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English

Z-ECO

ZIEGLER PAPER MILL

Environmental Report 2009

ZIEGLER PAPIER

www.zieglerpapier.com

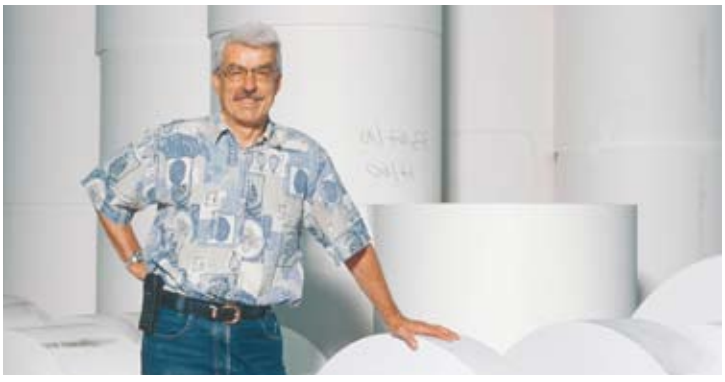
DEAR READER

You have before you the seventh edition of Z-ECO, in which Ziegler Paper Mill informs its external partners about its environmentally relevant activities and achievements during 2009.

In many respects, 2009 was a turbulent and eventful year for Ziegler. One central event was the sale of the company by the Ziegler family, who had run the mill for 5 generations, to the Kuttler Frey family. Thanks to the orderly transition and the continued presence on the board of directors of the former managers in an advisory function, the transfer of ownership was achieved with no great problems. The new proprietors enjoy the confidence of the staff and can continue to count on the support of a highly committed workforce.

Turbulence was an inescapable characteristic of the markets during the year under review. From the very outset, a real slump in demand for our products made itself felt, which lasted into the autumn. For this reason, it proved necessary to run down capacity by means of additional unplanned shutdowns of production. By the end of the year, this added up to a reduction of some 15% in the amount of paper supplied to our customers. As the same period saw the price of raw materials, in particular that of pulp, sink considerably, financial results remained unaffected despite the lower production volume.

The effect on our environmental performance, however, was a different matter. Due to the considerably higher number of periods when machinery was shut down and then started up again, coupled with unfavourable batch sizes and production sequences, there was a deterioration in virtually all areas in comparison with the previous year, particularly in respect of specific values. Nevertheless, it must be stated that we continue to operate at a comparatively very high level. The new year has started off very positively with regard to plant utilisation and we are optimistic of repeating the good results attained in 2008 with the mill running at full capacity once again.



Dr. Reinhard Jäger, Mill 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. The headquarters and production facilities of this independent fine paper manufacturer are located in Grellingen near Basel, Switzerland.

Our premium products are sold in the following countries (previous year's sales figures in brackets): Switzerland 48% (48%), Germany 19% (19%), United Kingdom 8% (7%), USA 4% (5%), Austria 4% (4%), Italy 4% (3%), Holland 3% (3%) and France 4% (4%). Other markets account for approximately 6% (7%) of sales. The country-by-country breakdown for 2009 shows scarcely any change over the previous year. 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. 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.

FACTS 2009

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	62 200 tonnes (sales volume)
Wire width PM 3	331 cm (trimmed)
Weight range	40 – 400 g/m^2
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	200 people working days or shift work
Sales	approx. CHF 103 million
Investments	approx. CHF 4.7 million
Legal form	Family-owned corporation (AG) with share capital of CHF 1 million
Year established	1861

PRODUCTION VOLUME	UNIT	2006	2007	2008	2009	DIFFERENCE FROM PREVIOUS YEAR
Gross production	tonnes	78 464	82 641	85 050	76 760	- 9.7 %
Net production	tonnes	65 513	69 737	72 516	62 246	- 14.2 %
Waste	tonnes	12 951	12 904	12 534	14 514	+ 15.8 %

During the course of 2009, almost 15% less production volume was supplied to customers in comparison with the previous year. These lower sales necessitated additional shut-downs of production machinery over the course of the year. The volume of waste was disproportionately high, partly because of the shut-downs, but partly also because of the lines produced and the size of the batches manufactured.

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

Although fresh water usage during the year under review fell by 2.4%, this was considerably less sharp than the decrease in the volume of paper produced. As a result of this, specific consumption of fresh water rose. As shutting down and starting up production machinery are particularly water-intensive, these impact especially strongly on fresh water usage.

	UNIT	2006	2007	2008	2009	DIFFERENCE FROM PREVIOUS YEAR
Fresh water usage	m^3	404 198	387 701	397 279	387 893	- 2.4 %
Specific fresh water usage	l/kg paper gross	5.15	4.69	4.67	5.05	+ 8.1 %

2.2 Raw materials

During the year under review, 1.029 kg of raw materials was used to produce 1 kg of paper sold (without water component) compared with 1.027 kg the year before. This confirms a high level of efficiency in our usage of raw materials. It should be noted, however, that 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. Nevertheless, a modest increase in comparison with the previous year is plausible, since the volume of both paper sludge and solids in our wastewater climbed slightly.

