Table of contents

Foreword 5

Preface 7

About the Authors 9

Acknowledgements 13

Abbreviations 22

Units 23

Technical Glossary 24

Part 1: SUGARCANE AGRICULTURE 33

1 **Sugarcane and its environment** 35
1.1 Introduction 35
1.2 The changing global sugarcane landscape 35
1.2.1 Sugar supply and demand dynamics 35
1.2.2 Trade liberalization 36
1.2.3 Economic development 36
1.2.4 Biofuel and renewable energy 37
1.2.5 Technological change 37
1.2.6 Global warming and climate change 37
1.2.7 Environmental issues 38
1.3 The impacts of sugarcane production on the environment 39
1.3.1 Biodiversity loss 39
1.3.2 Water resource use 40
1.3.3 Pollution of water sources 41
1.3.4 Soil loss impacts 43
1.3.5 Soil degradation 44
1.3.6 Air quality impacts 45
1.3.7 Social and community impacts 46
1.3.8 Summary of Good Management Practices 47
1.4 The soil-plant-climate continuum 51
1.4.1 Climate 51
1.4.2 Soils 53
1.5 Physiology of the sugarcane plant 54
1.5.1 Brief overview 54
1.5.2 Main growth stages in sugarcane 56
1.5.3 Plant characteristics that impact on cultivar performance 56
1.6 Sugarcane cultivars 59
1.6.1 Cultivars the key to economic sustainability 59
1.6.2 New emerging developments 59
1.6.3 Sugarcane taxonomy 60
1.6.4 Centers of origin 60
1.6.5 Hybridization 61
1.6.6 Diseases 61
1.6.7 Pests 61
1.7 Cultivar management 62
1.7.1 Identification 62
1.7.2 Agronomic characteristics 62
1.7.3 Main components of yield 63
1.7.4 Harvesting and transport 63
1.7.5 Milling quality characteristics (see also Section 2) 63
1.7.6 Plant breeding and selection 64
1.7.7 Field and planting hygiene 64
1.7.8 Seedcane management 64
1.8 Conclusions 66
1.9 References 68

2 **The soil and its environment** 73
2.1 Why is knowledge of soil important? 73
2.2 Origin of soils and their distribution 73

2.2.1 Soil composition and functions 73
2.2.2 Weathering agents contributing to soil formation 74
2.2.3 Soil development 75
2.3 Recognizing important soil properties 78
2.4 Impact of clay content on agronomic management 83
2.5 Classifying soils 86
2.6 Use of soil specific management guidelines 91
2.7 The role of soil mapping 93
2.7.1 Choosing an appropriate classification system 94
2.7.2 Potential benefits of soil survey maps 94
2.7.3 Range of soil mapping options 95
2.8 Soil health issues 95
2.8.1 The new emerging view of soil health 95
2.8.2 Yield plateau assessments 96
2.8.3 Paired site outcomes 96
2.8.4 Loss of organic matter 97
2.8.5 Acidification 98
2.8.6 Soil salinity and sodicity 99
2.8.7 Soil compaction 99
2.9 Management strategies for improving soil health 100
2.9.1 What constitutes a healthy soil? 101
2.9.2 Good management practices to improve soil health 101
2.9.3 Green manuring 102
2.9.4 Bioremedial amelioration with organic amendments 105
2.9.5 Minimum or reduced tillage 107
2.9.6 Managing soil acidification 107
2.9.7 Trash management 107
2.9.8 Managing soil compaction 111
2.9.9 Financial, social and environmental costs of improving soil health 111
2.10 Conclusions 113
2.11 References 113

3 **Sugarcane cropping system** 117
3.1 Land use planning and conservation 117
3.1.1 Introduction 117
3.1.2 Land evaluation 117
3.1.3 The land use plan 123
3.1.4 Monitoring and evaluation plan 127
3.2 Crop establishment 128
3.2.1 Introduction 128
3.2.2 Crop eradication 129
3.2.3 Seedbed preparation 132
3.2.4 Planting 134
3.2.5 Ratoon management 138
3.3 References 143

