Priority Cotton By-products Activities for Development

National Capacity Building Workshop (UNCTAD)

Harare, Zimbabwe, Sep 27-28, 2017






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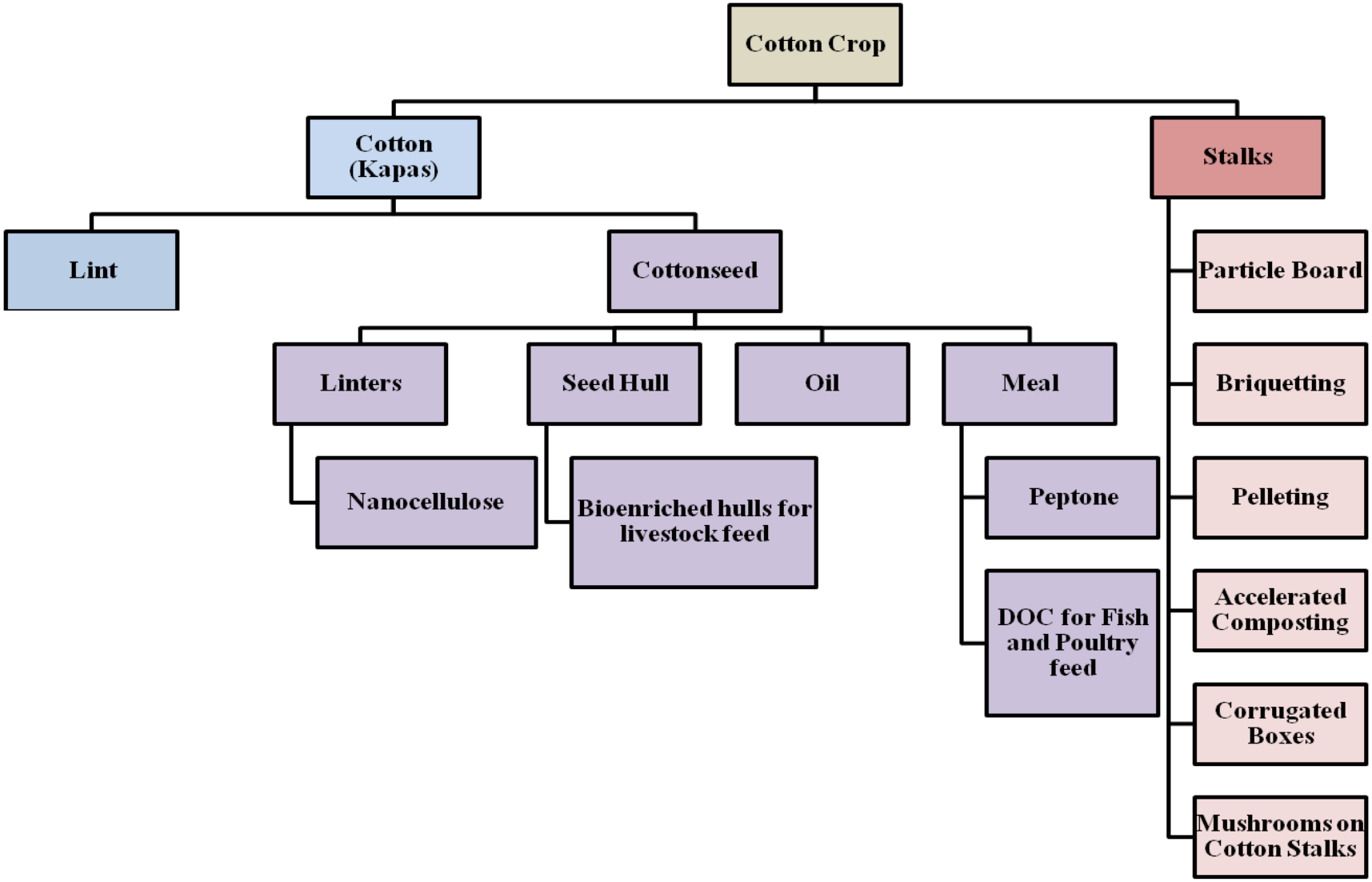
Cotton Sector in India (2016-17)

