

WE ACT

in a sustainable way

SUSTAINABILITY REPORT 2017



BLUE BOX
PARTNERS

PACKAGING FOR EUROPE



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Introduction

Dear stakeholders,

In 2006, four European family businesses, operating in the corrugated board industry, faced the same challenges. The companies were successful in their own market, experienced substantial growth and an entrepreneurial management aimed to add a European dimension to the company. They combined forces and created Blue Box Partners EEIG, a new packaging alliance, with clear statutes and partnership agreements, operating in a sustainable environment, respecting people and the environment.

After 11 years, Blue Box Partners (BBP), with 68 plants and 8000 employees, became one of the three major players being able to offer a solution for the innovation and supply of corrugated packaging in 20 European countries, Mauritania and Cuba. The vertical integration towards the production of raw materials was an important asset to this success.

Sustainable family values, local anchoring, an entrepreneurial spirit, financial stability and a mutual desire to invest in the circular industry are the key to success for the BBP alliance.

In this report, you will discover how WE ACT in a sustainable way and we welcome you to be our partner.



“ I am proud to present to you the first BBP Sustainability Report.”

Jean-Paul Macharis
Managing Partner and Chairman BBP

We assume responsibility towards people, society and the environment

As independent family-run companies, the BBP Partners are distinguished by solidarity with their business partners and employees, and gladly assume responsibility. With a focus on people, society and the environment, each BBP Partner designs the business in a respectful and sustainable manner.



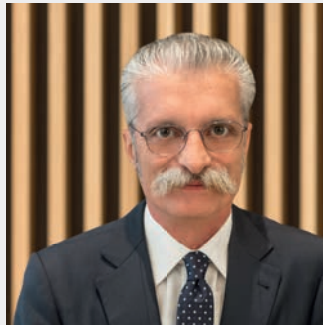
The management faces behind the alliance (from left to right): Jean-Paul Macharis, Dr. Jan Klingele, Antonio Sada, Ruben Martinez



Dr. Jan Klingele

Managing Partner BBP
Managing Partner Klingele Group

For us, sustainability is about having a long-term corporate perspective and assuming responsibility for the environment, community, our employees and within the alliance BBP. As a family company and manufacturer of ecological products, sustainability is one of our firmly established principles. This means we use resource-saving procedures in the production of our paper and corrugated board packaging, we develop eco-friendly products and solutions and we offer family-friendly jobs with rich prospects and fulfil our social responsibility towards local communities.



Antonio Sada

Managing Partner BBP
Managing Director Cart-One Sada Division

Sustainability has been representing a fundamental and cross element for the basis of our activities in Italy for many years. We firmly believe that doing business doesn't mean producing richness for the individual but it is an expression of social value, growth opportunity and development as well as producing an important impact on the territory. This is the spirit that characterises the daily activities of BBP and we are aware of protecting the environment by guaranteeing that our processes don't effect the environmental balance.



Ruben Martinez

Managing Partner BBP
President of Hinojosa Group

We have been committed to Corporate Social Responsibility over the years. We carry out a lot of actions in Spain by implementing alternatives to waste water treatment that allow the complete reusability of the industrial water at our plants. We collaborate with many Non Governmental Organisations with initiatives such as the donation of cardboard cradles or cardboard boxes for humanitarian purposes. We encourage a healthy lifestyle among our employees by supporting their involvement in sporting events/activities. With these efforts in terms of sustainability we want to contribute to the great effort that BBP is doing at the European level.

Founded

2006



Countries

22

in Europe, Africa and Cuba

Paper Mills

5

European Sales Manager (ESM)

6



Sales

2,090

billion Euros

Production Plants

68



Blue Box Partners (BBP), the pan-European alliance, was founded in 2006 as a European Economic Interest Grouping (EEIG). The EEIG is an entity, based on the law of the European Union. All four members are successful and well-established family-run companies in the packaging sector for corrugated cardboard packaging and corrugated board base paper in their home markets.

The four companies of the alliance



Cart-One S.r.l., head office in Italy



Hinojosa Packaging Solutions, head office in Spain



Klingele Papierwerke GmbH & Co. KG, head office in Germany



VPK Packaging Group NV, head office in Belgium

Organisational profile

We are one of the corrugated packaging leaders in Europe.

Our success can be measured with our facts and figures.

The product spectrum offered by the four family-run companies in the alliance is large and diverse. There are no limits to what we can package. We develop, produce and supply corrugated cardboard packaging for everything that is required. We consistently align our packaging solutions to your needs and requirements.

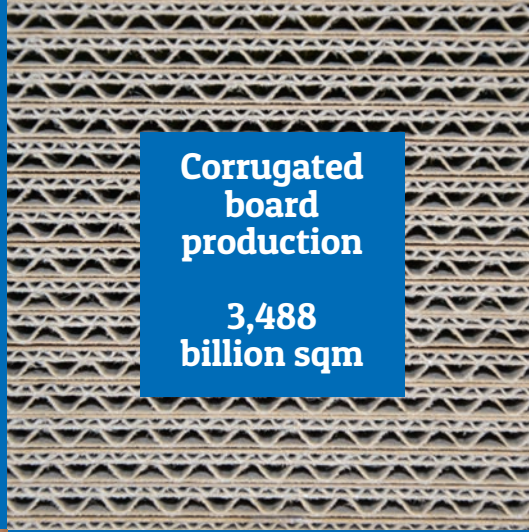
Employees

8000



Corrugated board production

3,488 billion sqm



Business units

- Corrugated Box Plant
- Paper Mill
- Power Plant
- Wind Energy Plant
- Corrugated Sheet Plant
- Corrugated Sheet Feeder Plant
- Solid Board Plant
- Merchant
- Logistics

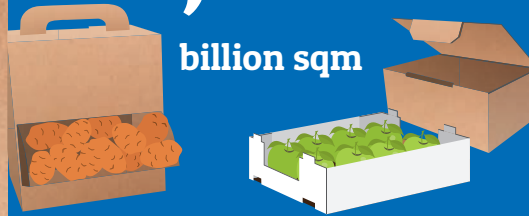


Paper Production

1,197 million tons

Production Capacity

4,000 billion sqm



Future investments in 2018

about 200 million Euros



Products

- Corrugated board base paper (container board)
- Corrugated cardboard
- Corrugated sheets
- Corrugated packaging e. g.: corrugated boxes, die-cut packaging, lock-bottom, pre-glued folding cartons, packaging for hazardous goods, shipment packaging, special solutions, e-commerce packaging
- Corrugated board furniture
- Solid board

Industry expertise

- Food / Fruits + Vegetables
- Logistics / Delivery / Online Distribution / Paper Production
- Electronics / Engineerings / Mechanics Trade / Beverages
- Chemicals / Hazardous Goods / Sports / Toys / Leisure / Fabrics / Hygienic Products / Cosmetics

Industry served

Reporting on the markets/industry served, the figure gives an indication on a scale of 1-4 (1: LOW to 4: HIGH) on BBP products being sold in the industries indicated.

