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English

Z-ECO

ZIEGLER PAPER MILL

Environmental Report 2008

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ZIEGLER PAPER IMPROVES ENVIRONMENTAL PERFORMANCE

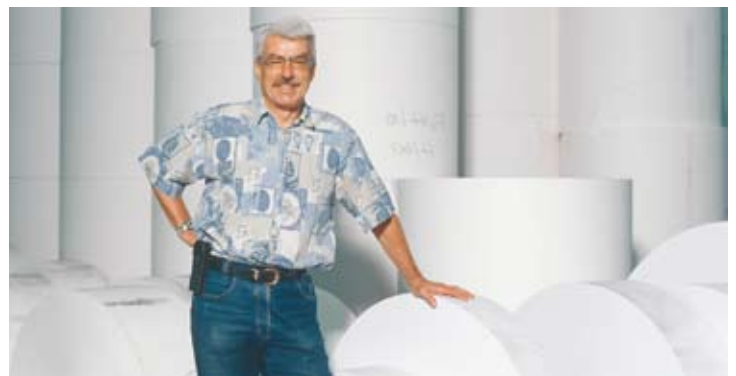
You are reading the sixth edition of Z-ECO, in which Ziegler Paper Mill informs its external partners about its environmentally relevant activities and achievements during 2008. The year proved very difficult economically for the paper industry, too, with the cost of both raw materials and energy rising during the second half of the year. These difficulties led to problematic margins and a number of mills were even compelled to close their doors in certain market segments with overcapacity, where it was not possible to increase the price of paper products sufficiently. Contrary to the trend for the sector as a whole, we at Ziegler enjoyed such positive utilisation of resources during the course of the year that we had to cancel the two-week overhaul scheduled for the summer in order to be able to supply all our customers. The result was that we manufactured and sold 4 % more paper overall in 2008 than in the previous year. Given this situation, it even proved possible for us to make adjustments to our prices in certain areas so that we can be satisfied with our results for the year.

We were also successful in improving our achievements on the environmental front. We are particularly pleased to have succeeded in effectively halving the volume of solid materials in our wastewater. At the same time, it also proved possible to bring about a significant reduction in the amount of paper sludge produced. This shows that the new wastewater treatment plant that went online in 2007 is functioning as it should and that the volume of solid pollutants in our wastewater resulting from the production process has been reduced considerably. The gratifying side effect of this is that we re-

tained some 115 tonnes more of reusable materials from the production process than in the year before.

It also proved possible to maintain the previous year's extremely good levels in respect of specific energy and water consumption to a very large extent. But the higher the performance we achieve, the less room there remains for additional improvements.

On the basis of the agreed targets for a reduction in CO₂ emissions by 2010 that had been submitted and approved, the Swiss government for the first time in the year under review allocated a CO₂ quota to us in accordance with the new legislation. We only needed to take partial advantage of this and therefore remained exempt from the CO₂ levy as a result of the improvements in respect of CO₂ emissions we had previously effected. This meant that we had some of the quota left over which we were able to use as we saw fit.



Dr. Reinhard Jäger, Production Manager and Head of the Environmental Management System

1. ZIEGLER AT A GLANCE

Ziegler Paper Mill produces premium-quality wood-free fine papers for the printing industry and customised specialty papers for industrial processing. Its headquarters and production facilities are located in Grellingen near Basel, Switzerland.

As an independent specialty paper manufacturer of manageable size and with short decision-making paths, we are able to react swiftly and flexibly to customer requirements. Despite stiff competition, we continue to be successful in the marketplace thanks to our consistent niche policy, individual customer service and range of comprehensive solutions.

Our premium products are sold in the following countries (previous year's sales figures in brackets): Switzerland 48 %

(47 %), Germany 19 % (16 %), United Kingdom 7 % (8 %), USA 5 % (7 %), Austria 4 % (4 %), France 4 % (3 %), Italy 3 % (4 %) and Holland 3 % (3 %). Other markets account for approx. 7 % (8 %) of sales.

