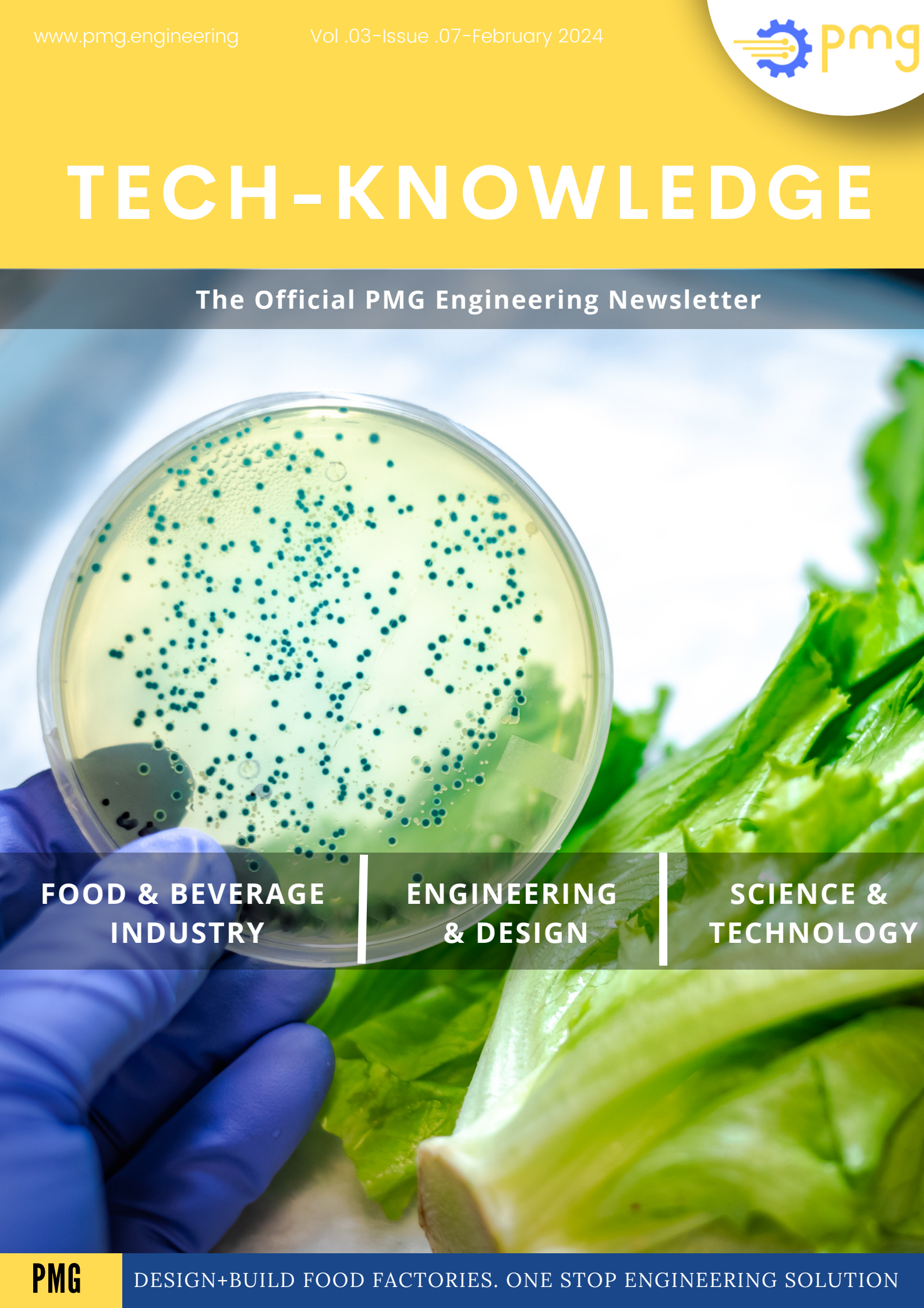


TECH-KNOWLEDGE

The Official PMG Engineering Newsletter

A close-up photograph of a petri dish held by a gloved hand, showing numerous small, dark, circular bacterial colonies on a yellow agar surface. In the background, there is a piece of fresh green lettuce.