	FOOD	■ ■ ■ ■
	FEED	■ ■ ■ ■
	RETAIL	■ ■ ■ ■
	AUTOMOTIVE	■ ■ ■ ■
	CHEMICALS	■ ■ ■ ■
	CONSTRUCTION	■ ■ ■ ■
	COSMETICS	■ ■ ■ ■
	METAL	■ ■ ■ ■
	PAINT	■ ■ ■ ■
	PHARMA	■ ■ ■ ■
	TEXTILE	■ ■ ■ ■

LOCATIONS

We supply our customers all over Europe, Africa and Cuba

We are well positioned for our customers throughout Europe, ensuring close proximity to all of them. Recently, we have also established branches in Africa and Cuba. We are constantly working on the further expansion of our locations and are committed to continuous growth.




Canary Islands



Nouadhibou

Nouakchott

 Box/Specialities Plant, Sheet Plant/Feeder

 Paper Mill



We deliver in the following countries

- | | | |
|---|--|--|
|  Austria |  Ireland |  Spain |
|  Belgium |  Italy |  Sweden |
|  Cuba |  Luxembourg |  Switzerland |
|  Denmark |  Mauritania |  The Czech Republic |
|  France |  Norway |  The Netherlands |
|  Germany |  Poland |  United Kingdom |
|  Greece |  Portugal | |
|  Hungary |  Romania | |

Vision

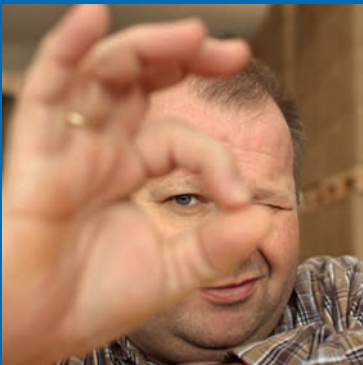
Our aim is to be one of the top European suppliers for corrugated cardboard packaging solutions.

Always thinking of ways that will benefit our customers as well as our own development through creative innovation. We achieve this by:

- Short lines of communication in the customers' preferred language
- Providing a good working environment allowing employees to do their best and achieve their potentials every day
- High amount of investment in cutting-edge technology for our solvency and stability
- Creating more value for our customers with a continuous improvement process
- Further roll-out of our activities in sales and R&D throughout Europe
- Offering a wide range of products with continuous development, dynamic services and the best quality



Our motto for eternity!



Mission

We have a clear objective:
The optimum provision for
our customers corrugated
cardboard packaging needs.

All over Europe. One-stop
shop. In any quantity. In all
qualities. At any time.

Sustainability statement



Dear stakeholders,

Environmental protection, flexible work, international cooperation: regardless of the current fast pace of life, the existential questions of our time demand sustainable answers now more than ever. As Blue Box Partners, we take this responsibility very seriously – WE ACT! Our first sustainability report offers you a comprehensive overview of the facts, milestones and successes along the way. After all, for us as a manufacturer of environmentally-friendly packaging solutions, sustainability lies at the very core of both our business and our corporate philosophy. As a family-run company, we use investment, creativity and passion to demonstrate our constant dedication to optimally and sustainably reconciling the environment, economy and social conduct.

For instance, our “Blue Circle” project at Blue Paper in Strasbourg and our commitment to sustainable water management at Hinojosa are excellent examples of how we make processes more resource-efficient throughout the entire value chain. At the same time, we promote occupational health and safety projects at our plants and help our employees to maintain a balance between work and private life.

Our success confirms the great trust that our customers invest in us. With over 8000 employees at 68 production sites, we produced around 3.5 billion square metres of corrugated cardboard and some 1.2 million tonnes of paper in 2016 – and broke the two billion turnover mark. Together with our customers, we want to continue this sustainable growth in the future, with a strong, international presence, comprehensive advice and new approaches to innovation development. Above all, however, we want to achieve this with teams that really understand our customers and work together with them to create the very best solutions.

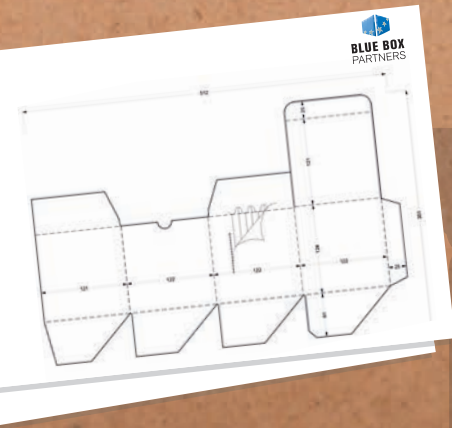
We’d be happy to tell you more about this in a personal meeting. Therefore, don’t view our first sustainability report as a mere source of information – more than anything, it’s an invitation to a dialogue!

“Sustainability is an essential part of our corporate philosophy.”

Armin Höttges
Managing Director BBP



10 am. Safety training
1 pm. Meeting packaging optimisation
3 pm. Medical check

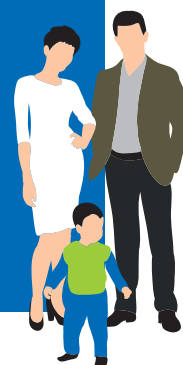


WE ACT SOCIALY

Our focus lies in the attractive and employee-oriented design of the workplace, work conditions and safety, coupled with opportunities for professional development, compatibility of family life and career, and health care.

Benefits

- Better work-life balance
- Professional development
- Workplace health promotion
- Higher operational safety and safety at home





Case Klingele Papierwerke, Germany

Fit for a good work-life balance and success

Successes can only be achieved in a trusting working atmosphere with qualified and motivated employees. We are committed to this goal and work towards it through e.g. customised training, healthcare provision and flexible work.

Work-life balance

The concept of a family-oriented company is embodied by Klingele. Our goal is to ensure that our employees feel well looked-after and are able to give their best, whatever their circumstances. Depending on employees' personal situations and job profiles, we work in coordination with supervisors and the HR department to offer made-to-measure, flexible working times, for example through home office or part-time models. Offering part-time reintegration to employees returning after parental leave has become another routine, yet valued part of our day-to-day business.

For a few years now, the summer holidays have been a particularly lively time of the year for us: at our Remshalden site, we offer parents from our company the opportunity to take advantage of six weeks of holiday care for their children in collaboration with a neighbouring company and a family education centre. Every day from 8 am to 5 pm, educational professionals organise a varied programme for children aged 3 to 12. Indoor and outdoor games and one full-day excursion per week make sure that boredom is kept at bay – and if the little heroes ever grow weary, there is also a room where they can rest.

Curious parents also pop by from time to time, and can then continue their work without having to worry about looking after their children.