4 **Weed control** 145
4.1 Background 145
4.2 The need for weed control in sugarcane 145
4.3 Weeds of sugarcane 146
4.3.1 Weed groups 146
4.3.2 Weeds associated with poor growth areas 148
4.3.3 Some problem species 149
4.4 Non-chemical weed control methods 150
4.4.1 Physical 150
4.4.2 Hand weeding and hand hoeing 151
4.4.3 Mechanical cultivation 152
4.5 Chemical weed control 152
4.5.1 Broad categories of herbicides and their use 152
4.5.2 Chemical groups of herbicides 153
4.5.3 Timing of herbicide application 155
4.5.4 Fate of herbicides in the environment 157
4.5.5 Choice of herbicide treatment 159
4.5.6 Formulations 160
4.6 Application of herbicides 160
4.6.1 Application equipment 160
4.6.2 Weather conditions and drift control 162
4.6.3 Chemigation 162
4.6.4 Herbicide regulation 163
4.6.5 Responsible use of herbicides 163
4.7 Integrated weed control 164
4.8 Weed control planning 164
4.9 Optimizing performance and minimizing negative impacts 164
4.10 References 168

5 **Sugarcane nutrition and fertilization** 169
5.1 Introduction 169
5.1.1 Nutrients required by sugarcane 169
5.1.2 Principles of nutrient management 170
5.1.3 Amounts of nutrients taken up by sugarcane 171
5.1.4 Impact of climate on nutrient uptake 171
5.1.5 Soil factors affecting nutrient supply 173
5.1.6 Clay minerals 173
5.1.7 Cation exchange capacity 173
5.1.8 Soil organic matter 174
5.1.9 Soil pH, acidity and alkalinity 174

5.1.10 Movement of nutrients in the soil 175
5.2 Nitrogen (N) 176
5.2.1 Importance of nitrogen 176
5.2.2 The nitrogen cycle 176
5.2.3 Nitrogen losses 178
5.2.4 Factors affecting the nitrogen requirement of sugarcane 179
5.2.5 How to adopt soil specific nitrogen recommendations 183
5.2.6 Nitrogen fertilizers 186
5.2.7 Managing N fertilizer 187
5.3 Phosphorus (P) 191
5.3.1 The importance of phosphorus 191
5.3.2 Phosphorus cycle in the soil 192
5.3.3 Factors affecting phosphorus availability 193
5.3.4 Phosphate carriers 194
5.3.5 Managing the P requirement of sugarcane 194
5.4 Potassium (K) 196
5.4.1 Importance of potassium 196
5.4.2 Potassium cycle in the soil 197
5.4.3 Factors affecting potassium availability 197
5.4.4 Potassium sources 199
5.4.5 Managing the K requirement of sugarcane 200
5.5 Calcium (Ca) 203
5.6 Magnesium (Mg) 203
5.7 Sulfur (S) 205
5.8 Silicon (Si) 206
5.8.1 Benefits from silicon treatment 207
5.8.2 Soil Si source/sink pools 207
5.8.3 Managing silicon nutrition 208
5.8.4 Silicon fertilizer sources for sugarcane 208
5.8.5 Silicon leaf deficiency symptoms 209
5.9 Micronutrients 209
5.10 Good management practices for minimizing environmental impact 211
5.11 General conclusions 212
5.12 References 213

6 **Irrigation** 219
6.1 Sugarcane water demand 219
6.1.1 Crop water requirements (CWR) 219
6.1.2 Irrigation requirements in relation to the soil water balance 220
6.2 Influence of type of soil on irrigation 221
6.2.1 Soil morphology 221
6.2.2 Soil physical properties affecting irrigation 222
6.2.3 Soil texture as a factor in choice of irrigation method 223
6.2.4 Management allowable deficit 224
6.2.5 Moisture extraction patterns 225
6.2.6 Soils and water quality 225
6.3 Irrigation application systems 225
6.3.1 Low pressure systems: surface irrigation 225
6.3.2 Medium pressure systems: drip irrigation 227
6.3.3 Medium pressure mechanized systems: center pivot irrigation 230
6.3.4 Medium pressure mechanized systems: linear systems (moving laterals) 231
6.3.5 High pressure manually moved systems: impact sprinklers 232
6.3.6 Very high pressure self-traveler systems: travelling guns/rain guns 234
6.4 Choice of irrigation method 235
6.4.1 Economic aspects 235
6.4.2 Summary of factors influencing the selection of a particular irrigation system 236
6.4.3 Energy aspects 236
6.5 Irrigation performance 237
6.5.1 Efficiency 237
6.5.2 Uniformity 239
6.5.3 Improvement of irrigation efficiency 240
6.6 Scheduling 243
6.7 Potential impact of irrigation practices on the environment, communities and health 244
6.7.1 Environmental impact assessment (EIA) for irrigation developments 245
6.7.2 Environmental Management System (EMS) for sugarcane developments 245
6.7.3 Effects on communities 245
6.7.4 Effects on health 246
6.8 Water supply and hydrology 246
6.9 References 248

