	3,56,051			
PNG	SCM	-	3,85,297			
Fuel for transport						

Energy Consumption at Mysuru Plant

Diesel Litres 1,124 1,351	Diesel	Litres	24	1351
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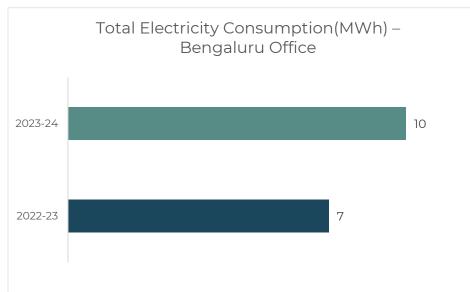
Energy

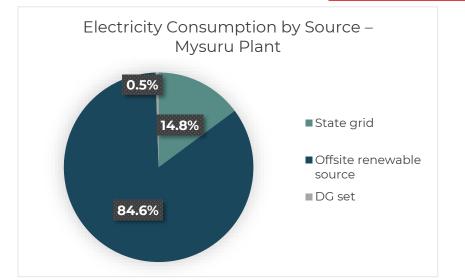


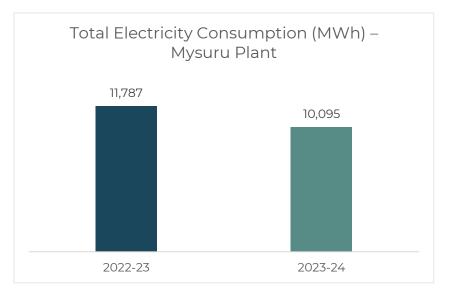
- The total electricity consumption for the reporting year is 10,095 MWh, reflecting a 14% reduction compared to the previous year.
- The electricity consumption by source shows our reliance on off-site renewables as the most significant source at 84.6%, state grid at 14.8% and DG sets at 0.5%.
- This strategic shift demonstrates our efforts to reduce reliance on fossil fuels and minimize the environmental impact of its operations.

Electricity – Bengaluru Office

Electricity consumption at our Bengaluru sales office is 10 MWh. The electricity consumption
has increased by about 29% compared to the previous year. This increase in electricity
consumption can be attributed to an increase in the office space and additional resources.
Although there was a significant increase in electricity usage during the reporting period,
we remain dedicated to optimizing our energy footprint.







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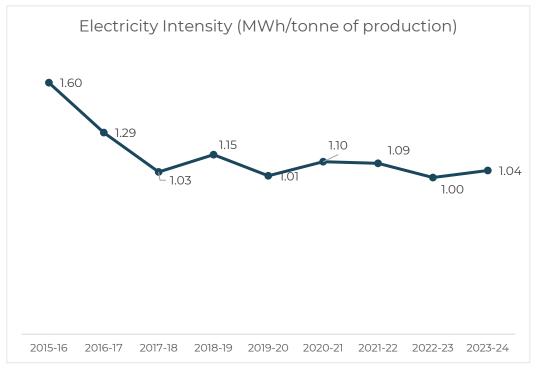
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Energy



Electricity Intensity – Mysuru Plant

- Electricity intensity is a metric that reflects our operational efficiency. It measures the megawatt-hours (MWh) of electricity consumed per tonne of production, expressed as MWh/tonne.
- The electricity intensity for the reporting period is 1.04 MWh per tonne of production, reflecting a 4 % increase compared to the previous year, owing to the reduction in the production quantity
- Although the electricity intensity has increased from the previous year, we are actively exploring and implementing energy-efficient technologies and initiatives to minimize energy consumption and reduce our environmental impact.





Emissions

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At Bhoruka, we have been monitoring our emissions (Scope 1 and Scope 2) to have a better understanding of our carbon footprint and identify areas for improvement.

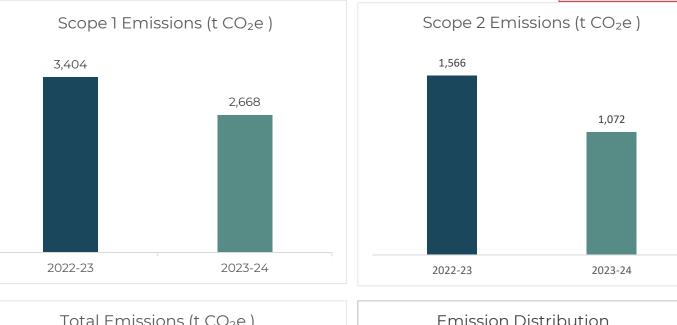
- Scope 1 emissions: These are direct emissions from sources owned or controlled by the company, such as fuel consumed in DG sets, furnace oil and LPG used in operations, and fuel consumed by the company's vehicle fleet, etc., furnace oil and PNG used for operations.
- **Scope 2 emissions:** These are indirect emissions from purchased electricity.