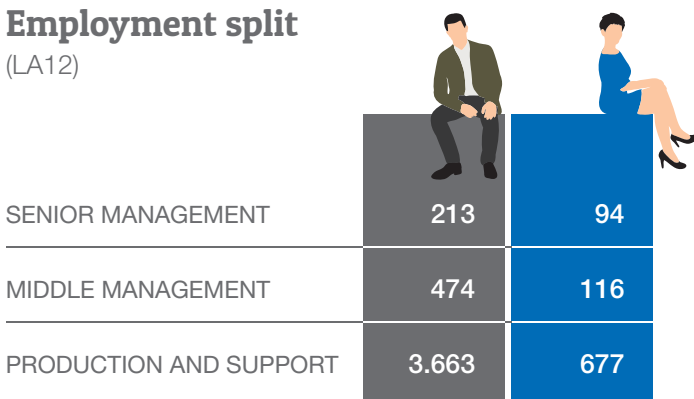
The decision to make use of the holiday programme is easy – and not least because Klingele almost completely assumes the costs. It's hardly surprising, then, that most of the young participants come back year after year.

“Thanks to the holiday programme, my wife and I not only had much more freedom in our daily schedule, but also a clear mind. After all, we knew we could trust Klingele and our children were in good hands.”

Carmine Anania
Machine Operator Production

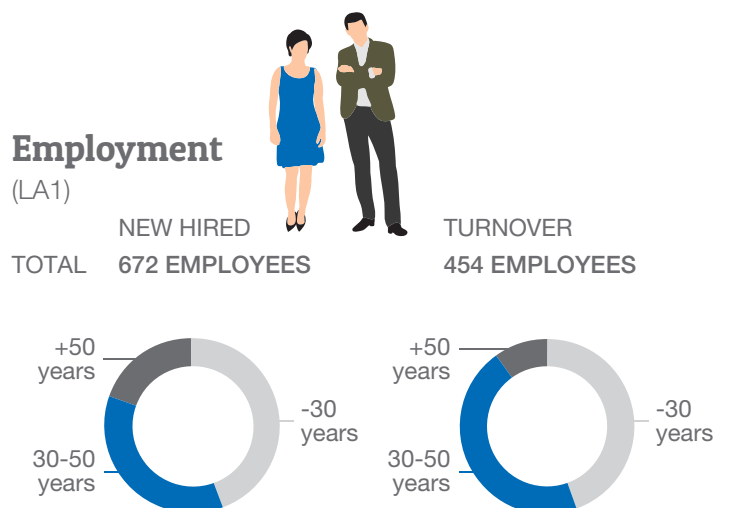
Employment split

(LA12)



Employment

(LA1)



The employment data are limited to our box plants and paper mills in Europe.

Klingele Academy: Further training and careers made to measure



akademie
KLINGELE

In order to continue to be successful in times of technological change and dynamic markets, we need employees whose knowledge and skills are up to date. Our Klingele Academy takes care of this. A wide range of seminars in diverse areas offers our employees the opportunity to continuously develop their skills and knowledge in their familiar working environment, without having to travel to far-off training locations. The programme is aimed at colleagues in the commercial field, as well as long-term practitioners in production – the key criteria for the programme design at the Klingele Academy is individual needs, which is ascertained in each case in a personal interview. We also respond to the increasing internationalisation of our company by holding some of our seminars in English.

The Klingele Academy is a central component of our personnel development – a concept that we take very seriously and embrace in day-to-day business. At Klingele, having a degree is not mandatory for a successful career in management – and there is more than enough ‘living proof’ of this. We offer dedicated colleagues countless opportunities: right from the very first day of training, we are on hand to encourage and support our employees to make a successful contribution to our company.



Klingele supports us in our personal development. I think that's great! It means that I can stay up to date and also be much more competent when dealing with customers and suppliers."

Stefanie Kaiser
Project Manager

HEALTH DAY
GERMANY

Health day: Fit for life – and for work @ Klingele

Health is the most important pillar for a fulfilling life – and yet at the same time, it's all too easy to forget about healthcare plans. The health of our employees is important to us, which is why we invite workers at our Remshalden site to participate in our annual Health Day.

The event, which carries a different slogan every year, offers employees preventative check-ups, especially those might not be at the forefront of everyday life. The tests are aimed at a wide range of occupational groups, and thus at the real circumstances of everyday work in our company with all its different facets. Whether muscle group measurements, venous exams or stress tests, the check-ups give participants valuable information about their personal state of health. After the test, employees are informed of the evaluation and receive tips on how to improve their health. Barriers to participation have been set deliberately low: the check-ups are held during working hours and are voluntary – and it goes without saying that test results are kept strictly confidential.

An attractive offer, which unsurprisingly is met with a positive response and is regularly fully booked.

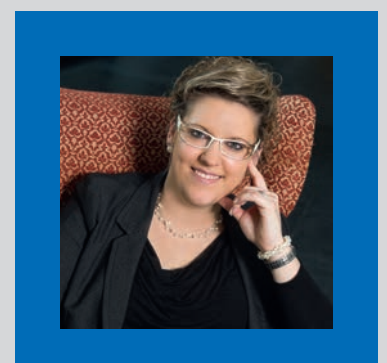


Our responsibility for the health of our employees – annual health checks by medical professionals with subsequent evaluation and advice

As a family business, it's important to us to offer an attractive work environment with a positive work-life balance. And we are obviously achieving this – we have many colleagues who have been with us for a very long time, and employee anniversaries of 25 and more years are no rarity here."

Julia Hottmann

Personnel Management, Head Office Remshalden





Case Cart-One, Italy

“Safe Circle” – for more safety @ home

The issue of safety in the workplace is thoroughly regulated – but according to statistics, many more risks lurk within our own four walls. At Sandra S.p.A., a subsidiary of the Italian Cart-One, we have launched Safe Circle, a campaign for improved safety in the home.

The kitchen harbours the most dangers

Especially in the manufacturing sector, the topic of safety has been a high priority for decades, and this has certainly led to significant successes. From 1963 to 2015, the number of accidents in the workplace in Italy fell some 73% to 416,000 – which is, of course, still a considerable figure. The private sphere of employees has, however, been neglected, despite the fact that there is sufficient reason to take a closer look: a total of 4.5 million accidents were reported to have taken place in Italian homes in 2012 alone. Behind this figure lie countless blows of fate, many of which could probably have been avoided. Statistics reveal that women over the age of 25 are particularly at risk, and the most dangerous room in the house is the kitchen, followed by the bathroom (for women), or the balcony or terrace for men.

This is sobering news for everybody – and should motivate us to carry out a critical examination of our homes or apartments. This subject has now also assumed utmost importance. In 2015, the 193 UN members signed the 2030 Agenda for Sustainable Development. Out of a total of 17 targets, one prescribes the assurance of health and well-being for people of all ages – which is certainly no mean feat. At Sandra S.p.A., a subsidiary of the Italian Cart-One, we are using the ‘Safe Circle’ project to work on the specific implementation of this target with a special focus on the subject of safety in the home.