**FOOD & BEVERAGE
INDUSTRY**

**ENGINEERING
& DESIGN**

**SCIENCE &
TECHNOLOGY**

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INSIGHT ON ESSENTIAL COMPONENTS OF FOOD RECALL PROGRAM IN A FOOD INDUSTRY



Introduction

Product recalls are inevitable reality of working in food industry which can be frightening for both food processors as well as for consumers due to the harm and fear they cause among them. People generally focus on its negative side only, but they are very essential and must happen regularly as they can prevent serious damages to the consumer's health. Product Recall is action of removing food products from the market at any stage of the food chain which may pose a safety risk to consumers. A food recall may be initiated because of a report or complaint from a variety of sources – manufacturers, wholesalers, retailers, government agencies and consumers. It may also occur because of a food business's internal testing and/or auditing.

Product Recall Program

A recall program is a written action plan that is carefully constructed, tested, and evaluated to ensure efficiency. It is the safety net that can prevent consumers from buying or eating a potentially harmful food product. Having an efficient recall program may reduce a company's liability, while a non-existent or poor recall program can have serious economic and legal consequences.

Components of Product Recall Program

Recall Team

Identifying recall team members and assigning recall duties enables the recall procedures to be conducted quickly and smoothly. The recall program should also identify the person who will coordinate the recall. The recall coordinator should have the authority to call upon other recall team members as needed to address the issues at hand. Recall team should include people responsible for decision making,

Complaint file

When a complaint is received, it is important to record the details and start an investigation either at your plant or your distribution facility. Early action on your part may enable you to identify potentially unsafe products and correct problems or enable you to stop selling the product until it is determined that it is safe.

Complaint file

When a complaint is received, it is important to record the details and start an investigation either at your plant or your distribution facility. Early action on your part may enable you to identify potentially unsafe products and correct problems or enable you to stop selling the product until it is determined that it is safe.

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Traceability System

Being able to determine which products need to be recalled allows you to limit the scope of a recall. If the specific affected products cannot be identified, you will need to broaden the scope of the recall, often recalling more products than necessary, which results in more financial losses.

Production amounts (Manufacturers)

In case of a recall, a company must ensure most of the affected product is removed from the marketplace. Having an accurate record of how much product has been sold, and how much is still on the premises, helps to ensure that all customers are notified of the recall.

Shipping and sales records

Maintaining accurate shipping and/or sales records is crucial because they can enable a company to limit the recall to only the customers who received the affected products.

Recalled product Records

It is beneficial to develop recall product records to ensure that recalled products are controlled and do not get into the hands of customers. Such records should include the name of the product being recalled, the amount,

Recall Procedures

Every recall plan should contain a step-by-step explanation of what to do when a product needs to be recalled. Following this plan will help food manufacturers and distributors ensure that important steps are not overlooked during this time of crisis.

Recall effectiveness

A company recalling a product is responsible for notifying all customers who bought the affected products. They should also verify that all customers have stopped the distribution of the affected products, and that all recalled products have been returned to the processors or distributors' control or other designated area as instructed in the recall notification.



Testing the recall program

Mock recalls test a company's ability to recall products without actually recalling them. Mock recalls are strongly suggested and should be tested on a regular basis. The goal is to be able to identify every affected lot, know exactly where it is at any point in the process, and know who to contact to bring it back. Many a times mock recall can be an eye-opener for the food processors who think that their recall program is full proof. Mock recalls should test both product-tracking and ingredient-tracking systems. Results of the practice must show that a manufacturer/distributor is able to handle a 95-100 % of recall situation.

Conclusion

At first instance food recalls are seen as a public health issue only, but they are also responsible for significant economic losses also. According to findings of one reputed survey, the average cost of a recall to a food company is around \$10M for direct costs, in addition to brand damage and lost sales. However, the costs for larger brands may be significantly higher based on the preliminary recall costs reported by firms of some recent recalls. Thus, it can be concluded that it can be one of the biggest threats to profitability, if not managed properly.

INSIGHT ON IMPORTANCE OF HOLD AND RELEASE PROGRAM OF NON-CONFORMING PRODUCT USED IN FOOD INDUSTRY



Introduction

Hold and Release program is a preventive measure program which safeguards the company against product recall and provides assurance that non-conformity ingredients/products are not used at any stage of the food supply chain. This program is a great way to ensure that the finished product that your food business is sending out into the marketplace is not only going to be safe, but also meet the desired product attributes. A food product can be classified as safe when it does not contain any biological, chemical, or physical hazards.

