



1032 Bay Beach Road • Green Bay, Wisconsin 54302

SERVICE AND MANAGEMENT OF RETURNABLE CONTAINERS



GREEN TIER

Advantage: Business Advantage: Environment

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Tosca Ltd. 2013 Annual Report

Tosca Ltd. was accepted into the Green Tier program in October of 2010. Since that time, we have continued to work towards reducing our impact on the environment and improving the sustainability of our facility and the products and services we offer our customers.

Our Green Team has met frequently throughout the year. Early in 2013, the Green Team put together a list of objectives and since that time, we have worked towards achievement of these objectives.

Some of the objectives that have been achieved include:

- Reduced scores on two of our highest scoring Environmental Aspects by minimizing quantities of pH neutralization chemicals on hand. Both of these solutions contained sulfuric acid, an extremely hazardous substance. By managing on-hand quantities of this chemical to keep totals below 1,000 lbs at any one time, we have reduced our risk of spills and injuries and eliminated the need to include sulfuric acid on our annual Tier II report to the DNR.
- Installation of a rinse water reclamation system on our Returnable Plastic Container wash line. Water usage has been reduced by approximately 2 gallons per container washed since installation in February. We average approximately 75,000 washes per month, which will result in annual conservation of 1.8 million gallons of water and approximately \$5,000 in water use charges.
- Insulation of all production area walls to conserve heat. Our buildings are concrete block construction with an R value of 2. Foam insulation of hollow space in the block raised R values to 14. Assuming winter weather will be normal, Tosca should save approximately 3,100 decatherms of natural gas used for building heat in upcoming winters. With 2013 gas pricing locked in at approximately \$4.50/dekatherm, this will save Tosca around \$14,000 in natural gas charges.
- Worked with our local Publically Owned Treatment Works (POTW) to determine if waste beer generated in our beer keg repair department can be used in an anaerobic digester being designed that is planned to come on-line in 2015. The intent is for the digester to supply electrical power for the POTW's operations. The beer will be an excellent source of nutrients for the bacteria in the digester if we can supply a sufficient amount on a regular

basis. As of now, no further testing needs to be done until closer to actual start-up date for the digester.

- Holding another round of recycling of Tosca Team member's personal electronic equipment, which resulted in collection and recycling of 1,222 lbs of miscellaneous electronic waste.
- Identified a solvent-free ink ribbon used to print labels that are applied to clean containers prior to shipment. This ink will reduce our carbon footprint from the printing process by 70%. A side benefit to switching to this ribbon is that it will save Tosca over \$300/year on ribbon costs.

In addition, Tosca's Green Team has been working on other objectives that are not completed at this point in time. These include:

- Additional segregation of utility usage by product line. This will allow us to get a better and more accurate accounting of utility usage per product produced so we can identify big utility users and work on reducing per piece utility usage.
- Modification to our cheese container paint stripping line that will use circulation pumps to skim contaminants off the surface rather than hot water spray nozzles currently in use. If successful, this change should save 1.4 million gallons of water each year and 2,400 decatherms of natural gas used to heat the water. Between the water charges and the gas savings, we expect to save over \$20,000 per year and to pay this project off in less than 6 months.
- Development of a system to combine waste streams of different pH values to reduce chemical usage for neutralization.

Tosca Ltd. will continue to research options for increasing our sustainability in 2014. The Green Team will be developing objectives that will help us make further reductions in our emissions and utility usage per item produced. Employee awareness and participation are vital to the sustainability of our EMS and environmental excellence. We encourage everyone to participate by providing suggestions on ways to reduce waste, use environmentally friendly products, and reduce energy consumption.