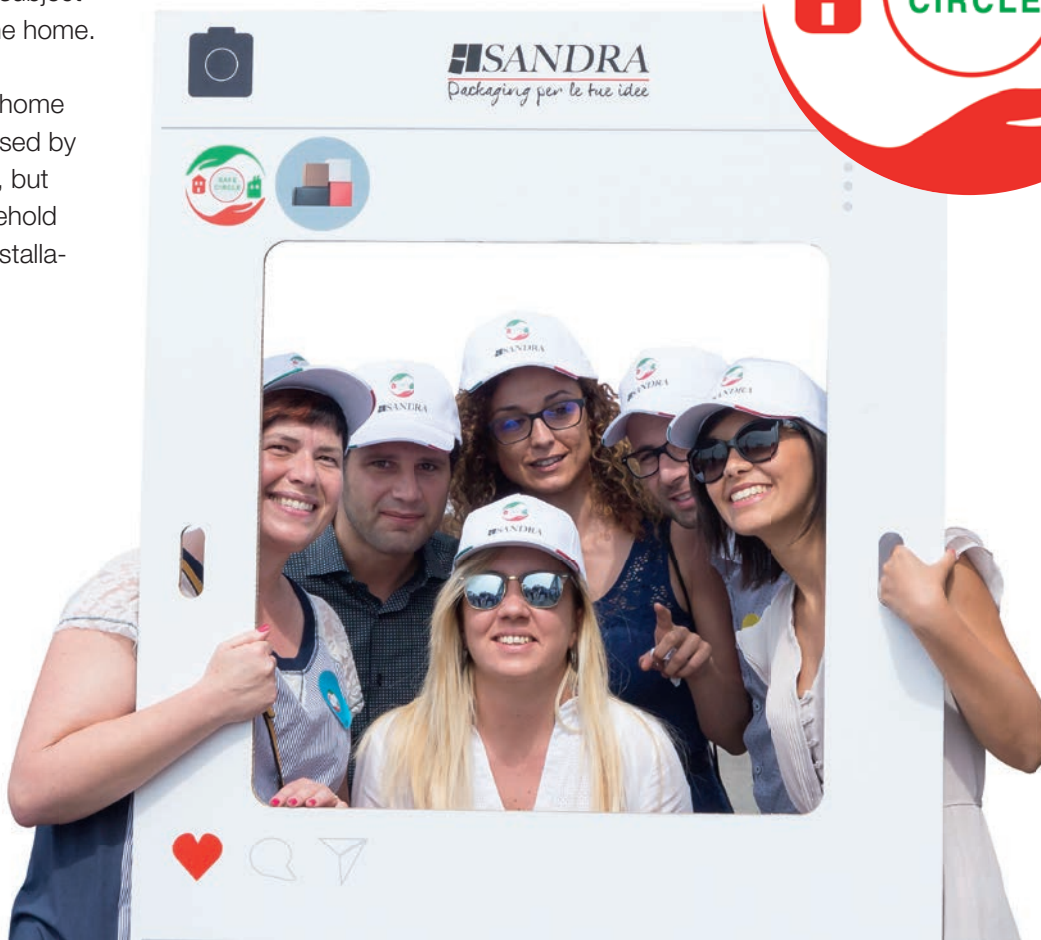
Accidents at home are often caused by carelessness, but also by household goods and installa-



tions that no longer meet current safety standards. These can cause serious injuries and in the worst case, even death. Through training sessions, we want to raise awareness amongst Sandra employees of potential risks in the private sphere, and jointly develop solutions to minimise these risks.

Experience, tools and methods from the business environment are included in the project.

Plans are already in place to carry out the project in other Cart-One companies, too. In addition, the “Safe Circle” measures are to be expanded to external collaborators and suppliers. The project has obviously been well received. “Over 70% of our employees attended the internal information event on “Safe Circle” and are actively participating in the project,” comments Project and Safety Manager Luca la Rocca.





In fact, I believe that a company must certainly do well to the region and people. Especially for future generations, this is why we, as combined effort, consider the environment and work respectfully with those who work at Sandra Division.”

Fausto Ferretti

Managing Director Cart-One, Sandra Division

Detailed risk assessment of all living areas

“Safe Circle” was launched in 2016 and continued in 2017. A “new start” is planned for 2018 – then with new subjects and priorities depending on needs and demand. After all, once you start attentively analysing your everyday environment, you’re sure to find a whole range of risk candidates. These include an outdated electrical system, wobbly furniture, slippery floors and, of course, the way to work.

As a first step, the employees at Sandra were given detailed information about the concept and its methodology at a company meeting, where they were also given material on the topic of safety and comprehensive check lists for the various living areas. Using these lists, the employees were instructed to carry out a risk assessment in their private surroundings and identify potential risks. The entries on the check lists are then used to calculate a total value, which reflects the degree of danger that exists in certain living areas. This enables the participants to receive an objective risk assessment for their apartment or house, along with a recommendation for action.

Afterwards, they receive feedback from the project representatives within their own company, as well as safety information from external advisors. Participation is completely voluntary, and no one is forced to disclose details of their living conditions.

Nevertheless, both the projects and its methods have met with a positive response, and it seems that a considerable number of participants have already made changes in their own homes. The employees are not left alone with the

The aim of “safety @ home”

is to help one’s own workers and employees improve the safety condition inside their own homes by implementing the hazard prevention techniques of the workplace, thus creating a true Safety CIRCLE between the Company and the Home Environment.

We aim to ...

- raise gained awareness on the home and commuting hazards.
- make available experience, tools and methods developed in the companies over the years in the field of occupational safety to the employees, so that they can be also exploited in the home environment.
- train all workers about the safety behaviors in every situation.
- develop a safe culture together.



results of their own “safety audit”. Sandra has negotiated price reductions for its employees with a range of companies in the area, including electricians and installers.

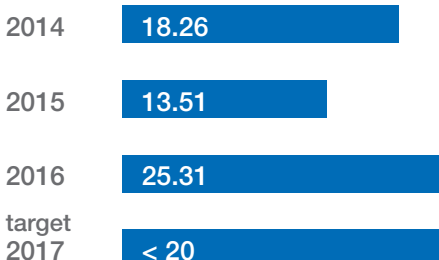
Managing Director Fausto Ferretti and his top management are firmly behind the project. “We want to establish a culture of safety that spans both the business and private spheres, whilst simultaneously protecting the privacy of our employees,” reports Luca Rocca. “The response leaves absolutely no room for doubt – we’ve definitely chosen the right path.”