	UNIT	2006	2007	2008	2009	DIFFERENCE FROM PREVIOUS YEAR
Specific raw material usage	kg bone dry /kg paper bone dry	1.035	1.028	1.027	1.029	+ 0.2 %

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 the gas turbine. Any extra electricity required is purchased from the public grid. The waste heat from the gas turbine is used together with additional heat from a natural-gas furnace 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 under review, power consumption fell by around 9% in line with the smaller volume of paper produced. Specific power consumption, however, was only marginally higher than in the previous year since relatively little power is consumed when production is at a standstill.

As the gas turbine is generally shut down when the production machinery is not running, the amount of electricity generated thermally was lower than the year before. The situation in respect of gas consumption is similar to that of electricity consumption: as a result of the periods when production machinery was shut down, absolute gas consumption was approximately 8% lower than the previous year, while specific gas consumption was a good 2% higher. In any case, repeatedly shutting down the paper machine has less of a negative impact on energy than on fresh water and wastewater.

It is interesting to note that specific steam consumption, on the other hand, tended to decrease somewhat. This points to the fact that less water had to be vaporised in the dryer section per tonne of paper produced. One factor contributing towards this result was certainly the system for recovering heat from the central power plant which became operational in the summer (see “ecogoal” section).

Total specific energy consumption rose slightly over the year-back level by 1.6%, as both specific electricity and specific gas consumption increased as a result of production machinery being additionally shut down over the year.

	UNIT	2006	2007	2008	2009	DIFFERENCE FROM PREVIOUS YEAR
Thermal power production	MWh	29 632	30 538	31 106	28 938	- 7.0 %
Power consumption	MWh	36 626	38 651	40 404	36 703	- 9.2 %
Specific power consumption	kWh/kg paper gross	0.467	0.468	0.475	0.478	+ 0.6 %
Gas consumption	MWh	149 755	150 026	154 338	142 237	- 7.8 %
Specific gas consumption	kWh/kg paper gross	1.909	1.815	1.815	1.853	+ 2.1 %
Specific steam consumption	kg steam/kg paper gross	1.887	1.786	1.769	1.756	- 0.7 %
Total specific energy consumption (purchased electricity + gas)	kWh/kg paper gross	1.997	1.914	1.924	1.954	+ 1.6 %

3. WASTE EMISSIONS

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 which went into operation in 2007. In this plant, suspended solids are flocculated, almost totally removed by filtration and discharged as compacted paper sludge.

The repeated shutdowns during the course of the year also had an impact on wastewater; despite the considerably lower gross production volume, the absolute amount of wastewater was practically the same as for the previous year, which resulted in a marked deterioration in terms of specific values. The same is true of waste solids. However, the runnability of the paper machine also affects the volume of waste solids, since increases in the number of breaks in the web and the resultant time the machine is idle lead to a higher loss of fibres, which has an effect on the sludge produced. In 2009, the solids content of exiting wastewater amounted to 110 mg/l (previous year: 91 mg/l) and was therefore still well below the permitted level of 200 mg/l as per our wastewater agreement.

	UNIT	2006	2007	2008	2009	DIFFERENCE FROM PREVIOUS YEAR
Wastewater	m^3	321 635	290 043	287 361	287 593	+ 0.1%
Specific wastewater	l/kg paper gross	4.10	3.51	3.38	3.75	+ 10.9%
Waste solids	kg	98 231	55 670	26 270	26 880	+ 2.3%
Specific waste solids	g/kg paper gross	1.252	0.674	0.309	0.350	+ 13.3%

During 2009, too, the Office of Environmental Protection and Energy once again took three random samples to check the composition of our wastewater. In all cases, our waste treatment plant and the composition of the wastewater samples conformed to requirements.

Before the clarified wastewater is returned to the ecosystem through surface water, it is also treated biologically at the ARA municipal treatment plant in Birsfelden.

3.2 Waste air

Significant quantities of waste air are produced by

- Ventilation and air-extraction of the paper machine and manufacturing halls: Although the presence of organic pollutants resulting from pulp and other raw materials can be detected, they are irrelevant as an emission. The fact that the waste air escaping into the atmosphere is visible is caused by the presence of condensed steam in the waste air.
- Generation of electricity and heat in the central power plant through the combustion of natural gas:

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 (SO_2), nitrogen oxides (NO_x) and soot, all of which tend to have a regional impact and
- the release of the greenhouse gas CO_2 from fossil fuels, which has a global impact.

