



**WS Packaging Group, Inc. – Algoma, WI
1102 Jefferson St.
Algoma, WI 54201**

2015 Green Tier Annual Report

WS Packaging Group, Inc. - Algoma applied for the Green Tier program on October 3, 2011 and was formally accepted into the program as a Tier 1 participant on March 23, 2012.

WS Packaging Group, Inc. – Algoma is located at 1102 Jefferson St. in Algoma, WI and currently employs approximately 450 people. WS Packaging Group, Inc. is an industry leader in printing and flexible packaging and manufactures such products as pressure sensitive labels, coupons, tags, and decals. The company has four facilities located in Wisconsin of which two are located in Algoma, one in Neenah, and one in Oak Creek. Our sustainability goal is to not only provide products that are environmentally sound throughout their lifecycles but also continually strive to become a better steward in protecting our environment while conserving energy and natural resources.

ENVIRONMENTAL IMPACT & WASTE REDUCTION PROGRAM

LANDFILL REDUCTION

As part of the corporation's strategic sustainability plan, our facilities have focused on an effort to reduce the amount of waste sent to the local landfill. In working toward this goal, our Algoma facility has partnered with a local materials lifecycle management company since 2010. This company has developed a process for converting production leftovers into enviro-fuel cubes or pellets that are a clean biomass alternative energy fuel product. Thereby, the waste from one process becomes the resources for another. The cubes contain zero mercury, have low sulfur content, and are greenhouse-gas-friendly. The combustible materials are converted into the enviro-fuel cubes by blending it with other incoming waste streams, feeding it through a size reduction (cutting and shearing) process, and then extruding it through cubing mills.

The Enviro-Fuel Cubes:

- Produce between 7,000 and 12,000 BTU/lb.
- Can be used in most combustion applications that have ash handling applications
- Typically cost less than wood, coal, oil, or gas

Previously, all of our waste had gone to the local landfill. This included pressure sensitive waste matrix and trim from our production process. Now, each month we send about 80-90% of our waste to be made into Fuel Pellets.

Note:

WS Packaging Group, Inc. along with other manufacturing facilities was notified in December of 2014 that in early 2015, Greenwood was “temporarily” stopping taking any more “matrix” material until further notice. Greenwood has stated that they will notify us when they start accepting material once again.

That decision was based on their business needs. However, this will cause a dramatic rise in our waste now having to go to the landfill for disposal.

This resulted in a <95%> decrease in the amount of material that we have been recycling for 2015 into fuel pellets.

GREEN CERTIFICATION

WS Packaging Group has earned the Label Initiative for the Environment (L.I.F.E.) certification at its Jefferson Street plant in Algoma, Wis., from the Tag and Label Manufacturers Institute (TLMI). The L.I.F.E. program is an audited sustainability certification process tailored specifically to the narrow-web printing and converting industry and is comparable to ISO 14001 certification requirements. The L.I.F.E. certification establishes operation metrics and process improvements that enable printing companies to determine cost-effective ways to reduce their environmental impact and share this commitment with their customers. Having this third-party L.I.F.E. certification confirms to our customers that we uphold the highest sustainability standards in the industry and can provide documentation to meet their chain-of-custody requirements. The Algoma facility was the first WS Packaging location to achieve the L.I.F.E. certification, through extensive documentation and a two-day audit. WSPG has since had 3 other facilities obtain the L.I.F.E. certification. WS Packaging – Algoma in January, 2013 has been audited and recertified for the L.I.F.E. Certification.

Algoma was recertified into TLMI in June of 2014.

Algoma was recertified into TLMI in June of 2015 with a 5yr audit conducted by NSF.

<http://www.wspackaging.com/environment>

Listed below are other sustainability efforts that have been implemented or improved upon in 2015.

ELIMINATING MATERIAL WASTE

WebFlex™ Online Service:

We offer artwork uploads and transfer, product inventory management, reporting, and shipment tracking through our patented WebFlex™ online service, available to our customers 24/7. Our WebFlex system, in conjunction with our corporate-wide computer system, has further increased our efforts towards a paperless workflow process with electronic quoting, order placement, order acknowledgement, and invoicing.

Lean Manufacturing:

Our purchasing procedures now require all raw material suppliers with direct material shipments to eliminate the material roll plastic wrap, which equates to just over one pound of plastic per pallet. Instead, the material rolls are secured to the pallet with a double-band material strap and edge guide system. Currently this plastic wrap savings involves over thirty percent of our material purchases.

Our facility has made a huge capital investments in butt-splicers to reduce labor and paper waste by “joining” roll ends to complete the maximum label quantity per roll. This has resulted in a reduction of up to 1.48 million feet of paper waste per press per year.

Through our many Kaizen efforts, Algoma is continually improving their “LGFG” (Last Good to First Good) setup times on press. By continually striving to lower this standard, we shorten setup time and reduce wasted material in the process. Average LGFG time is approximately 72 minutes over all. We started at approximately 150 minutes overall. That is a 52% reduction in press setup time and continuing.

Our LGFG goal for 2016 is to average 69 minutes.

We have installed 2 new Mark Andy P7 presses in 2015. This type of press is much more energy efficient and with less setup time.

INNOVATION FOR OUR CUSTOMERS

MultiVision® Label Line:

WS Packaging Group supports the efforts of brand owners to improve their long-term push toward sustainability by offering cost-effective packaging solutions. For our customers, we offer our own patented MultiVision® product line of extended text labels, providing additional label space through multi-layer extended text constructions. A significant advantage of the MultiVision label is its ability to eliminate the use of cartons, folded instruction sheets, and their associated costs, by having all the required consumer information right on the bottle or tube.

Linerless:

In 2012, WS Packaging’s R& D department has developed a line of labels that are linerless, thus eliminating the liner waste disposal and expense for our customers. For the past two years, WS Packaging has been working jointly with organizations in North America and Europe to further develop linerless labels and the application technology. For decades, the pressure sensitive industry required silicon-coated backing paper to run and dispense labels to consumer products. Linerless technology eliminates the need for a silicon backing paper and relies on unique and specially designed application technology to bridge the gap. Without the silicon backing paper, WS Packaging is able to eliminate a waste steam, reduce waste transportation costs, and increase a client’s equipment production time without sacrificing the package integrity.

Shipping:

As part of our packaging reduction program, we offer our customers a reusable corrugated box system, whereby customers send us their boxes that will be used for their final product shipment to retail, and we use those same boxes to send their labels to their plants. For one of our customers that ship products to a very large retailer, this reusable box program saved them over seven tons of corrugated in one year. We also developed a reusable pallet system or product-stacking configuration, whereby corrugated boxes are eliminated entirely and product is placed directly on the shipping pallet with corner reinforcement, core plugs, and limited shrink-film for protection.

Materials:

One of the key strategies in a “green” process is package design, since it is the point where we can prevent waste, optimize our use of resources, select safer materials, and plan for the recyclability or recoverability of our packaging. We can source and print on certified recycled

materials or alternative materials from renewable resources. Exciting new developments are taking place all the time in this area, enabling us to recommend alternatives as our suppliers develop and bring them to the marketplace. We can also provide the documentation on sustainable raw materials to meet our customers' "chain of custody" requirements, ensuring our material suppliers are certified through the Sustainable Forestry Initiative (SFI) and Forest Stewardship Council (FSC) for responsible forest management.

25.51 Tons of SFI Certified copy/print paper was purchased for our offices in 2015.

EMPLOYEE EDUCATION AND AWARENESS

Facility Teams and Audits:

Although WS Packaging has a corporate sustainable committee dedicated to analyzing its current "green" position and environment-related activities, each facility is required to have its own committee members to manage all local activity. Each facility maintains a matrix of measurement criteria such as clean production techniques, energy use, recycling, and management practices, and then shares "best practices" across the company as part of our continual improvement and standardization. We are using this data and related projects to record and measure facility activities and progress.