Our domestic market of Switzerland continues to account for the lion's share of sales and will continue to do so in the future, too. Nevertheless, export markets are becoming increasingly important for Ziegler Paper, particularly for our specialties. In the USA, we have been represented by our own sales company since 2001, while in Europe and Asia we work together with international trading companies. Foreign exchange developments during the year under review led to a fall-off in business in the USA and the United Kingdom.

FACTS 2008	
Business	Production of premium-quality, wood-free fine papers and specialties
Product lines	Corporate Design, Natural Design, CAD/Office, Specialties
Plant & equipment	Paper machine PM 3 (last overhaul 2004), slitter-winder, large-format sheet cutter, small-format sheet cutter; central power plant with gas turbine / waste heat boiler (combined heat and power plant)
Annual output	72 500 tonnes (sales volume)
Wire width PM 3	331 cm (trimmed)
Weight range	40–400 gsm
Quality assurance system	ISO 9001:2000, Registration No. 08-342-047 (03.04.2008–02.04.2011)
Environmental quality system	ISO 14001:2004, Registration No. 08-342-047 (03.04.2008–02.04.2011)
Work safety system	OHSAS 18001:2007, Registration No. 08-342-047 (03.04.2008–02.04.2011)
FSC certificate	FSC-STD-40-004 (1.0), Registration No. SQS-COC-24310 (12.09.2005–11.09.2010)
Raw stock	Market pulps with FSC certificate and from other internationally recognised wood certification programmes. Transported exclusively by ship and rail.
Water	Own ground water well; high level of closed-loop recirculation
Workforce	182 people working days or shift work
Sales	approx. CHF 127 million
Investments	approx. CHF 3.0 million
Legal form	Family-owned corporation (AG) with share capital of CHF 1 million
Year established	1861

PRODUCTION VOLUME	UNIT	2008	2007	DIFFERENCE FROM PREVIOUS YEAR
Gross production	tonnes	85 050	82 641	+ 2.9 %
Net production	tonnes	72 516	69 737	+ 4.0 %
Waste	tonnes	12 534	12 904	- 2.9 %

The increase in production volume over the previous year is the result of our not shutting down production in the summer as scheduled due to customer demand.

2. USE OF RESOURCES

The specific consumption of fresh water, raw materials and energy provides a measure for the efficiency of our utilisation of resources.

2.1 Fresh water

Fresh water usage during the year under review developed almost exactly in line with the increase in our production volume

and has stabilised at a low level. Over the past five years, we have succeeded in reducing our absolute consumption of fresh water by 7.5 %, despite the fact that gross production has increased by more than 25 %. This results in no less than 27 % reduction in specific fresh water usage compared with the level five years ago. Nevertheless, there remains room for improvement, albeit no longer of the same magnitude. Fresh water usage has a high correlation with the resultant volume of wastewater; the difference between the two is primarily due to the water that evaporates in the dryer section of the paper machine. Every improvement in the usage of fresh water therefore leads to a corresponding reduction in the volume of wastewater.

	UNIT	2008	2007	DIFFERENCE FROM PREVIOUS YEAR
Fresh water usage	m ³	397 279	387 701	+ 2.5 %
Specific fresh water usage	l/kg paper gross	4.67	4.69	- 0.4 %

2.2 Raw materials

During the year under review, 1.027 kg of raw materials was used to produce 1 kg of paper sold (without water component) compared with 1.028 kg the year before. This confirms a high level of efficiency in our usage of raw materials.

The difference in absolute figures is roughly equivalent to the reduction in fibrous and filler materials in the wastewater (paper sludge and solids). In any case, calculating all raw materials in bone dry terms always involves a degree of uncertainty due to lack of precision in respect of specific water content.

	UNIT	2008	2007	DIFFERENCE FROM PREVIOUS YEAR
Specific raw material usage	l kg bone dry /kg paper bone dry	1.027	1.028	- 0.1 %

2.3 Energy

Energy supply at Ziegler Paper Mill is based on a combined heat and power plant with a gas turbine. Electricity is generated thermally using co-generation with our gas turbine and any extra power required is bought from the public grid. The waste heat from the gas turbine is used together with additional heat from a natural-gas furnace in order to produce steam for the paper machine. As the gas consumption shown in this report covers both the heating needs of the paper machine as well as power requirements for the thermal generation of electricity, the total of energy needed is made up of the sum of purchased gas and purchased electricity. During the year covered by the report, power consumption increased by 4.5 % and specific power consumption by 1.5 %.

