

Sara Lee Food and Beverage

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The Company

Sara Lee Food and Beverage – Farms and Plant Divisions, was originally started by Bert Vilas in 1902. Through the years, the company expanded and changed names to Bil-Mar. In 1987, Sara Lee purchased the plant from Bil-Mar and over the years since, Pump and Tumble, Hand Stuff and Foil Breast Operations have been added. Sara Lee’s Feed Mill produces more than 100,000 tons of turkey feed annually and the 165,000 square-foot plant will process more than 8.5 million birds this year. This is all accomplished though the outstanding efforts of approximately 660 hardworking Iowans.

Project Background

Sara Lee understands its impact on the environment and continually strives to find new and better ways to operate and lessen its environmental footprint. Currently 0.095 pounds of solid waste is produced

per 100 pounds of finished product, and Sara Lee is committed to further reducing the generation of waste.

Incentives to Change

Sara Lee Foods is currently implementing lean manufacturing. In order for lean manufacturing to be successful, wastes in the production process must be identified and solutions created. These wastes hurt both the environment and the company’s bottom line. Sara Lee is currently looking to implement a number of waste reduction ideas to further limit impacts on the environment.



Air Pollutants Diverted in Tons

	Total for all sectors
SO2	2.2
CO	0.8
NOX	1.2
VOC	0.8
LEAD	0.0
PM	0.0

Green House Gases Diverted in Tons (CO2 Equivalent)

	Total for all sectors
CO2	1,328.8
CH4	195.4
N2O	78.9
CFCS	5.7

Project	Annual Cost Savings	Environmental Results	Status
INSTALLING A SOLENOID AND TIMER ON THE FEATHER SEPARATOR TO CONSERVE WATER	\$4,200 in water treatment	2.1 million gallons of water Reduced chemical use	In Progress
AIR COMPRESSOR MAINTENANCE LEAK DETECTION AND REPAIR	\$6,400 in energy costs	158,500 kWh	Implemented
PREVENTIVE MAINTENANCE AT THE FEED MILL	\$250,00-500,000 in increased production and savings	109,000 kWh 19,500 Therms	In Progress
INSTALL A REVERSE OSMOSIS SYSTEM TO CAPTURE BLOW DOWN HEAT	\$84,000 in energy, chemical and water savings	66,500 Therms 4.6 tons of chemicals 2.5 million gallons of water	In Progress
INSTALLING A SPIRAL FREEZER TO REDUCE DRY ICE USE	\$252,000 in labor savings	2.5 million pounds of LCO2 use avoided	Recommended
VACUUM ENERGY CONSERVATION: REDUCE PUMP MOTOR RUN TIME	\$16,600 in energy costs	415,000 kWh	Recommended
INSTALLING CARBON FILTERS TO TREAT AIR IN WATER TREATMENT BUILDING	\$20,800 in energy costs	22,500 Therms	Recommended
HYDRAULIC ENERGY CONSERVATION: REDUCE CONVEYOR MOTOR RUN TIME	\$1,560 in energy costs	39,000 kWh	Recommended
PUMP AND TUMBLE PROCESS OPTIMIZATION	\$17,500 in labor savings	Investigating	In Progress
BOILER INEFFICIENCIES; PROFESSIONAL TUNING OF THE FIRING AND INSULATE BARE PIPES	\$14,500 in energy costs	15,000 Therms	Recommended
LIGHTING CHANGE	\$2,250 in energy savings	40,000 kWh	In Progress