Occupational health and safety (LA5)

LOST TIME FREQUENCY NUMBER

Amount of work accidents

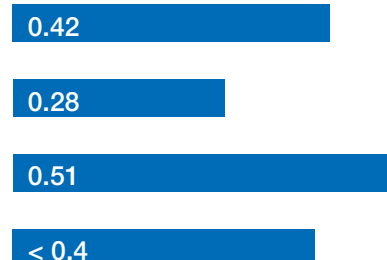
$$LTIR = \frac{\text{sum accidents} \times 1,000,000}{\text{sum total worked hours}}$$



SEVERITY NUMBER

Amount of total days lost due to a work accident

$$SNR = \frac{\text{sum lost calendar days} \times 1000}{\text{sum total worked hours}}$$





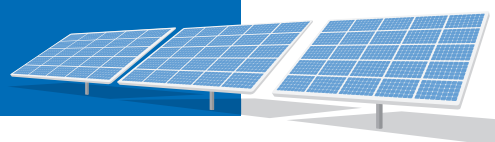
WE ACT ENVIRONMENTALLY

As a producer of sustainable products made of paper and corrugated cardboard, we have been dedicated to systematic environmental management for many years.

This helps us to reduce the consumption of energy and valuable resources such as water, whilst lowering emissions in water and the air.

Benefits

- Sustainable water & energy management
- Environmental protection
- Reduction of water & energy consumption
- Less emissions to water and air





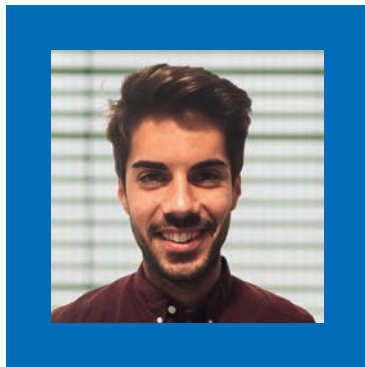
Case Hinojosa Packaging Solutions, Spain

Preventing waste: Water recycling management

Closed loop recycling management aims to re-use resources that are employed in the manufacturing process as efficiently and loss-free as possible. The model is also applied to water management at our partner Hinojosa.

In the Blueprint for the Protection of European Water Resources published in 2012, the European Commission identified the re-use of treated wastewater as a possible measure to improve water supply in the EU. While the relevant institutions are working on various regulations for its implementation, we've already set to work at Hinojosa in Spain. With a cutting-edge water purification plant in the Hinojosa Packaging Pacs corrugated cardboard factory, we recycle water used in the production process so meticulously that we can then re-introduce it into the production cycle. For this, membrane technology is used, which filters out even the smallest particles from a medium such as water. The effect: polluted water no longer needs to be disposed of; at the same time, water consumption decreases in the plant thanks to recycling.

Compared to the previous status quo, this represents a huge step forward. Before introducing the new plant, wastewater was treated in a physical process involving coagulation and press filters. This meant that water from the production process – primarily ink-contaminated wastewater – was first collected in a storage tank. This was followed by the flocculation and coagulation of the tiny dirt particles in order to make them big enough to ensure their easier separation from the water during filtration. The resulting slurry was passed to press filters, and the clarified water was then disposed of, since its quality was not sufficient for reuse even after this treatment process. This meant that Hinojosa had to draw all of its water needs afresh from the public water supply network.

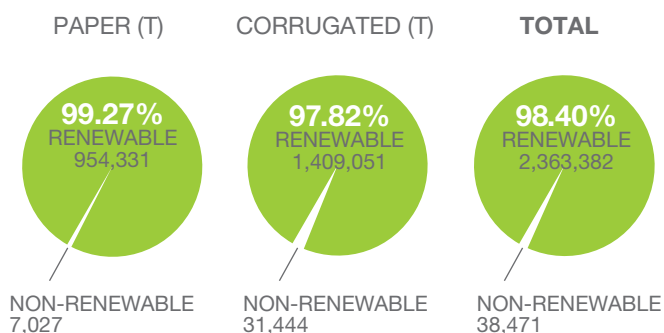


However, a new plant in the corrugated cardboard factory with a multi-stage cleaning process transformed the situation into a clear win-win, both for the environment and the company. After cleaning in the press filter, the water is now no longer disposed of, but is collected once again and fed into a settling tank, where gravity separates production substances (such as ink particles) from the water. Next, the water undergoes a further, two-stage cleaning process using ultrafiltration and nanofiltration. Both procedures use membrane technology, which helps to separate and concentrate macromolecular substances and small particles. The difference between the two methods lies solely in the degree of separation – the membranes used in ultrafiltration are capable of secreting substances with a size of 2-100 nm. In nanofiltration, the membranes have a maximum pore size of 2 nm and can therefore filter out even the tiniest particles.

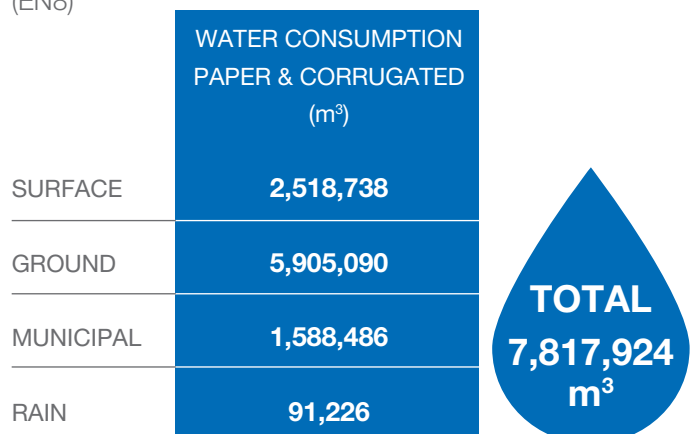
“The water purification plant makes a key contribution to sustainable water management and the environment.”

