

Flambeau River Papers 2016 Sustainability Report

Green Tier, Green Master, and ISO 14001 certified Flambeau River Papers continues to be guided by policies that ensure continuous improvement and that resources are used wisely. Aggressive goals continue to be set to assure minimal environmental impacts. A summary of the mill's environmental status as well as the other sustainable initiatives the mill is working on follows.

Residuals

The mill did not have to landfill any wastewater treatment residuals in 2016 since the landspreading of these residuals continue to provide farmers with the nitrogen and other nutrients their fields need. The mill also reported a record low amount of the residuals generated not only for the year but the mill has also started January 2017 off with the lowest residual generation for a month ever. The shutdown of the mill's deinking operation which was the largest source of residuals is the main reason, but the shutdown of this operation has also resulted in smoother operation of the paper machines resulting in less overall fiber loss. The sulfite area has also contributed by minimizing the amount of fiber that is unusable.

Demand for the mill's one-time-use turn-up tape to make baskets similar to what is shown below continues to be strong. More tape has become available with the switch of using this method of threading paper now on two paper machines. Please call (715) 762-5375 or stop by the mill's security entrance to inquire about receiving some of the material.



Water

Work continues on minimizing water use. A target on the percentage of water withdrawn from the Flambeau River used for cooling water as compared to total use has been set. Two recent projects will give the mill the best chance of making the goal. New heat exchangers on a hot pulpmill wastewater stream will reduce the amount of cooling water needed. The addition of a variable speed drive on the mill's largest river water withdrawal pump as well as the ability to make changes to the running of the heat exchangers tied to this pump from series to parallel operation not only result in only having to pump the amount of water needed but it also maximizes the heating potential during the winter months when warm water is needed.

Air

There was one exceedance of the mill's air permit in 2016 when a stack test conducted in July showed that the stacks associated with the decker processes in the pulpmill

were just over their sulfur dioxide limit. Even though follow-up stack testing showed emissions well under the limit studies continue to ensure that there is not a repeat of that event. The much anticipated start up of a data historian early in 2017 will make resolution of such events much easier.

A surprise air inspection by EPA occurred on Monday, November 28, 2016. To date, EPA has not identified any violations that were found during the audit. Aside from the exceedance mentioned previously, all other air testing was well within compliance including the mill's main boiler compliance check with the Boiler MACT limits that went into effect on January 31, 2016.

ISO 14001

100% compliance continues to be the mill's main objective for 2017. The results of the week long 2016 3rd party audit were favorable with the mill being recommended for certification to the revised ISO 14001-2015 standard in November. Chemical stewardship and the study of the water intake structure rule are the other topics that will be focused on for 2017.

Greenhouse and other community involvement

The mill had another successful growing season with the Flambeau River Community Growing Center which is the greenhouse that is located on mill property. The site continues to host a variety of events and provide raised beds for use by the community. Workshops on everything from aquaponics, garlic beds, rain barrels, and instructions on how to make hoop houses occurred. There will be a focus next year on working with kids with the goal of having an evolving educational program. The mill continues to be a part of the local chamber and to have a representative on the charter school board.

Employees

Veteran papermakers and those from other manufacturing environments continue to join the mill's ranks while others with many years of service continue to retire. One day in early 2017 three people retired that between them had 127 years of service to this mill. When challenged with creating an acronym that demonstrated the mill's environmental philosophies several entries were submitted. The following clever arrangement of the bullet points of the mill's environmental policy was selected as the winner:

COMPLETE CAIR

Comply fully with all applicable environmental legislation and regulations

Open government relationships

Minimization of environmental impact

Publicize regularly on our environmental performance to our management committee, our employees, and the communities in which we operate

Listen to the needs of key stakeholders

Environmental management systems

Track objectives and targets established for environmental management and performance improvement

Evaluate environmental performance of our operation and personnel

Communicate constructively with the communities in which we operate and other key stakeholders

Audit our environmental operations

Implement new and modern environmental technologies

Risk management

Flambeau River Papers managed the challenges of 2016. 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.