



Maryland Green Registry MEMBER

The Maryland Green Registry promotes and recognizes sustainable practices at organizations of all types and sizes. Members agree to share at least five environmental practices and one measurable result while striving to continually improve their environmental performance.

Green Bay Packaging

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Paperboard Packaging and Display Manufacturer

Member since May 2012

Management and Leadership



Environmental Policy Statement

Green Bay Packaging (GBP) is a privately-owned, vertically integrated, containerboard company with a heritage of environmental stewardship and sustainable business practices. GBP has a proven commitment to protecting the environment and the health and safety of its employees, customers and their communities.

GBP has integrated environmental concerns into business decision-making and product development. It is committed to:

- *Comply with applicable regulations and laws*
- *Strive for continuous improvement of environmental performance through advancing training, innovation and technology*
- *Track and report environmental metrics and performance*
- *Adopt, promote and enforce policies to protect the environment*
- *Ensure environmental management systems align with operational and business frameworks*
- *Conduct audits and self-assessments of environmental management systems and policies*
- *Respond in a timely and appropriate manner to resolve concerns*
- *Instruct employees in awareness and shared responsibility of environmental issues and good business practices*
- *Communicate environmental principles and core values to employees, customers, suppliers, community and stakeholders*
- *Constructively participate in development of public environmental policies*

- *Promote sustainability by resource conservation, pollution prevention, recycling, efficiency, responsible forestry, and waste reduction in the workplace*

*The successful implementation of this policy depends on the commitment of employees at all levels of the company. Suggestions for improvements to environmental management systems are encouraged. **We** integrate sustainable practices to optimize resources and responsibly balance economic, social and environmental goals in producing quality and innovative products for our customers. Striving for continuous improvement in performance, Green Bay Packaging is committed to the pursuit of sustainable principles that support a responsible and effective stewardship.*

As a commitment to superior performance, components of the sustainable strategy include:

- *balancing economic, social responsibility and environmental stewardship*
- *managing operations in a manner that protects the environment, health and safety of our employees and communities*
- *striving for continuous improvement in sustainable performance*
- *reviewing systems and operating practices to ensure regulatory compliance and corrective actions*
- *working proactively with customers and suppliers to effectively produce quality goods that maintain product guarantee standards*

Environmental Team

Renee Sakell is our Division Environmental Director. She reports to David Pollock- Operations Manager, and in turn to Tyson Aschliman, General Manager. Tyson signs off on all environmental reports monthly. Renee also works with Warren Dodge, Plant Engineer/Maintenance Manager, on the daily maintenance and monitoring of our environmental systems and reporting. David, Tyson, Renee, and Warren all speak daily regarding daily environmental issues.

Annual Environmental Goals

Reduction in energy waste due to idle time via improvements to set-up/change-over processes, and 10% reduction in paperboard process waste by YE 2016. Idle time due to set-up is unnecessary machine energy usage that is not adding value to the process or the economy—it's a “waste of energy”.

Environmentally Preferable Products and Services

We produce corrugated (paperboard) industrial boxes, retail packaging, and point-of-purchase displays. A paper called “containerboard” accounts for the vast majority of our raw materials (well over 90% by weight and cost), and, by nature, is very recyclable. Paperboard packaging is one of the most common household and industrial waste products to be recycled in the US and in the world. Furthermore, over 95% of our fiber supply base comes from certified sustainable resources, earning our plant an SFI certification (Sustainable Forestry Initiative). Finally, our very own 330,000 acres of corporate timberlands, from which we derive our own fiber resources, are FSC certified (Forestry Stewardship Council).

Nearly 100% of our solid material waste (paper) at our division is recaptured, baled, and recycled at the paper mills. Approximately 50% of our raw material tonnage is 100% recycled stock.

We have numerous other logistics arrangements among our supply chain and service offerings to our customers that work to mitigate freight expense and carbon emissions due to unnecessary OTR hauls.

Environmentally Preferable Purchasing

The vast majority of our purchasing costs are driven by raw material paper procurement. (Paper stock accounts for around half of our total operating costs in any given month.) Although GBP owns paper mills in the Southwest and Northern Midwest, the majority of our paper is provided by “trade partners” (competitors in the paperboard industry) on a “ton-for-ton” trade. This allows us to drastically limit our carbon footprint due to freight.

