# Eco-Friendly Non-Fired Bricks in Nepal

## - Introduction to Good Bricks System





Oct 2023

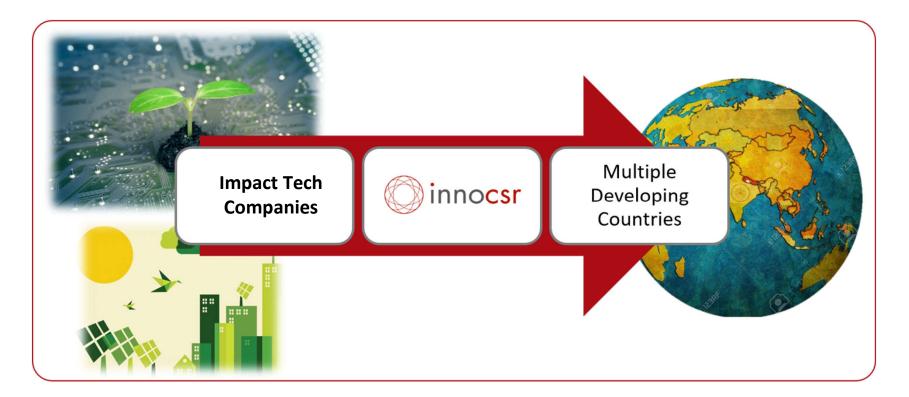


### InnoCSR introduces eco-friendly technologies to developing countries

InnoCSR is a Material Technology company established in 2008 headquartered in South Korea.

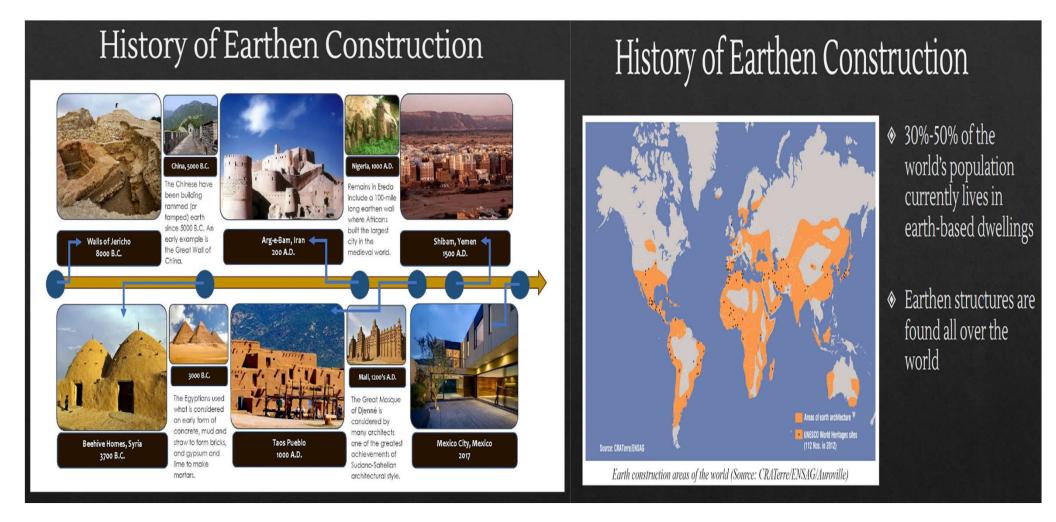
InnoCSR has accumulated extensive global network and business insights.

InnoCSR's **Technology Business NOW** uses these resources to help companies who have proven Green Technologies to go into developing countries to do good and do well.