As there were no significant changes to plant and processes, it is not possible to localise the reason for this higher consumption exactly. Most probably, the slight increase in power consumption is the result of refining pulp.

Specific gas consumption was exactly the same as for the year before, although absolute gas consumption rose by 2.9 % due to the higher production volume. We were unable to effect the improvement we were originally planning here by overhauling the waste heat boiler owing to lack of time.

Although we managed to reduce specific steam consumption by 1%, no clear trends can be seen.

Since we used more electrical power, the figure for total specific energy consumption was 0.5 % worse than last year.

	UNIT	2008	2007	DIFFERENCE FROM PREVIOUS YEAR
Thermal power production	MWh	31 106	30 538	+ 1.9 %
Power consumption	MWh	40 404	38 651	+ 4.5 %
Specific power consumption	kWh/kg paper gross	0.475	0.468	+ 1.5 %
Gas consumption	MWh	154 338	150 026	+ 2.9 %
Specific gas consumption	kWh/kg paper gross	1.815	1.815	0.0 %
Specific steam consumption	kg steam/kg paper gross	1.769	1.786	- 1.0 %
Total specific energy consumption (purchased electricity + gas)	kWh/kg paper gross	1.924	1.914	+ 0.5 %

3. WASTE EMISSIONS

Every industrial activity generates waste products and paper making at Ziegler Paper Mill is no exception. With our certification in compliance with ISO 14000, however, we have committed ourselves to a sustainable reduction in our emissions through a process of continuing improvement.

3.1 Wastewater

The fresh water obtained from the company's own groundwater catchment system is used over and over again thanks to

in-house recycling. After having been used repeatedly, the water is cleaned in the mill's own mechanical treatment plant. The figures show that this treatment plant is functioning very well, as the volume of solids in the wastewater fed to the communal treatment system was less than half the volume for the previous year. The reduction in this area has amounted to almost 75 % in just two years. The solids content of the exiting wastewater amounted to 91 mg/l (previous year: 192 mg/l) and was therefore well below the permitted level of 200 mg/l (as per wastewater agreement)

	UNIT	2008	2007	DIFFERENCE FROM PREVIOUS YEAR
Wastewater	m ³	287 361	290 043	- 0.9 %
Specific wastewater	l/kg paper gross	3.38	3.51	- 3.7 %
Waste solids	kg	26 270	55 670	- 52.8 %
Specific waste solids	g/kg paper gross	0.309	0.674	- 54.2 %

Although wastewater volume remained virtually constant compared with the year-back level (-0.9 %), there was a further reduction of 3.7 % in specific wastewater which resulted in an exemplary 3.4 l/kg paper. In 2008 too, the Cantonal Office of Environmental Protection and Energy once again took three random samples to check the composition of our wastewater and found in all cases that our waste treatment plant and the composition of the wastewater samples conformed to requirements. Before the mechanically clarified wastewater is returned to the ecosystem through surface water, it is also treated biologically at the municipal treatment plant. The cleaning efficiency of this biological treatment plant was ensured at all times.

3.2 Waste air

Significant quantities of waste air are produced by

- Ventilation and air-extraction of the paper machine and manufacturing halls:

Random samples taken from the air extracted from the paper machine have shown that although the presence of organic pollutants resulting from pulp and other raw materials can be detected they are irrelevant as an emission.

- Generation of electricity and heat in the central power plant through the combustion of natural gas:

This on the other hand is very relevant as a source of emissions. As the central power plant demonstrates very constant emission values when in continuous operation, emissions are as a rule measured by a certified company on the authority of the relevant monitoring department (Basel Air Pollution Control Office) every two years or when changes have been made to the power plant. These measurements were performed on 31 January 2008 and written confirmation given of full compliance with all appropriate limits.

When talking about the waste air from our central power plant, a distinction must be made between

- the emission of the air pollutants carbon monoxide (CO), sulphur dioxide (SO₂), nitrogen oxides (NO_x) and soot, all of which tend to have a regional impact and
- the release of the greenhouse gas CO₂ from fossil fuels, which has a global impact.

