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May 14, 2012

Nick Kempf
Fredman Bag Company
5801 West Bender Court
Milwaukee WI 53218

Subject: Welcome to Green Tier

Dear Mr. Kempf:

Congratulations! We are glad to welcome you into Green Tier. You join a group of companies who are not only committed to superior environmental performance but also to superior economic performance.

In recognizing your past accomplishments and future commitments we promise to work towards promoting and rewarding your facility for taking the lead in environmental performance while assuring strong economic performance. We are committed to publicizing Fredman Bag as a Green Tier participant on the DNR website. Undoubtedly, there will be other opportunities to bring the attention of your accomplishments to the forefront, and we hope to assist you in any manner possible in doing so as a Green Tier partner.

Mike Griffin has been assigned as your single point of contact. He can be reached at 414-263-8554 or at mike.griffin@Wisconsin.gov. Please contact Mike with any questions concerning communications, required approvals, or technical assistance you may need. For your convenience the attached guidance outlines your benefits and important dates that affect your participation.

On behalf of the Wisconsin Department of Natural Resources, I am proud to extend this welcome to you. We are committed to working with you to build a customized relationship under the Green Tier Program. I am excited to embark on our new relationship and my staff is ready to assist as your business grows.

Sincerely,

/s/ Cathy Stepp

Cathy Stepp
Secretary

Attachments: Green Tier Commitment Outline
 Green Tier Logo Files and Guidance CD

Green Tier Commitment Outline for Fredman Bag – Milwaukee, WI

Approval Date – May 14, 2012

Commitment Outline Updated: 02-18-2020

The updates since participation started are:

- Functionally Equivalent EMS implemented
- Change of project coordinator
- Updated general content, format and links

I. Environmental Management Systems (EMS) & Audit Requirements

Your EMS must either be ISO-certified, or you must demonstrate that it is functionally equivalent. For information on how to demonstrate the functional equivalency of your EMS, please see: <https://dnr.wi.gov/files/PDF/pubs/co/C0503.pdf>

You have agreed to implement your EMS on or before **May 31, 2013**. Within 30 days please email your EMS implementation date to: GreenTier@Wisconsin.gov, your Project Coordinator, JenniferA.Birkholz@Wisconsin.gov and your Single Point of Contact (SPOC), Mike.Griffin@Wisconsin.gov.

To maintain good standing with Green Tier EMS requirements:

- A. On or before, **May 31, 2013** and every year after that, perform an environmental management system audit. The department recommends that your first audit be completed by a DNR-approved outside EMS auditor. The list of approved auditors can be found at: <https://dnr.wi.gov/topic/GreenTier/Auditors.html>
- B. On or before, **May 31, 2015** and every third year, this audit **must** be completed by a DNR-approved outside EMS auditor.

II. Provide an Annual Report

- A. **Annual Report Due Date** - We have mutually agreed that the deadline for your Green Tier annual report is **June 30, 2013** and annually thereafter. (Please feel free to discuss alternative reporting dates with your Project Coordinator, JenniferA.Birkholz@Wisconsin.gov should your needs change.)
- B. **Reporting on Environmental Performance Commitments:** Your first report should follow the annual report instructions provided below and should provide data on your progress toward meeting your environmental performance commitments laid out in your Green Tier application or your previous year's Green Tier annual report.
- C. **Annually**, you will need to report progress on the commitments that you have made. For more details about annual reports and metrics, see the annual report instructions provided on the website; <https://dnr.wi.gov/topic/GreenTier/ReportInstructions.html>
- D. Please submit Green Tier Annual Reports to: GreenTier@Wisconsin.gov and your Single Point of Contact (SPOC), Mike.Griffin@Wisconsin.gov.

III. Work toward Superior Environmental Performance

Implement environmental improvements that aim to achieve Superior Environmental Performance as defined in Green Tier law. This means environmental performance that results in measurable or discernible improvement in the quality of the air, water, land, or natural resources, or in the protection of the environment, beyond that which is achieved under environmental requirements. More information on Superior Environmental Performance can be found here:

<https://dnr.wi.gov/topic/GreenTier/SuperiorEnvironmentalPerformance.html>

IV. Green Tier - Tier 1 – DNR Commitments

- A. **Single Point of Contact (SPOC):** Your single point of contact or SPOC is your liaison to the department, answering your questions or making connections within DNR or with other experts. Your SPOC is: Mike Griffin, Phone 414-263-8554, Cell 414-750-0737, Mike.Griffin@Wisconsin.gov
- B. **Green Tier Logo:** Green Tier participants may use the Green Tier logo on stationery, promotional and educational materials related to your facility. Logo files as well as the Green Tier Style Guide with additional guidelines and information are available online at: <https://wi-dnr.widencollective.com/portals/nkc57xuv/GreenTierBranding>. Your Project Coordinator can provide you with the current access code.
- C. **Recognition:** Along with the certificate of recognition, the department will host a [participant web page](#) for easy reference. Participants should provide information and pictures on their environmental efforts to populate the webpage. We will also promote your successes throughout your tenure in Green Tier using a variety of DNR communication channels.
- D. **Project Coordinators:** You should also feel free to contact your Project Coordinator for Green Tier specific information. Project Coordinators provide support to SPOCs and participants providing reminders on Green Tier requirement dates and by promoting a participant's successes. Your project coordinator is: Jenni Birkholz, Phone 608-266-8226, Cell 608-514-2182, JenniferA.Birkholz@Wisconsin.gov.
- E. **Minimum Inspection Frequency:** When you have implemented an EMS, you are entitled to inspections at the lowest frequency permitted by the programs under law. The department will work with you to determine how this will work for you.
- F. **Deferred Civil Action:** You are entitled to Deferred Civil Enforcement as described in statutes (299.83(6m)(d)). If you discover a violation of an existing environmental requirement, you are entitled to protection from any civil penalties that the department might otherwise impose if you:
 - 1. Notify the department
 - 2. Provide a corrective action plan and documentation of your Environmental Management System (EMS) adjustments that ensure the violation will not happen again, and
 - 3. Correct the violations within 90 days

Notice: Collection of this information is authorized under s. 299.83 Wis. Stat. Participation in Green Tier and completion of this form are voluntary. Personal information collected on this form, including such data as your name, address, phone number, etc., will be used in the implementation of Green Tier and will be made broadly available under the Green Tier program. Information will also be made accessible to requesters under Wisconsin's Public Records Law (ss. 19.32 - 19.39, Wis. Stats.). If you need to request confidential treatment of any information in order to protect a trade secret, please contact a DNR representative prior to submitting this form. Applications must be considered complete by the DNR in order to be processed. For complete application instructions, see "Green Tier Application Instructions," publication number CO-501.

This application is for... (check one): Tier 1 Tier 2 (attach Letter of Intent to this form)

I. Applicant Information

Contact Name	Title		
Ken Hennen	Technical Services Manager		
Street Address	City	State	ZIP Code
5801 West Bender Court	Milwaukee	WI	53218
Telephone Number	Fax Number	E-mail Address	
(414) 462.9400	(414) 462.9409	khennen@fredmanbag.com	

II. Facility Information

Facility Name	County		
Fredman Bag			
Street Address	City	State	ZIP Code
5801 West Bender Court	Milwaukee	WI	53218
Mailing Address	City	State	ZIP Code
5801 West Bender Court	Milwaukee	WI	53218

Please provide all DNR Facility Identification numbers (FID #) that apply to the covered facility or activity.

241276750

III. Scope of Green Tier Participation (check one)

- This application covers all activities at the facility listed in Section II.
- This application covers all activities at more than one facility. For each facility to be covered under this application provide the information from Section II on a separate page labeled **Attachment 1**.
- This application **does not** cover all activities at every covered facility. Please describe the exact scope of activities and facilities to be covered in the program on a separate page labeled **Attachment 1**.

IV. Environmental Performance

Please provide the following information on a separate page labeled **Attachment 2**. Refer to the *Application Instructions* for definitions of environmental performance and superior environmental performance.

Tier 1 Applicants:

- Describe your past and current environmental performance with respect to each covered facility or activity included in this application. Within this attachment establish a baseline date against which future progress can be measured.
- Describe your future plans for enhancing the environment with respect to the same facilities/activities.

Tier 2 Applicants:

- Provide information demonstrating your record of superior environmental performance. Within this attachment establish a baseline date against which future progress can be measured.
- Describe the measures you propose to take to maintain and improve your superior environmental performance.

V. Environmental Management System (EMS)

- a. Have you implemented an EMS that is certified to the ISO 14001 standard? Yes No (circle one)
- b. Have you implemented an EMS that is functionally equivalent to ISO 14001? Yes No (circle one)

If you circled "No" for both questions, you are not eligible for Tier 2. Please proceed to Section VI only if you are applying for Tier 1.

If you circled "Yes" for either question, please provide a copy of the following documents labeled as **Attachment 3**:

- Proof of ISO 14001 certification OR functional equivalence (refer to *Application Instructions* for details)
- Environmental policy statement and scope statement
- Documented objectives and targets for the covered facilities/activities

VI. Public Notice/Stakeholder Identification

Please provide in a separate document labeled **Attachment 4** a list of stakeholders whom you know or expect will have a strong interest in your Green Tier application, as well as contact information for those stakeholders. This information will help DNR expedite the processing of your application. Tier 2 applicants must provide additional information about stakeholder involvement in a Letter of Intent. Refer to *Application Instructions* for details.