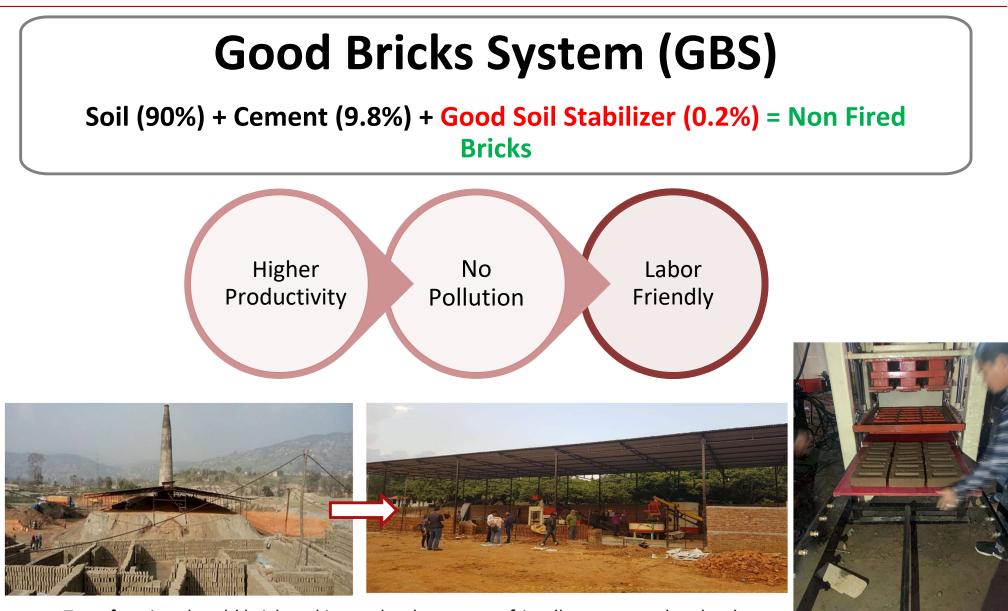
## **History**





**Good Bricks System** 

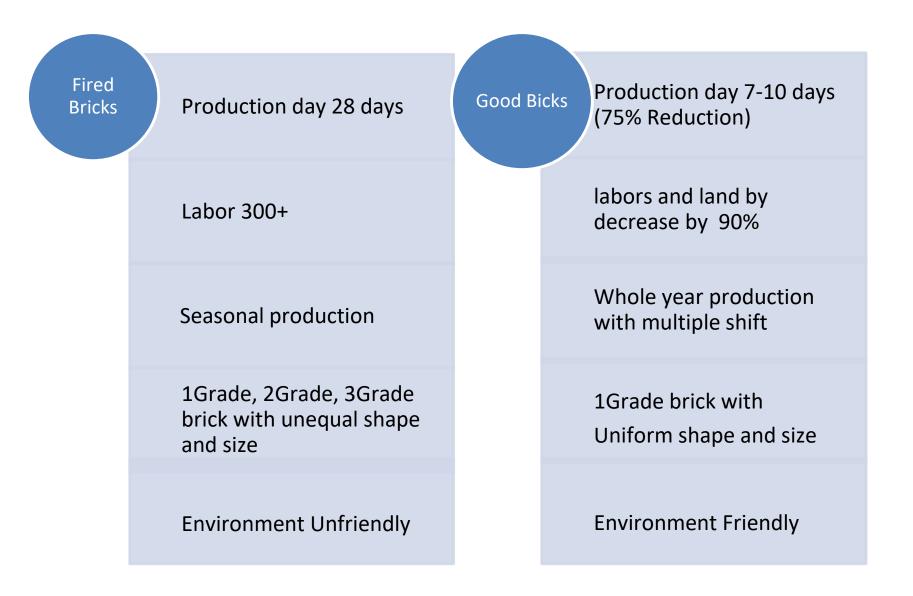




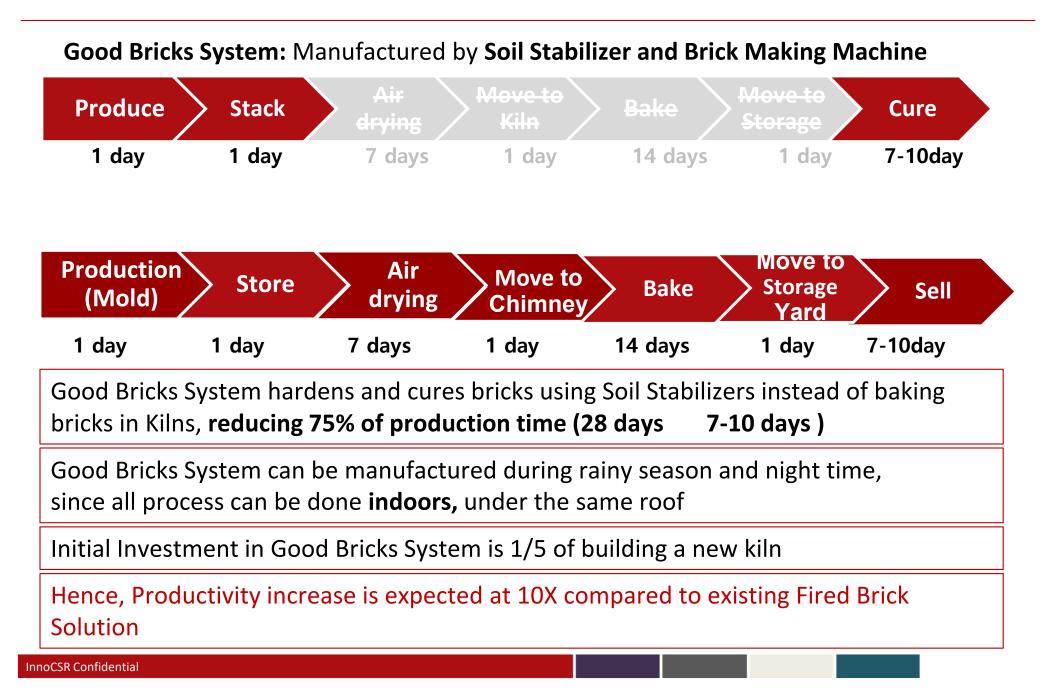
Transforming the old brick making technology to eco friendly automated technology

