Flambeau River Papers Environmental Report

Green Tier, Green Masters, and ISO 14001 certified Flambeau River Papers continues to be guided by environmental and energy policies that ensure continuous improvement and that resources are used wisely. The mill’s dedication to making sound environmental and energy decisions continues to be a priority. A summary of the mill’s ISO 14001 status and the water, air, and solid waste issues the mill is dealing with follows.

**Water**
A total suspended solids exceedance occurred on April 22, 2013, at the mill’s wastewater treatment plant. One of the causes of the exceedance was higher than normal flows. While it was unfortunate that we had that 1 exceedance and thus just missed our 100% compliance target for 2013, that experience led us to develop and institute an improved status of the wastewater treatment plant communication system.

Ironically just as the improved communication was being rolled out, flows to the wastewater treatment plant were noticeably increasing. Just after Labor Day a leak of approximately 1,000 gallons per minute of river water was found to be entering the mill on the western edge of the power canal. Flows greatly subsided in November after repairs were made.

**Air**
Work continues on determining how to comply with the Boiler MACT air rule which was printed in the Federal Registrar on January 31, 2013. In addition to performing the required 2013 stack test of the mill’s main boiler, the stack test was also used to gather extra data to determine if there were alternative types of pollution control that could be considered versus the expensive electrostatic precipitator option. Data gathered looks favorable towards other technologies which steps will be taken forward with in 2014. As for the other boilers, the EPA provided guidance on how to determine how the wood oil fuel that is received from a fellow Wisconsin company can continue to fit in the mill’s future under Boiler MACT. This led the mill to submit a permit application to be able to add the wood oil to a boiler with pollution control equipment capable of meeting the new Boiler MACT limits. The DNR is working on the permit. Fugitive dust also remains a concern. Sources are shut down when possible during extreme weather conditions.

**Solid Waste**
The road ban season was long last year, but the mill was still able to land apply the vast majority of the sludge with farmers receiving the nitrogen, phosphorus, calcium, sulfate, and magnesium benefits. Many area townships were able to benefit from the mill’s spent cooking liquor which was used as road binder on their roads when excess was available due to a railcar shortage and a slowdown at the plant that takes the sugars out. Baskets, ornaments, and placemats are a few examples of items that continue to be made from the turn up tape. Anyone that is interested in receiving some of the material can stop into the mill’s security entrance and ask for a sample.
While the mill had a previous relationship with 5R Processors, the mill decided to do more by working with their Asset Recovery Team (ART). A few shipments of equipment were sent out in 2013 with more shipments planned for 2014. The mill wants to take advantage of “5R’s strategic use of recycling, redeployment, and reselling surplus equipment.” The mill agrees with 5R’s philosophy that “equipment can often be used elsewhere.”

ISO 14001
As always, Flambeau River Papers targets 100% compliance as part of ISO 14001. Progress was made on the following main focuses for 2013:

- Boiler MACT Air Rule
- Evaluation of Compliance Element of the Standard
- Follow up on the temperature exceedance which had occurred within the last few days of 2012

While the auditor was impressed with work completed in 2013, the mill did receive 5 non-conformances during the 4-day full ISO 14001 recertification audit in November. The auditor had several examples where more work, especially in regards to calibration, was needed. All response plans have been accepted by the registrar. The following will be the main focuses for 2014:

- Continued Work on the Boiler MACT Air Rule and Other Rules
- Improvement to Calibration Policies
- Communications Policies

Flambeau River Papers managed the challenges of 2013. The mill’s commitment to being a responsible environmental and energy steward hasn’t changed. If you have questions or concerns about our environmental performance please contact us during office hours at (715)762-5375 or by calling our 24-hour community concerns hotline at (715)762-5239. Please visit flambeauriverpapers.com to see the mill’s environmental policy and for more information about the mill.