Energy Reduction:

Our energy conservation program has included such facility improvements as adding dimmer switches and motion sensors for lighting in offices and production areas, facility electrical upgrades, purchasing new, more efficient equipment, making building/equipment improvements in heating and cooling, fixing compressor lines to eliminate air leaks, and scheduling more frequent equipment cleaning, while focusing on preventative maintenance.

WS Packaging Group is committed to sustainability investments by designing, manufacturing, and delivering products, using the most efficient materials and methods, ensuring everyone's health and safety, while minimizing our consequential energy use and the environmental impact from all of our business efforts. We have converted some aisle way lights (in production) to LED.

2015 Projects

1. Increase in amount of VOC's emitted. Increased in 2015 by 9.2% due to increase in film business using more solvent based inks.
2. Decreased Nitrogen usage by 70.4%. This decrease was due to an additional installation of a new Nitrogen Tank that was initially filled with 68,287lbs of Nitrogen in Nov-2014. The initial fill was completed in 2014 and usage for 2015 recorded.
2014 - 312,364 lbs.
2015 – 92,462 lbs.
<219,900>lbs. reduction of 70.4%
3. Continue program of recycling flexo plates.

- a. 2013-Averaging between 800 and 1000 lbs. per month that are recycled.
 - b. Previously these plates went into the landfill
4. Decreased the amount of waste recycled into fuel pellets by <95%> over 2014. All of the matrix bales are now sent to the landfill.
5. Perfected Linerless style of label and have customers purchasing them.
 - a. Received the Business Friend of the Environment Award for Environmental Innovation.
 - b. Received the APICs Fox Valley Chapter Sustainability Company of the Year in 2012 for this effort.
 - c. 2015 – Approximately 1.1% of our label sales were attributed to liner-less product. Stayed approximately the same from 2014.
6. Only 9% of our total waste was recycled in 2015. The worst was because Greenwood fuels stopped taking waste matrix. This resulted in a decrease of <95%> in recycled waste into fuel pellets.
7. 2015 - Installed 2 - P7-Mark Andy Presses utilizing UV LED Inks and UV LED Lighting. Much more energy efficient.

2016 Planned Initiatives

1. Pursue ICS proposal for cutting energy usage by 6% - 12% per year.
2. Reschedule Air Leak detection study throughout the facility and correct all air leaks that are found. Scheduled for 2016.
3. Two roof-top Air Conditioning unit replaced in 2015. Replace equipment with energy efficient as needed.
4. Continue to identify vendors to recycle shrink film and unsupported film. PVC material is very hard to recycle.
5. Continue to identify vendors to recycle/reuse sludge from Waste Water Treatment and plastic 1 gallon jugs and plastic 5 gallon pails.

6. As technology increases and pricing decreases, we will further investigate the option of converting over UV-Fluorescent lighting to UV-LED lighting on our older presses. It may become a “cost effective” option in the future.
7. Installation of another P7-3 press from Mark Andy with LED UV light capabilities.
8. Installation of two new MSP 26” press that utilize UV LED Inks and UV LED Lights. Much more energy efficient. This press replaces an older MA-4300 13” press. The old press was deactivated.

**WISCONSIN DNR GREEN TIER
SUSTAINABILITY METRICS**

Period Covered: FY-2014

Company Name:	WS Packaging Group, Inc.		
Facility Name:	Algoma / Jefferson Street		
Address:	1102 Jefferson Street		
City, State, Zip:	Algoma, WI 54201		
Environmental Coordinator:	AJ Bonnell (EH&S Manager)		
Coordinator Phone:	Work: (920) 866-6307	CELL: (920) 321-4001	
Coordinator E-Mail:	abonnell@wspackaging.com		

Metric	Not Collected/ Not Available	Quantity	Units	Period - if not Calendar Year
DEMOGRAPHICS				
Sales		\$88,519,840.82	\$	Jul 13/ Jun 14
Money saved because of material or process improvements		\$500,000.00	\$	Jul 13/ Jun 14
Profit or Loss		2.0%	%	Jul 13/ Jun 14
Employees	Approx.	400	Each	Jul 13/ Jun 14
Multiple between highest paid and lowest paid employee			%	
Alternative Transportation Support		N/A	\$ or ?	
Total Purchases	Direct Materials	\$ 40,586,080.00	\$	Jul 13/ Jun 14
In-State Purchases	31%	\$12,581,684.00	\$	Jul 13/ Jun 14
% of Purchases Made from Companies that participate in Green Tier or Green Masters:			%	
LAND				
Total Land		5	Acres	Jul 13/ Jun 14
Paved/Covered Land		2	Acres or sq ft	Jul 13/ Jun 14
ENERGY				
Electricity	Calendar Yr	9,995,450	kWh	Jan 14/ Dec 14
		4.4%	% Decrease	Jan 14/ Dec 14
Natural Gas	Calendar Yr	9,425,700,000	BTU	Jan 14/ Dec 14
		19%	% increase	Jan 14/ Dec 14
Renewable Energy (generated on-site)		0%	% of total use	
Renewable Energy (as a % of utility electricity mix)		0%	%	
WATER				
Total Water Used	Calendar Yr 4- Meters	2,233,700	gallons/year	Jan 14/ Dec 14
		29.9%	% increase	Jan 14/ Dec 14
Source - private well		0%	% of total use	
Source - public system		100%	% of total use	Jan 14/ Dec 14
Water Recycled/ Reused	Pre-treated before discharge Avg 9,500g per week	494,000	gallons/year	Jan 14/ Dec 14
		0%	% reduction	Jan 14/ Dec 14
Regulated Pollutants Discharged (BOD, TSS, Metals)		N/A	lbs/ year	
		N/A	% reduction	
AIR				
Total Air Emissions	Air Emissions Inventory Summary Report	11.13	Tons/ year	Jan 14/ Dec 14
		13.10%	% reduction	Jan 14/ Dec 14
Ozone-Depleting Substances	Air Emissions Inventory Summary Report	63	lbs/ year	Jan 14/ Dec 14
		28.4%	% reduction	Jan 14/ Dec 14
Greenhouse Gas Emissions		N/A	lbs/ year	
		N/A	% reduction	
WASTE				
Hazardous Waste Disposal	Refiled as a LQG for 2012,2013 & 2014	49,081	lbs/ year	Jan 14/ Dec 14
		50.2%	% Increase	Jan 14/ Dec 14
Universal Waste Disposal		N/A	lbs/ year	
		N/A	% reduction	
Non-Hazardous Waste Disposal		481.2	lbs/ year	Jan 14/ Dec 14
		N/A	% reduction	
Material Recycled/ Reused		3133.8	Tons/ year	Jan 14/ Dec 14
		-17.2%	% Decrease from 2013	Jan 14/ Dec 14
Recycled/ Reused Content		1.60%	% of product	Jan 14/ Dec 14
TRANSPORTATION				
Hybrid Vehicles		N/A	Each	
Gasoline Used	@2.50g Avg	13,136	Gallons	Jul 13/ Jun 14
Diesel Used - vehicles		N/A	Gallons	
Diesel Used - Generators		N/A	Gallons	
Alternative Fueled vehicles (CNG, LNG, Fuel Cell, Electric)		N/A	#	

ADDITIONAL METRICS				
Please list all other designations/certifications (for example: LEED, Green Globes, Green Masters, Energy Star, ISO 14001):	TLMI Cert.			Jun-14