3.2.1 Air pollutants CO, SO₂, NO_x, soot

Monitoring report of 31 January 2008: all limits complied with.

3.2.2 Release of fossil CO₂

Heat and electricity are generated at Ziegler Paper Mill by burning natural gas. This produces CO₂, a gas which has a major impact on the environment. As alternative technologies that do not depend on fossil fuels are not likely to be available in the near future, Ziegler Paper Mill relies on the solution that is best for the environment at the present time: a natural-gas-based combined heat and power plant with a gas turbine for generating electricity and a waste heat boiler for producing steam with emphasis on the best possible energy efficiency.

The release of CO₂ is one of the most important environmental issues in the area of climate protection. The Swiss government has passed legislation governing CO₂ emissions aimed at reducing by 2010 fossil fuel emissions of CO₂ resulting from energy consumption by 15 % in absolute figures compared with 1990 levels. This should be achieved by means of voluntary agreements on the part of users of fossil fuels aimed at reducing their emissions to a set target. Users that do not enter into these agreements or do not reach the targets set have to pay a levy in respect of CO₂ from fossil fuels.

In 2007, Ziegler Paper submitted its company-specific reduction goals for scrutiny by the monitoring system of the Energy Agency for Industry (EnAW). In December 2007, the government accepted in writing that the reduction targets complied with legal requirements.

After the CO₂ legislation came into force, the Federal Office for the Environment for the first time allocated CO₂ emission credits for the year 2008. These are based on the CO₂ intensity shown by the EnAW's monitoring system in comparison with the agreed CO₂ intensity target. While these figures are being calculated individually for 2008, 2009 and 2010, the allocation of credits for 2011 and 2012 will be based on those for 2010. Cumulative CO₂ pollution for 2008–2012 must not exceed cumulative emission credits for the same period. Should this be the case, any missing credits must be purchased; whereas a positive balance may be sold or carried forward.

As it was not possible to achieve the planned reduction in gas consumption due to postponement of the overhaul to the waste heat boiler, a slightly higher CO₂ intensity was registered than in the previous year. But since this was more than 15 % better than the targeted figure, we enjoyed a positive balance of CO₂ credits in excess of 5 500 tonnes of CO₂. This amount is being carried forward to the following year since Ziegler Paper has decided against selling its credits.

STATUS COMPLIANCE CO2 REQUIREMENTS (AS PER MONITORING BY ENAW)

	UNIT	2000 (START)	2007	2008
CO ₂ output	tonnes (CO ₂ /year)	27 992	29 705	30 559
Cumulative reduction in CO ₂ output	tonnes (CO ₂ /year)	0	6 171	6 177
CO ₂ intensity (ACTUAL)	%	100	82.80	83.18
CO ₂ intensity (TARGET)	%	100	98.58	98.39
Credits	tonnes (CO ₂ /year)	27 992*	35 367*	36 144
Remaining credits	tonnes (CO ₂ /year)	0	5 662*	5 585

*) Theoretical values as credits allocated in 2008 for first time.

3.3 Solid waste

Our waste management programme is governed by the motto: "Prevent – recycle – re-use!"

- Virtually all scrap generated during paper production and finishing is recycled internally and forms a component in all our fibre recipes.
- The mechanical treatment plant also produces waste in the form of paper sludge, which consists primarily of fibres and fillers. As this represents a loss of valuable raw materials, it is our constant endeavour to minimise this loss by means of appropriate process controls. The year under review saw the production of 280 tonnes of paper sludge bone dry compared with 366 tonnes for the previous year (average dryness content approx. 50%). This means that we succeeded in reducing paper sludge by more than 23% over the year before, when reduction had already amounted to 20%. Since 2007, the paper sludge we produce has been fermented to create valuable, environmentally-neutral biogas in a newly-opened plant located near the mill.

- Waste from packing paper, cardboard, printed matter and spool cores is recycled externally as waste paper. Waste stretch film is also recycled externally.
- Wood waste from shipping and packaging is treated externally in a CO₂-neutral thermal process.
- The vast majority of waste materials from maintaining the infrastructure are separated, collected and recycled externally.
- Our paper products, which make an essential contribution to the recovered fibre for maintaining the waste paper fibre cycle, can be completely recycled after use by our customers.
- Packaging materials from our paper shipments can also be dealt with by our customers using the same means of recycling and re-use cited above.