In the reporting year, our total operational emissions are 3,741 t CO_2e , of which scope 1 emissions are 2,668 t CO_2e accounting for 71% while scope 2 emissions are 1072 t CO_2e at 29%.

Our total operational emissions have decreased by 24 % compared to the previous year. This decrease in our total emissions reflects our strong commitment to reducing our carbon footprint.

Emissions from the Bengaluru office

In the Bengaluru office, scope 2 emissions are 7 t CO_2e , with a 33% increase from the previous year at 5 t CO_2e .



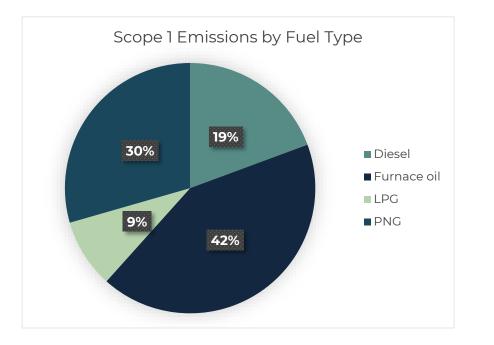


Emissions



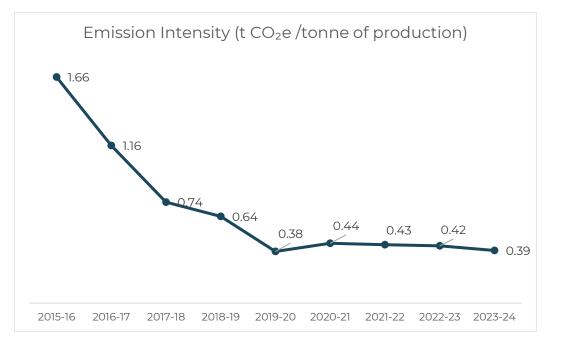
Scope 1 emission distribution

- During the reporting period, most of the scope I emissions were attributed to furnace oil at 42%, followed by PNG consumption at 30%, diesel used for DG sets, production, and company-owned vehicles accounted for 19%, and LPG at 9%.
- This year, we have introduced PNG in our operations, which has led to a reduction in LPG consumption.
- Scope 1 and 2 emissions have decreased by 21% and 3%, respectively, compared to the previous year.



Emission Intensity

- The operational emission intensity at the Mysuru plant is 0.39 t CO₂e/tonne of production. The emission intensity has reduced by 8% compared to 2022-23 (0.42 t CO₂e /tonne).
- Our emission intensity from 2015-16 (baseline year for energy & emissions) has seen a significant reduction of 76 %. (1.66 to 0.39 t CO₂e /tonne of production).
- This demonstrates our continued commitment to decoupling emissions growth from production increases and minimizing our environmental impact per unit of output.



Water

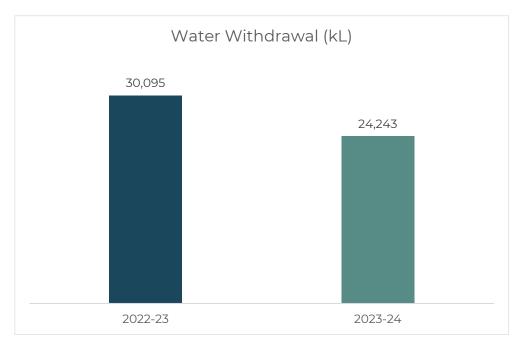


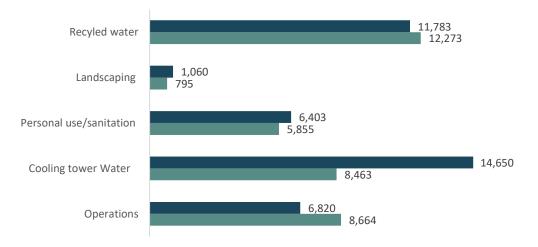
Water Consumption (kL)

Water Withdrawal and Consumption

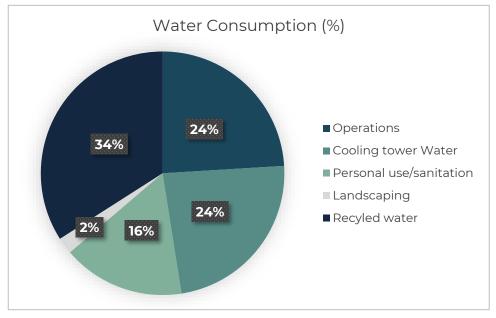
The primary source of water for our Mysuru manufacturing plant is municipal water sourced from the Cauvery river along with recycled water.