## Why Good Bricks?





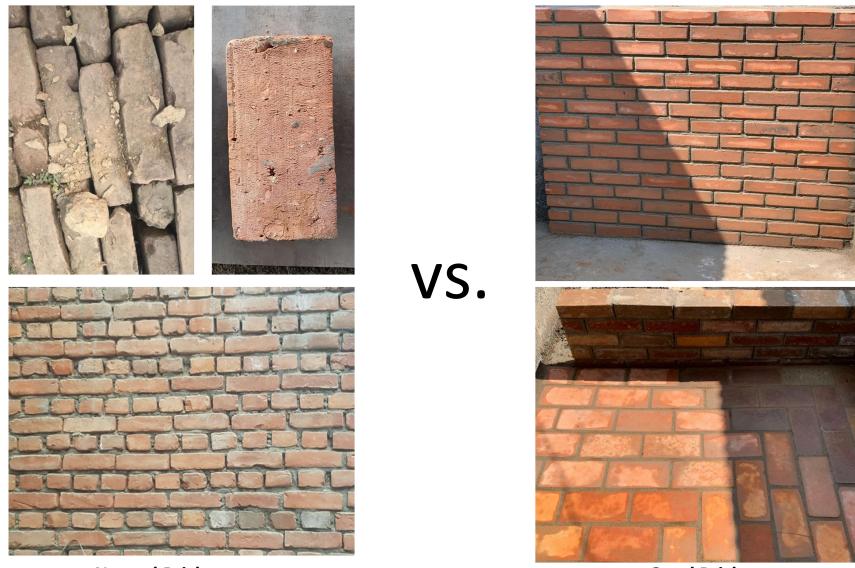
### **Good Bricks System increases productivity significantly**



### Good Bricks system produces better quality bricks



– Easier Construction, Less Construction Materials, and Better Results



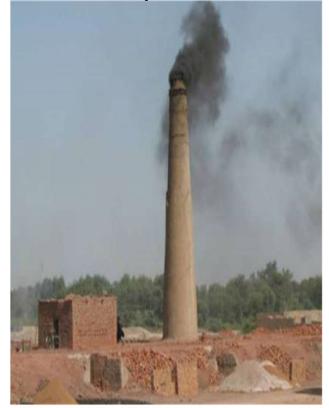
**Normal Bricks** 

**Good Bricks** 

### **Good Bricks system is beneficial**







- Average yearly production = 5.14 billion
- Average Hire of HR = 300+ People
- Challenging Policy from Government due to pollution
- High dependency on foreign labors and coal

### **Good Brick System**



Average yearly production = 10 – 20 million per machine (8 and 16 Hours of Production) Average HR Required = Minimum 20 people No hassle on approval from Nepal Government No Environmental issues, No Labor Issues No Coal supply issues Easily Expandable to multiple machines → Above # is for '1' machine only Land requirement 10% of Local Brick Kilns Use of locally available resources (cement, soil, labor and Soil Stabilizer)



### Good Brick system is good for Nepal's Environment

Energy consumed by a Good Brick = 0.0036 Wh per brick (Considering 15 million bricks production consume 536 KWh energy).

Energy consumed by conventional brick = 2230 Wh per brick

(Considering 5 billion bricks consume 1 million ton coal each year. Thus 1 brick consume 0.2 kg of coal as energy).

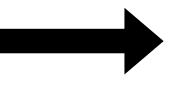


• No Brick Burning Process - No combustion of fossil fuel

### Conventional Brick Making

Kilns emit large amounts of CO2 by using coal to bake bricks





### Good Bricks System

Bricks are made with machines and stabilizers, without the need of fire





- Feasibility Test will take approximately 12 days from the date of soil arrives at InnoCSR's Good Bricks Test Center (GBTC) in KTM
- After initial order is placed, It will take approximately 8-12 weeks for machine and soil stabilizer to arrive in Nepal



**Good Bricks Vs Traditional Bricks** 

innocsr

### Good Bricks System meets the Nepal Gov's Standard



### Requirement of Nepal Government on Construction Bricks (For Fired Brick A class=7.8 Mpa ,B

class =3.5 Mpa) (For CSEB A class=5-7 Mpa, B Class-2-5 Mpa)