Non-conforming product is defined as a product at any stage in the process that does not meet agreed food safety and quality criteria. This can apply to any raw materials, ingredients, packaging materials, work-in-progress or finished product. It can also apply to any other material used in the facility that can impact product safety or quality, e.g. cleaning chemicals, processing aids, equipment.

Elements of Hold and Release Program

A. Hold and Release Planning:

- a) a written detailed plan that includes plant-specific procedures to be used to implement an effective program.
- b) Include a tracking and documentation system that identifies the product(s) placed on hold, and the release or appropriate disposition process upon receipt of test results.
- c) Provide written justification for production issues (e.g., raw materials, product shelf-life, physical space to hold product, ability to fill customer orders, line separation) to support the requested notification time prior to agency sampling.

B. Marking/ Tagging System:

Markers and Tags helps in distinguishing products held/ rejected from other products. Examples of identification systems include:

- a) Use of color-coded shrink-wrap,
- b) Use of color-coded tape (like crime scene tape),
- c) Use of color-coded tags

READ MORE....



Address the tracking of product held (e.g., where is it located, if transported offsite – carrier, delivery information, location at off-site storage).

C.Maintaining Control of Product(s) being Held:

Establishments should have following procedures in place to prevent products being held from entering production area:

- a.If possible, store the product being held away from other products.
- b.Clearly identify the product being held to distinguish it from other products to prevent it from being shipped accidentally.
- c.Protect unpackaged product from cross-contamination.
- d.Track the location of the product being held during storage and transportation.

D.Recordkeeping:

Test and Hold programs should:

- a.Provide a written, detailed description of the entire test and hold procedure.
- b.Ensure control of the product(s) being held.
- c.Include a written agreement with all off-site storage facilities used to store product while it is being held pending test results.
- d.Document Certificate of Analysis (COAs) and any test results for any raw materials being used in raw, ground product.
- e.Document COAs, any test results and letters of guarantees from suppliers of raw materials.



f.Provide a documentation system that:

- Identifies product(s) being held
 - Includes date and time of sample collection
 - Includes product name
 - Includes raw material information
 - Includes production or lot code
 - Includes product volume
 - Includes plant contacts
 - Includes the release of product or appropriate disposition
- g. Document sanitation and reinspection procedures designed to ensure the separation of product runs or production lines.

Conclusion

Clearly, food control involves many difficult issues. Some of these are highly technical, while others are partly technological and partly political. The mutual goal should be to resolve these questions in a way that considers the needs of governments, consumers, and industry. For governments, there is the need for enforceable standards that are convincing to both consumers and industry. For consumers, food control systems must provide meaningful protection against real and important hazards. Finally, industry needs standards that permit flexibility and efficiency in producing and marketing foods that will serve their customers - the world's consumers.

A close-up photograph of a glass filled with ice cubes and a dark, bubbly liquid, likely cola. The background is blurred, showing warm, golden-brown tones.

INDUSTRY BUZZ

Prasuma receives the International Taste Award from the Brussels-based International Taste Institute.

As the first and only Indian food brand to win an International Taste Award, Prasuma—India's top frozen food brand known for its dedication to quality and taste—has accomplished a remarkable milestone. Its spicy chicken momos and BBQ chicken bao buns received two stars out of three from the esteemed International Taste Institute in Brussels for the Superior Taste Award 2024.

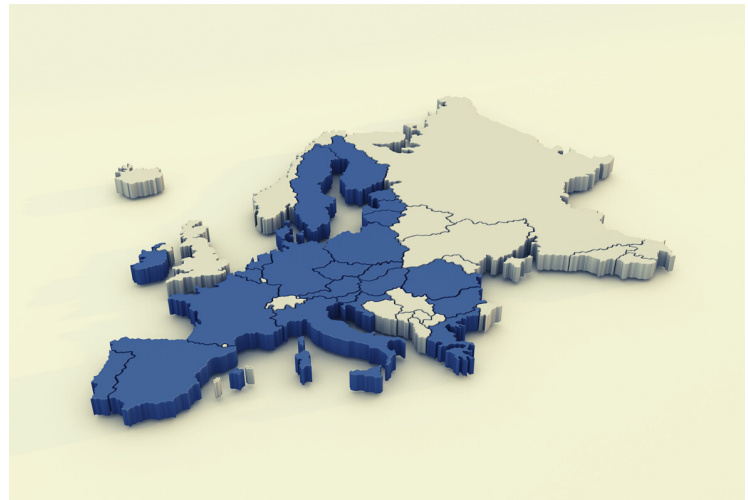
The CEO of Prasuma, Lisa Suwal, stated, "This is an exciting acknowledgement. We are thrilled that an Indian brand serving the ubiquitous Momo street food has gained recognition on the global scene! Every dish on our menu is freshly made and incredibly delicious since we take great pride in it. It's as fresh as though you prepared it from scratch at home. The highest quality flour, spices, and veggies are purchased directly from farms or locations where they can be found in their most pristine forms.