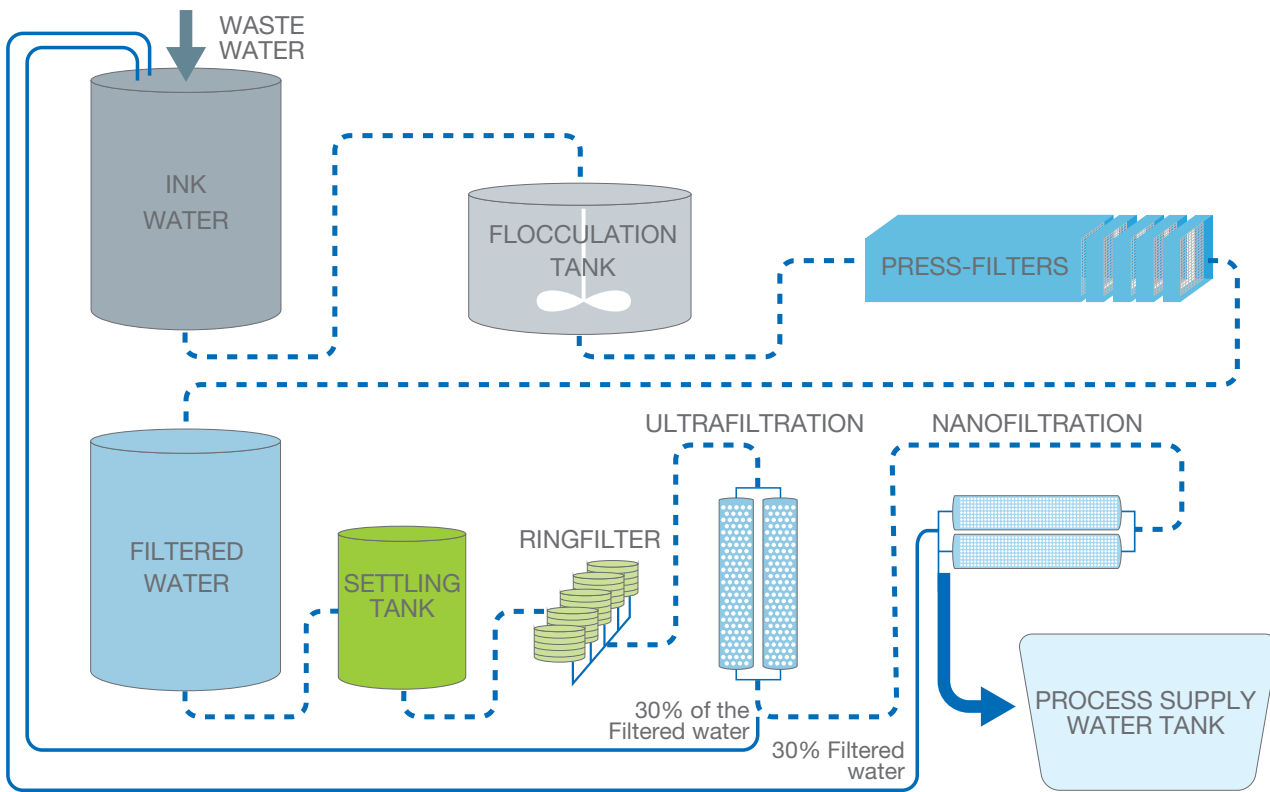
Borja Burriel Vidal
Process Technician

Material
(EN1)



Water
(EN8)





The membrane technology enables even the finest particles to be filtered out of the water. In nanofiltration, the membranes have a maximum pore size of 2 nm. A multi-stage cleaning process yields water with an impeccable quality, which can be re-used in production once again. As a result, Hinojosa becomes “self-sufficient” whilst also protecting the environment.

The new plant was implemented in 2016 and has been in operation since January 2017; the investment totalled €100,000 and has paid off in numerous ways: On the

one hand, the multi-stage cleaning process yields a water quality that enables up to 100% of the recycled water to be re-used in production. Instead of taking valuable (but not free) resources from the public network, Hinojosa is now almost “self-sufficient” – which, of course, also has a positive impact on the water bill. Similar systems have now also been introduced in another Hinojosa factory in Spain. Above all, however, the new water purification plant makes a key contribution to sustainable water management and the environment. “With the new plant, ink particles are efficiently filtered from the water and can be disposed of easily and reliably as solid waste,” states Borja Burriel Vidal, process technician at Hinojosa.

Fact sheet water purification plant at Hinojosa Packaging Pacs:

- Implementation: 2016
- Investment: € 100,000
- Aims: sustainable water management, environmental protections, reduction of water consumption in the factory, cost reduction
- Processes used: membrane technology (ultrafiltration, nanofiltration)
- Result: 100% of treated wastewater can be re-used for production

Moreover, the project in the corrugated cardboard plant at Hinojosa is no one-hit wonder, but rather part of a sustainable overall strategy. This strategy consists of several components, all of which aim to ensure resource conservation and sustainable business – Hinojosa has also introduced a similar facility at another of its sites (Vegabaja Packaging in Alicante). At its Bernabéu plant near Valencia, Hinojosa has installed solar panels and a biomass power plant. Further measures introduced at Hinojosa to protect the environment and reduce the company’s CO₂ footprint include certification in accordance with ISO 50001 (energy management system) and innovation cleaning systems for paper production, in addition to employee offers to encourage them to take the bus to work instead of making the journey by car. A sustainability strategy that not only proves that economics and ecology can indeed be successfully united, but will hopefully also be repeated by many others, too.



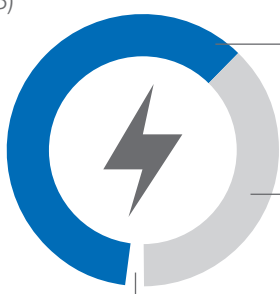
Energy
(EN3)



**ENERGY USE
PAPER & CORRUGATED
(MJ)**

TOTAL	4,895,353,202
MJ/T	4,630

Energy split
(EN3)



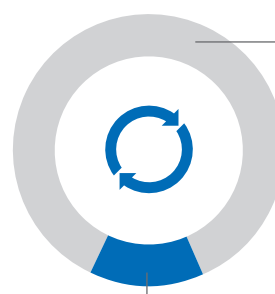
61%
STEAM PRODUCTION
2,537,638,918 MJ

38%
ELECTRICITY
2,045,800,001 MJ

1%
HEATING BUILDING 32,960,178 MJ
COOLING 36,096,191 MJ



4%
ELECTRICITY SOLD
74,667,059,563 MJ



86%
NON-RENEWABLE
4,565,898,980 MJ

14%
RENEWABLE
1,342,001,263 MJ

The energy data are limited to our box plants and paper mills in Europe.

Emissions to water and air

(EN15-EN21-EN22)



	Total	T (m ³)/ T produced
CO ₂ EMISSIONS (T)	525,540	0.169
NO _x EMISSIONS (T)	474	too small to measure
SO _x EMISSIONS (T)	3,663	too small to measure
WATER DISCHARGE TO TREATMENT PLANT (m ³)	3,663	2.262



Eco-footprint (per ton finished product)

EMISSIONS TO AIR
(ton/ton product)

0,209
CO₂
OPERATIONS

0,02
CO₂
TRANSPORT

DEPLETION OF NATURAL RESOURCES

2,49
WATER
WELL WATER
(m³/ton product)

1242
ENERGY
NON RENEWABLE
(mj/ton product)

EMISSIONS TO WATER
(m³/ton product)

2,786

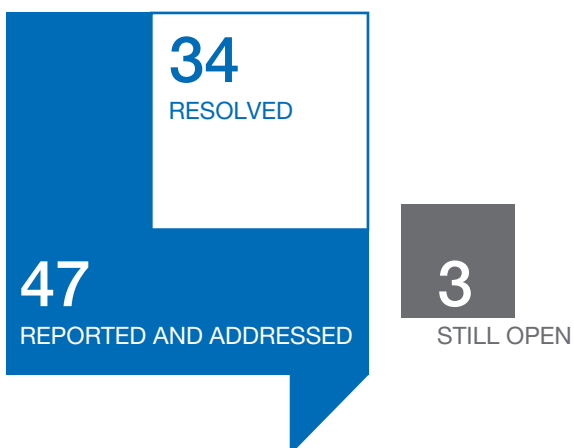
WASTE (LANDFILL & INCINERATED)
(ton/ton product)