### Good Bricks System meets the requirement.



COMPRESSIVE STRENGTH TEST

Company Name: InnoCSR Nepal Pvt. Ltd. Material: InnoCSR Nepal Bricks Report No: 7711MTL028

Description	Unit	S-1	S-2	S-3	Remarks
Date of testing			2077/11/07		
Dimension	cm.	23.66*11.35*5.25	23.67*11.38*5.24	23.56*11.35*5.11	
Surface area	cm <sup>2</sup>	268.54	269.36	267.41	
Volume.	cm <sup>3</sup>	1409.84	1411.47	1366.44	
Weight	gms	2812.00	2790.00	2680.00	
Density	g/cm <sup>3</sup>	1.995	1.977	1.961	
Breaking Load	KN	438.95	448.80	498.15	
Breaking Strength.	Mpa	16.35	16.66	18.63	
Avg. Breaking Strength.	Mpa		17.21		

Material supplied By: Inno CSR Nepal Pvt. Ltd.

Dated :- 2077/11/07

Tested By Chinikaji Maharjan **Deputy Instructor** 

Yadin Shrestha Head Civil Department

	k and Concre	Compressive Strength Test				
Client : G Date : 2	CB Bricks (InnoC 079.1.19	SR Nepal Pvt. Li	d.)			
	Sample No.	1	2	3		
D	ate of Testing		2079.1.13			
Original	Length	23.00				
Dimension	Breadth		10.95			
cm	Height		6.13			
San	ple Weight, gm	2690.30	2715.60 2779.30			
Testing	Length	23.00	23.00	23.00		
Dimension	Breadth	10.95	10.95	10.95		
cm	Height	6.13	6.13	6.13		
Sar	nple Weight, gm	2903.80	2937.50	2985.40		
S	urface Area, cm <sup>2</sup>	251.77	251.77	251.77		
	Volume, cm <sup>3</sup>	1544.33	1544.33	1544.33		
	Density, gm/cm3	1.88	1.90	1.93		
1	Failure Load, kN	357.90	350.10	393.30		
Compressive Strength, Mpa		14.22	13.91	15.62		
tean Compressive	Strength, Mpa		14.58			

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Soil Rock & Concrete Laboratory NEA Bhagwan Pan, Swayambhu Kathmandu

## Good Bricks System meets the Nepal Gov's Standard



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1.	Water Absorption %	14.98	14.98	20 Max.	IS:3495:Part 2:1992
2.	Compressive Strength N/mm2	8.56	8.56	7.5 Min (For Grade 7.5)	IS:3495:Part 1:1992
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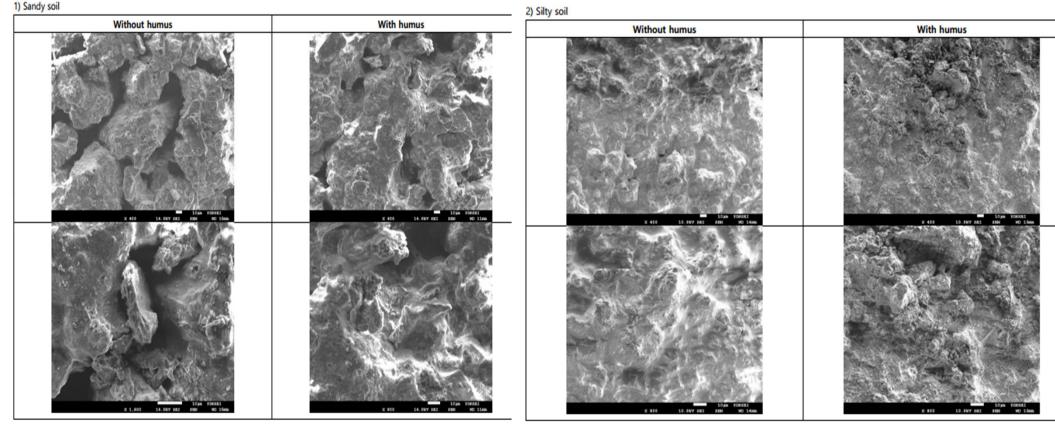
Sagarmatha Engineering Lab (P).Ltd. Banasthali,Kathmandu Email:inf@sagarmathalab.com.np Website: www.sagarmathalab.com.np							
Client	Inno CS	R Nepal Pv	L.L.td.				
Sample Name	Karachi	Sample Bri	ck				
Mix Composition:							
Soil	90%						
Cement	9.80%						
0.2 % Good Brick Soi	Stabiliz	er					
Test Standard:	IS 1077	, IS 2180 and	NS 1/2035				
Soil Location	Karachi	Pakistan					
Casting Date		2080/04/0	4	Testing Date	2080/04/16		
		Compressiv	e Strength	Test of Brick	,		
Specimen No:		1					
Length of Brick, L mm		239	-				
Breadth of Brick, B mm		113	-				
Height of Brick, H mm		50					
Volume of Brick, V=(LxBxH)/1	0° mm'	1347936.3					
Weight of Brick, gm		2641					
Density, D=m/V Kg/m3		1959.3					
Loaded area, A mm <sup>2</sup>		27048.8889					
Load KN		235					
Corrected load, M KN		251.685					
Corrected strength, N/mm <sup>2</sup>		9.30		$\bigcirc$			
Tested by:							
Note: Sample Provided by C	lient				* HelhmanAs		