Experience the bounty of the Northwest Frontier in Diya.

The Leela Ambience Gurugram Hotels & Residences celebrate Northwest Frontier Cuisine, India's most acclaimed dish that embodies the nation's historical taste.

Northwest Frontier Cuisine, well-known for its flavorful spices, is expertly chosen and cooked by Indian chef Bobby Jaiswal at Diya. A ten-day culinary pop-up with an unmatched assortment of foods will wow your taste buds from February 16 to 25. Savour the genuine flavours of the Indian North-West Frontier region, where food is prepared using age-old methods in tandoors or clay ovens.

The thoughtfully designed menu features an array of mouthwatering options, from appetizers and main courses to desserts. Savour speciality foods like Bharwan Tandoori Aloo, Raan, Barra, Potli Kebab, and Malai Paneer Tikka at the food festival. Savour the delicious Kabool ka murg pulao and the must-try Makhan wali dal.





Food Safety and standards
Authority of India



FSSAI to permit labelling of the word "ORS" with a disclaimer.

Following the Office of Comptroller General of Patents Designs and Trade Marks' ruling that it was compliant with Section 17 of the Trademarks Act of 1999, the FSSAI has agreed to permit producers to use the word "ORS" as a trademark on the labels of their products.

The FSSAI issued an order on July 14, 2022, allowing FBOs with valid trademarks for product names similar to ORS to manufacture such products under their respective trademarked names until the Office of the Comptroller General of Patents Designs and Trade Marks (CGPDTM) made a decision that will be final and binding on all such FBOs, in response to complaints about numerous food companies selling products named ORS, which is also a drug formulation approved by the WHO.

Agricultural exports are propelled by APEDA from \$6 billion in FY 1988-1988 to \$26.7 billion in FY 2022-2023.

A remarkable \$26.7 billion was exported from agriculture in the fiscal year 2022-2023 thanks to the proactive interventions of the Agricultural and Processed Food Products Export Development Authority (APEDA), which began with modest annual exports of USD 0.6 billion during 1987-1988. The export basket has been expanded to over 200 countries, demonstrating an impressive Compound Annual expansion Rate (CAGR) of 12%, which highlights this journey of exponential expansion.

India's agricultural exports were \$53.1 billion in the fiscal year 2022-2023, with APEDA accounting for 51%. Of the 23 Principal Commodities (PCs) in APEDA's export basket, 18 showed positive growth from April to December 2023. Remarkably, with an average growth rate of 12%, 13 out of 15 significant PCs with exports over USD 100 million in the prior year saw positive growth.



The Coca-Cola Company has named a new operational unit leader for South Korea and Japan.

The Coca-Cola Company has declared that, as of April 1, Murat Ozgel, who has led the business's Bottling Investments Group since 2022, will take over as president of the Japan & South Korea operating unit.

On February 1, Ozgel became the Chief Customer & Commercial Officer, replacing Jorge Garduño.

As president of BIG, Ozgel oversees most of Coca-Cola's in-house bottling facilities. To take advantage of further growth prospects with independent bottling operations, Ozgel oversaw the franchising of businesses in five different nations in this capacity.

"Murat is a deeply experienced leader with a strong reputation for team management and driving business transformation," stated Henrique Braun, president of international development.

WEEKS HIGHLIGHT

NON-TECHNICAL CONTENT



19 FEBRUARY

CHHATRAPATI SHIVAJI JAYANTI

Chhatrapati Shivaji jayanti is celebrated on February 19 , Shivaji was also known as the 'Mountain Rat' and was widely known for his guerrilla warfare tactics. He was called so because of his awareness in geography of his land, and guerrilla tactics like raiding, ambushing and surprise attacks on his enemies. He knew the importance of a good army, and with his skills, expanded his father's 2000 soldier army to 10,000 soldiers.

FEBRUARY

DID YOU KNOW?



