

Energy Allocation Tool

General Mills have developed a strong training program along with standardized tools that allow new energy engineers to deliver savings quickly. The Energy Allocation Tool allows General Mills to account for every BTU being consumed in different systems. For example, on the electrical side, the tool would include energy usage for lighting, compressed air, refrigeration, pumps and fans, processing motors broken out by line, and HVAC. On the thermal side, gas usage would be broken out into HVAC, hot water, and each processing unit's steam or gas usage. The energy allocation exercise clearly identifies the areas of high energy consumption.

| | % Total Energy |
|------------------------------|-----------------------|
| Electrical Allocation | 61.6% |
| Lighting | 6.0% |
| Compressed Air | 11.0% |
| Refrigeration | 17.0% |
| Utility Support Equipment | 1.0% |
| HVAC | 7.5% |
| Process Fans | 3.0% |
| Pumps | 4.6% |
| Production System 1 | 3.0% |
| Production System 2 | 2.0% |
| Large Unit Op 1 | 3.0% |
| Large Unit Op 2 | 3.5% |
| Gas Allocation | 38.4% |
| Hot Water | 6.0% |
| Boilers | 12.3% |
| Ovens | 7.0% |
| Production System 1 | 3.0% |
| Production System 2 | 2.0% |
| Large Unit Op 1 | 3.3% |
| Large Unit Op 2 | 3.8% |
| Building Heat | 1.0% |
| Total Energy | 100.0% |