

Kimberly-Clark Experimental Mill Annual Report for 2006

X-Mill Background

Kimberly-Clark Experimental Mill applied for the Green Tier program on February 3, 2006. We were formally accepted into the program as a Tier I participant on September 6, 2006.

Kimberly-Clark Experimental Mill is located in Neenah, WI and currently employs 30 people. The facility's primary function is to develop and deliver a continuous stream of innovative product and process solutions for the Family Care business sector.

Green Tier Superior Environmental Performance:

Implementation of an EMS consistent with ISO 14001:

- The written program is complete. The Experimental Mill will receive an internal audit in April of 2007 to measure compliance regulatory requirements that are consistent with ISO 14001.

Continued reduction of water and energy consumption:

- Electricity: 2007 Initiatives – Replace 121 400 watt metal halide fixtures with high efficiency fluorescent fixtures. Twenty-one have been replaced. The yearly reduction in KW's is expected to be 11,138. With approximately 100 more fixtures being replaced, it is estimated that an additional 532 KW's per fixture per year will be saved. Other energy reduction efforts prior to Green Tier have reduced electrical usage by 2,096,285 kWhr's or 31% since 2003. This converts to a CO₂ reduction of 3,279 tons.
- Water: 2007 Initiatives – A water filter and pump with drive motor will be modified to allow recycling the water on the manufacturing vacuum pumps. The projected savings once the modifications have been completed is approximately 4.2 million gallons of water per year. Other water reduction efforts prior to Green Tier have reduced water usage by 381,915 hundreds of gallons or 43% since 2003.
- Natural Gas: Due to process changes and other efforts prior to Green Tier, natural gas consumption has been reduced by 3,491.4 dekatherms or 56% since 2003. This converts to a CO₂ reduction of 126 tons.

Continued waste minimization efforts:

- An outlet for office waste was established so that 100% of the office waste is now recycled. Our recycling program was rejuvenated in 2006. Our previous office waste recycling facility became inoperable. We now use the same vendor for our office waste as we do for our broke.
- Another KC facility has an outlet for empty five gallon plastic pails. In 2006 we started shipping our five gallon pails to the other facility for recycling. This amounts to approximately 200 empty units per year being recycled instead of going to a landfill.
- Through our chemical approval process, chemical inventory has been reduced by 59% since 2004. The chemical management process allows us to control chemical waste volume.

Commitment to X-Mill Environmental Policy Statement:

- The X-Mill continues to promote and support our Environmental, Health and Safety programs which work to eliminate loss to People, Equipment, Material, and Environment. Facility Management supports and is directly involved with loss control programs.

Commitment to advancing groundwater remediation:

- 2007 Initiative – Develop long term plan to bring the former Badger-Globe site remediation to closure that will satisfy WDNR, and Kimberly-Clark's Environment & Energy and Family Care Product & Technology Development requirements. Proposals have been received by three different companies and are being reviewed.

Commitment to training employees on their roles to assist in maintaining a facility that is environmentally compliant:

- Annual HazComm refresher training is required of all employees and researchers/customers.
- Annual Storm Water Pollution Prevention refresher training is required for all employees.
- Annual Spill Prevention Control and Countermeasure refresher training is required for all employees.
- 2007 Initiative – Implement web-based training program for environmental aspects within the facility.

Management Review of EMS

EMS program elements are reviewed on a weekly basis with facility management and the Environmental, Health and Safety Management System (EHS MS). An EHS MS audit is being conducted in April 2007. The audit will encompass our EMS.

Economic and other benefits of participating in Green Tier

Participation in Green Tier has accelerated the environmental cost reduction and loss control initiatives at our facility.

The WDNR's Green Tier program and the X-Mill's participation will be in the Kimberly-Clark's 2007 Environmental Sustainability Report.