Sugar grinding plants are industrial facilities that are used to grind and mill sugar into various forms, such as granulated sugar, powdered sugar, or icing sugar. These plants typically consist of a series of machines and equipment that work together to grind, sift, and package sugar.

Types

- 1. Granulated sugar:**
Used in a wide range of food products, including baked goods, beverages, and condiments.
- 2. Powdered sugar:**
Used to make frosting, glazes, and other types of confectionery.
- 3. Brown sugar:**
Made using molasses and has a distinctive brown color and flavor. It is commonly used in baking, as well as in sauces and marinades.
- 4. Specialty sugars:**
Used to produce specialty sugars, such as demerara sugar, muscovado sugar, and turbinado sugar.



Fact 1

Specializing in sugar grinding plants, our company delivers cutting-edge solutions for efficient processing, ensuring high-quality output. With state-of-the-art technology and expertise, we design and construct plants tailored to meet diverse production needs. From initial consultation to installation and support, we prioritize precision, reliability, and customer satisfaction. Trust us for streamlined sugar processing solutions that optimize productivity and elevate your business to new heights.



BAKING OVENS

1/3

A baking oven is a kitchen appliance that is specifically designed for baking, roasting, and grilling food. Baking ovens are available in a variety of sizes, from small countertop models to large commercial-grade ovens used in bakeries and restaurants.

Uses

1. Bread:

Commonly used to bake different types of bread, such as white bread, whole wheat bread, sourdough bread, and artisanal bread.

2. Cakes:

Used to bake cakes of all types, including sponge cakes, pound cakes, layer cakes, and cheesecakes.

3. Cookies:

Used to bake cookies of all shapes and sizes, including chocolate chip cookies, sugar cookies, oatmeal cookies, and shortbread cookies.



2/3

4. Pastries:

Used to bake a variety of pastries, including croissants, Danishes, turnovers, and puff pastries.

5. Pies:

Used to bake pies of all types, including fruit pies, cream pies, and savoury pies.

6. Pizza:

Used to bake pizzas of all types, including thin crust, deep dish, and stuffed crust pizzas.

7. Muffins and cupcakes:

Used to bake muffins and cupcakes in a variety of flavours, including chocolate, vanilla, blueberry, and banana.



3/3

Fact 2

Baking ovens are the heart of any kitchen, transforming raw ingredients into delectable delights. With precise temperature control and innovative features, they empower chefs to create culinary masterpieces. From crispy bread to golden pastries, these ovens ensure even baking and consistent results every time. Elevate your baking game with the reliability and versatility of modern baking ovens.

ALMONDS

1/3

Almonds are a type of tree nut that is widely consumed around the world. They are a popular ingredient in various foods and snacks and are often consumed as a healthy snack. They are high in protein, healthy fats, fibre, vitamins, and minerals, which makes them a healthy and nutritious food choice.

Almonds have a hard outer shell, which must be removed to access the edible part of the nut. The edible portion of the almond is the white kernel inside the shell. A Some common almond products include:

1. Almond butter: A spread made from ground almonds, which can be used as a substitute for peanut butter.
2. Almond milk: A plant-based milk made from ground almonds, which can be used as a dairy milk substitute in cooking and baking.
3. Almond flour: A flour made from ground almonds, which can be used as a substitute for wheat flour in baking.
4. Almond extract: A flavoring agent made from almonds, often used in baking and cooking.
5. Almond snack bars: Snack bars are made from almonds, nuts, seeds, and other ingredients. Almond bars are often marketed as a healthy snack option.
6. Almond oil: A type of oil made from almonds, often used in cooking and as a skincare product.

• One of the major drivers of the almond market is the increasing awareness of the health benefits of almonds. Almonds are a good source of protein, healthy fats, fiber, and other important nutrients, which makes them a healthy and nutritious food choice.

• The rising incidence of lifestyle-related diseases, such as diabetes and heart disease, and plant-based diets has led to an increased demand for healthy and functional foods, which include almonds.

2/3

- In addition, the use of almonds in the cosmetic and personal care industry is expected to grow, as almonds are a good source of vitamin E and other nutrients that are beneficial for skin health.