- In the reporting year 2023-24, the total water withdrawal was 24,243 kL, marking a 19 % reduction from the 30,095 kL withdrawn in 2022-23.
- The overall water consumption for 2023-24 is 23,777 kL, compared to 28,933 kL in 2022-23, excluding recycled water. This represents a 17 % decrease in overall water consumption compared to the previous year.
- We are actively exploring strategies to optimize water usage efficiency further and reduce our overall water footprint.





■ 2022-23 ■ 2023-24

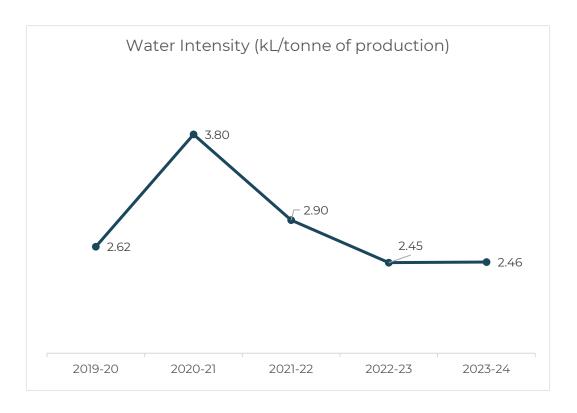


Water



Water Intensity at Mysuru Plant

- Water intensity measures the amount of water used per unit of production, expressed in kiloliters per tonne (kL/tonne).
- In FY 2023-24, the water intensity was 2.46 kL/tonne which is slightly higher as compared to the previous year(2.45kL/tonne).



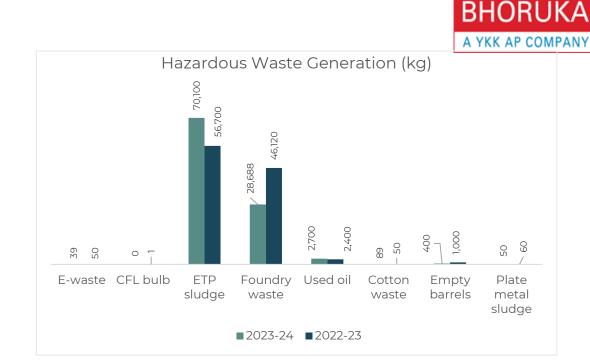
Water Conservation Initiatives

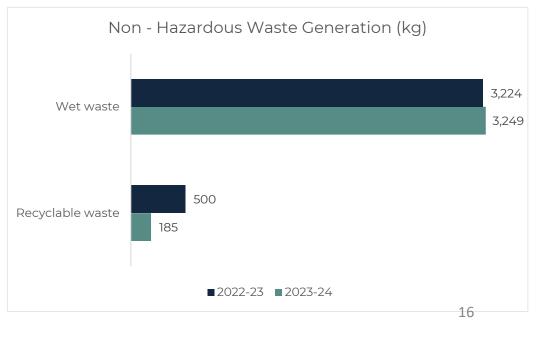
- Our commitment to environmental responsibility extends to optimizing water usage and efficiently managing water discharge.
- To conserve water, several measures have been implemented in the facilities: using a broom instead of a hose to sweep shop floors, utilizing treated water for gardening, fixing leakages, taking showers instead of baths, and installing a water-saving toilet flush system.
- Bhoruka operates a 35 KLD Effluent Treatment Plant (ETP) and a 30 KLD Sewage Treatment Plant (STP) to treat industrial and domestic wastewater, respectively. The treated water is repurposed for gardening.
- In the reporting year, 34% of the water consumption is through recycled water.
- Our commitment to responsible water management is evident in our year-on-year increase in recycled water usage. This year, we achieved a 4 % increase in overall treated water usage, rising from 11,783 kL in 2022-23 to 12,273 kL in 2023-24

Waste

- At Bhoruka Extrusions, we prioritise waste management strategy to achieve our sustainability goals.
- The waste generated in the facility is categorized into: Hazardous and Non-hazardous wastes.
- Hazardous waste includes foundry waste, used oil, ETP sludge, plate metal sludge, empty barrels and e-waste.
- Non-hazardous waste consists of organic (wet) waste and recyclables such as paper, plastic, and cardboard.
- In FY 2023-24, the total waste generated was 105,500 kg, marking a 4 % reduction compared to the previous year.
- Hazardous waste generation was 102,066 kg, while non-hazardous waste generation was 3,434 kg. The generation of hazardous and non-hazardous waste decreased by 4 % and 7 %, respectively, compared to the previous year.