**WISCONSIN DNR GREEN TIER
SUSTAINABILITY METRICS**

Period Covered: FY-2015

Company Name: WS Packaging Group, Inc.
 Facility Name: Algoma / Jefferson Street
 Address: 1102 Jefferson Street
 City, State, Zip: Algoma, WI 54201
 Environmental Coordinator: AJ Bonnell (EH&S Manager)
 Coordinator Phone: Work: (920) 866-6307 CELL: (920) 321-4001
 Coordinator E-Mail: abonnell@wspackaging.com

Metric	Not Collected/ Not Available	Quantity	Units	Period - if not Calendar Year
DEMOGRAPHICS				
Sales		\$105,354,883.55	\$	Jul 14/Jun 15
Money saved because of material or process improvements	Projected	\$1,256,842.00	\$	Jul 14/Jun 15
Profit or Loss		21.0%	%	Jul 14/Jun 15
Employees	Approx.	490	Each	Jul 14/Jun 15
Multiple between highest paid and lowest paid employee			%	
Alternative Transportation Support		N/A	\$ or ?	
Total Purchases	Direct Materials	\$51,558,537.23	\$	Jul 14/Jun 15
In-State Purchases	31%	\$15,983,146.54	\$	Jul 14/Jun 15
% of Purchases Made from Companies that participate in Green Tier or Green Masters:			%	
LAND				
Total Land		5	Acres	CY-2015
Paved/Covered Land		2	Acres or sq ft	CY-2015
ENERGY				
Electricity	Calendar Yr	9,914,142	kWh	CY-2015
		0.8%	% Decrease	CY-2015
Natural Gas	Calendar Yr	9,592,900,000	BTU	CY-2015
		2%	% increase	CY-2015
Renewable Energy (generated on-site)		0%	% of total use	
Renewable Energy (as a % of utility electricity mix)		0%	%	
WATER				
Total Water Used	Calendar Yr 3- Meters	1,951,200	gallons/year	CY-2015
		13.0%	% Decrease from 2014	CY-2015
Source - private well		0%	% of total use	
Source - public system		100%	% of total use	CY-2015
Water Recycled/Reused 24 X 7 Operation	Pre-treated before discharge Avg 16,144g per week	839,488	gallons/year	CY-2015
		15.5%	% recycled increase	CY-2015
Regulated Pollutants Discharged (BOD, TSS, Metals)		N/A	lbs/ year	
		N/A	% reduction	
AIR				
Total Air Emissions	Air Emissions Inventory Summary Report	12.2	Tons/ year	CY-2015
		8.70%	% increase	CY-2015
Ozone-Depleting Substances	Air Emissions Inventory Summary Report	63	lbs/ year	CY-2015
		8.7%	% increase	CY-2015
Greenhouse Gas Emissions		N/A	lbs/ year	
		N/A	% reduction	
WASTE				
Hazardous Waste Disposal	Refilled as a SQG for 2016	33,986	lbs/ year	CY-2015
		30.8%	% Decrease	CY-2015
Universal Waste Disposal		N/A	lbs/ year	
		N/A	% reduction	
Non-Hazardous Waste Disposal	Refilled as a SQG for 2016	39,907	lbs/ year	CY-2015
		N/A	% reduction	
Material Recycled/ Reused	Greenwood Fuels stopped taking matrix material in Jan-2015	160	Tons/ year	CY-2015
		-95.0%	% Decrease from 2014	CY-2015
Recycled/ Reused Content		1.60%	% of product	CY-2015
TRANSPORTATION				
Hybrid Vehicles		N/A	Each	
Gasoline Used	@2.00g Avg	8,411	Gallons 36% Reduction	Jul 14/Jun 15
Diesel Used - vehicles		N/A	Gallons	
Diesel Used - Generators		N/A	Gallons	
Alternative Fueled vehicles (CNG, LNG, Fuel Cell, Electric)		N/A	#	
ADDITIONAL METRICS				
Please list all other designations/certifications (for example: LEED, Green Globes, Green Masters, Energy Star, ISO 14001):	TLMI Cert.	5-Year Audit		Sep-15



Sustainability Policies & Procedures		
1.0 Clean Production Techniques		
1.1 Releases to Air	Performance Measurement	References for obtaining measurements
<p>1.1.1 Program to decrease facility VOC, HAP, and UV releases to air</p> <ul style="list-style-type: none"> ➤ Many solvent-based inks have been replaced by water-based inks and UV inks. However, we had an increase in business requiring more solvent based inks in 2015. ➤ Total VOCs emitted has been reduced by over 44% over the past 11 years.* ➤ Digital platemaking technology has eliminated photo film processing materials, chemicals, and solvents. ➤ Our employees are trained in our Hazard Communications program to ensure all chemicals containers are labeled. 	<p>VOCs emitted in 2015 were 12.18 tons. (An increase of 9.5% from 2014)</p> <p>Increase is mainly due to the increased business volume of product using solvents/solvent inks. Doing more film product.</p> <p>Our goal is to reduce it by 5% in 2016.</p>	<p>Annual Air Emissions Inventory Summary Report</p> <p>Pat Olsen (DNR Report)</p> <p>Calendar Year</p>
<p>1.1.2 Program to use best management practices to avoid other releases to air</p> <ul style="list-style-type: none"> ➤ All exhaust stacks are at 25 feet above the ground. ➤ All used solvent or shop towels are stored in a closed metal container marked with “Excluded Solvent Contaminated Wipes” and sent out weekly for laundering ➤ It is company policy that all solvent parts cleaners’ covers are closed when not in use. ➤ All screw-in drum top funnels must keep lids closed when not adding waste. ➤ Investment was made for a new more efficient nitrogen tank that has greatly reduced the amount of nitrogen being released into the atmosphere during high-pressure situations. ➤ The majority of our inks and varnishes have zero HAPs. All other inks and varnishes have very minimal HAPs. 	<p>Nitrogen Usage: Algoma-Jefferson 2014 – 312,364 lbs <u>2015 – 92,462 lbs</u> 219,900 (reduction of 70.4%)</p> <p>Moved Coater press to Rabas St.</p> <p>Our goal is to reduce it by 5% in 2016.</p> <p>No Rabas St data included.</p>	<p>Annual Air Emissions Inventory Summary Report</p> <p>EH&S Manager (Tier II Report)</p> <p>Calendar Year</p>

1.2 Releases to Water		
<p>1.2.1 Program to decrease quantity of facility releases of water</p> <ul style="list-style-type: none"> ➤ Preventive Maintenance Program on all faucets ➤ With the switch to our digital platemaking technology, we no longer need a still for reclaiming solvents. The still required non-contact cooling water that had been disposed of into the city sewer system. 	<p>Water usage for: 2014 = 1,926,800 gal. (corrected) 2015 = 1,951,200 gal.</p> <p>There are only 3-Water meters that pertain to Algoma Jefferson.</p> <p>Our goal is to reduce our usage in 2016 by 3%.</p> <p>Actual was a 1.3% increase for 2014 usage.</p>	<p>Request from Algoma Utilities</p> <p>Request from Bonnie Junio bjunio@wppienergy.org</p> <p>3-Water Meters for Algoma Jefferson</p>
<p>1.2.2 Program to minimize releases into waste water</p> <ul style="list-style-type: none"> ➤ All of our water-based waste inks and rinse go through a waste water treatment device. All hazardous parts of the waste are removed and fully encapsulated before being sent to the landfill. Remaining water is clear and sent to the city sewer system. <ul style="list-style-type: none"> ○ Each batch of pretreated wastewater is tested and logged before released into the city sewer.* ○ pH reading of 6-9 must be maintained before release. 	<p>16,144 gallons of water are treated per week (increase)</p> <p>Our goal is to have 100% of all releases into the city sewer system free from any hazardous substances.</p>	<p>All releases are pH factor based. We average a 6.8 pH factor on all releases after treatment.</p>
1.3 Waste		
<p>1.3.1 Program to minimize solid waste sent to landfill from production</p> <ul style="list-style-type: none"> ➤ 0% of our previous landfill waste is now sent to a facility to convert the waste into fuel pellets in 2014. ➤ It is our goal to increase the waste percent no longer sent to the landfill in 2015, however, this will be dependent on Greenwood accepting waste matrix. ➤ All corrugated materials are sent in to be recycled. 	<p>3,433 tons of waste hauled to the landfill in 2015 (73.3%) increase.</p> <p>2014- 350 tons recycled (89% decrease over 2014)</p> <p>Greenwood has suspended acceptance of material as of</p>	<p>Algoma Monthly Recycling Numbers</p> <p>EH&S Manager</p>