Major Market Players

1. Blue Diamond Growers
2. Olam International Limited
3. The Wonderful Company LLC
4. Mariani Nut Company
5. Borges Agricultural & Industrial Nuts
6. Harris Woolf California Almonds
7. Treehouse California Almonds
8. Select Harvests Limited
9. Sran Family Orchards
10. D.L. Jardine's California Almonds

Commercial Production

1. **Growing:** Almond trees require a specific set of environmental conditions, including warm temperatures, ample sunlight, and well-drained soil.
2. **Harvesting:** Almonds are harvested in the fall when the nuts are ripe. The nuts are either picked by hand or harvested mechanically, depending on the size of the orchard.
3. **Processing:** Once the almonds are harvested, they are typically processed to remove the outer hull, which is inedible. The almonds are then either roasted or left raw, depending on the intended use. Roasting helps to enhance the flavor and texture of the almonds.
4. **Packaging:** The processed almonds are then packaged in suitable containers, such as bags, boxes, or cans, to ensure they stay fresh and safe for consumption. Packaging may also involve labeling and branding to help consumers identify the product.
5. **Distribution:** The final product is distributed to wholesalers, retailers, and other customers, either directly or through intermediaries. Distribution may involve transportation and storage of the product to maintain its quality and safety.

3/3

Fact 3

Almonds, nature's powerhouse, offer a bounty of nutrients packed into a tiny package. With a rich history dating back thousands of years, these versatile nuts are celebrated for their heart-healthy fats, protein, fiber, and array of vitamins and minerals. From snacking to cooking, almonds add a delightful crunch and nutty flavor, elevating dishes and promoting overall wellness with every bite.

PISTACHIO



1/3

Pistachio nuts are a type of tree nut that is widely consumed around the world. They are a popular ingredient in a variety of foods and snacks and are often consumed on their own as a healthy snack. Pistachios are high in protein, fiber, healthy fats, vitamins, and minerals, which makes them a healthy and nutritious food choice.

The edible part of the pistachio is the green kernel inside the shell. Pistachios are available in a variety of forms, including whole, shelled, roasted, salted, and unsalted.

Some common pistachio products include:

1. Pistachio butter: A spread made from ground pistachios, which can be used as a substitute for peanut butter.
2. Pistachio milk: A plant-based milk made from ground pistachios, which can be used as a dairy milk substitute in cooking and baking.
3. Pistachio flour: A type of flour made from ground pistachios, which can be used as a substitute for wheat flour in baking.
4. Pistachio ice cream: A type of ice cream made with pistachio flavoring and chopped pistachio nuts.
5. Pistachio snack bars: Snack bars are made from pistachios, nuts, seeds, and other ingredients. Pistachio bars are often marketed as a healthy snack option.
6. Pistachio oil: A type of oil made from pistachios, which is often used in cooking and as a salad dressing.

- Pistachios are a good source of protein, healthy fats, fiber, and other important nutrients, which makes them a healthy and nutritious food choice. Pistachios are a popular ingredient in various plant-based foods, such as nut milk, nut butter, and nut-based snacks.

2/3

Major Market Players

1. Wonderful Pistachios & Almonds LLC
2. Germack Pistachio Company
3. Setton Pistachio of Terra Bella, Inc.
4. Horizon Growers LLC
5. AZNUT, LLC
6. Meridian Growers LLC
7. Primex Farms LLC
8. ARO Pistachios Inc.
9. Keenan Farms
10. American Pistachio Growers

Commercial production

1. Growing: Pistachio trees require specific environmental conditions, including warm temperatures, ample sunlight, and well-drained soil.
2. Harvesting: Pistachios are harvested in the fall when the nuts are ripe. The nuts are either picked by hand or harvested mechanically, depending on the size of the orchard.
3. Processing: Once the pistachios are harvested, they are typically processed to remove the outer hull, which is inedible. The nuts are then either roasted or left raw, depending on the intended use. Roasting helps to enhance the flavor and texture of the pistachios.
4. Packaging: The processed pistachios are then packaged in suitable containers, such as bags, boxes, or cans, to ensure they stay fresh and safe for consumption. Packaging may also involve labeling and branding to help consumers identify the product.
5. Distribution: The final product is distributed to wholesalers, retailers, and other customers, either directly or through intermediaries. Distribution may involve transporting and storing the product to maintain quality and safety.

In commercial production, large-scale machinery and equipment are often used to handle the pistachios and carry out the various stages of production.