- Area Under Cotton Cultivation : 10.5 million hectares
- Cotton Production : 5.88 million tonnes
- Cottonseed production : 11.5 million tonnes
- Cotton Stalk Production : 26 million tonnes
- Cotton Farmers : 5 million

Value Addition to Cottonseed and Stalks



Industrial Applications of Cottonseed Meal

Cottonseed Meal: India's Experiences

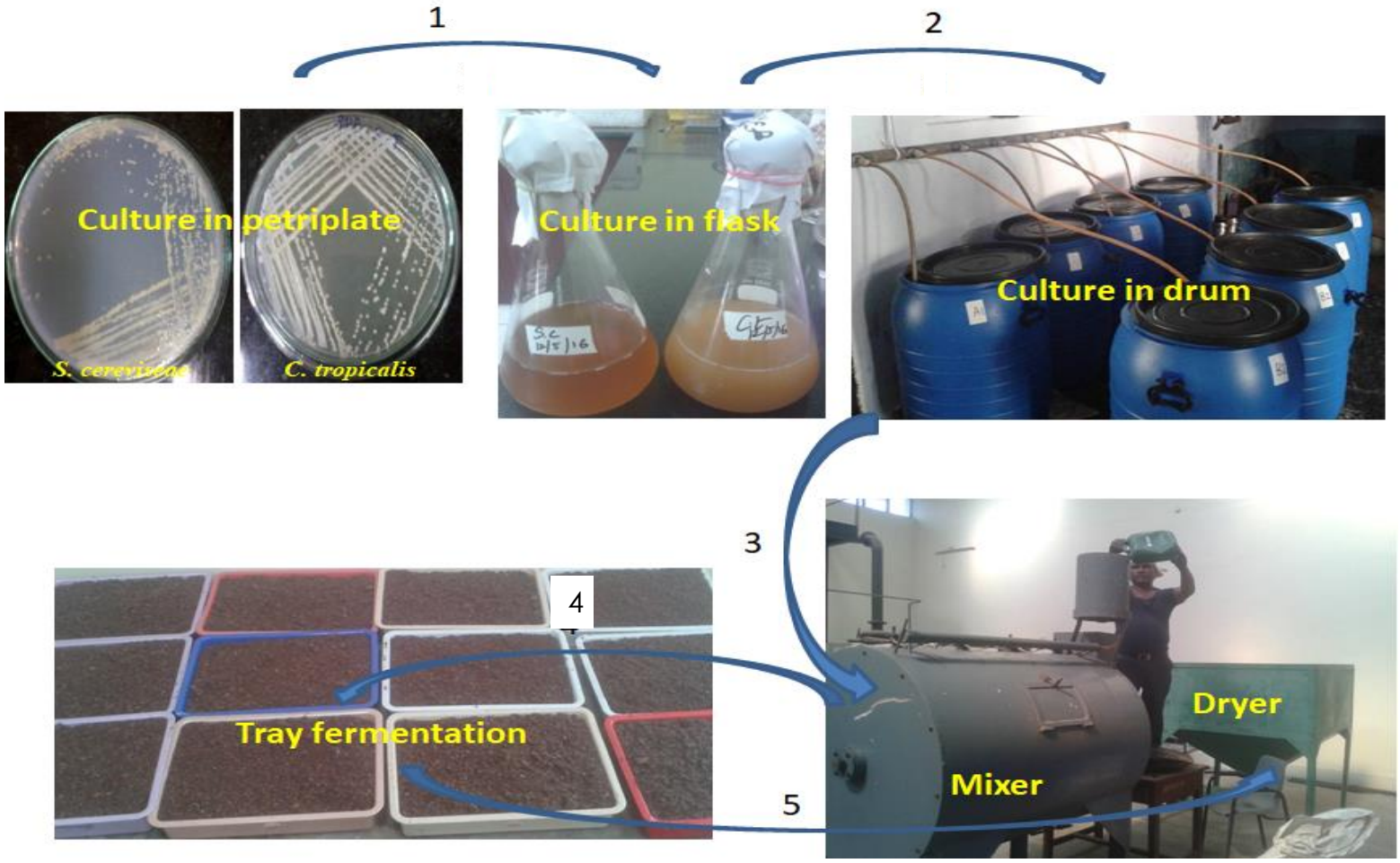
- Availability : 5.75 million tonnes annually
- Oiled Cake: 5.4 m tonnes and De-oiled cake: 0.35 m tonnes
- Uses: Mostly used for ruminates feeding
- Total gossypol content: 0.6 - 1.15% (0.05 – 0.7% free gossypol)
- Gossypol: Limitation to non-ruminants like fish and Poultry
- Large scale production of degossypolised meal under trials
- Small scale production of degossypolised meal for poultry and fish feeding, etc. using CIRCOT technology