### What is the scientific theory behind soil stabilizers?

Mineral salt such as, sodium chloride and magnesium chloride are mixed with water to create a Pozzolanic reaction, which will break the chemical bonds of the organic matter in the soil mixture.

Soil stabilizers will react to these surfaces and create an ionic bond effect that will stiffen and consolidate inorganic matter. This will condense inorganic matter. soil, and cement to secure a significant amount of strength. 3. Scanning electron microscopic images (SEM)



## SS toxic Report



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	• •		TEST (TEM)	UNT	DETECTION				TEST REGULTS	TEST METHOD
APPLICANT : SUBSURFACE INFORMATIION TECH	REPORT NO. : M	281-18-00187			UNIT	LEVEL 1	LEVEL2	UEVEL3	<b>#1</b>	
APPECANT . SUBJUT/ACE INFORMATION TECH.	SAMPLE RECEIVED DATE : 2		CADMUM (Cd)	mgikg	0.10	4	10	60	0.13	
		018-07-09	COPPER (CU)	mgikg	1.0	150	500	2 000	9.3	
		OF 2	ARSENIC (AS)	mgitg	1.50	25	50	200	2.95	1
		MERCURY (H	MERCURY (Hg)	mgikg	0.01	4	10	20	ND	1
			LEAD (PD)	mgikg	1.5	200	400	700	26.9	1
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TEST CONDUCTED : AS REQUESTED BY THE APPL			NICKEL(NI)	maka	0.4	100	200	500	2.8	1
			FLUORINE(F)	mgitig	10	400	400	800	253	NATIONAL
			ORPs	mglkg	0.05	10	10	30	ND	INSTITUTE OF
			POBs	maka	0.05	1	4	12	ND	RESEARCH
			CYAN(CN)	mgikg	0.2	2	2	120	ND	NO.2017-22 (2017.8.11)
			PHENOL	mgitg	0.02	4	4	20	ND	1
			BENZENE	mgitg	0.1	1	1	3	ND	1
			TOLUENE	mgikg	0.1	20	20	60	ND	1
			ETHYLBENZENE	maila	0.1	50	50	340	ND	1
			XYLENE	mailia	0.1	15	15	45	ND	1

PREPARED AND CHECKED BY FOR FITI

Hak joo, Lee HAK JOO, LEE QUALITY MANAGER

AUTHORIZED BY FOR FITI Jun Je 400 JE-GOO JUN PRECIDENT

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## Durabilty





## Durability















### Sample House made from Good Bricks





**Constructed On 2020** 



The building Today







**Constructed On 2019** 



The building Today







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## Norms And Specification, Standards (National)



### • According to Nepal National building Code (NBC 202:2015)

• Section 3.2

• Bricks: The bricks shall be of a standard rectangular shape, burnt red, hand-formed or machine-made and shall conform to the Nepal Standard NS: 1/2035. Bricks used as masonry units shall be of class A1 or class B1 as per NS: 1/2035 with compressive strength as specified in clause5.5

### • 3.4 Stabilized Soil Block

Stabilized soil blocks to be used for the masonry shall be free from major deformation and visible cracks. The stabilized soil blocks can be prepared from soil mixed with stabilizers such as lime, cement, bitumen, and the alike. The size of stabilized soil blocks are generally 300mmx150mmx100mm. The crushing strength of stabilized soil blocks shall not be less than 3.5N/mm2.

• According to the (NBC 000 )Section 1.4.3

### • 1.4.3 Masonry

• The use of burnt-brick-in-cement-mortar masonry as a structural element in a highly seismic country like Nepal is not preferred and alternative materials should be chosen wherever possible.

Following is the part of Design Catalogue that includes Compressed Stabilized Earth Brick/Block Masonry (latest update 2017).