Unlike the paper machine, the central power plant is very relevant as a source of emissions. For this reason, it is inspected by an official monitoring authority (Basel Air Pollution Control Office). After the overhaul of the boiler used for recovering heat from the waste air from the central power plant, waste emissions were measured on 21.12.2009 by a certified company on behalf of the authorities and written confirmation was provided that all appropriate limits were complied with in full.

3.2.1 Air pollutants CO, SO_2, NO_x, soot

Monitoring report of 21.12.2009: all limits complied with.

3.2.2 Release of fossil CO_2

Heat and electricity are generated in the Ziegler mill by burning natural gas. This produces CO_2, 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 CO_2 is one of the most important environmental issues in the area of climate protection. For this reason, the Swiss government has passed legislation governing CO_2 emissions which requires that by 2010 fossil fuel emissions of CO_2 resulting from energy generation are reduced by 15% in absolute figures compared with the 1990 level. 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 CO_2 from fossil fuels.

Ziegler Paper was therefore actively involved from the outset in developing an industry-wide solution for the Swiss paper manufacturing sector. Under the leadership of the Energy Agency for Industry (EnAW), a Swiss organisation that was founded in 1999, reduction targets were formulated throughout the industry. These targets are shown in the table below; only the targets in respect of CO_2 output and CO_2 intensity are legally relevant for exemption from the CO_2 levy.

Although, for the reasons given in relation to energy, CO_2 intensity and energy efficiency were poorer than for the previous year, in both categories we are still clearly under the target limits for 2009 and the agreed targets for 2010.

As far as absolute CO_2 output is concerned, we are also markedly under the target output for 2009 and 2010, since in the course of the year we used less gas as a result of machinery shut-downs.

REDUCTION TARGETS FOR ZIEGLER PAPER MILL [AS PER ENAW CALCULATION MODEL WITHOUT CORRECTION FOR COMBINED HEAT AND POWER GENERATION]

	STATUS 2000	ACTUAL 2008	TARGET 2009	ACTUAL 2009	AGREED TARGET 2010
CO_2 output in t/a	27 992	30 559	29 065	28 163	29 184
CO_2 intensity[1] in %	100.0	83.2	98.2	87.8	98.0
Energy efficiency[2] in %	100.0	118.4	103.6	113.0	104.0

[1]) 100 x CO_2 output / (CO_2 output + reduction in CO_2 output [2]) 100 x (TEC + reduction in TEC) / TEC; TEC = total energy consumption

3.3 Solid waste

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

- The major waste product in paper production and finishing is the manufacturer's own paper scrap. Virtually all our scrap 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. This sludge consists primarily of fibres and fillers. Since it 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 316 tonnes of paper sludge bone dry compared with 280 tonnes for the previous year (with an average dryness content of approx. 45%). Since 2007, the paper sludge we produce has been fermented to create valuable, environmentally-neutral biogas in a biogas 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.
- Waste materials from maintaining the infrastructure are collected, separated and the vast majority recycled externally.
- Our paper products can be completely recycled after use by our customers and contribute to the recovered fibre that is essential for maintaining the waste paper fibre cycle.
- 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

In last year's Z-ECO, we reported on a cross-linking agent used in the coating formulation of one of our coated products that contained traces of formaldehyde, which led to markedly offensive odours in certain areas of the paper machine. During the year under review, we succeeded in replacing this agent with an alternative product that is completely free of formaldehyde.

Since this replacement, the only factor that can impact on operating personnel is noise, which we effectively combat by distributing individually-customised ear protectors to staff and obliging them to wear these.

5.2 Work safety

A decisive improvement in work safety was achieved by investing in larger and sturdier empty drums for reeling the paper. This now makes it possible for heavy drums to be used with sufficient safety reserve against spools breaking.

- As is the case every year, an external audit was performed by the Swiss Accident Insurance Fund (SUVA).
- During supervisory training, a safety inspection tour was made during which any gaps in safety provisions were noted, documented and subsequently dealt with.
- 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.
- The annual training session for our shift workers focused in particular on the dangers of working with fork-lift trucks.
- A monthly notice displayed on bulletin boards provides staff with constantly up-dated information on the current status with regard to accidents.
- Poster campaigns on the subject of safety with documentation material from SUVA were continued.

The number of accidents and the amount of time lost in consequence remained much the same as for the previous year. Regrettably, however, we did experience one serious accident on the paper machine. A member of staff caught his arm in an inadequately secured pinch point resulting in a broken forearm. Fortunately, the injury was not too serious and the safety guard at the pinch point was immediately modified to ensure that it is no longer accessible.