Possibility of By-products Preparations from Cottonseed Meal in Zimbabwe (2016-17)

- Area Under Cotton Cultivation : 150,000 hectares
- Cottonseed Meal : 35,000 tonnes
- Midland & Mashona Land (70 %) : 17,500 tonnes
- Mesoland Centra & Masvingo (25%) : 8,750 tonnes
- Mesoland East & Matabele Land (5%) : 1,750 tonnes

- **Preparation of degossypolised cottonseed meal using CIRCOT Technology**
- **0.8 TPD capacity**

CIRCOT : Degossypolization Technology



Degossypolized Cottonseed Cake

- CIRCOT microbial process
  - Reduction of free gossypol content (80%),
  - Reduce bound gossypol (60 %),
  - Reduce crude fibre (30%)
  - Improvement of protein content (40%)
  - Improvement in lysine content (25%)
- Gossypol level meets standard: Protein Advisory Group, UPA
- Enable Cottonseed meal for Poultry and Fish feed
- Human Protein Supplement

Industrial Applications of Linters

Linters from Cottonseed: India's Experiences

Short fuzzy fibres from cottonseed

Uses

- Cellulose Nitrate (explosives)

- Cellulose acetate (film, membranes etc.)

- High grade paper (currency, security)

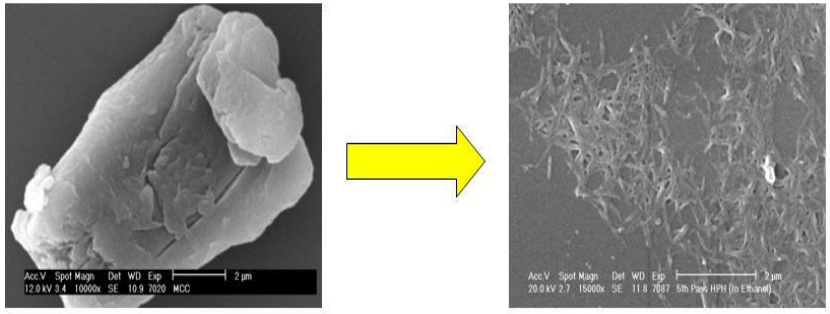
- Medical grade cotton (Absorbent)

- Micro Crystalline cellulose (Filler in Tablets)
- Food Casings, Felts

Nanocellulose from Cotton Linters

Nanocellulose (size < 100nm)

- ✓ High mechanical strength (1 to 10GPa)
- ✓ High young modulus (100-130GPa)
- ✓ High surface area (50-200 m^2/g)
- ✓ Bio degradable
- ✓ Novel optical properties

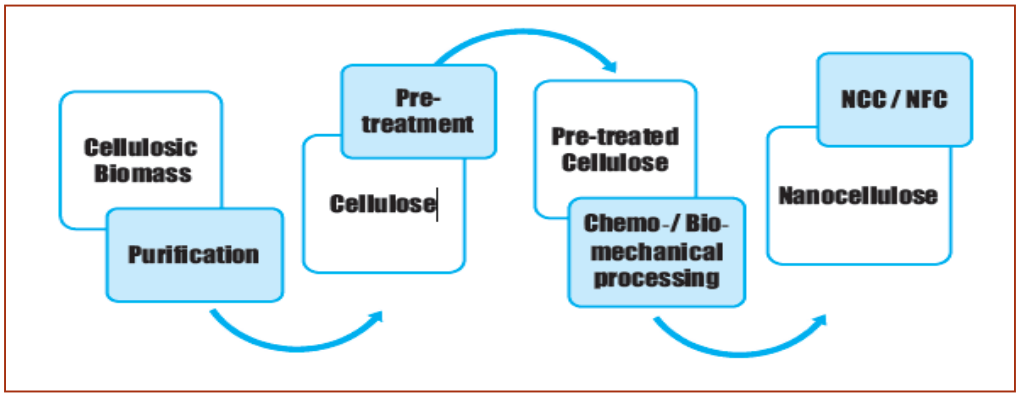


MCC from Cotton Fibers

Nanofibrils

5th Pilot Plant in the World (1st Plant in Sweden – 2011)