7 **Drainage, irrigation water quality and salt affected soils** 251
7.1 Introduction 251
7.2 Drainage of agricultural lands 252
7.3 Types of drainage 252
7.3.1 Internal drainage of soils 252

7.3.2 Inundation 253
7.3.3 Aeration 254
7.4 Water table management 254
7.5 Drainage methods 256
7.5.1 Surface drainage 256
7.5.2 Subsurface drainage 258
7.5.3 Mole drains 259
7.6 Drainage design 261
7.6.1 Surface drainage design 261
7.6.2 Subsurface drainage design 263
7.6.3 Pumped outfalls 266
7.7 Flood control 266
7.8 Water quality 266
7.9 Water blending 268
7.10 Water table depth 269
7.11 Salt affected soils 270
7.12 Salinity dominated soils 270
7.12.1 Origin of saline soils 270
7.12.2 Measurement of salinity 271
7.12.3 Influence of salinity on crop yield 271
7.13 Reclamation of saline soils 272
7.14 Irrigation method and salinity control 273
7.15 Sodicity dominated soils 273
7.16 Reclamation of sodic soils 276
7.17 Salinity, sodicity and cane yield 277
7.18 Impact of drainage and salinity on the environment 278
7.19 Impact of drainage on health 279
7.20 Good management practices 280
7.20.1 Pre-implementation: survey and planning requirements for drainage 280
7.20.2 Post-implementation: identification of drainage, salinity and sodicity problems 280
7.20.3 Monitoring of drainage, salinity and sodicity problems 281
7.20.4 Mitigation measures 281
7.21 References 282

8 **Disease control** 285
8.1 Introduction 285
8.2 Sugarcane quarantine 286
8.3 Integrated disease control in sugarcane 287
8.4 Varietal resistance 287
8.5 Seedcane health 288
8.6 Effective crop eradication 290
8.7 Roguing 290
8.8 Other cultural methods of disease control 291
8.9 Sugarcane industry disease control schemes 291
8.10 Monitoring disease incidence 291
8.10.1 Monitoring diseases in seedcane nurseries 291
8.10.2 Monitoring diseases in commercial fields 292
8.11 Chemical control 292
8.12 Some common diseases of importance 292
8.12.1 Ratoon stunting disease (RSD) 293
8.12.2 Smut 293
8.12.3 Mosaic 294
8.12.4 Rust 295
8.12.5 Red rot 295
8.13 Diseases in selected regions 296
8.13.1 Australia 297
8.13.2 Papua-New Guinea 297
8.13.3 The Far East and India 297
8.13.4 Africa 297
8.13.5 The Americas 297
8.14 The way forward towards sustainable control of diseases 297
8.15 Summary 298
8.16 References 300

9 **Pest control** 301
9.1 Introduction 301
9.1.1 Integrated pest management 302
9.1.2 Pesticides 302
9.1.3 Steps in managing a pest problem 305
9.2 Stalk borers 308
9.2.1 Top borer, Scirpophaga excerptalis 308
9.2.2 Sugarcane stem borers, *Diatraea* species 309
9.2.3 African sugarcane borer, *Eldana saccharina* 311
9.2.4 Other stalk borers 312
9.3 White grubs 315
9.3.1 Canegrubs in Australia 315
9.3.2 Other white grubs and soil insect pests 317
9.4 Sap feeders 318
9.4.1 Above ground sap feeders 318
9.4.2 Below ground sap feeders 319
9.5 Leaf feeders 321
9.6 Nematodes 322
9.6.1 Control strategies 323
9.7 Vertebrates 324

9.8 Social, financial and environmental costs of pest control 325
9.8.1 Social cost of practices used to control pests 325
9.8.2 Financial cost of pests 325
9.8.3 Environmental cost of practices used to control pests 326
9.9 Summary 326
9.10 References 327