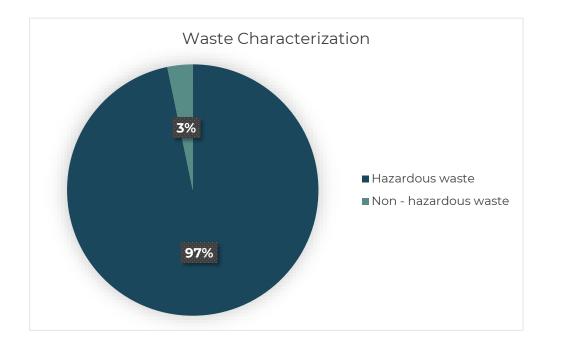




Waste

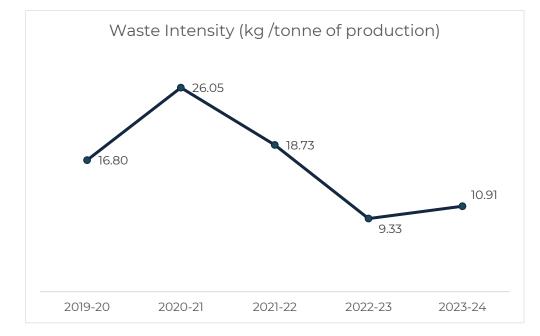
Waste Characterization

- Of the total waste generated, hazardous waste constituted 97%, while non-hazardous waste made up the remaining 3%.
- Within the hazardous waste category, ETP sludge accounted for 69%, foundry waste for 28%, used oil for 3%, and other waste types in minor quantities.
- In the non-hazardous waste category, wet waste comprised 95%, and recyclable waste made up 5%.



Waste Intensity

- Waste intensity, measured in kg/tonne, indicates the amount of waste generated per tonne of production.
- In the reporting year, the waste intensity was 10.91 kg/tonne of production, an increase from the previous year's 9.33 kg/tonne.
- We are actively working to reduce this waste intensity.



Material Management :

At Bhoruka, we currently recycle 98% of our aluminium scrap. In the coming years, we plan to incorporate the recycling of 2% of dross and chips.

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Biodiversity

- Biodiversity is a vital component of our ecosystem stability that delivers essential services, supports food security, provides medicinal resources, boosts the economy, and enriches cultural experiences.
- At our Mysuru campus, we maintain a green cover of 54% of the total area, surpassing the Indian regulatory requirement of a minimum of 33% green cover.
- Bhoruka's dedication to sustainability is further enhanced by preserving biodiversity through tree-planting drives and expanding the green cover within its facilities.

Environment – Best Practices

Bhoruka demonstrates unwavering commitment to optimizing energy consumption through renewable sources and energy-efficient equipment. As part of this effort, we conduct energy audits at the plant level and implement various energy-saving initiatives.

Our major energy conservation initiatives at the plant include:

- Replacing reciprocating compressor chillers with VFD-based screw compressors.
- Adopting soft approaches and behavior changes, such as installing transparent roof sheets in inspection areas to maximize natural lighting





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Social Data Review



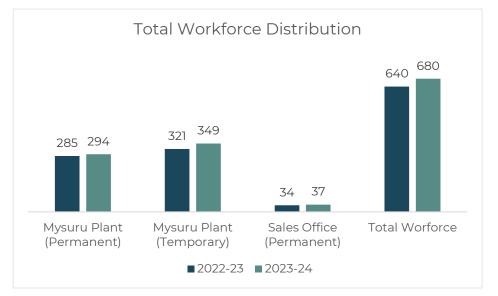
Overview

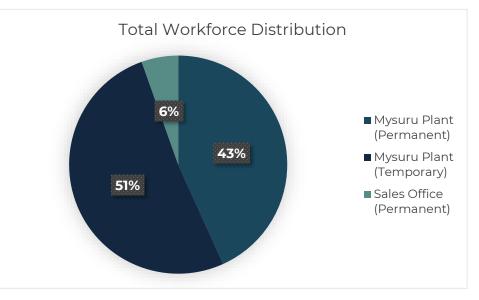
At Bhoruka Extrusions, a strong emphasis is placed on social responsibility. Our social responsibility lies in ensuring our employee wellbeing, fostering a diverse and inclusive workforce, maintaining a safe workplace and contributing to the welfare of the community. This section highlights our performance in social areas such as employee metrics, Occupational Health and Safety (OHS), training and Corporate Social Responsibility (CSR). We ensure to achieve our ESG goals through efficient monitoring of our performance in social, utilizing a data-driven approach.

Workforce Composition and Growth

In the reporting year 2023-24, Bhoruka had a total workforce of 680 employees, reflecting a 6.3% increase from the previous year. This growth in the workforce was witnessed both in the Mysuru plant and across all sales offices.

Our workforce has a balanced composition encompassing 49% permanent employees and 51% temporary workers. Among permanent employees, 43% are based at the Mysuru plant and 6% are based at eight sales offices across India. Temporary workers are outsourced on a need basis in the Mysuru plant and are not present in sales offices.