3.4 Noise

In the year covered by this report, no complaints were received from local residents. Noise emission limits along the perimeter of the mill site were complied with in full.



4. ACCIDENTS

There were no accidents or other incidents that might have resulted in contamination of the soil or water (River Birs, groundwater) in the year under review.

5. POLLUTION AND WORK SAFETY

In compliance with our legal obligations, but also out of respect for our employees and their health, we ensure the best possible standards of work safety and protection against pollution within the mill.

5.1 Protection against pollution

There is some need for action in respect of anti-pollution measures since formaldehyde contained in the coating hardener (coaters and calenders) can give rise to markedly offensive odours. Measurement of specific concentrations by a specialised laboratory has shown that the concentrations of formaldehyde in the various workplaces are well below the maximum permissible values for such pollutants in the workplace and therefore represent no health risk to staff. Nevertheless, we are intending to replace the coating hardener that we currently use with an alternative product that contains no formaldehyde.

5.2 Work safety

2008 represented a milestone in work safety: when our quality and environmental management systems were re-certified,

work safety in compliance with OHSAS 18001 was for the first time integrated into the combined QES system (quality/environment/work safety). An internal training session was also staged.

- As is the case every year, an inspection was performed by the Swiss Accident Insurance Fund (SUVA).
- A basic course in work safety was held for all new members of staff.
- There were also courses held for fork-lift drivers in accordance with our work-safety programme.
- Training for our shift workers presented the responsibilities of staff and superiors in respect of safety installations.
- There was also training in respect of the safe handling of chemicals, which had been modified as a result of the new certification as per ISO 14 000.
- Poster campaigns on the subject of safety with documentation material from SUVA were continued.
- In addition, a potentially dangerous feed on the slitter-winder was identified and eliminated by means of modification to the control system.

Unfortunately, the number of accidents suffered by staff rose slightly over the previous year's (very good) figures. However, since the amount of time lost in consequence remained virtually the same, the severity of these accidents was less than the year before, i.e. we had a larger number of inconsequential accidents. No trend is evident as to the cause of these accidents.

	UNIT	2008	2007	2006	2005	2004
Industrial accidents	Number	14	10	22	14	17
Non-work-related accidents	Number	19	13	17	29	13
Time lost due to industrial accidents	%	0.37	0.36	0.89	0.17	0.34
Time lost due to non-work-related accidents	%	0.24	0.26	0.59	0.60	0.11

6. AUDITS AND LEGAL REQUIREMENTS

- In April 2008, the SWISS TS performed a new audit which integrated the work safety management system OHSAS 18001:2007 into the combined quality management system ISO 9001:2004 and environmental management system ISO 14001:2004.
- In September 2008, the SQS, CH-3052 Zollikofen, carried out a maintenance audit for the FSC-STD-40-004 (1.0) chain-of-custody standard. This means that Ziegler Paper continues to be authorised to supply FSC products bearing the FSC label in accordance with the mixed-credit system. These products have been subjected to thorough monitoring

and come from forests run in compliance with the principles and criteria of the Forest Stewardship Council (FSC). The new feature is that all Ziegler products are gathered together in one product group, which makes it possible in principle to supply every category of Ziegler paper with a FSC certificate.

- In addition, one of our customers performed a supplier audit at the Ziegler mill in October 2008 (in the place of an internal audit), which included the environmental management system (which the audit report described as exemplary).
- No relevant changes came into effect in respect of legal stipulations.

7. ECOLOGICAL BALANCE SHEET

In our environmental reports to date, we have provided information on our environmental performance in respect of the utilisation of raw materials and resources to produce paper ready for sale. However, the complete environmental impact of a kilogramme of Ziegler paper is probably more important as far as the consumer is concerned. This includes all the foregoing stages and processes that are involved. An overall evaluation of this kind is also extremely valuable for Ziegler Paper Mill itself. For this reason, specialised environmental consultants drew up the first ecological balance sheet to give details of the environmental impact and carbon footprint of the paper manufactured by Ziegler. To help our readers understand the results, we are including the following details:

- Data used: Ziegler consumption statistics for the year 2007.
- System limits: all upstream processes from the origin of the raw materials through to the processing stages, including transport to Ziegler’s dispatch ramp.