0,033

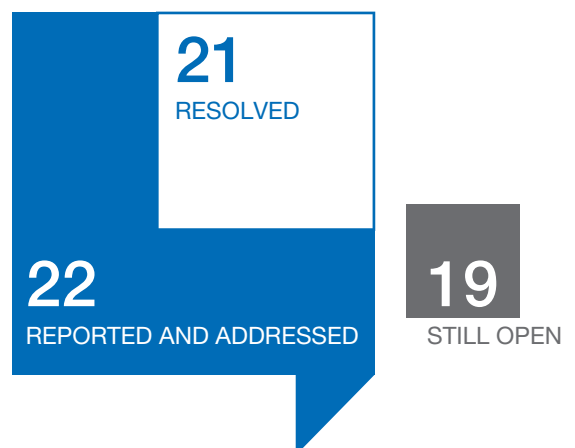
Transport
 OUTBOUND DELIVERIES
 (EN33)

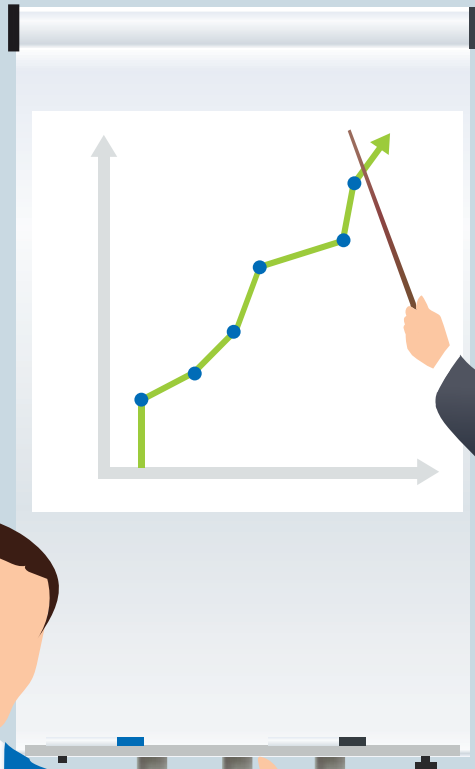


Environmental grievances
 (EN34)



Social grievances
 (LA16)





WE ACT ECONOMICALLY

Instead of disposing of raw material waste in a complex process, we convert it into valuable energy and efficiently integrate it back into the production process. This closes the cycle.

Benefits

- Reduction of greenhouse gas emissions and fossil energy consumption
- Increase the share of renewable energy
- Efficient circular economy
- Less waste to landfill





Case Blue Paper, France

“Blue Circle” – where ecology embraces economy

Blue Paper has always been a pioneer of sustainability. With a new plant that uses waste paper to generate steam for paper production, the paper mill is set to become a successful model of closed loop recycling management.

Blue Circle: We close the circuit

Blue Paper is our new “powerhouse of paper” at the heart of Europe. The paper mill was established in 2013 as a joint project between the Klingele Group and VPK Packaging. With a width of 8.5 metres, the paper machine boasts an impressive format; every year, 400,000 tonnes of paper are produced here for the corrugated cardboard sector using waste paper. Blue Paper employs 150 staff members and in 2016, the paper mill generated a turnover of € 135 million. Environmental protection and energy efficiency have always set the pace at Blue Paper. For example, in 2015, the mill was equipped with a gas engine that uses bio-natural gas to produce clean electricity, alongside a steam turbine that is connected to a biomass boiler.

With the Blue Circle project, we now have a new operating lever that enables us to make our energy supply more efficient whilst improving our environmental footprint and relieving the pressure off our wallet. For this, we use a resource that up until now, we have had to pay for – the waste paper that is used to produce paper in the mill contains six to seven percent foreign matter, such as paper, wood and plastic, which makes up a volume of some 25,000 tonnes per year. To date, such waste has been disposed of through external partners in France and Germany. In France, it goes to landfills, and in Germany, it is incinerated.

With a new plant, however, we want to transform the potential energy from the waste into steam, which can then be used to support the paper drying process in the mill. The project is run under the title “Blue Circle”, and the name says it all – after all, it not only promotes the use of clean energy, but is also a kind of blueprint for successful closed loop recycling management.

Less CO₂ emissions, less gas consumption, less waste

With Blue Circle, Klingele and VPK Packaging are pursuing ambitious goals. A total of 12,000 tonnes of waste per year, which were previously disposed of in landfills, can now be purposefully reused. The waste contains around 50% biomass (wood, paper fibres) – in other words, renewable fuel – thus reducing CO₂ emissions. Gas consumption is also expected to fall by about 80%. In addition, the 500 lorries that have been used to collect



“Since the start-up of BLUE PAPER, we had to use external service providers to eliminate the impurities found in the recycled paper bales, such as plastic, wood and textiles. As these process residues can be incinerated to generate green electricity, steam and heat, there was a clear opportunity to improve our environmental processes. A working group was set up to analyse the project in detail. The BLUE CIRCLE project was born.”

François Bru
General Manager, Blue Paper

the paper waste from Blue Paper and transport it to our partners, are no longer needed. Last but not least, the plant also aims to offer other manufacturers the opportunity to dispose of their waste materials there for a fee. This will not only enable Blue Paper to make savings on disposal costs, but will also generate new revenue.

During the plant construction, it quickly became clear that good preparation is everything. “We prepared an initial study back in 2015; then we looked at different technological options for the plant,” reports Johan Dhaese, who, as project manager, is now responsible for the implementation. Construction work began in April 2017, and we expect the plant to be in operation from around the end of May 2018. “Blue Circle is the perfect example of how closed loop recycling management works. The raw materials used are not disposed of expensively, but are instead efficiently integrated back into the manufacturing process. It’s a viable project that benefits everyone – especially the environment.”

Technology for sustainable energy generation: It's full steam ahead!