3/3

Fact 4

Nature's green gems, brimming with irresistible flavor and wholesome goodness. These little powerhouses pack a punch of protein, fiber, and essential nutrients, making them a guilt-free indulgence. Whether enjoyed as a crunchy snack, sprinkled over salads, or incorporated into decadent desserts, pistachios add a delightful crunch and nutty richness to any dish. Elevate your culinary experience with these delicious, versatile treats.



Kernels are the edible part of certain types of seeds or nuts. They are typically removed from the shell or husk of the seed or nut before consumption. Kernels are a common ingredient in a wide range of food products, including snacks, baked goods, and confectionery.

Common examples of kernel



Almond



Cashew



Pine Nut



Hazel Nut



Pumpkin

Market scope

- The market scope for kernels is significant, as they are a widely consumed and versatile ingredient in many food products. One of the primary drivers of the kernel market is the increasing awareness of the health benefits of kernels. Kernels are an excellent source of protein, healthy fats, fibre, and other essential nutrients, which makes them a healthy and nutritious food choice.
- Moreover, there is a growing trend towards plant-based and vegan diets, which presents an opportunity for producers and suppliers of kernel products to expand their product offerings. Kernels are a popular ingredient in vegan and plant-based foods, such as nut milk, nut butter, and nut-based snacks.
- The market for kernels is also driven by the increasing demand for convenience and ready-to-eat food products. Kernels are often used as a snack or as an ingredient for many food products, including confectionery, baked goods, and snack bars.
- In addition, the use of kernels in the cosmetic and personal care industry is expected to grow. Kernels are a good source of vitamin E and other nutrients that are beneficial for skin health.

Major market players

1. Archer Daniels Midland Company
2. Olam International Limited
3. Blue Diamond Growers
4. Barry Callebaut AG
5. SunOpta Inc.
6. Kerry Group
7. Treehouse Foods, Inc.
8. The Hershey Company
9. Roquette Frères
10. Barry Farm Foods

Commercial production

- 1. Growing:** Kernels require specific environmental conditions, such as adequate sunlight, water, and nutrients.
- 2. Harvesting:** Kernels are harvested when they are fully mature and ripe depending on the type of kernel, it may involve hand-picking or using mechanical equipment.
- 3. Processing:** Once the kernels are harvested, they are typically processed to remove the outer shell, which is often inedible. The kernels are then either roasted, salted, or left raw, depending on the intended use. Roasting helps to enhance the flavor and texture of the kernels.
- 4. Packaging:** The processed kernels are then packaged in suitable containers, such as bags, boxes, or cans, to ensure they stay fresh and safe for consumption. Packaging may also involve labeling and branding to help consumers identify the product.
- 5. Distribution:** The final product is distributed to wholesalers, retailers, and other customers, either directly or through intermediaries. Distribution may involve transportation and storage of the product to maintain its quality and safety.

In commercial production, large-scale machinery and equipment are often used to harvest the kernels and carry out the various stages of production.

Fact 5

Kernels are the edible inner parts of seeds or nuts, packed with essential nutrients and flavors. They serve as the heart of various fruits and grains, such as almonds, walnuts, and sunflower seeds. These nutrient-rich powerhouses are prized for their versatility and health benefits, adding crunch, taste, and nourishment to a wide array of dishes, from salads to baked goods and beyond.



Fact 6

Preserved fruit offers nature's sweetness captured in time, preserving the essence of ripe flavors and vibrant colors. From succulent strawberries to tangy apricots, each bite embodies the peak of freshness, extending the joy of harvest throughout the year. Whether enjoyed solo as a wholesome snack or incorporated into delightful recipes, preserved fruit serves as a delicious reminder of nature's bounty and the art of preservation.



PMG ENGINEERING

About PMG

Delivering End-to-End Engineering
Design & Construction Management in
Food & Beverage Industry



Meeting Global Benchmarks

In ENGINEERING DESIGN and PROJECT MANAGEMENT
for FOOD and BEVERAGE Industry with SINGLE POINT ACCOUNTABILITY

Process Engineering | Project Management | Mechanical | Electrical | Automation | Food Safety

PEOPLE DELIVERING RESULTS

Safe-by-choice. First Time Quality. Maximize Value. Objectivity.
Ownership. Reliable and Trustworthy Business.

- MAKING CUSTOMERS THE INDUSTRY LEADERS
- ENGINEERING MUST CREATE BUSINESS VALUE
- MEET THE EXPECTATIONS OF ALL STAKEHOLDERS
- OPTIMAL ENGINEERING

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