<ul style="list-style-type: none"> ➤ The following items are sent in to recyclers: aluminum, copper, steel, monitors, computers, fluorescent bulbs, plastic bottles, cell phones, batteries, end boards, pallets and waste flexo plate material. (Bader Plug and Nelson Company) 	<p>January of 2015 and has not started to accept product to this date. Recycled 171Tons of “Truly Recycled Waste) (72.6% increase over 2014)</p>	<p>Blue Waters Badger Plug</p>
<p>1.3.2 Program to ensure proper disposal of hazardous waste</p> <ul style="list-style-type: none"> ➤ We have a Hazardous Waste Program in place. <ul style="list-style-type: none"> ○ Our “Hazardous Waste Program” describes policies and procedures to meet WI DNR compliance for hazardous waste. ○ Procedures are in place for the proper handling of hazardous waste. ○ Documentation of all hazardous waste shipments are kept on file. ○ All aerosol cans are punctured, emptied, and recycled. ○ 33,986 lbs. of hazardous waste were shipped in 2015. 	<p>In 2015, we shipped out 33,986 lbs. of hazardous waste. (30.8% Decrease over 2014.) Issues with the comingling of waste streams have been resolved and we have been reclassified as a SQG for 2016.</p> <p>Our goal is to reduce our hazardous waste in 2016 by 50%.</p>	<p>Annual Hazardous Waste Report Refer to Badger/HW Manifest data EH&S Manager</p>
<p>1.3.3 Program to recycle or encourage recycling of liner material from customers</p> <ul style="list-style-type: none"> ➤ We have partnered with a recycling company that specializes in liner recycling. Based on their area of the U.S., customers are given the specifications for the program and referred to the closest recycling center for their liner disposal. The recycler company has release liner service centers located in nine different cities throughout the United States to make it easier and more convenient for customers to recycle their liner. 	<p>Greenwood has put their activity on hold.</p> <p>We have partnered with a recycling company to offer pick up of liner from our customers and send it in for recycling.</p>	<p>Obtain information from Mary Hyde (Marketing Dept.)</p>
<p>1.4 Office and Facility</p>		
<p>1.4.1 Policy and programs for using environmentally preferable cleaning practices in facility and office</p> <ul style="list-style-type: none"> ➤ Approximately 11% of our cleaning supplies are non-toxic, biodegradable, non-hazardous, non-flammable, and non-corrosive. We propose to increase that to 22%. ➤ Cleaning products with no or low VOCs are used wherever 	<p>25% of cleaning products used are biodegradable, non-hazardous, non-flammable, and non-corrosive.</p> <p>Our goal is to replace more</p>	

<p>possible.</p> <ul style="list-style-type: none"> ➤ Each custodial employee has been trained in Hazard Communications. They know and understand that they must read and follow product labels and use only the amount needed. Cleaning procedures are in place. ➤ We have invested in an automated “Flexowash” plate cleaner, which has eliminated the process of cleaning plates by hand with alcohol and acetate. ➤ We have invested in an automated “Flexowash” anilox roll cleaner, which uses a less corrosive chemical for cleaning and has reduced exposure to employees, who are cleaning rolls by hand. ➤ As part of our waste reduction/energy reduction program, several air hand dryer have been installed in the bathrooms and the paper toweling dispensers removed. <p>All bathroom tissue and paper toweling purchased are composed of 100% recycled fiber.</p>	<p>cleaning products with eco-friendly cleaners and raise that % to 50%.</p> <p>We have converted our “hand cleaner” to North Woods Power Stuff.”</p> <p>This is a totally “green/environmentally friendly” hand cleaner.</p>	<p>Obtain information from Maintenance Dept. (Cleaning Personnel is now contracted through Clean Power, Inc.)</p>
<p>1.4.2 Policy and program to give purchasing preference to environmentally preferable materials such as office supplies, paper, equipment, etc.</p> <ul style="list-style-type: none"> ➤ We use centralized purchasing/leasing for office equipment, consumable supplies, etc. <ul style="list-style-type: none"> ○ Mandates staged approval process for purchase ○ Standardizes product lines ○ Deploys (leased) copier products company wide ○ Eliminates uninformed product purchase decisions ➤ All copier machines use remanufactured toner, which eliminates toner cartridges from going into the landfill. 	<p>In 2015, WSPG purchased 25.51 tons of Boise SFI Certified Copy Paper for office use.</p> <p>Presently using remanufactured toner cartridges. These are supplied through a 3rd party repair service vendor.</p>	<p>Kristi Luedke Purchasing</p> <p>Purchasing Dept.</p>
<p>1.4.3 Program to increase use of environmentally preferable packaging materials or practices for shipping</p> <ul style="list-style-type: none"> ➤ Customer supplied boxes <ul style="list-style-type: none"> ○ Final product shipping boxes supplied by the customer are used for label order returns ○ One customer measured reusable box program resulting in seven tons of corrugated saved each year 	<p>This is part of our Estimating/Sales and Purchasing areas that always “suggest” an environmentally</p>	<p>Customer Service Dept.</p>

<ul style="list-style-type: none"> ➤ Unique product-stacking configuration <ul style="list-style-type: none"> ○ Corrugated boxes(2MM) are eliminated entirely ○ Product is placed directly on the shipping pallet ○ Corner reinforcement and shrink film protection ➤ PATENTED PRODUCT CONSTRUCTION <ul style="list-style-type: none"> ○ Our MultiVision® product line of extended text labels provides additional label space through multi-layer extended text constructions ○ Eliminates the use of cartons, folded instruction sheets, and associated costs, by having all the required consumer information right on the bottle or tube ○ We produce linerless labels, eliminating the liner waste product and disposal expense ○ We offer a product prototypes or “mock-ups” service for new sustainable packaging ideas, label designs, alternate materials, new constructions, and POP/POS for new product lines 	<p>satisfactory solution to meet customer needs.</p> <p>However, more often than not, Customers are NOT willing to pay the added costs for such materials.</p>	<p>Vision Team (Mary Byce)</p>
<p>1.5 Compliance and Violations</p>		
<p>1.5.1 Program to eliminate compliance fines, violations, and complaints</p> <ul style="list-style-type: none"> ➤ Each WSPG facility completes a quarterly Corporate Environmental Compliance Checklist and submits it to the Corporate Environmental Director ➤ Our facility deploys 6S principles. All employees have been trained. ➤ Each WSPG facility completes a Quarterly Risk Management Score Card. Twenty-six different safety directives are listed, completed, and recorded on an annual basis. ➤ Our facility is BRC compliant and must pass an annual audit to retain that status. The audit includes inspection of operational methods and personal practices, maintenance for product safety, cleaning practices, integrated pest management, and adequacy of production safety programs. 	<p>We have recently passed a “BRC” audit with a pending “A” grade.</p> <p>BRC audits are much more stringent than “AIB” audits.</p>	<p>Refer to “Permits” binder-section 7 (DNR Miscellaneous)</p> <p>Justin McCabe or D’Onne Murray</p> <p>QA Manager</p>