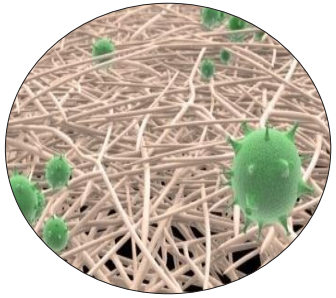
ICAR-CIRCOT pilot plant with capacity of 10kg/day



ICAR-CIRCOT Process

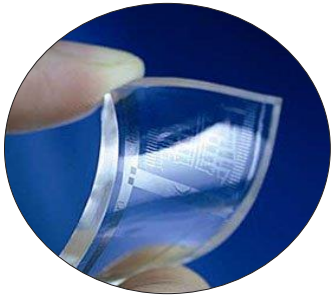
Applications of Nanocellulose

Virus filtration



Emulsion/
dispersion stabilizer

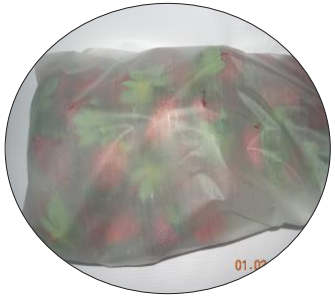
Liquid Crystal
Display



Non-caloric
Food thickeners

Targeted drug
delivery

Fillers in
Cement



Fillers in Film

Paper Coating &
Furnish Additives

Industrial Applications of short staple/comber noil cotton

Short staple/comber noil cotton: India's Experiences

- **Availability :** 0.25 million tonne **annually**
- **Properties: staple length < 20 mm, MIC: 3-5; strength: 25g/tex Trash: 0.1-0.25%**
- **Commercial Uses:** Surgical Cotton, medicated cotton, Cotton Ball, Ear buds, wadings, security paper, currency notes, blend for coarse yarn and OE spinning for denim production
- **Under Trials:** Technical Textiles, etc.

Standard of Absorbent cotton

Raw Material	Virgin Cotton/Comber noil
Sinking Time/absorbency	< 10 Sec
Water Holding Capacity	Not less than 24 times of It's weight in water
Ether Soluble Substances	Max 0.50 %
Water Soluble Substances/Per 5g	Not more than 0.50%
Alcohol Extract	Colorless
Sulphate Ash	Max 0.40%
Surface Active Substances	Max 2mm
Mercury	None when examined under ultraviolet light
Odor	Odorless
Foreign Matter	Absent
Extractable Coloring Matters	Negative
Moisture (%)	8

Absorbent Cotton Preparation Process

i. Bale opening- manual or machine

ii. Pre-cleaning & opening- cleaner

iii. Kier/HTHP bleaching (100 ^{0}C Temp and 4 bar pressure using wetting agent, NaOH and H_2O_2

