

# Tip Sheet

## Energy Efficiency

### Process Heat

1. Maximize boiler efficiency through optimizing or adding controls (such as temperature resets and oxygen trimming)
2. For most effective condensate return, monitor and maintain steam trap
3. Ensure integrity of pipe insulation for steam systems
4. Evaluate heat recovery opportunities

### Refrigeration

1. Reduce condensing head pressure and raise suction pressure across system
2. Regularly conduct preventative maintenance on heat exchangers, condenser/cooling tower, and evaporator coils, valves, and regulators
3. Calibrate control points
4. Optimize sequencing of equipment

### Pumps/Fans

1. Add/optimize variable frequency drives (VFDs) on all large pumps and fans (>5 horsepower), where the load changes over time or is currently valved for speed control

### Compressed Air

1. Conduct system leak detection & repair
2. Reduce open compressed air blows
3. Adjust pressure setting to minimum level needed for process
4. Eliminate unnecessary uses of compressed air
5. Optimize compressed air storage

### Lighting

1. Install LEDs and controls