### Design Catalogue Volume II



### INTRODUCTION

DUDBC has prepared second volume of Design Catalogue and named it as "Catalogue for Reconstruction of Earthquake Resistant Houses Volume II". The Catalogue includes architectural design, structural detailing and material estimate. The main objective is to support urban and rural households in reconstruction of their houses.

The model designs of seventeen houses provided in the catalogue are placed under the following twelve technologies:

Interlocking Brick Masonry

- Confined Hollow Concrete Block Masonry
- Hollow Concrete Block Masonry
- Earth Bag Masonry
  - Light Gauge Steel Structure Steel Structure

Rat Trap Bond Masonry

- Compressed Stabilized Earth Block Masonry
- Random Rubble Masonry with GI Wire Containment . Timber Structure Bamboo and Stone Masonry Hybrid Structure
  - Debris block Masonry

The designs provided in this catalogue are based on calculations, model test and analytical tests as these technologies are not covered by Nepal National Building Code, 2060. These designs are approved by Ministry of Urban Development. For each design included in the catalogue, the following information is provided:

- 3D view of the design
- Floor plans
- Elevations
- Section
- **Structural Details**
- Quantity estimate of major materials

Designs included in this catalogue can be selected and used as they are, for reconstruction of urban and rural housing . For designs, other than those included in this catalogue, detailed engineering design and approval from concerned authorities shall be done.

> Compressed Stabilized Earth Block (CSEB) Technology makes use of mud as a predominant building material. The properties of soil used are improved by using stabilizers like cement. The proposed technology is very suitable for rural areas where local materials are used and their quality improved by adding small quantities of non local materials. Featured design C.S.E.B.-4.1 is a low cost, single storied two room residential units of load bearing stabilized earthen block walls with mud stabilized soil roof over bamboo rafter and purlins. Design Model C.S.E.B.-4.2 is a two storied residential units with eight rooms. Load bearing walls are made of Earthen block stabilized with chemicals.

#### MATERIAL PROPERTIES( C.S.E.B 4.1)

Block Size: 30cm X 20cm X10cm Min Compressive Strength on gross area CSEB: 3.5 Mpa MATERIAL PROPERTIES( C.S.E.B 4.2)

Properties	Solid Brick
Size	230*110*55 mm
28 days dry compressive strength	7.5 - 10 MPa
28 days wet compressive strength (after 24 hours immersion)	3 - 4 MPa
Apparent bulk density	2100 - 2350 kg/m3
Total Water absorption	5 - 10 %
Moisture content	< 0.03%
Dry Shrinkage	< 0.04%
Shell thickness	

C.S.E.B.-4.1 C.S.E.B.-4.2

## National and International



Standard Norms and Specification for CSEB Block CSEB Green Buildings in Nepal July 2012	<ul> <li>भारतीय मानक</li> <li>सामान्य भवन निर्माण में प्रयुक्त स्थायीकृत</li> <li>मृदा की ब्लॉक — विशिष्टि</li> <li>( दूसरा पुनरीक्षण )</li> </ul>
Hari Darshan Shrestha	Indian Standard STABILIZED SOIL BLOCKS USED IN GENERAL BUILDING CONSTRUCTION — SPECIFICATION ( Second Revision )
	ICS 91.100.15
Government of Nepal	
Ministry of education	
Department of Education	* (Intranet Print) * * (Intranet Print) *
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This manual is developed by	© BIS 2013
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Centre of Resilience Development	New DELHI 110002
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## **Current Standards for CSEB**





#### LIMITATIONS, IF ANY

- Not suitable for high rise structures. However, can be used for non-load bearing applications or filler walls.
- In order to have quality production of blocks, the soil need to be tested characterized and design mix need to be prepared.
- Training of masons and artisans are required.

#### MARKET LINKAGES

- The precast components can be locally cast near construction site.
- It can also be produced by small entrepreneurs and supplied to consumers at State/ Block/ village level

#### MAJOR PROJECTS

- 2,698 earthquake resistant houses, after the 2001 Bhuj earthquake in Gujarat.
- Auroville Kindergarten, Solar kitchen Prarthna apartments, Tibetan pavilion, etc.
- Primary School at Jantanagar, Nepal Built in 20 days with the community (Precasting was done in 3 months)
- Al Medy Mosque at Riyadh, 420 m<sup>2</sup>, 18.05 m high minaret - Built in 7 weeks with ~ 75 unskilled masons and ~ 150 workers
- Kaza Community Centre, Spiti valley, India Rammed earth - First prize (Low Carbon Award) from Green Building & City Solutions Awards 2016
- Sharanam at Pondicherry Double storey lodges

#### CERTIFICATION/INDIAN STANDARD/ ENDORSEMENT

- IS 1725-2013 Stabilized Soil Blocks for General Building Construction
- GSDMA India, adopted CSEB for the rehabilitation of the regions affected by the January 2001 Gujarat earthquake in Kutch district
- Government of Iran (Housing Foundation) adopted CSEB for the rehabilitation of the regions affected by the December 2003 earthquake in Bam.
- The government of Tamil Nadu (Tsunami Relief and Rehabilitation), India, for the reconstruction of the zones affected by the December 2004 Indonesian tsunami.