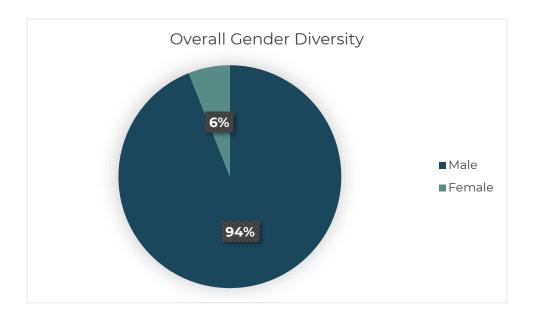




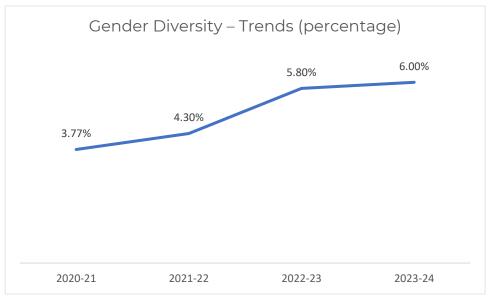


Gender Diversity

- Bhoruka is committed to establishing a diverse and inclusive workforce and emphasizes the importance of gender diversity. We have been progressing on improving gender diversity year on year.
- We strive to foster a work environment that includes women at all levels of the organization. We are actively focussing on increasing women in our workforce and making it more inclusive.
- During the FY 2023-24, the overall gender diversity is 6% female and 94% male employees. Gender diversity in the reporting period has increased when compared to the previous year which was at 5.8%.
- The gender diversity at the Mysuru plant among permanent employees is 4.4% while it is 6% for temporary workers, while the gender diversity across our sales offices is 19%.







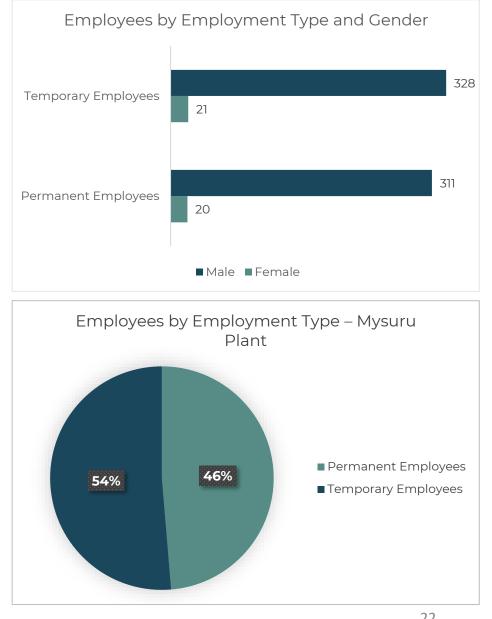


Employees – Permanent and Temporary

- Among the total workforce, permanent employees and temporary workers constitute 49% and 51% respectively.
- Of both permanent employees and temporary workers, 94% are male and 6% are female employees.

Mysuru Plant

- Of the total workforce, 95% are based at the Mysuru plant and the remaining 5 % at sales offices. The workforce has increased by 6% compared to the previous reporting year.
- In the Mysuru plant, permanent employees constitute 46% while temporary workers comprise 54%.
- The overall gender diversity at the Mysuru plant comprising both permanent and temporary employees is 5.3%.

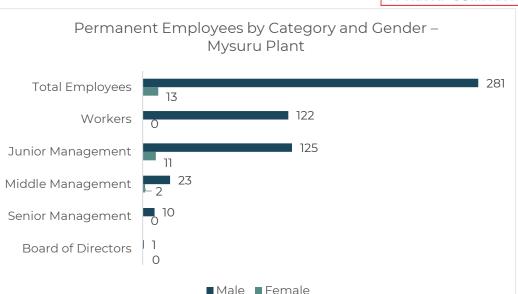


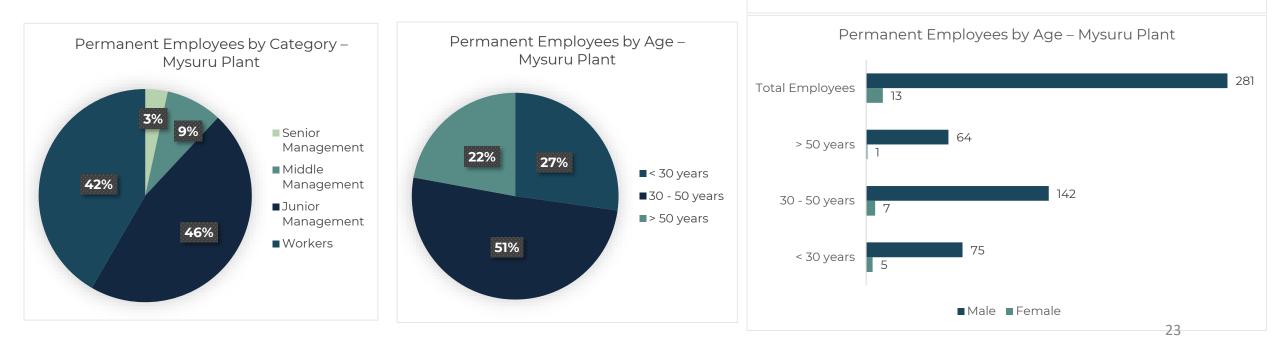
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Employee Data