	UNIT	2004	2005	2006	2007	2008	2009
Industrial accidents	Number	17	14	22	10	14	14
Non-work-related accidents	Number	13	29	17	13	19	22
Time lost due to industrial accidents	%	0.34	0.17	0.89	0.36	0.37	0.42
Time lost due to non-work-related accidents	%	0.11	0.60	0.59	0.26	0.24	0.16

6. AUDITS AND LEGAL REQUIREMENTS

- In March 2009, the SWISS TS performed a monitoring audit of our combined system in accordance with ISO 9001: 2000, ISO 14001: 2004 and OHSAS 18001: 2007 standards. This confirmed that all the requirements for maintaining certification were met in full.
- The environmental management system was also subjected to an internal audit in December 2009.
- In addition to this, in October 2009 the SQS, CH-3052 Zollikofen, carried out a maintenance audit for the FSC-STD-40-004 (1.0) and FSC-STD-40-005 (2.1) chain-of-custody standards. 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).
- No relevant changes came into effect with regard to legal stipulations.

All legal requirements in respect of both the environment and work safety were complied with in full; no matters are pending with the authorities.

7. ECOLOGICAL BALANCE SHEET

In our environmental reports, we provide information on the environmental performance of Ziegler Paper Mill in respect of the utilisation by our company of raw materials and resources to produce paper ready for sale. As far as the consumer is concerned, however, what is probably more important is the complete environmental impact of a kilogramme of Ziegler paper "from cradle to grave", including all upstream stages and processes. For this reason, we commissioned specialised environmental consultants to draw up an ecological balance sheet for the first time in 2008. This was based on data from 2007 and gave details of the environmental impact and carbon footprint of the paper manufactured by Ziegler. In 2009, this ecological balance sheet was updated using data from 2008 in order to determine any changes that had occurred in our environmental performance.

- Data used: Ziegler consumption statistics for the year 2008.
- System limits: all upstream processes from the origin of the raw materials, through the processing stages, right up to transport to Ziegler's dispatch ramp.
- Methodology: EMIS 5.3 ecological balance sheet software. Data used for upstream processes are based on standard data from Ecoinvent 2.1. Consumption and emission data for pulp were obtained direct from the pulp manufacturers.
- Assessment method for environmental impact: in accordance with the UPB 2006 method of the Swiss Agency for the Environment, Forests and Landscape (BUWAL). So-called ecopoints are assigned and totalled as per a distance-to-target method. For the weighting of this method, Switzerland's official policy aims for the environment are also taken into account in addition to existing pollution.
- 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 CO_2 equivalents.

	ENVIRONMENTAL IMPACT Ecopoints/kg paper		**CARBON FOOTPRINT** kg CO_2 equivalent/kg paper	
	2008	**PREVIOUS YEAR**	**2008**	**PREVIOUS YEAR**
Total (100 %)	4813*	4339	1,42	1,40
Ziegler Paper	6.1 %	4.7 %	40.0 %	40.4 %
Pulp	86.3 %	89.2 %	40.4 %	39.3 %
Other raw materials	7.6 %	6.1 %	19.6 %	20.3 %

***) There is absolutely no basis for comparison between the ecopoints for 2008 and those for the previous year since an updated assessment method (UBP 06 W) was used for 2008.**

Only marginal changes were recorded in comparison with the previous year. As before, some 95% of the environmental impact of the paper produced by the Ziegler mill is the result of upstream processes, with by far the major proportion due to the manufacture and transport of the pulp used. This is the case despite the fact that Ziegler makes exclusive use of pulp from controlled forestry operations (controlled wood), in part even with the FSC label.

Nor has there been any change in respect of carbon footprint: some 40% of CO_2 emissions come from the energy used to manufacture the paper. The same contribution is made by pulp, while other raw materials account for around 20%.

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

- By far the greatest potential for reducing the environmental impact of our papers lies in the choice of the pulp used in their production. However, it must be borne in mind that our freedom of choice in respect of pulp is limited by both technical and economic factors.

  On the other hand, the potential for improvement in the actual manufacturing process and with regard to other raw materials is small.
- The actual production process of the paper is a major factor in CO_2 pollution. All measures that contribute towards improving energy efficiency are not only important for fulfilling the targeted reduction in CO_2 output we have contractually agreed to, but also make a significant contribution towards improving our products' carbon footprint.

ACHIEVEMENT OF GOALS

The Management had set the following concrete environmental goals for 2009:

- The reduction of specific gas consumption by 3% in comparison with the year-back level after overhaul of the waste heat boiler.
- Achievement: Due to the overlapping of consumption effects as a result of the factors shown under energy statistics, it proved impossible to demonstrate the planned savings explicitly. The reduction in specific steam usage taken over the entire year, however, does suggest that a de facto saving was achieved.

FUTURE OBJECTIVES

Compilation of a programme of measures aimed at reducing wastewater, taking into consideration conditions for the cost structuring of wastewater charges from 2010 on.

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