10 **Chemical ripening, flower suppression and growth** 331
10.1 Introduction 331
10.2 Background 331
10.3 Natural ripening 332
10.3.1 Temperature 332
10.3.2 Age 334
10.3.3 Water stress 335
10.4 Chemical ripening 336
10.4.1 Milling periods and crop characteristics 336
10.4.2 Identifying crops that are suitable for chemical ripening 337
10.4.3 Chemicals used for ripening 337
10.4.4 Cultivar responses to chemical ripening 339
10.4.5 Methods of applying chemical ripeners 340
10.4.6 Factors influencing crop response to chemical ripeners 341
10.5 Flowering 344
10.5.1 The occurrence of flowering 344
10.5.2 Suppression of the flowering process 345
10.6 Possible environmental impacts of chemicals used for ripening and flower control 346
10.6.1 Effects of some ripening chemicals on soil organisms 346
10.6.2 Chemical release into the environment 347
10.7 Potential impacts of growth regulators on economics and possible collateral damage 348
10.7.1 Economic impacts 348
10.7.2 Potential social health impacts 348
10.8 Mitigating factors impacting on the effective use of ripeners and ethephon to control flowering 349
10.9 Conclusion 350
10.10 References 352

11 **Harvesting and haulage** 355
11.1 Harvesting 355
11.1.1 Pre-harvest 355
11.1.2 Manual system 355
11.1.3 Mechanical whole stick 358
11.1.4 Chopper harvesters 359
11.1.5 Factors affecting harvesting and loading 360
11.1.6 Summary of social, financial and environmental risks and benefits of each practice 362
11.2 Haulage 363
11.2.1 Haulage systems 363
11.2.2 Transloading 366
11.2.3 Factors affecting haulage systems 367
11.2.4 Summary of social, financial and environmental risks and benefits of each practice 370
11.3 References 372

12 **Agrochemicals and farm safety** 375
12.1 Agrochemicals 375
12.1.1 Background 375
12.1.2 Pesticide regulation 376
12.1.3 Agrochemicals used in sugarcane production 380
12.1.4 Environmental and safety concerns with sugarcane pesticides 380
12.1.5 Minimizing negative impacts 381
12.1.6 Standards and certification 386
12.2 Farm safety 386
12.2.1 Background 386
12.2.2 Safety management systems (also see Part 3, Chapter 3.) 387
12.3 References 392

13 **Biomass management: ethanol and electricity generation** 395
13.1 Co-products: ethanol and biomass for electricity production 395
13.1.1 Introduction 395
13.1.2 Ethanol 396
13.1.3 Power generation 400
13.1.4 Cellulose technology 400
13.2 Variety breeding for ethanol and biomass 401
13.2.1 Recent directions in plant breeding 401
13.2.2 Future strategies in plant breeding 402
13.3 Towards good pre-harvest field management practices 403

13.3.1 Ethanol 403
13.3.2 Biomass for cogeneration through green cane harvesting 404
13.3.3 Benefits and problems arising from converting from burnt to green cane harvesting 405
13.3.4 Quantities of trash 406
13.3.5 Quality of cane residues 407
13.4 Harvesting techniques to maximize biomass deliveries to the factory 408
13.4.1 Trash collection from chopper harvested cane 408
13.4.2 Costs of switching from burnt to green harvested cane 410
13.5 Vinasse: composition, utilization and effects on soils 411
13.5.1 Composition of vinasse 411
13.5.2 Direct application in irrigation water or by tanker trucks 411
13.5.3 Effect of vinasse on cane yield and quality 412
13.5.4 Effect of vinasse application on soils 413
13.5.5 Use of vinasse in land reclamation 414
13.5.6 Vinasse evaporation 414
13.5.7 Other mechanisms for disposal of vinasse 416
13.6 Social and environmental risks of ethanol and biomass production 416
13.6.1 Ethanol 416
13.6.2 Biomass production 418
13.7 Conclusions and the way forward 419
13.8 References 419