VII. Enforcement Record

Please review the Enforcement Record requirements described in the *Application Instructions* very carefully, and then check the appropriate box:

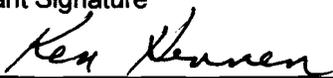
- All enforcement record requirements relevant to this application are satisfied.
- All enforcement record requirements relevant to this application are **not** currently satisfied. A waiver of the enforcement record requirements is requested.

If a waiver is requested, please provide information describing any requirements not met and a justification for the waiver request on a separate page labeled **Attachment 5**. Note that waivers will be granted only in exceptional circumstances.

VIII. Tier 1 Applicant Statement of Commitments

I commit with my signature to the following statements and certify that all information provided in this application is true and correct under penalty of law:

- Implement, within one year of the date of this application, an EMS for each covered facility or activity that is certified to the ISO 14001 standard or is functionally equivalent to ISO 14001 as determined by DNR.
- Conduct annual EMS audits, with every 3rd EMS audit performed by a DNR-approved outside environmental auditor.
- Submit to DNR an annual report on each EMS audit that is in compliance with s. 299.83(6m)(a), Wis. Stats.
- Submit to DNR an annual report on progress towards meeting objectives related to improved environmental performance for aspects regulated under chs. 29 to 31, 160, or 280 to 299, Wis. Stats., unregulated environmental aspects, or voluntary actions to restore, enhance, or preserve natural resources.

Applicant Signature 	Date Signed 27 Jun 2011
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IX. Tier 2 Applicant Statement of Commitments

I commit with my signature to the following statements and certify that all information provided in this application is true and correct under penalty of law:

- Conduct annual EMS audits performed by a DNR-approved outside environmental auditor.
- Conduct or have another person conduct an annual audit of compliance with environmental requirements that are applicable to the facilities and activities covered under Green Tier.
- Submit to DNR an annual report on each EMS audit that is in compliance with s. 299.83(6m)(a), Wis. Stats.
- Submit to DNR an annual report on each compliance audit that is in compliance with s. 299.83(6m)(a), Wis. Stats.

Applicant Signature	Date Signed
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X. For Department Use Only					
Date Received	Initials of Reviewer	Status	Date Returned to Applicant for Additional Information	Date Denied	Date Approved



Attachment 1

This application covers all activities at the facility listed in Section II of the Green Tier Application.

Fredman Bag Company
5801 West Bender Court
Milwaukee, WI 53218



Attachment 2

For over 120 years Fredman Bag has been committed to maintaining our environment. In fact, the company was founded on the process of recycling. Used burlap bags were bought back from farmers and feed mills to be repaired then resold again and again. As the company has grown and evolved that same commitment has remained as a top priority.

With the transition to printed polyethylene bags came the need for capture and destruction of VOC to prevent emission to the outside air. In 1985 a catalytic incinerator was installed with a minimum overall efficiency of 70%. This was in full operation until a Regenerative Thermal Oxidizer (RTO) replaced it in 2005, which increased efficiency to a minimum of 75% with lower operating costs.

In 2006, overall production efficiencies were improved to the point where the 7-day workweek was replaced with a 5-day workweek with little to no impact on production lead times or delivery.

Other initiatives include:

- Inefficient warehouse bay lighting and older T12 fluorescent fixtures were replaced by T8 units from Orion Systems in entire west section and approximately 50% of east production area.
- Variable speed drives were installed on the overhead roof vents to be adjusted as converting bag machines were idled.
- Closed loop on chill water used on printing presses.
- Closed loop on compressed air used throughout the facility
- Reduction of scrap, recycling of scrap polyethylene.
- Ink and solvent laden rags sent out to for cleaning and reuse.
- Solvent used in clean-up operations is recycled.
- Pallets are sent out to be repaired/recycled.
- Upgraded doctor blade chambers on 6-color press to use less ink and lower fugitive VOC emissions.

We continue to look for more efficient practices in our production and ways to reduce our scrap. A separate gas meter was installed on the RTO for the purpose of determining actual gas use on this unit. Using this data, we will determine if it is more efficient to idle the unit during weekend hours or shut it down completely and start up again at the start of production. We also continue to assess our electrical needs to reduce our consumption.



By the end of 2011 we expect to do the following:

- Reduce Glycol Ether PM use by 50% (from 25000 Lbs to 12500).
- Replace 142 floor-washing solvent with water-based solvent blend.
- Add insulation to the roof underlayment.
- Replace hot water heater with higher efficiency unit.
- Replace six more light fixtures in laminator area.
- Add automatic controls on the variable speed drives for the overhead exhaust.
- Add corrugated to the recycle program.
- Add zipper string plastic spools to the recycle program.