Permanent Employees – Mysuru Plant

- Of the total permanent employees, 88% are based at the Mysuru plant with 95.6% male and 4.4% female employees.
- At the Mysuru plant, the employee distribution by seniority is as follows: senior management makes up 3%, middle management accounts for 9%, junior management represents 46% and workers comprise 42%.
- We are proud to have permanent employees from different age categories constituting a diverse and experienced workforce. Categorizing based on age shows most employees are within the 30-50 age group at 51%, followed by those under 30 years at 27%, and those over 50 years at 22%.

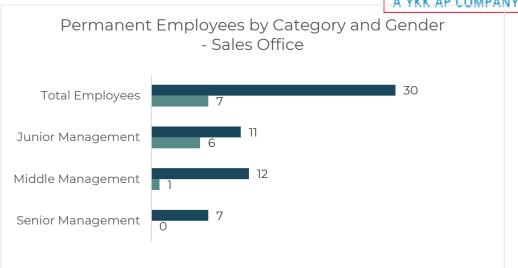




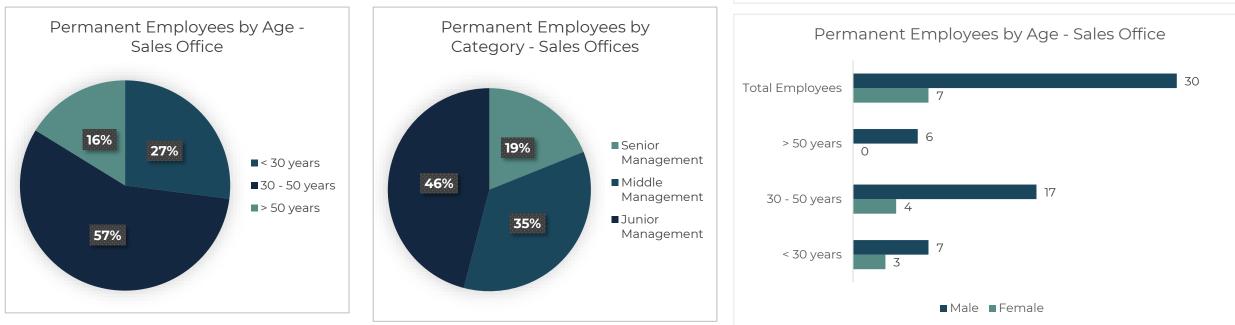


Permanent Employees – Sales Offices

- Of the total permanent employees, 11% are based at sales offices with 81% male and 19% female employees.
- Among permanent employees in sales offices, senior management constitutes 19%, middle management makes up 35%, and junior management represents 46%.
- Categorizing employees by age shows that the 30-50 age group constitutes the majority at 57%, followed by below 30 age group at 27% and above 50 age group at 16%.



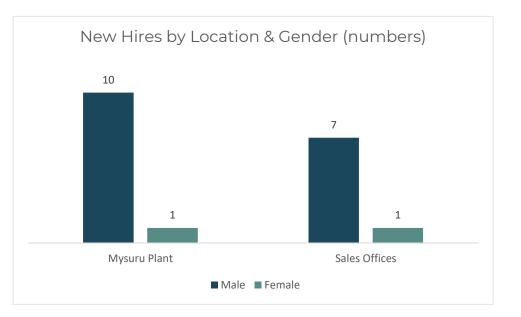
■ Male ■ Female

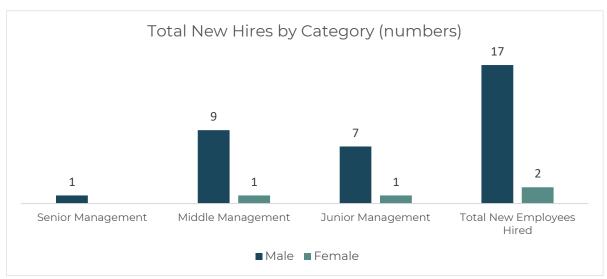




New Employees Hired

- Bhoruka Extrusions is expanding its workforce with new hires, a strategic move designed to boost operational efficiency and foster future growth.
- In the reporting year 2023-24, 19 new employees were hired, with 11 employees hired in the Mysuru plant accounting for 58 % while the remaining 42% were hired at the sales offices.
- Of the total new hires, 89% are male and the remaining 11% are female.
- In the Mysuru plant, the maximum new hires were in junior management at 64%, followed by middle management at 27% and senior management at 9%.
- In the sales offices, the maximum hiring was in the middle management category at 88%, followed by junior management at 13%.