14 **Decision support systems for sugarcane production managers** 421
14.1 Introduction 421
14.2 Decision support systems 422
14.3 Crop models 423
14.4 Crop production 423
14.4.1 CanePro SQR 424
14.4.2 Cultivars 425
14.4.3 Nutrition 425
14.4.4 Herbicides 425
14.4.5 Pesticide 426
14.4.6 Irrigation 426
14.5 Harvesting 426
14.5.1 Harvesting schedule 427
14.5.2 Trashing DSP 427
14.6 Loading and transport 428
14.6.1 Vehicle scheduling 428
14.6.2 Vehicle selection 429
14.6.3 Zone placement 429
14.6.4 Shortcuts 429
14.6.5 Compaction 430
14.7 Supply chain 430
14.8 Bio-energy 430
14.9 Miscellaneous 431
14.9.1 Carbon footprint 431
14.9.2 GIS applications 431
14.10 Conclusions 431
14.11 References 432

Part 2: SUGARCANE PROCESSING MANAGEMENT 435

1 **Cane processing, production of sugar, ethanol and power** 437
1.1 Cane quality 437
1.1.1 Effect of cane quality on recoverable sugar and capacity 437
1.1.2 Management of cane supply 440
1.1.3 Cane delays 440
1.1.4 Effect of cane delays on recovery 441
1.1.5 Cane receipt and payment 442
1.1.6 Distribution of proceeds between millers and growers 443
1.2 Cleaning of cane 444
1.2.1 Cane washing 444
1.2.2 Management of water circuit 445
1.2.3 Dry cleaning 445
1.2.4 Removal of tops and leaves 446
1.2.5 Removal of rocks and soil 446
1.3 Water use and recycling 447
1.3.1 Factory water balance 447
1.3.2 Condensate and process water usage 449
1.3.3 Factory cooling water systems 450
1.3.4 Boiler ash scrubber systems 450
1.3.5 Segregation of streams 450
1.4 Technology choices 451
1.4.1 Extraction 451
1.4.2 Clarification 452
1.4.3 Evaporation 452
1.4.4 Syrup clarification 452
1.4.5 Pan boiling 452
1.4.6 Centrifugals 452
1.4.7 Sugar drying 453
1.4.8 Fermentation 453
1.4.9 Distillation 453

1.4.10 Energy efficiency 453
1.5 Energy and chemical use in refining 454
1.5.1 Refined sugar – autonomous refineries 454
1.5.2 Refined sugar – back-end refineries 455
1.5.3 Plantation white sugar 455
1.6 Process loss control and monitoring 456
1.6.1 Measurement of recovery efficiency 456
1.6.2 Physical losses 456
1.6.3 Chemical losses 457
1.6.4 Microbiological losses 457
1.7 Environmental management systems 457
1.7.1 Procedures and monitoring systems 457
1.7.2 Factory policies 458
1.7.3 Internal audits 458
1.7.4 External audits and reporting 458
1.7.5 Bunding of storage areas 458
1.8 Management of energy 459
1.8.1 Energy generation from bagasse 459
1.8.2 Bagasse balance and management of surplus/deficit 460
1.8.3 Bagasse drying 461
1.8.4 Efficient management of boilers 462
1.8.5 Supplementary fuels 462
1.8.6 Factory steam and energy balance 463
1.8.7 Batch vs. continuous processing 464
1.8.8 Generation of power for export 465
1.8.9 Utilization of waste heat 467
1.8.10 Potential for biogas generation and use 467
1.8.11 Energy-saving lighting, ventilation and other opportunities 468
1.9 Sustainability and management of carbon emissions 468
1.9.1 Sustainability 468
1.9.2 Estimation/measurement of carbon footprint 469
1.9.3 Finance opportunities for emission reductions 470
1.9.4 Use of sustainability metrics 471
1.10 Safety training and safety management 472
1.10.1 Policy and management 472
1.10.2 Hazards in the workplace 472
1.10.3 Risk assessment and mitigation 472
1.10.4 Training 473
1.10.5 Safety equipment 473
1.10.6 Measurement of lost time due to safety incidents 474
1.11 References 475

