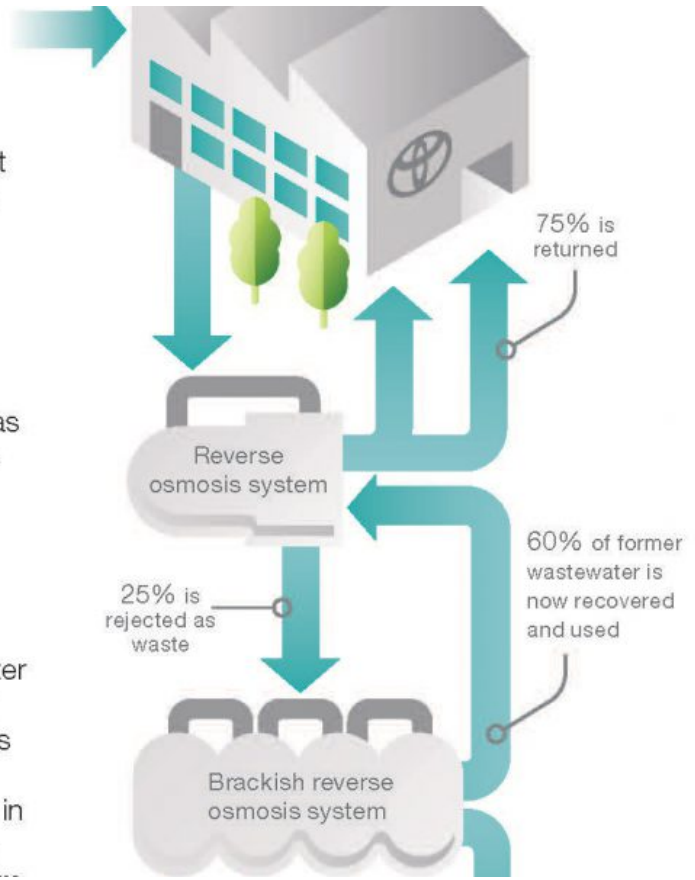


# How Toyota Saves 61 Million Gallons of Water Annually

December 16, 2013

- as painting vehicles.
- STEP 2** The water goes through prefilters and is fed into a reverse osmosis system that further separates impurities before being used in the manufacturing process.
- STEP 3 (old way)** From there, 75% went straight to the process for use and 25% was rejected as waste due to containing the concentrated impurities.
- STEP 3 (new way)** The 25% that contains impurities now goes into what's called a brackish reverse osmosis system. After further filtering, 60% of that waste is recovered and goes back into the first reverse osmosis system to be used in the manufacturing process.



Plant processes, such as painting vehicles, require very pure H<sub>2</sub>O. Typically 25 percent of the water coming into a facility doesn't make the cut. But by implementing a system called reverse osmosis that separates impurities before the manufacturing process, Toyota has increased usable water from 75 to 90 percent at several of its plants. Let's hear it for not going with the flow!

For more information about Toyota's environmental efforts, view the North American Environmental Report at <http://www.toyota.com/about/environmentreport2013>.

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