Employee Turnover

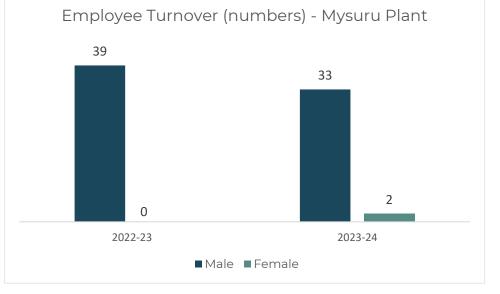
- Employee turnover leads to shifts in the organization's human and intellectual capital, which can affect overall productivity. We have been proactively implementing strategies to reduce employee turnover and establish a stable, engaged workforce.
- In FY 2023-24, the total turnover is 42 employees, of which 93% are male and 7% are females.
- 83% of the total turnover was at the Mysuru plant while the remaining 17% were in the sales offices.

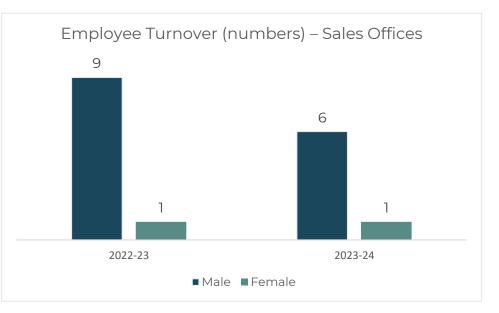
Mysuru Plant:

- In FY 2023-24, the total employee turnover in the Mysuru plant was 35 employees of which 94% were males and 6% were females..
- The highest turnover was observed in junior management at 74%, followed by middle management at 17%, and senior management at 9%.

Sales Offices:

- Sales offices saw a turnover of 7 employees with 86 % male and 14 % female.
- The maximum turnover in the sales office was observed in junior management at 71% followed by middle management at 29%.





Training & Development

Bhoruka Extrusion prioritizes providing learning and development opportunities to its employees to enhance their knowledge, skills and productivity. In the reporting year 2023-24, a total of 3493.5 hours of training were provided to the employees, with peremployee training of 1.6 hours.

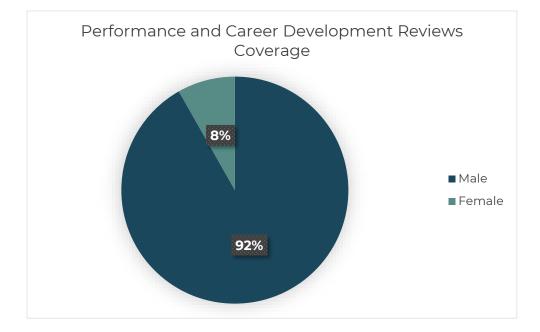
The training programs are offered to employees in all categories. Training topics include revisions in company policies, data security practices, workplace etiquette, technical skill development, and emergency responsiveness. The list of training topics are:

- Company policies
- Information security
- Workplace etiquette
- Fire safety and fire extinguisher operation
- Disaster management awareness
- Mock evacuations
- First-aid training
- Machine operations and material handling
- Chemical safety
- Electrical equipment safety
- PPE awareness training
- Accident prevention
- Cutting machine hazards and precautions

Performance and career development review

At Bhoruka Extrusions, regular performance and career development reviews are conducted for employees from different categories.

During the FY 2023-24, performance and career development reviews were conducted for a total of 146 employees, with 92% of them being male and 8% female.



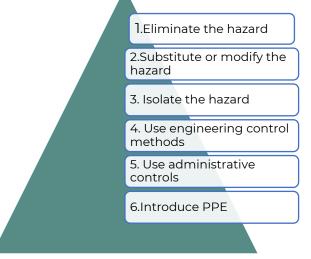
Employee benefits

Employees receive benefits such as medical insurance, festival advances, emergency loans, and the option to work from home. These benefits do not apply to temporary and part-time workers.



Occupational, Health and Safety

Bhoruka Extrusion has a comprehensive Occupational, Health and Safety (OHS) system which adheres to international standards. OHS management covers all permanent and contractual employees. Work-related hazards are identified, and risks are assessed for both routine and non-routine tasks through safety inspections, audits, worker and manager interviews, and evaluations of work practices to gain insight into potential hazards that could pose harm to workers. Our approach to hazard control follows a structured hierarchy that is followed to minimize risks:



A dedicated health and safety committee conducts monthly meetings to ensure the effectiveness of the health and safety system. Regular toolbox meetings and safety training are conducted. OHS training topics include

- Fire safety: fire extinguisher operation, on-site fire drill
- Disaster management
- Handling chemicals
- First-aid training
- Forklift operations
- Crane & hoist training
- Earthing systems & practices

Workers are involved in the OHS management system through company safety patrol, shop floor meetings, conversations with workers, risk assessment and health check-ups.