1.6 Innovative Program		
<p>1.6.1 Significant and Innovative programs to reduce or eliminate adverse environmental impacts in operations</p>	<p>Original Cross-Connection Inspection was conducted in November, 2013. Re-inspected in November, 2015.</p> <p>This is a mandatory annual inspection process.</p>	<p>A Cross-Connection Control Program was put in place to eliminate any possible contamination into the public water distribution system. All deficiencies were corrected. EH&S Manager</p>
2.0 Energy and Greenhouse Gases		
2.1 Energy Use		
<p>2.1.1 Program to increase energy efficiency of production, offices and facilities</p> <ul style="list-style-type: none"> ➤ A facility Sustainability team was established in 2008 to find ways to reduce energy usage and costs and eliminate waste. ➤ Lighting motion sensors have been installed in all bathrooms, in the new remodeled customer service department, and in other various parts of the facility ➤ An air leak study was completed in June, 2013. ➤ In the last year, we made significant capital investment in technology that reduces energy waste during roll changes during shut-down and re-starting. ➤ 60 % of all “EXIT” signage lights have been switched over to LED lighting. ➤ We are investigating installation of LED “Egress” lighting 	<p>1 new energy efficient AC roof top units installed in 2014.</p> <p>Remodeled more offices installing more perimeter light sensors (as requested) in 2015.</p> <p>There were 9,914,142 kWh's used in 2015 which was a .8% Decrease from 2013. (2-</p>	<p>Maintenance Manager & EH&S Manager</p> <p>Request from</p>

<p>outside of the building.</p> <ul style="list-style-type: none"> ➤ Two rooftop AC units were upgraded within the past year to more energy efficient models ➤ We are looking at establishing office temperature guidelines/limits for each season. 	<p>new P7 press's were installed and increased production in 2015, were the primary reasons for this Decrease.)</p>	<p>Bonnie Junio bjunio@wppienergy.org</p>
<p>2.1.2 Program to increase energy efficiency of distribution fleet</p>	<p>No measurement at this time.</p>	
<p>2.2 Greenhouse Gases</p>		
<p>2.2.1 Program for greenhouse gas management</p>	<p>2013 – 75,994 Therms Used 2014 – 94,258 2015 – 95,930</p>	<p>Increase Rates</p> <p>42.1% 24.0% 1.8%</p> <p>TLMI Calculator Spreadsheet</p>
<p>2.2.2 Program to increase use of renewable energy</p> <ul style="list-style-type: none"> ➤ Investigating purchase of renewable energy through our utility company <ul style="list-style-type: none"> ○ We can purchase 100 blocks or more per month ○ Cost: Industrial rate of \$2.00/300 kWh block ○ Purchasing 307 blocks = 25% of consumption on one account (\$614.00) 	<p>In 2015 no renewable energy was purchased.</p> <p>Our goal is to purchase 1% renewable energy in 2016.</p>	<p>Sustainability Committee</p>
<p>2.2.3 Program to offset greenhouse gas emissions</p>	<p>Electric/Gas combined GHG metrics; 2014 – 3,458 Metric Tons CO₂</p>	<p>YOY Variance 3.6% Increase</p>

	2015 – 1,305 Metric Tons CO ₂	-62.3% Decrease TLMI Calculator Spreadsheet
2.3 Greenhouse Gases		
2.3.1 Significant and Innovative programs to reduce energy use or offset greenhouse gases	Held a Corporate Energy-Kaizen event to reduce energy usage on weekends.	Policies and procedures were created and training held for Weekend Shutdowns.
3.0 Product Design		
3.1 Integration of Environmental Performance into Design		
3.1.1 Program to design output and process to minimize waste in production and application <ul style="list-style-type: none"> ➤ We have formed a waste committee, focused on waste reduction plant wide. ➤ We utilize lean manufacturing processes and tools, such as Kaizen events, to gather ideas/suggestions from all areas and functional line personnel for waste reduction solutions. ➤ We have created a model and are actively focusing on material SKU consolidation. To date, we have eliminated 59 SKU's, reducing the likelihood of obsolescence and subsequent waste. ➤ In the last year, we made significant capital investment in technology that reduces waste due to shutting down and starting back up with roll changes. 	Quality KPI (Returns & Allowances) was .37% in 2014. 2015 – R&A ended at .49% That's a 25% Increase in R&A 2016 – Goal is .30% of Sales New measurement is Last Good to First Good. 2014 – 72 Minutes Avg 2015 – 72 Minutes Avg 2016 – Goal is 69 Min Avg	Quality Manager Production Manager

<ul style="list-style-type: none"> ➤ We are developing environmentally friendly coatings that may reduce the consumption of over-laminate films. ➤ We have worked with major customers to create a recycling program for silicone liner. ➤ We have major accounts that have eliminated the use of corrugated boxes in shipping, utilizing a skid pack design. ➤ Order by the roll rather than the master (Exact, TIPS, precise, etc. - no off cuts) ➤ Order only what is needed per job requirements within the allowable over/under run percentage (less chance of unassigned inventory) ➤ SKU rationalization: <ul style="list-style-type: none"> ○ Consolidate purchases to use tier one suppliers ○ Consolidate SKU's ○ Consolidate sizes within a SKU ○ Move away from minimum buy materials ○ Set target materials per category (i.e. WHG, SG, foil, etc.) ➤ Unassigned material inventory plan <ul style="list-style-type: none"> ○ Roll up, Substitute, Slit, or Use for make ready ○ Sell <ul style="list-style-type: none"> ▪ Transfer to another WSPG facility ▪ Roll exchange/ broker ○ Donate to local technical school ➤ Yearly review of job costing to verify actual vs. estimated waste and make-ready on repeat jobs. ➤ No-stretch wrap program” on the pallets for direct material shipments received from suppliers. 	<p>Maintained LGFG in 2015.</p>	
<p>3.1.2 Program to work with customer to design graphics to minimize processing and material and energy use</p> <ul style="list-style-type: none"> ➤ Expanded Gamut printing/ 6- and 7-color process: Ink stations set up with the same inks to reduce change overs and setup. More efficiency gained at press, less material used for setup 	<p>Approximately 800 to 1000 lbs. of plates were recycled each month in 2015.</p>	

<p>and possibly fewer plates.</p> <ul style="list-style-type: none"> ➤ Plate Recycling: We recycle used flexo plates through a recycling program with Nelson Company. ➤ Recommend a size adjustment (width) to reduce material waste and better fit the master roll width. ➤ Recommend a size adjustment to utilize in-house tooling rather than purchase new. ➤ Recommend a size adjustment (length) to utilize existing magnetic cylinder rather than purchase a new engraved die. ➤ Recommend a size adjustment to run more across on press – running more efficiently and reducing run time on press. ➤ Look at the possibility of digital production vs. flexographic to eliminate plate and art charges. ➤ Offer our patented MultiVision® extended text labels with multiple-ply construction to eliminate extra packaging such as carton, instruction sheet, etc. 		<p>Plate Making Dept.</p>
<p>3.2 Environmentally Preferable Materials</p>		
<p>3.2.1 Program to use environmentally preferable facestock and tag stock materials</p> <ul style="list-style-type: none"> ➤ We offer our customers materials that create more sustainable packaging such as: <ul style="list-style-type: none"> ○ Recycled papers <ul style="list-style-type: none"> ▪ Composed of 10% to 100% post consumer waste. ○ Dissolvable papers <ul style="list-style-type: none"> ▪ Washes away with either cold or hot water ○ Tree-Free papers made of fibers from fast growing plants such as: <ul style="list-style-type: none"> ▪ Sugar Cane ▪ Bamboo ▪ Hemp ▪ Cotton Linters ○ Biodegradable films <ul style="list-style-type: none"> ▪ Made from regenerated cellulose 	<p>In FY-2013, WSPG has sold 8.1% PET liner.</p> <p>In FY-2014 WSPG has sold 8.4% PET liner.</p> <p>Increase of 3.6%.</p>	<p>Purchasing Dept.</p>