iv. Neutralization and Hydro extraction

v. Wet opening

vi. Drying

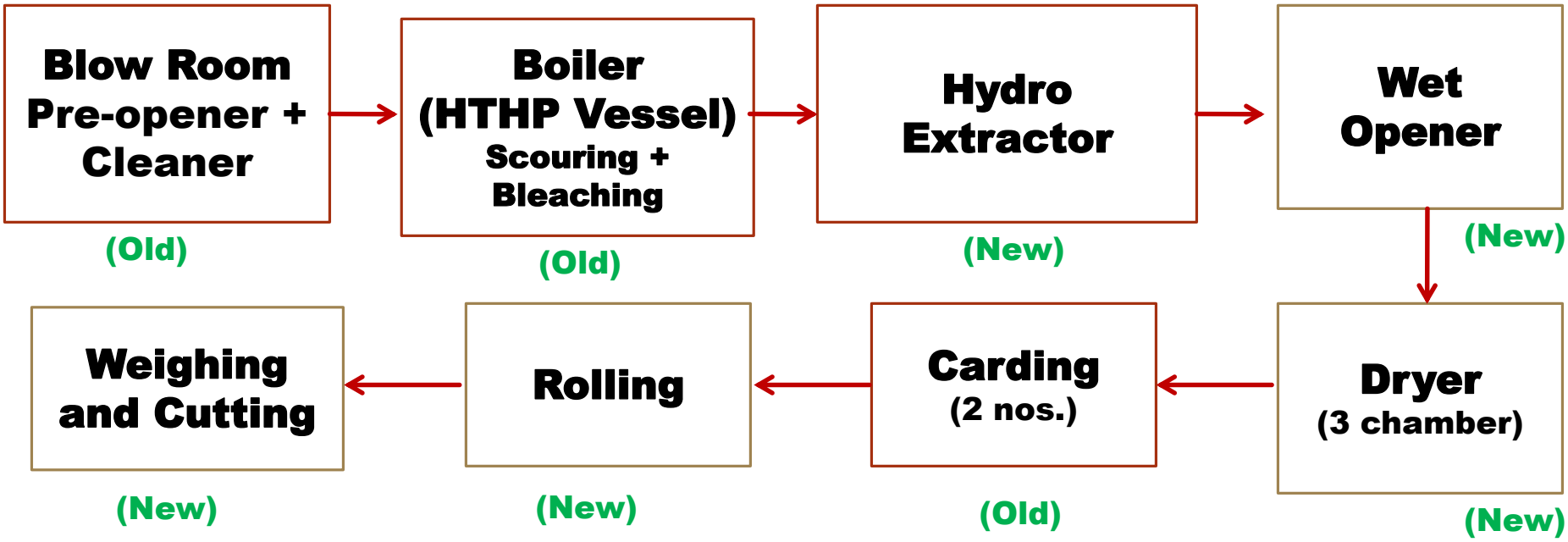
vii. Carding

viii. Cutting, weighing

ix. Packaging

Flow Chart for Absorbent Cotton Plant

- **Capacity**: **1.5 TPD for 3 shifts** (Semi automatic can be converted to fully automatic)



Commercial utilization: Absorbent Cotton

A	Capital Investment (1.5 TPD Capacity)	INR (Rs.)	USD
	Land and Building (Land Area: 1000 sq. m; Building for Machinery: 600 Sq. M ; Material storage area:200 Sq. M ; Office Building: 300 Sq. M)	**0.50**	**7,692**
	Plant and Equipment	**4.00**	**61,538**
	Auxiliary and Service Equipment (Electricals and handling tools)	**0.50**	**7,692**
	Total investment	**5.0**	**76,923**
B	**Operational Expenses**		
	Raw Material Cost for 1 year (1.5 TPD for 300 days @ Rs. 90,000 per tonne)	**40.05**	**616,153**
	Operational cost including repair and Maintenance and other charges (Rs. 40,000/tonee) for 1 year	**18.0**	**276,923**
C	**Gross Annual Income (Rs. 1,900,00/tonne)**	**85.5**	**1,315,384**
	Net annual income (Rs. 50,000/tonne)	**2.25**	**34,615**
D	Payback period: **27 months**	Return on investment : **37%**	

Cotton Stalks and Its Commercial Utilization

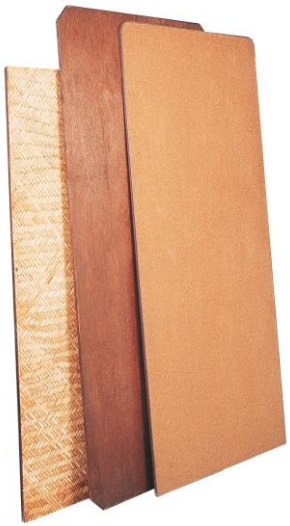
Cotton Stalks: India's Experiences

- **Availability : 26 million tonnes annually**
- **Utilization: About 5-6 % commercially utilized**
- **Properties: about 60% holocellulose, 27% lignin and 6% ash,**

  Gross calorific value: 4000 kcal/kg
- **Commercial Uses: Briquettes, Pellets, Compost, Power generation**
- **Under Trials: Particle Board, Pulp And Paper, Hard Boards, etc.**








Commercial Utilization of Cotton Stalks in India

Briquetting Plants

- Installed plants: about 100
- Capacity/plant: 20 TPD
- Size of briquettes: 90 mm diameter
- Uses: As substitute for coal for firing boilers in industries, brick kilns, etc.