#### CURRENT STANDARDS FOR CSEB

CSEB was first introduced in 1950s and earth construction methods have a very long history. However, the development of standards and specifications related earth construction methods are very poor and Table gives a summary of available standards.

Table 3	Available	Standards	for	CSEB
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Publication	Standard or Code of Practice	Critical Parameters
IS 15:1725-1982 Specification for Soil Based Block Used in General Building Construction: First Revision (2)	Standard	Block sizes, Compressive Strength (not less than 20 kgff/cm2), water absorption (not more than 15%)
Australian Handbook of Earth Construction (3)	Handbook	Covers many aspects of earth construction. Defines soil parameters, construction methods including rammed earth.
New Zealand Standard on Earth Construction (4)	Standard	Covers many aspects of earth construction. Defines soil parameters, construction methods including rammed earth.
New Mexico Building Code (1)	Appendix to standard	Brief addition to cover aspects of earth construction.

### **International Standards**

#### 2.2.2 Cement stabilisation

#### 2.2.2.1 Efficacy and dosage

The efficacy of the dosages depends on the texture and structure of the earth, and on how it is used. 4 to 12% of the weight of the dry earth gives good results. Some types of earth require only 3% whereas others, with the same dosage, behave less well than without the cement. In general, at least 6% cement is needed to obtain satisfactory results. Compressive strength remains highly dependent on the dosage.

The dosages indicated are relative to dry weight and are determined in laboratory conditions. Measures for checking in the workshop or on site should take account of the specific hygrometric conditions existing locally.

#### 2.2.2.2 Efficacy parameters

#### Types of earth

Almost all types of earth can be stabilised with cement. The best results are obtained with gravely and sandy types of earth. Compression at optimum water content is the most efficient.

#### 2) Organic matter

This is recognised as deleterious, and as a general rule, an organic matter content in excess of 1% is risky; earth containing more than 2% should not be used.

#### 3) Sulphates

When dry, calcium sulphates, which are frequently found, are less deleterious than magnesium sulphates. When wet, sulphates are always very deleterious. Sulphates destroy the hardened hydraulic binder matrix and increase the sensitivity to humidity of the clays. A specific study for earth containing more than 2 to 3% total sulphate content is indispensable.

#### 4) Oxides and metallic hydroxides

Essentially, these are iron and aluminium oxides which are rarely present in excess of around 5% and which in that event have little effect. In types of earth containing more than 5%, stabilisation has been observed to be highly effective with little cement.

#### 5) Water

In principle one should reject water containing organic matter and salty water: these may cause efflorescence. Water rich in sulphates may be unfavourable.



#### 2.2.2.4 Additives

Certain products, added in small quantities to the earth-cement during mixing, can improve certain of its properties.

#### 1) Reducing sensitivity to organic matter

Slaked lime, used at 2%, can reduce the deleterious effect of organic matter, as can calcium chloride (0.3 to 2%) which also accelerates the setting of the cement.

#### 2) Modifying the plasticity of the earth

Slaked lime can also be used to modify the plasticity of the earth and to restrict the formation of nodules.

#### 3) Rendering the earth water-proof

Bitumens, in emulsion or cut-back, used at 2 to 4%, enable CEBs to be made impermeable.

### **Press Release:**



### Press Conference at Hotel Shangri-La held on 4<sup>th</sup> Mar 2020:

epaper.nagariknetwork.com



#### NMB Bank

NMB Bank launches home loans with fixed interest for five years

KATHMANDU (REPUBLICA): NMB Bank has launched an enhanced variant of its home loan product, with interest rate fixed for 5 years. The offer comes with fixed interest rate of 11% per annum with the said rate being locked for 5 years. However, the maximum tenure under the NMB home loan fixed interest rate is up to 25 years. According to the officials of the bank, the product offering is one of the best in the housing loan segment in the industry and the objective of the product is to bring a sense of respite to the mental and financial pressure that customers face with fluctuating interest rates on their home loans.