<ul style="list-style-type: none"> ○ Bio-plastic films <ul style="list-style-type: none"> ▪ Made from renewable resources, rather than petroleum, including: <ul style="list-style-type: none"> • Starch • Corn > PLA film • Cellulose > Acetate ➤ We offer our customers paper that is FSC / SFI certified. 	<p>Green Bay Packaging (FSC/SFI) 2015 – 45.1 tons (78.1% increase)</p> <p>Avery 2015 – 1,033 tons (89.9% increase)</p>	
<p>3.2.2 Program to use environmentally preferable adhesives and fasteners</p> <ul style="list-style-type: none"> ➤ To facilitate the reuse of containers, we offer our customers a dissolvable adhesive that can be cleanly removed. ➤ We offer our customers a recycle-compatible adhesive. <ul style="list-style-type: none"> ○ Allows paper fibers and adhesive to be separated in the recycling process. <ul style="list-style-type: none"> ▪ Permits envelopes, papers, catalogues, etc. containing PS labels to be recycled without contaminating the recycled product. <p>We offer our customers a water-based acrylic adhesive and solvent-free silicone.</p> ○ Minimizes hazardous waste and air emissions 	<p>11.82 Tons of Water Based adhesives ordered in 2015.</p>	<p>Renee Zimmerman Chemical Buyer</p> <p>E-Mail Reference</p>
<p>3.2.3 Program to use environmentally preferable liner material</p> <ul style="list-style-type: none"> • Natural Kraft Liner <ul style="list-style-type: none"> ○ Performs the same as white liner. ○ Does not require bleach, chlorine dioxide, or die. ○ Can be recycled with other paper liners. • PET Liners <ul style="list-style-type: none"> ○ Thinner than paper. ○ Creates less waste. <p>NOTE: Silicone-coated release liner, butt rolls, jumbo rolls, and obsolete stock can be recycled by companies such as Greenwood Fuels. They have 8 locations in the USA and 1 location in Canada. Please see more information at their website: http://www.channeledresources.com.</p>	<p>2015 PET Liner – 10.7% Paper Liner – 88.8% PPK Liner - .4% Styrene Film Liner - <.1%</p> <p>Note: Currently Greenwood is NOT accepting any material.</p>	<p>Jodi Swobada Purchasing Dept.</p>

<p>3.3 Innovative Program</p>		
<p>3.3.1 Significant and innovative programs resulting in environmentally preferable design</p>	<p>We now have customers purchasing our "Liner less" product. 1.1% of label sales in 2015.</p>	<p>Stayed about the same for 2015</p>
<p>4.0 Management Practices</p>		
<p>4.1 Overall Management of Business Operations</p>		
<p>4.1.1 Policy that outlines Environmental Commitment</p> <ul style="list-style-type: none"> ➤ Our Environmental Policy is stated as follows: At WS Packaging Group, we operate our business as a corporate citizen committed to sound social, ethical, and environmental management, which includes protecting our environment, managing our energy use, and conserving natural resources. Our goals are to ensure that our company facilities and business operations comply with federal, state, and local laws and sustainable standards and to provide products that are environmentally sound throughout their lifecycles. We conduct our operations in an environmentally responsible manner and develop sustainable packaging improvements and solutions for our customers. We believe that an appropriate balance can and should be achieved between environmental goals and economic health and performance. 	<p>No measurement</p>	<p>Corporate Risk Director. Pat Olsen</p>
<p>4.1.2 Policy to review environmental risks</p> <ul style="list-style-type: none"> ➤ Each Department has conducted an inspection of the waste water discharge, air emissions, etc. using the "Environmental Aspects Identification Form". ➤ All solvents are stored in an "Explosion Proof" room. This room has a floor drain that drains into a holding tank. The room is designed to prevent any spills from escaping into the 	<p>Developed an Environmental Aspects Identification form to identify our risks.</p> <p>No measurement at this time.</p>	<p>Corporate Risk Director. Pat Olsen</p>

<p>environment.</p> <ul style="list-style-type: none"> ➤ All Hazardous Waste barrels are stored with a containment unit underneath to prevent spills from getting into the environment or into a sewer drain. Spill kits are readily available. 		
<p>4.1.3 Programs to monitor performance</p> <ul style="list-style-type: none"> ➤ All usage of inks, coatings, and solvents are recorded electronically. Every bottle that goes to press has a bar code and is scanned. Reports are computed monthly and are documented to determine the amount of VOCs emitted for the month. ➤ An annual Air Emissions Inventory Summary Report is submitted to the Wisconsin DNR. ➤ A spreadsheet is kept on file and is updated daily to calculate the amount of material that is sent to the local landfill and to the local recycler to be converted to fuel pellets. 	<p>WSPG Algoma (Jefferson St.) received the Green Tier-1 Certification with Wisconsin DNR in 2011.</p> <p>It was renewed after our 5 year audit in 2015.</p>	<p>Corporate Risk Director. Pat Olsen</p> <p>Quarterly Environmental Checklist</p>
<p>4.1.4 Policy to set annual continual improvement objectives and targets</p> <ul style="list-style-type: none"> ➤ Corporately we have formal metrics for multiple key business objectives. We have set objectives for improvement, specifically for waste reduction and energy usage reduction ➤ As a facility, we develop an annual formal Strategic Action Plan to address improvement efforts. We then meet quarterly with each department to review our progress in our strategic plan. ➤ Each WSPG facility must complete a Sustainability Scorecard. The scorecard is designed to apply a score to 41 separate items that cover Clean Production Techniques, Energy Efficiency, Recycling, and Management Practices. 	<p>WSPG scorecard was 132 for 2014.</p> <p>Our facility score on the WSPG Scorecard for 2013 was 126.</p> <p>Our goal is to score 130 or higher in 2015.</p> <p>Score or 157 for 2015.</p>	<p>EH&S Manager</p>

<p>4.1.5 Program to develop Environmental Best Practices Awareness</p> <ul style="list-style-type: none"> ➤ A corporate Sustainability Committee was established in 2008. ➤ All new employees are trained in Safety and General Manufacturing Practices before they begin employment. ➤ Each month our facility has a mandatory facility-wide meeting for all employees, educating and sharing progress and ideas. Production, Quality, Lean, Safety, and Sustainability are standard topics of each month’s presentation. ➤ Recycling programs are in place to recycle all eligible items and reduce waste volume sent to the landfill. ➤ Each WSPG facility is required to complete an “Environmental Compliance Self-Assessment Guide”. <ul style="list-style-type: none"> ○ Attachment: Environmental Self-Assessment Guide 		<p>EH&S Manager</p>
<p>4.1.6 Programs outlining Emergency Response procedures</p> <ul style="list-style-type: none"> ➤ A Spill Response Team is composed of employees that are trained annually. There are employees from each shift on the team. ➤ Procedures are in place for employees to follow when dealing with hazardous waste. ➤ There is an Emergency Response Team comprised of employees from all three shifts. Each member has been trained in first aid and in the use of the defibrillator. ➤ WSPG has a “Business Continuity Plan Playbook” designed to ensure the survival of the company. ➤ WSPG has a “Crisis Management and Emergency Action Plan” that outlines procedures in case of an emergency. ➤ All new employees attend a New Employee Orientation and are educated on the emergency response procedures in this facility. 	<p>Environmental and Sustainability were topics that were added to the WSPG “Business Continuity Plan Playbook” in 2013.</p> <p>All production employees received RCRA training in March 2015.</p> <ol style="list-style-type: none"> 1. Hazardous Waste Into. 2. Hazardous Waste Emergency Response (ERT Team) 3. Hazardous Waste Manifest (Those shipping Hazardous Waste.) 	<p>Corporate Risk Director. Pat Olsen</p>