Independently-Audited Environmental Management System

We are not ISO certified, but our Corporation does have its own, independent, robust, internally audited environmental control system, managed at a corporate level, involving the local environmental, plant, and general management team for plant-level implementation and maintenance. Additionally, our top-tier customers all have their own independent environmental impact audits that occur on our premises periodically, as a prerequisite for business contract renewals and awards. In 2016, we will be AIB certified, which carries with it in-depth audit of environmental controls and processes.

Waste

Solid Waste Reduction and Reuse

Our facility has achieved a 10% reduction in solid material waste (primarily paperboard). All of our plastic strapping, steel drums, plastic ink buckets, and other minor waste materials are also collected, cleaned, and recycled or re-used.

Recycling

- *Waste paperboard material (process): ~200 Tons/ Month = \$30,000/month plus value of trash removal/ landfill cost*
- *Steel drums, plastic banding, other materials: Over 500 Cubic Feet of materials per week. Savings come from reduction of trash removal/landfill cost*

Energy

Energy Efficiency

In 2012, GBP-Baltimore joined the RMI (Regional Manufacturers Institute) "GREEN TEAM," which is focused on local-level energy and carbon reductions among its members by application of best practices, employee training, and accountability.

In 2014, we re-committed to the next generation of Green Teams with RMI. Between the two terms, the following are being achieved:

- *Pulsed scrap collection (modified to block-off of unused ports)*
 - *Implemented January 2012*
 - *Cost \$150, 1hr of labor*
 - *\$7500/ 67,000kWh annualized savings*
- *Programmable Thermostats on heaters*
 - *Ordered Thermostats for warehouse.*
 - *Installation in March on 2nd shift*
 - *\$1100 implementation costs*
 - *\$8500/ 848MMBtu savings annually*
- *Flatbed Die-Cutter Line Scrap Collection Port*
 - *"Switch" already exists that would give us the desired effect. Has not been used appropriately.*
 - *Re-training 4 crews involved with use of the apparatus January, 2012*
 - *Cost= \$0*
 - *Savings = \$1000/ 9000kWh annually*
- *Cog Belts on scrap blower system*

- *Installed/ implemented 3/19/12*
- *Incremental cost \$300*
- *Expected savings \$1,100-3,300/ 9600-26000kWh annually*
- *2015 installation of energy-efficient Boiler*
 - *Includes high-pressure condensate return to reduce amount of process heat needed to heat boiler water, recapturing what was previously “waste” heat*
 - *Includes several environmental controls to further improve our environmental responsibility standards, mitigating process water and waste*

We also engage our employees by providing best practices training for energy conservation at both work and at home.

Renewable Energy

Structural limitations to our roof prevented us from moving forward with a solar energy project that we explored in 2013

Transportation

Employee Commute

We are located ½ block from the Gilroy Rd. Light Rail stop. Many of our employees commute to Hunt Valley daily from the city of Baltimore and south of the City.

Efficient Business Travel

We utilize a monthly subscription service called “MegaMeeting.com,” which is an interactive, multi-seat videoconferencing system. We interact with sales staff, vendors, customers, and other divisions using this tool. We also heavily utilize a remote network, VPN, and cloud-based IT tools that give about a dozen of our sales employees inside access to the plant and office from off-premises. This eliminates literally hundreds of commutes a month to the office, allowing personnel to connect and work right where they are.

Fleet Vehicles

We purchase our fleet vehicles used and require the drivers to do necessary maintenance as a prerequisite for use of the vehicle and to maintain fuel efficiency.

Water



Water Conservation

We are installing water meters on all converting equipment. We will monitor the meters to determine where the water is being used the most and then look for ways to reduce the amount of water being consumed. 100% of our process waste water is treated internally before being safely ejected into the municipal system in accordance with our wastewater permit issued by the Baltimore County EPA. Internal and external testing of these ejections are completed per the permit requirements. Additionally, we have installed timed wash-up cycle valves on our process equipment to minimize waste water in the production process.

Profile Updated November 2015



Help build a greener, more sustainable Maryland through voluntary practices that reduce environmental impacts and save money.

Learn more at www.green.maryland.gov/registry

