Purpose
Improving energy efficiency results in significant cost and energy savings which also reduces environmental impacts and supports our climate protection commitments.

Scope
These requirements apply to the Coca-Cola system’s manufacturing locations.

Requirements

Compliance
Implement management practices and controls in accordance with the stricter of Company requirements or applicable legal requirements related to energy efficiency.

Establish and maintain processes to identify, assess and verify compliance with current versions of applicable legal requirements. These processes may be specific to energy efficiency or part of a more comprehensive legal compliance process.

NOTE: “Applicable legal requirements” mean any law, regulation, rule, requirement, standard, norm, decree or code applicable to the relevant facility issued by any governmental or regulatory agency, authority or body at the national, federal, state, provincial, local or municipal level. It may also include international or regional treaties, laws and/or multi-country agreements, such as, but not limited to United Nations Guidelines adopted into locally applicable law.

Energy Assessment
Conduct and record an initial assessment of the site to identify potential opportunities to reduce energy consumption and quantify financial and environmental impacts.

The assessment must:

- Measure or estimate the energy consumption of major systems such as steam boilers, air compressors, refrigeration systems, bottle blowing equipment, production lines and lighting systems.
- Be a stand-alone document or may be included as part of a more comprehensive environmental aspects and impacts assessment.
- Include financially viable opportunities documented in an action plan.
Outline the procedures to control environmental impacts from high-energy consuming processes.

Be updated whenever significant changes occur with potential impact on energy consumption (e.g. the addition of lines, bottle blowing processes, hot-filled products, etc.). Review at least annually to verify that it is current.

**Performance Management**
Implement processes to monitor and manage energy efficiency performance.

- Comply with the EOSH Performance Measurement Requirements (ES-RQ-130).
- **Establish BU-approved energy efficiency targets for at least three years.** Update Energy Efficiency targets every three years or more frequently if needed.
- If the energy efficiency targets are not being met, develop and implement an Energy Efficiency Improvement plan to demonstrate progress towards achieving the targets. The plan must:
  
  - Be reviewed at least once annually with the BU.
  - Include objectives, actions and an implementation schedule.

**Maintenance and Inspection**
Implement maintenance and inspection programs to ensure the equipment and processes operate at their designed energy efficiency. At a minimum, follow the manufacturer’s recommendations and, if applicable, related legal requirements.

NOTE: It is highly recommended that sites enroll in the Top 10 Energy Savings Program (see references)

**References**
EOSH Performance Measurement Requirements ES-RQ-130

## Revision History

<table>
<thead>
<tr>
<th>Revision Date</th>
<th>Summary of Change</th>
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<tbody>
<tr>
<td>17-Aug-2015</td>
<td>Simplified the grammar of the document to improve the translation process and field comprehension. Limited scope to manufacturing sites.</td>
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<tr>
<td></td>
<td>Energy Assessment Section: Added “include financially viable opportunities documented in an action plan.”</td>
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<td>Performance Management Section: Added “Establish BU-approved energy efficiency targets for at least three years.”</td>
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<tr>
<td>01-Jan-2010</td>
<td>Revised document released as part of the TCCMS Redesign - Governance Reset. This document contains content from the previous version with reformatting and significant rewording.</td>
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<tr>
<td>14-May-2008</td>
<td>Substantial rewrite of entire document to provide specific energy efficiency requirements for equipment and systems.</td>
</tr>
<tr>
<td>15-Sep-2005</td>
<td>Corrected some format errors, no content changes</td>
</tr>
<tr>
<td>3-March-2005</td>
<td>Reformatted in TCCQS KQ format</td>
</tr>
<tr>
<td>31-Dec-2001</td>
<td>Initial Issue</td>
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