<p>4.1.7 Program to ensure corrective and preventative action management</p> <ul style="list-style-type: none"> ➤ Our Safety Program’s policy ensures we conduct an investigation for every accident and incident of “near miss”. <ul style="list-style-type: none"> ○ An Accident Investigation Form is used to determine the “root cause” of an accident, and corrective actions are determined with a target date and a person accountable for completion. ○ A “Supervisor’s Near Miss Report” is completed whenever an incident occurs and there are no injuries. The form is designed to determine the root cause of the incident and create an action plan to prevent reoccurrence. ➤ Our Safety Committee performs monthly safety audits of departments. All non-compliance items are recorded in the Safety Meeting minutes, assigned to a person for correction, and given 30 days to correct. ➤ Operating Procedures are in place to assign responsibilities for documenting non-conformities as reported by customers. <p>WSPG has a “Crisis Management and Emergency Action Plan” that outlines procedures in case of an emergency.</p>	<p>Corrective Action Plan using the Environmental Non-compliance Investigation Form</p>	<p>Corporate Risk Director. Pat Olsen</p>
<p>4.1.8 Program to ensure regular performance review</p> <ul style="list-style-type: none"> ➤ An “Internal Audit Procedure” is used to audit each of the environmental items on an annual basis. 	<p>Utilize EA (Environmental Aspects) form and Process Flowcharts.</p>	<p>EH&S Manager</p>

<p>4.1.9 Program to ensure proper maintenance of equipment</p> <ul style="list-style-type: none"> ➤ An annual Maintenance Program is in place for all presses. ➤ We plan to install an annual Maintenance Program for all Rewinders. ➤ A preventive Maintenance Program is in place for all printing presses. ➤ There are several ‘External” Maintenance Programs in place for various high tech machines. ➤ Inspection of all HVAC units is completed annually. ➤ All press operators must attend and pass a Press Operator Certification class. ➤ An audit for Air Leaks was performed in 2008, 2010 & 2013. ➤ A program is in place for preventive maintenance of all UV cassettes. The life of UV bulbs are tracked and monitored. ➤ All scissors lifts are inspected annually by an outside contractor. ➤ All forklifts are inspected semi-annually by an outside contractor. ➤ The Quality Assurance Department calibrates the following instruments semi-annually: scales, rub tester, and digital calipers. The following instruments are calibrated annually: bar code scanner, micrometer, digital force gauges, and the pull tester. 	<p>Our Air Leak Inspection was not performed in 2015.</p> <p>Our next scheduled inspection for Air Leaks will be in 2016.</p> <p>Fluorescent Bulb Crusher has been authorized for purchase.</p> <p>Annual Maintenance Program is in place.</p>	<p>Production Support Manager</p>
<p>4.2.0 Other Certifications</p> <ul style="list-style-type: none"> ➤ 4.2 Program to maintain certification by one or more third-party audited environmental programs other than L.I.F.E. 	<p>Wisconsin DNR Green Tier Certified</p>	<p>Originally Certified in 2011. Recertified in 2015.</p>

WSPG SUSTAINABILITY SCORECARD

WSPG Facility:

Algoma
1102 Jefferson St.

Person completing scorecard:

Terry Moede
Consulting Service

Date: March 25, 2016

Do not fill in

SECTION	SCORE
1.0 Clean Production Techniques	49
2.0 Energy	28
3.0 Recycling	40
4.0 Management Practices	40
TOTAL	157

1. Complete this scorecard by placing an '**X**' in the column that best captures the extent of your involvement in the activity listed in each row.

2. A rating for this level of performance (e.g., No Activity, Acceptable, Good) will translate into points as shown in the chart below.

3. The "Points" will be multiplied by the "Score Multiplier" to create a "Score" for that line item. The "Score Multiplier" gives more weight to activities that have a greater impact.

4. If you select '**Formal Program**', you must provide a description of this program in writing.

The components of a program are to be determined by each participant. However, to meet the requirement for the scorecard, the program must at least contain:

- A measurable goal and timeframe for achieving it (e.g., 10% reduction by 2012)
- A description of the activities that will be undertaken to achieve that goal
- A description of the control and monitoring mechanism (e.g., how you will collect and evaluate data)

The criteria for evaluating your current involvement and the corresponding Score are listed below.

Column	Score	Points
No Activity: We have not engaged in this activity	No Activity	0
Investigating: We are currently investigating the development of a program or target.	Acceptable	1
Formal Program: We have established a formal engagement in this activity, with programs, goals, control and measurement systems (must provide program description).	Good	2
Performance Measurement: This column captures our performance in this category for the reporting year.	NA	

1.0 Clean Production Techniques	No Activity	Investigating	Formal Program	Performance Measurement	Unit of Measurement	Score Multiplier	Score
1.1 Releases to Air							
1.1.1 Program to decrease facility VOC, HAP and UV release to air			X	12.18	VOCs emitted in 2015 were 12.18 tons. (An increase of 8.1% from 2014) 2014 Emmissions were 11.13 tons per DNR Emmissions Summary Report. Increase is mainly due to the increased business volume of product using solvents/solvent inks. Our goal is to reduce it by 5% in 2016.	2	4
1.1.2 Program to use best management practices to avoid other releases to air			X	92,462	2014 - 312,364 lbs. Jefferson. 2015 - 92,462 lbs Our goal is to reduce it by 5% in 2016. Actual Nitrogen purchased resulted is a -70.4% Decrease from 2014.	2	4
1.2 Releases to Water							
1.2.1 Program to decrease quantity of facility releases to water			X	1,951,200	Water usage for: 2014 = 2,233,700 gal. 2015 = 1,951,200 gal. Our goal is to reduce our usage in 2016 by 3%. Actual was a 13% Decrease for 2015 over 2014 usage	2	4
1.2.2 Program to improve quality of water released			X	839,488	16,144 gallons of water are treated per week Actual reclaimed water is a 41% increase over 2014. Our goal is to have 100% of all releases into the city sewer system free from any hazardous substances.	2	4
1.3 Waste							

1.3.1 Program to minimize solid waste sent to landfill from production			X	160.0	Tons sent to Greenwood Fuels to be recycled into fuel Pellets. This is an -95% Decrease sent to Greenwood from 2014. Greenwood stopped taking material in early 2015.	2	4
1.3.2 Program to minimize solid waste sent to landfill from office and facility			X	181.8	Tons of miscellaneous recyclables That's a 74.3% increase over 2014.	2	4
1.3.3 Program to ensure proper disposal of hazardous waste			X	33,986	In 2015, we shipped out 33,986 lbs. of hazardous waste. (-30.8%Decrease over 2014.) Waste streams have been identified and separated and we are currently operating as a SQG for 2016. Our goal is to reduce our hazardous waste in 2016 by 50%.	2	4
1.3.4 Program to recycle "old" ink into black		X			Ongoing within our ink room	1	1
1.3.5 Program to recycle liner material from customers			X		See 1.3.1	2	4
1.4 Office and Facility							
1.4.1 Policy and programs for using environmentally preferable cleaning practices in facility and office			X		30% of cleaning products used are biodegradable, non-hazardous, non-flammable, and non-corrosive. We have converted our hand cleaner to North Woods Power Stuff. This is a totally green/environmentally friendly hand cleaner.	2	4