2 **Management of wastes and effluents** 477
2.1 Identification/characterization and disposal of solid wastes 477
2.1.1 Roadside cane spillage 477
2.1.2 Cane washing mud 477
2.1.3 Filter cake from juice clarification 477
2.1.4 Press muds from refinery processes 479
2.1.5 Boiler ash (and fly ash) 480
2.1.6 Sludge from effluent treatment plants 481
2.1.7 Laboratory filter papers with lead acetate precipitates 481
2.2 Management of waste water and other liquid effluents 482
2.2.1 Sources of liquid effluents 482
2.2.2 Legal requirements and reporting 484
2.2.3 Treatment technologies 486
2.3 Management of dust/particulate emissions 493
2.3.1 Boiler emissions regulations 493
2.3.2 Removal of particulates from boiler flue gas 494
2.3.3 Gaseous emissions 496
2.3.4 Management of dust from bagasse systems 497
2.3.5 Dust in the workplace 498
2.4 References 498

3 **Co-product production** 500
3.1 Management of molasses storage and handling 500
3.1.1 Losses in storage 500
3.1.2 Maillard reactions in molasses 500
3.2 Large scale storage of bagasse 501
3.2.1 Dry bulk storage of bagasse 501
3.2.2 Storage for paper manufacture 503
3.2.3 Export of bagasse 503
3.3 Management of vinasse from a distillery 504
3.3.1 Direct use of vinasse for irrigation 504
3.3.2 Evaporation to Condensed Molasses Solubles (CMS) 505
3.3.3 Spray drying 505
3.3.4 Incineration in boilers 505
3.3.5 Use in composting 505
3.3.6 Anaerobic digestion to produce biogas 505
3.3.7 Life cycle assessment of various options for vinasse usage 508
3.4 Marketability of treated residues 508
3.4.1 Compost 508

3.4.2 Filter cake 509
3.4.3 Boiler fly ash 509
3.4.4 CMS and spray dried vinasse 509
3.4.5 Bagasse pellets 510
3.4.6 Yeast 510
3.5 References 510

Part 3: SOCIAL, LABOR AND OUTGROWERS 513

1 **Introduction** 515
2 **Regulatory frameworks** 517
2.1 Legal and industry regulation 517
2.2 Market driven regulation 519
2.2.1 Bonsucro 520
2.2.2 Fair Trade International 522
2.2.3 Organically certified sugar 523
2.2.4 Partner organizations 526

3 **Human resource management** 527
3.1 Compliance 527
3.1.1 International labor conventions 528
3.1.2 Healthy working environment 531
3.1.3 Human resource development 534
3.1.4 Gender equality 534

4 **Social welfare and community initiatives** 537
4.1 Welfare service provision 538
4.1.1 Housing 538
4.1.2 Community industry engagement and environmental management 539
4.1.3 Education 539
4.1.4 Health care 541
4.2 Land and resource management 545
4.2.1 Land ownership 545
4.2.2 Displacement and compensation 546
4.2.3 Cultural practice and cultural asset management 546

5 **Outgrowers** 549
5.1 Outgrowers and the changing dynamics of the industry 549
5.2 Important factors in outgrower development 550
5.2.1 Social and technical preparation 550
5.2.2 Demand driven approach 551
5.2.3 Land 552
5.2.4 Climatic conditions – irrigation 552
5.2.5 Capacity 554
5.2.6 Ownership 554
5.2.7 Culture and tradition 554
5.3 Outgrower models 554
5.3.1 The individual outgrower model 555
5.3.2 The block farm model 556
5.3.3 The trust and management company model 558
5.3.4 The association led model 559
5.3.5 The community trust farm model 559
5.3.6 The joint venture model 561
5.3.7 The partnership model 562
5.4 Building capacity 563
5.4.1 Training 563
5.4.2 Methods and models for training outgrowers 565
5.5 Extension services 567
5.5.1 Extension service providers 567
5.5.2 Payment mechanisms for extension 575
5.5.3 Monitoring and evaluation of extension 577
5.6 Supporting services 577
5.6.1 Management Information Systems (MIS) 577
5.6.2 Aerial imagery and mapping 578
5.6.3 Contracted services 579
5.6.4 Seedcane supply 579
5.6.5 Input supply 580
5.7 Contractual arrangements 580
5.7.1 Cane supply agreement 580
5.8 Summary of good management practice recommendations 581
5.9 Conclusion 582
5.10 References 582

Appendix 1
Soil form identification key used in the South African sugar industry 587
Appendix 2
Guide to taking soil and leaf samples 588
Appendix 3
Examples of selected soil specific crop management recommendations 592
Appendix 4
Land forming for sugarcane 594
Appendix 5
Relevant chapter cross reference Index to IFC and Bonsucro Standards 597
Index 599