- Raw materials: Cotton Stalk (150,000 T for 4 months:); Soybean; saw dust, wood chips, bagasse, etc.,
- Benefits: Cheap-80% of Coal Price; Renewable Source,

farmers' income-Rs. 3000/ha for supply of chipped biomass

Commercial Utilization of Cotton Stalks in India (Contd.)

Pelleting Plant

- Installed Pelleting plants : 50
- Capacity/plant: 3 TPD & 60-80 TPD
- Size of pellets: 6, 8 and 10 mm diameter
- Uses: Boilers and Cooking in Restaurants

- Raw materials: Cotton Stalk (200,000 T for 4 months:); Soybean; saw dust, wood chips, bagasse, etc.
- Benefits: Cheap- half the commercial LPG prices; farmers' income-Rs. 3000/- per ha for supply of chipped biomass

Commercial Utilization of Cotton Stalks in India (Contd.)

Power Generation

- Installed power plants: 225
- Installed Capacity: 4831 MW
  (Ministry of New and Renewable Energy, 2016)
- Raw material Required: 48 TPD for 1 MW capacity

- Cotton Stalk, Soybean, Bagasse, Saw dust, etc.
- Benefits:
  - Renewable source for power generation
  - Power plants accept cotton stalks with high moisture content:50 - 60 %
  - farmer' income-Rs. 5000/- per ha for supply of chipped biomass

Commercial Utilization of Cotton Stalks in India (Contd.)

Particle Boards

- One ton Stalk used for 600 Kg Boards
- Plants accept Cotton Stalks as Substitute for Bagasse
- Particle Boards from Cotton Stalk conform with IS standard 3087-1985
- Uses: furniture making, partitioning, panelling, false ceiling, etc.

On-farm Utilization of Cotton Stalks

Compost

- CIRCOT accelerated process for compost preparation.
- Compost is enriched with nutrients, plant growth micro organisms
- Stable for the period up to one year.

Mushroom Production

- Oyster Mushroom (edible) can be grown from cotton stalks
- Mushroom yields up to 500 g per kg of cotton stalks

Parameter	Compost from cotton stalks	Farm Yard Manure
NPK content (%)	1.43 : 0.78 : 0.82	0.5 : 0.2 : 0.5
Duration (Days)	60	120

Cotton Sector in Zimbabwe (2016-17)

		2015-16	2016-17
❖ **Cotton Cultivation**	**(Ha)**	**101,660**	**150,000**
❖ Seed Cotton Production @ 281kg lint/ha	(Tonnes)	71,500	125,000
❖ Cottonseed production	(Tonnes)	28,800	70,000
❖ Oil	(Tonnes)	5,200	12,600
❖ Linter	(Tonnes)	2,000	4900
❖ **Cotton Stalk Chips**	**(Tonnes)**	**132,000**	**195,000**
❖ Cotton Farmers		200,000	

Possibility of By-products Preparations from Cotton Stalks in Zimbabwe (2016-17)

- Area Under Cotton Cultivation (expected) : 150,000 hectares
- Cotton Stalk Chips (@1.3 t chips/ha) : 195,000 tonnes

Midland & Mashona Land (70 %) : 136,000 tonnes

Mesoland Centra & Masvingo (25%) : 48,750 tonnes

Mesoland East & Matabele Land (5%) : 9,750 tonnes

- **Preparation of briquettes of 20 TPD capacity in 3 shifts**
- **Preparation of Pellets from 3 TPD capacity in 3 shifts**
- **Power generation of 30 MW capacity**
- **On-farm production of mushroom and composts**

Industrial Applications of Cotton Stalks

BRIQUETTING

Chipped Cotton Stalks/Soya/Bagasse → Manual or Tractor Feeding → Screw Conveying → Briquetting by Extrusion