<p>1.4.2 Policy and program to give purchasing preference to environmentally preferable materials such as office supplies, paper, equipment, etc.</p>			<p>X</p>		<p>No measurement at this time. In 2015, this was cost prohibitive for using recycled paper. Presently using remanufactured toner cartridges. This is done through our copy machine vendor service.</p>	<p>2</p>	<p>4</p>
<p>1.4.3 Program to increase use of environmentally preferable packaging materials or practices for shipping</p>			<p>X</p>		<p>This is part of our Estimating/Sales and Purchasing areas that always "suggest" an environmentally satisfactory solution to meet customer needs. However, more often than not, Customers are NOT willing to pay the added costs for such materials.</p>	<p>2</p>	<p>4</p>
<p>1.5 Compliance Violations</p>							
<p>1.5.1 Program to eliminate compliance fines, violations, and complaints</p>			<p>X</p>		<p>We have NO pending violations or fines. We are now GFSI - BRC Certified with a pending "A" grade. This is more stringent than the AIB audits.</p>	<p>2</p>	<p>4</p>

Description of Program and Goal:

Total

49

All Items in spreadsheet are referenced in the "WSPG Sustainability Policies & Procedures."

2.0 Energy	No Activity	Investigating	Formal Program	Performance Measurement	Unit of Measurement	Score Multiplier	Score
2.1 Energy Use							
2.1.1 Program to increase energy efficiency of production, offices and facilities			X	9,914,142	There were 9,914,142 kWh's used in 2015 which was a .8% Decrease from 2014. (2 new P7 press's were installed and increased efficiency in 2015, were the primary reasons for this Decrease.)	2	4
2.1.2 Program to increase energy efficiency of distribution fleet	X			8,411	miles per gallon, normalized annual fuel consumption Based on \$2.00 per gallon avg.	0	0
2.1.3 Program to reduce energy useage.		X			Sustainability Committee Refer to 2.1.3.6	1	1
2.1.3.1 Install Motion Sensor Light Switches in the office areas.			X		Continuing Program as needed	2	4
2.1.3.2 Install new Energy Efficient Rooftop AC Unit			X		2 new energy efficient AC RTU's 5 & 15 installed in 2015.	2	4
2.1.3.3. Program for "Equipment Shutdown" on weekends and holidays.			X		Revisited the weekend energy shutdown procedures with supervisors. 2- New P7 presses installed.	2	4
2.1.3.4 Program for "Equipment Shutdown" during breaks or when equipment is idle.			X		Presses are run through breaks. SOP's in Place. Leads step in temporarily.	2	4
2.1.3.5 Replace present lights with "Energy Efficient Lights". (ex: T-8 lighting) Also looking at installing LED lighting in production area		X			Sustainability Committee Some areas have converted to LED lights in Production area	1	1
2.1.3.6. Energy Audit conducted by a 3rd party. Proposal Pending ICS Group.		X			Sustainability Committee Meeting with ICS Group, Inc. on March 24th to submit their proposal for energy savings for a Cap-Ex in FY-2017.	1	1
2.1.3.7 Leak Detection Study (Air Leaks)			X		Part of facility PM program.	2	4
2.1.4 Program to increase use of renewable energy		X			In 2015 no renewable energy was purchased. Our goal is to purchase 1% renewable energy in 2016.	1	1

Description of Program and Goal:

Total

28

Review the "Sustainability Policies & Procedures" attached with this file.

3.0 Recycling	No Activity	Investigating	Formal Program	Performance Measurement	Unit of Measurement	Score Multiplier	Score
3.1 Programs established to recycle items rather than landfill							
3.1.1 Trim waste and matrix			X	160	Tons of material sent to Greenwood in 2015.	2	4
3.1.2 Corrugated and office paper			X	962	Lbs waste recycled	2	4
3.1.3 Aluminum			X	115	Pcs waste avoided through design	2	4
3.1.4 Capacitors			X	29	Lbs waste avoided through design	2	4
3.1.5 Old computers/monitors			X	1,502	Lbs waste recycled	2	4
3.1.6 Fluorescent bulbs and ballasts			X	837	Pcs waste avoided through design	2	4
3.1.7 Steel and copper wire			X	34.2	Lbs waste avoided through design	2	4
3.1.8 Batteries			X	103	Pcs waste avoided through design	2	4
3.1.9 Electronic Waste			X	280	Lbs waste telephones recycled	2	4
3.2.0 Plate Material Recycled			X	10,200	lbs per year average	2	4

Description of Program and Goal:

Total

40

Review the "Sustainability Policies & Procedures" attached with this file.

Review the "Algoma-1 Badger Plug Recycling" spreadsheet.

Review "Lamp Recyclers" for 2015.

4.0 Management Practices	No Activity	Investigating	Formal Program	Performance Measurement	Unit of Measurement	Score Multiplier	Score	
4.1 Overall management of business operations								
4.1.1 Policy that outlines Environmental Commitment			X		Sustainability Policies and Procedures Manual	2	4	
4.1.1.1 Do you hold any green certifications.			X		TLMI Green Tier-I	2	4	
4.1.2 Policy to review environmental risks			X		Developed an Environmental Aspects Identification form to identify our risks. Departmental Process Flow Maps	2	4	
4.1.3 Programs to monitor performance			X		WSPG Algoma (Jefferson St.) received the Green Tier-1 Certification with Wisconsin DNR in 2011. It was renewed in 2014.	2	4	
4.1.4 Policy to set annual continual improvement objectives and targets			X		Daily Gemba Review WSPG scorecard was 132 for 2014. Our facility score on the WSPG Scorecard for 2013 was 126. Our goal is to score 130 or higher in 2015.	2	4	
4.1.5 Program to develop Environmental Best Practices Awareness			X		Developed the TLMI calculator spreadsheet to help determine Best Practices	2	4	

4.1.6 Programs outlining Emergency Spill Response procedures			X		<p>Environmental and Sustainability were topics that were added to the WSPG "Business Continuity Plan Playbook" in 2013.</p> <p>Page 199 of the Emergency Action Plan.</p> <p>All production employees received RCRA training in March 2015.</p> <p>1. Hazardous Waste Into. 2. Hazardous Waste Emergency Response (ERT Team) 3. Hazardous Waste Manifest (Those shipping Hazardous Waste.)</p>	2	4
4.1.7 Program to ensure corrective and preventative action management			X		<p>We have the I-Maint Application.</p> <p>We have the Near Miss Program.</p>	2	4
4.1.8 Program to ensure regular performance review			X		<p>Gemba Meetings (Daily) Continuous Improvement Boards.</p> <p>Utilize EA (Environmental Aspects) form and EA Flowcharts.</p>	2	4
4.1.9 Program to ensure proper maintenance of equipment			X		<p>We have the I-Maint Application.</p> <p>We are able to schedule PM's on all types of equipment.</p> <p>Daily review by Maintenance.</p> <p>We also utilize 3rd party contractors.</p>	2	4

Description of Program and Goal:

Total

40

Review the "Sustainability Policies & Procedures" attached with this file.

Points Grand Total

157