#### InnoCSR Co Ltd Non-fired bricks technology enters Nepal

KATHMANDU (REPUBLICA): InnoCSR Co Ltd of South Korea is formally launching its nonfired brick business and Good Bricks Alliance. Issuing a statement on Wednesday, the company said its non-fired bricks solution, named as Good Bricks System, is an innovative method of producing bricks without baking by using soil stabilizer, cement and soil. Gorkha Innotech Pvt Ltd has adopted InnoCSR's good bricks technology in Gorkha, according to the company. Osika Neupane, marketing and sales manager of InnoCSR, said the production of bricks without baking plays a huge role in making environment safe and clean

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काठमाडौं, २१ फागुन (कास): नेपालमा इन्नोसिएसआरले औपचारिक रूपमा असल इँटा उत्पादन (आगोले नपोली उत्पादन गरिने इँटा) पद्धतिको व्यवसाय सुरुवात गरेको छ। इन्नोसिएसआरले माटो, सिमेन्ट

सोइल स्पेपलाइजर र पानीको मिश्रणबाट आगोमा नपोली बनाइने ईंटाको प्रविधि सुरु गरेको हो। आगोले ईंटालाई पोल्नुपर्ने परम्परागत विधिमा ईंटा भट्टाले धेरै वातावरणीय तथा स्वास्थ्य निम्त्याएको समस्याहरू अन्त्य गर्न असल डैंटा उत्पादन प्रविधिले सहयोग गर्ने कम्पनीले जनाएको छ । कम्पनीले बुधवार पत्रकार सम्मेलनको आयोजना गरी असल डैंटा उत्पादन प्रविधिको संख्वात गरेको जनाएको छ । यो प्रविधिबाट ईंटा उत्पादन गर्दा १० गुणा उत्पादकत्व वृद्धि हुने, धेरै अदक्ष कामदारहरूको प्रयोग नहने साथै कामदारहरूको प्रयोगभन्दा उच्च गणस्तरको हने. समान मल्यमा उपभोक्तसम्म पुग्ने र उत्पादकहरूलाई अधिकतम आम्दानी गराउने कम्पनीले जनाएको छ । कोरियन प्रविधिमा आधारित यो विधिले अधिकतम डैटा उत्पादन कम लागतमा उत्पादन

## नेपालमा असल इँटा उत्पादन प्रविधिको सुरुवात



गर्न मद्दत मिल्ने र वातावरणीय तथा सामाजिक समस्याहरूको समाधान गर्ने जनाएको छ।

इन्नोसिएसआर २००८ मा स्थापना भएको कोरियन कम्पनी हो । यसले कोरियालगायत विश्वका विकासोन्मुख देशहरू मलेसिया, फिलिपिन्स, चीन र नेपालमा ईंटा उत्पादनको क्षेत्रमा काम गरिसकेको छ । इन्नोसिएसआरका सीईओ साम योनसुक लिले सुरुवाती समयमा नेपालको विभिन्न क्षेत्रहरूमा करिव १८ महिना माटोको परीक्षण सम्पन्न गरेको बताए। यो प्रविधिमा आधारित गोरखा इन्नोटेक प्रालिले सन् २०२० फेब्रुअरीमा इन्नोसिएसआरको असल ईटा पद्धति अवलम्बन गरी गोरखाका उपभोक्तररूलाई बिक्री बितरण गरी सुरु गर्ने तयारी गरेको छ। यस उद्योगले करिब २ करोड ईटा वार्षिक रूपमा उत्पादन गर्ने जनाईएको छ। साथै स्थानीयहरूले घर निर्माण गर्न असल ईटाको प्रयोग गर्न थालिसकेको कम्पनीले जनाएको छ। पुल्चोक, ललितपुरको इन्जिनियरिङ क्याम्पसको निर्माण सामग्री परीक्षण प्रयोगशालामा असल ईंटाको धेरै पक्षररूको प्राविधिक जाँच गरी यसको कडापन १० एमपीए रहेको प्रमाणित गरेको छ। यसका अतिरिक्त यस कम्पनीले असल ईंटा उत्पादकररूको एउटा संघ संगठन गठन गरेको छ। जसलाई असल ईंटा उत्पादक संघ भनिएको छ। यसका सदस्यता असल ईंटा पद्धति प्रयोग गरी उत्पादन गर्ने उद्योगलाई





### **Pictures:**







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### 5. Machine



### **5.1 Machine Parts**

Parts of Automatic Good Bricks Machine



Hydraulic brick Press machine



Pan Mixer





Hydraulic Power Pack with cooling system

PLC System

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### 5. Machine



### Parts of Automatic Good Bricks Machine



Water Tank



Soil Hopper



Cement Silo

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### **Contact Details :**

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