PELLETTING

Chipped & Milled Cotton Stalks/Soya/Bagasse → Manual Feeding → Pelleting by Extrusion

POWER GENERATION

Chipped Cotton Stalks/Soya/Bagasse → Tractor feeding → Steam generation → Power generation

Connected Loads & Manpower

Briquetting plant

- Connected load: 90 HP
- Manpower requirement: 6/shift

Pelleting plant

- Connected load: 25 HP
- Manpower requirement: 3/shift

Power Generation

- Manpower requirement: 10/shift

Logistics for Supply of Cotton Stalks

- Uprooting of cotton stalks: 3-4 manpower/acre
- Collection after 1 week sun drying: 2 manpower
- Chipping: Tractor driven chipper, capacity 2 TPH, 11 manpower, 2 tractor cum trolleys
- Transportation: within 50 km
- Total logistics Price: Rs. 1500 per tonne at factory gate ($ 23 per tonne)

Chipping of Cotton Stalks

Shredding of Cotton Stalks

Briquetting

Pelleting

Commercial utilization: Power Generation

A	Capital Investment (30 MW Capacity)	INR in million	USD in million
	Land and Building (Land Area: 5 acre; Building for Machinery: 50 Sq. M ; Material storage area:5000 Sq. M ; Office Building: 50 Sq. M)	**100.0**	**1.53**
	Plant and Equipment	**800.0**	**12.37**
	Auxiliary and Service Equipment (Crushers, Gridding, Chimney, etc.)	**100.0**	**1.53**
	Total investment	**1,000**	**15.43**
B	**Operational Expenses**		
	Raw Material Cost for 1 year (1500 TPD for 360 days @ Rs. 2800 per tonne)	**1,510**	**23.23**
	Operational cost including repair and Maintenance and other charges (Rs. 30000/MWh) for 1 year	**7,776**	**119.63**
C	**Gross Annual Income (Rs. 57000/MWh)**	**14,775**	**227.29**
	Net annual income (Rs. 1000/MWh)	**250**	**3.84**
D	Payback period: **48 months**	Return on investment : **25%**	

On-farm Applications of Cotton Stalks

Composting from Cotton Stalks

- **Bio-enriched compost with nutrients, plant growth micro organisms prepared using ICAR-CIRCOT Accelerated process of composting**

Parameter	Cotton stalk Composts	FYM
NPK content (%)	1.43 : 0.78 : 0.82	0.5 : 0.2 : 0.5
Duration (Days)	60	120

- **Yield: 800 kg/tonne chipped stalks**
- **Production cost: Rs. 3000/tonne**
- **Selling Price: Rs. 3500/tonne**

CIRCOT Technology for Bio-enriched Composts from Cotton Stalks

1 Tonne Chipped cotton stalks

↓

0.2% NaOH

↓

10% cattle dung

↓

1.2% Urea and 2% Di-ammonium Phosphate

↓

1% microbial consortia

↓

50% Water

↓

Through mixing and heaping

↓

Cover with polyethylene sheets

↓

Mixing of heaps every week for aeration

↓

Bio-enriched Compost (After 60 days)

Mushroom from Cotton stalks

- Oyster Mushroom (edible) can be grown from cotton stalks
- Mushroom yields up to **500 g per kg of cotton stalks**

Mushrooms grown on cotton stalks

Bottom line

- Urgent need to increase the seed cotton production in Zimbabwe to feed the installed capacities of ginneries/oil expressers
- Utilization of Cottonseed oil is well established and is recognized as safe edible oil across the World
- Cottonseed meal is well established product for animal feeding, however, it can be explored for poultry and fish feeding
- Explore the option of Absorbent cotton Production

Bottom line (Contd.)

- Cotton stalks can be effectively used as Renewable source of energy : Briquettes, Pellets and Power generations
- Promote on-farm composting of cotton stalks: Reduction in input cost; Soil health improvement; increased productivity and Production of cotton.
- From cotton stalks, preparation of Kraft paper (corrugated boxes) and Particle Boards is not a feasible proposition
- Training cum Exposure programme on value addition to cotton By-produce

Thank You

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