

Annual Green Tier Report

**Times Printing Co.
100 Industrial Drive
Random Lake, WI 53075**

Tier 1 Annual Report

Introduction/Executive Summary

Implementing Green Tier and an Environmental Management System (EMS) into Times Printing Co. has been a very challenging and rewarding experience. The process has been an eye opener into how the many parts of the manufacturing process come into the plant, and go out of the plant.

We are still working through finalizing our EMS, but we have made a lot of progress through the system that we have in place so far. We have made small changes in reducing our volatile organic compounds (VOC) through an increased use of soy inks, and small reductions in levels of voc in our fountain solutions. We are currently on track for a goal of a minimum 15% reduction in voc in our blanket wash by the end of 2007.

In the area of waste minimization, we are in a successful program recycling our absorbent socks and pads. We have finalized an ink recycling program, not one we were hoping to achieve, but it is a step in the right direction. In the area of general refuse recycling, we are in the process of revamping our recycling program to make it more efficient and easier to be able to recycle within the plant. We are also working on a solvent recycling program where we would be able to recycle 90% of our used blanket wash in house and reuse it.

We have reduced some solvent usage, with the elimination of one particular solvent that we used sporadically throughout the plant, and replaced it with a biodegradable citrus product.

There have been some changes in the area of energy consumption. Over the last year and a half, we have tracked our reduction in energy consumption after installing all new high efficiency lighting fixtures throughout the plant. The company has also partnered with WE energies by installing two backup diesel generators that would allow WE energies to interrupt service during high peak energy demands.

Environmental Performance

1. VOC and Air Toxic Emissions Reductions

- a. We have begun to push the use of Soy inks in our sales department and have made some very good progress in acquiring jobs that want to use Soy based inks. With the use of soy inks in a number of jobs, we were able to reduce the volatile organic compound output by 49.8lb of voc.
- b. The pressroom department is working on reducing the VOC in wash. We have tested out a few low voc blanket washes, and the goal is to reduce the total VOC from blanket wash by 15%. However, it may be more if a low VOC wash from Rycoline works. If this is the case, we will see a drastic reduction from the wash because currently we use a wash with 6.7lbs/gal and the low voc wash from Rycoline has 2.18lbs/gal.
- c. The pressroom has also made small reductions in the levels of VOC's in our fountain solution. This has not yet been measured.

2. Waste Minimization

- a. Absorbent socks and pads – We partnered up with CRI recycling out of Wisconsin to recycle all of our absorbent socks and pads. We went from disposing of 38 drums of socks and pads each year to be burned, to completely recycling the socks of which those are returned to us and reused. The pads go through a process where the oil is extracted and the left over polypropylene is reused in other manufacturing sectors.
- b. Ink Recycling – We worked with a number of companies in the last two years regarding recycling our ink to reuse. We worked with Spectrum, and for a number of months they took our inks and had them processed back into pms colors. For a number of reasons, that did not work out the way we wanted it to. I then partnered with a company who takes inks and uses it for energy recovery. Since then, we have recycled 6325 gallons of ink or 52,750lbs.
- c. Recycling Stations – We currently recycle all types of items including glass, plastic strapping, and scrap paper. The paper gets bailed and sent off to Fort Howard where the paper is introduced into the process of becoming recycled paper. Last year, we recycled 20,440lbs of plastic which included plastic strapping used on the plant floor. We are also working on revamping our recycling stations on the plant floor to allow for ease of recycling by employees and cleaner area's.
- d. Solvent recycling – We are currently working on the purchase of a solvent recycling unit that would allow us to recycle in house and re-use up to 90% of our wash from the presses. We currently use roughly 16gallons per week of blanket wash, and this machine would allow us to recycle and reuse 14.4 gallons of this. This will drastically reduce the amount of spent blanket wash we send out for disposal right now.

3. Waste Oil
 - a. In the last two years we have recycled approximately 585 gallons of oil. This oil has been refined to lube stock or burned for energy recovery. This oil has come from our absorbents, press oil, and vehicle oil.
4. Minimizing solvent usage
 - a. We have slowly reduced and almost eliminated the use of film kleen solvent throughout the finishing department and replaced it with De-Solve-it Contractors solvent. The elimination of film kleen has seen an elimination of Isopropanol and Hexane and that has been replaced with a biodegradable citrus product in the Orange Sol product. This was a reduction of 60 gallons of film kleen each year.
5. Reduction of energy consumption
 - a. Lighting project – over the last year and a half, we have tracked our reduction in energy consumption after installing all new high efficiency lighting fixtures throughout the plant. What we saw was a reduction in kW hours of 606,887kw/year. This reduction helped reduce co2, so2, and no2 emissions. This came out to a reduction of 910,331lbs/year form CO2; 1,517,219lbs/year for SO2; and 3,519,947lbs/year for NO2.
 - b. The company also partnered with WE Energies and installed backup generators that would allow WE Energies to interrupt service to our plant and ease the load put on their energy demands during peak power times such as in the summer. I do not have any hard numbers on this because we have not yet had to use them.

EMS Audit

We have not yet audited our EMS at this time. The goal of this happening is May 1st. I will resubmit this report when this audit is complete.

Economic and other benefits of participating in Green Tier

Participating in the Green Tier program has really brought the concept of environmentally responsible companies into our inner workings, not just on a couple levels. Everyone is aware of its benefits to the company, and the benefits our surrounding neighbors and community.

One of the immediate benefits as an environmental professional was that when we needed to put together information for reports, specifically, a phase 1 environmental report, it was so easy to put together the paperwork needed because all of the aspects and impacts from all the departments were in a nice flow chart package, and it really made the auditor's job easy in establishing that the company was taking care of all of it's resources from "cradle to grave".

Another benefit internally was the use of the Green Tier concept in our marketing process. I see so many more jobs coming in from sales professionals requesting environmentally friendly inks and papers. Our sales professionals tell me that customers look at this type of progress in vendors more and more. I have worked with the sales force more in the last 6 months than in the entire 7 years I have worked at Times Printing.

When we look at how Times Printing participation in Green Tier has helped us externally. I think the main thing is that it has given us an ability to label our accomplishments and show the community that we do care.