- Methodology: EMIS 5.3 ecological balance sheet software. All upstream processes are based on standard data from ECOINVENT 1.3 (2006).
- Assessment method for environmental impact: in accordance with the UPB 97 method of the Swiss Agency for the Environment, Forests and Landscape. So-called ecopoints are assigned and totalled as per a distance-to-target method. This method also takes into account Switzerland’s official policy aims for the environment. The forestry evaluation is based on Ecoindicator 95, a method proposed by companies from the paper industry.
- Assessment method for carbon footprint: in accordance with the IPCC (Intergovernmental Panel on Climate Change). The most significant gases relevant to the climate are taken into account in respect of their effects over a period of 100 years and converted into CO₂ equivalents.

	ENVIRONMENTAL IMPACT Ecopoints/kg paper	CARBON FOOTPRINT kg CO ₂ equivalent/kg paper
Total (100 %)	4 339	1.40
Ziegler paper (%)	4.7	40.4
Fillers (%)	1.3	12.0
Other raw materials (%)	4.8	8.3
Pulp (%)	89.2	39.3

This ecological balance sheet showed that the direct impact of Ziegler papers on the environment is less than 5%. On the other hand, virtually 90 % comes from pulp purchased from external suppliers. The study also showed that even though the various sorts of pulp used by Ziegler all come from controlled forestry operations there are very large differences between their impact on the environment – up to as much as a factor of 7.8 between the best and poorest pulp. Plantation pulps, even those bearing the FSC label, come off markedly worse than pulp from waste wood and wood residues from natural forests.

If only the carbon footprint is considered, however, a very different picture emerges. Some 40 % of CO₂ pollution from our papers comes from the manufacturing process in the Ziegler mill, with approximately the same amount resulting from purchased pulp. The remaining 20% is due to purchased raw materials, particularly the calcium carbonate used as a filler.

A certain proportion of the CO₂ comes from the transport

from the pulp mill to the Ziegler paper mill. On average, European pulp is the cause of fewer CO₂ emissions than pulp from overseas. The factor between the best and worst pulp here is 2.5.

The ecological balance sheet makes it possible for Ziegler Paper to draw the following conclusions:

- By far the greatest potential for reducing environmental impact is in the production of the pulp used, although the choice of pulp is limited by both technical and economic factors.
- The actual production process of the paper is a major factor in CO₂ pollution. All measures that contribute towards improving energy efficiency are also important for fulfilling the targeted reduction in CO₂ output we have contractually agreed to and for improving our products’ carbon footprint. Suitable selection of the pulp we use can make a significant contribution in this respect. The use of precipitated calcium carbonate as a filler is also a factor that should not be ignored.

8. ACHIEVEMENT OF GOALS

The Management had set the following concrete environmental goals for 2008:

- The reduction of specific gas consumption by 3 % over the previous year after the overhaul of the waste heat boiler (see also section 3.2.2).

Status: It was impossible to overhaul the boiler due to the postponement of the scheduled summer plant shut-down. As a result, this goal is being put off until 2009.

- The reduction of specific solids loss (as the sum of paper sludge and solids in our wastewater) by 15 % over the previous year.

Status: For the year under review, solids loss came to 3.6 kg/tonne paper compared with 5.1 kg/tonne paper for the year before. This reduction of more than 29% went far beyond the goal we had set.

- Quoting on our website paper-specific environmental figures that people frequently ask about (carbon footprint, paper profile, etc.). These figures are calculated periodically in accordance with the relevant guidelines and also provide ecological information concerning the raw materials that are used by Ziegler in the manufacture of its papers.

Status: The compilation of our first ecological balance sheet (see section 7) means that all these figures are available.

9. FUTURE OBJECTIVES

We have set the following new environmental goal for 2009:

- The reduction of specific gas consumption by 3 % in comparison with the year-back level after overhaul of the waste heat boiler (see also section 3.2.2).





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