

**New York State
Environmental Investment Program
Capital Project Summary
The Carriage House Companies, Inc.**

Project Background

Carriage House Companies, Inc. is a producer of private label branded food products, headquartered in Fredonia, NY with facilities in multiple locations. More detailed information on Carriage House can be found at its website: www.carriagehouseecos.com. In 2000 Carriage purchased a facility in neighboring Dunkirk, NY and began producing a variety of items, including pancake syrup products and salad dressings. In 2002, the company found that expanded production at the site would be limited by capacity issues at the City of Dunkirk's wastewater treatment plant. Because of the capacity issue, the City had placed new restrictions on all food product manufacturing facilities in Dunkirk. Carriage House engineers performed a critical review of the entire facility and found several inefficient and wasteful operations. The team also identified equipment that would reduce wastewater discharges and production waste, thereby allowing for growth that would not put a greater burden on the City's treatment plant.

Project Description

This project assisted Carriage House to purchase new filling, capping and packaging equipment that would significantly reduce the amount of waste generated during packaging. The new equipment was designed to assure that containers being filled

were in the proper position, and that the containers were not over- (or under) filled. Carriage House estimated that it was losing approximately 670 tons of food products annually due to the filling issues, including 321 tons that were being washed down the drain to the City's treatment plant. The other 355 tons were either being landfilled or given away for use as animal feed. Carriage House also installed a water cooling tower at the facility to re-circulate 7.34 million gallons of process water and eliminate the need to discharge cooling water to the City's treatment plant. The economic benefit, from reducing product losses, decreasing packaging needs, using and managing less water, and increasing productivity and sales, was estimated to be six million dollars annually.

Project Results

Carriage House exceeded all of its performance goals. Product losses were cut by 800 tons/year. Eleven and a half million gallons of water are being re-circulated, and the business is realizing an economic return of over \$7.5 million annually. The project had an unanticipated benefit: as a result of the improvements at the Dunkirk facility, Carriage House closed an out-of-state facility and shifted that production to Dunkirk.

Contractor:	Chautauqua County IDA	NYS EIP Investment:	\$500,000
County:	Chautauqua	Contractor Match:	\$1,323,025
ESD Region:	Western Region	Total:	\$1,823,025
ESD Contact:	518/292-5340	Completion Date:	February, 2006