In the reporting year 2023-24, Bhoruka has recorded zero fatalities and high-consequence injuries., however, two minor work-related injuries were recorded, one in the male permanent category and the other in the male contractual category, which accounts for an injury rate of 1.44, while there were no injuries in the permanent female and contractual female categories.

Occupational Safety Metrics (2023-24)

Safety Parameters	Permanent Workforce (Men)	Contractual Workforce (Men)	Total
Number of work- related injuries	1	1	2
Rate of work- related injuries	1.47	1.42	1.44
Number of hours worked	136178	141178	277356

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Supplier Information

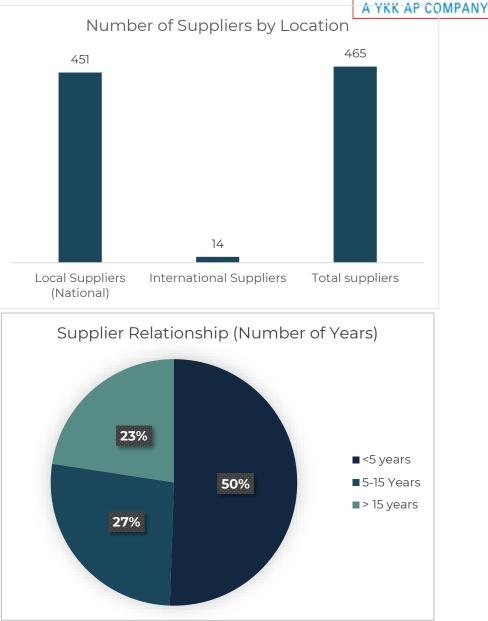
Supplier relationship plays a vital role in driving an efficient and sustained supply chain which helps maintain competitive edge in the market. We highly value fostering and sustaining robust relationships with both our national and international suppliers. Our collaborative efforts have established a network of around 465 suppliers this reporting year, which is crucial to our operational success.

Of our 465 suppliers, 97% are local (national), while the remaining 3% are international. As of this reporting year, approximately 23% of our suppliers have maintained a relationship with us for over 15 years. This longevity reflects our commitment to sustaining long-term relationships and demonstrates mutual trust and reliability. About 27% of our suppliers have been with us for 5-15 years, and 50% have had a relationship with us for less than 5 years.

The total supplier spending in the reporting year amounts to INR 222.15 Cr, of which 99.7% was spent on local suppliers and the remaining 0.3% was spent on international suppliers.

Among our suppliers, 56 hold ISO 9001 certification, and 7 have ISO 14001 certification.

By fostering these strong, enduring relationships, Bhoruka Extrusions reaffirms its commitment to integrity, excellence, and mutual growth within its supply chain.



Corporate Social Responsibility

At Bhoruka Extrusions, we believe that our success lies in the wellbeing of the community and environment in which we operate. Through our CSR initiatives, we strive to create positive social impact, promote environmental stewardship, and contribute to the overall betterment of society.

In 2023-24, we allocated INR 2,03,665 towards our CSR initiatives, focusing on tree planting, litter cleaning, and supporting educational institutions. Our initiatives aim to foster a healthy, safe, and educated society through targeted programs that provide tangible benefits. By supporting environmental initiatives and promoting academic activities, we strive to create a positive and lasting impact on the community. All the CSR activities are volunteered by our employees.

Initiative 1: Tree-Planting Event
Sector : Sustainable Development
No. of beneficiaries served : 60
No. of total hours volunteered by the employees: 60

On 13th July 2023, as part of our CSR initiative focused on environmental responsibility, around 60 employees participated in a tree-planting event in the neighborhood surrounding our factory. During the event, we planted around 40 saplings and installed 15 tree guards, demonstrating our commitment to fostering a greener and healthier community. Initiative 2: Litter cleaning activities
Sector : Sustainable Development
No. of beneficiaries served : 75
No. of total hours volunteered by the employees: 75

On 26th October 2023, a litter cleaning activity was organized in the vicinity of the factory. Approximately 75 employees participated in the event, successfully collecting over 30 bags of litter. This initiative highlights the company's commitment to environmental stewardship and community cleanliness.

Initiative 3: Contribution to Educational Institution - NGO **Sector :** Academic & Education

On 24th January 2024, as part of the Kannur School Project CSR activity, the company donated building materials to educational institution. The donation included 428 kgs of aluminium profiles, parts, and accessories for windows and doors, amounting to Rs. 1,83,665. This contribution underscores the company's commitment to supporting educational infrastructure and fostering community development.





THANK YOU