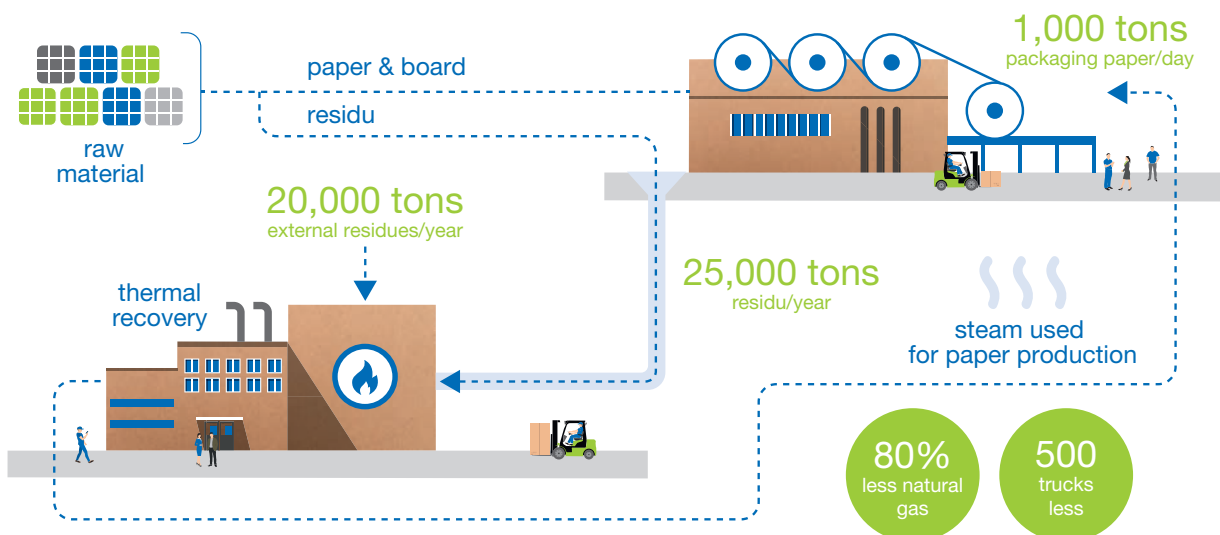
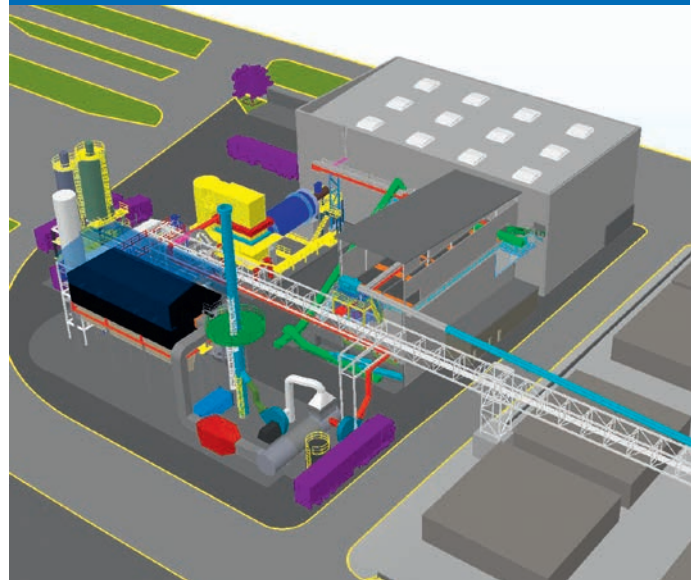
Johan Dhaese and his team considered a range of different technological options before finally opting for the following process: Fuels from external manufacturers are delivered to the plant by lorry and are then – just like the waste materials from their own paper – carried on conveyors to the so-called “bunker” for temporary storage. Energy generation then takes place in two stages. Primary gasification occurs after metal separation and coarse calibration in a rotary kiln. This method has the advantage that waste of widely varying consistencies can be used. In contrast, fluidized bed systems, for instance, require intensive pre-treatment of the waste materials. The secondary combustion of the so-called synthesis gas then follows in a post-combustion chamber.

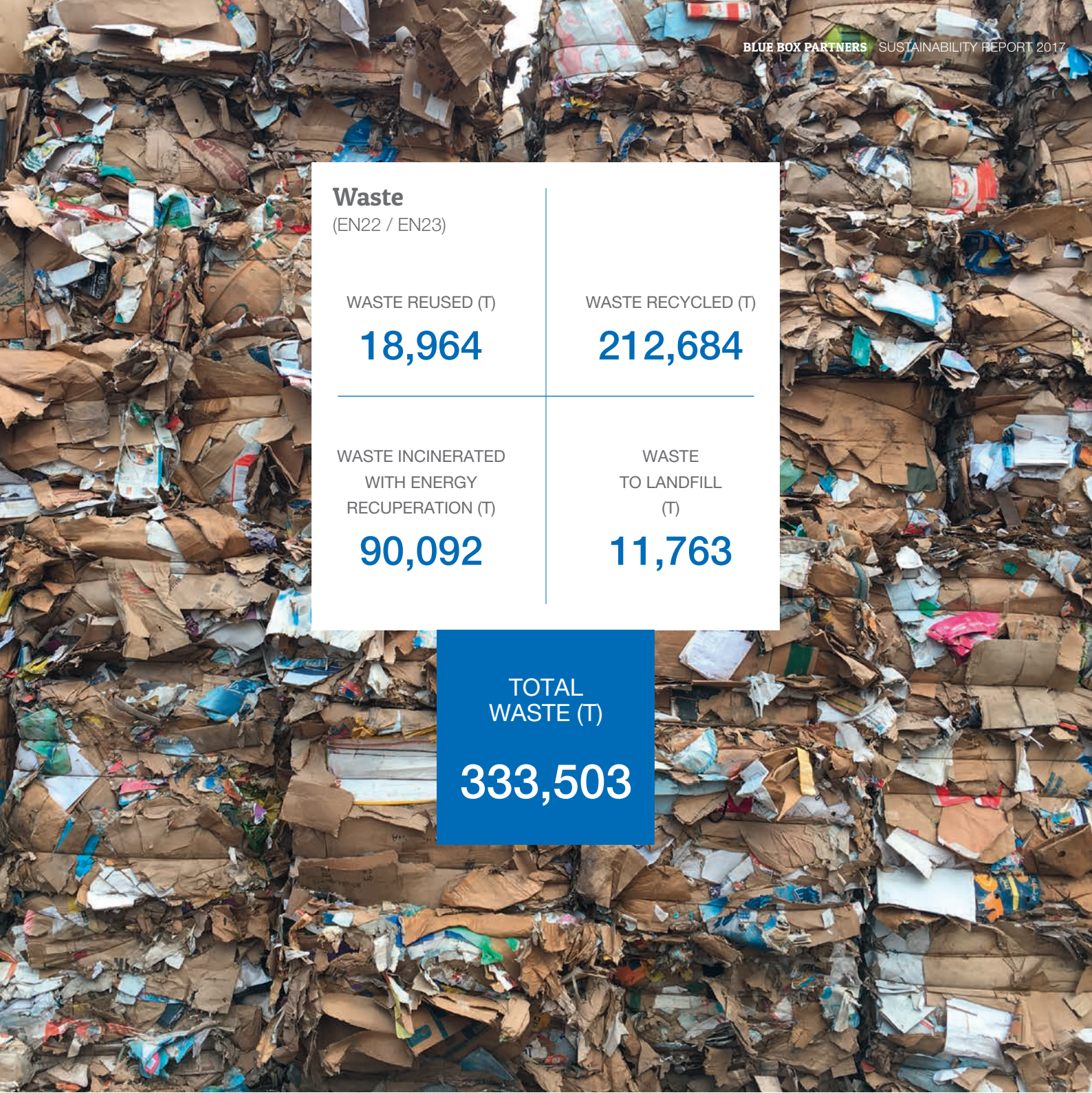
Next, 20 t steam/hour are generated in the first waste heat recovery boiler. The flue gases are cleaned as they exit the boiler: calcium hydroxide is injected into a reactor with a downstream dust filter system, which simultaneously separates all acids such as chlorine, sulphur and fluoride from the flue gas. The flue gases are then cleaned once again using the SCR method in order to remove nitrogen oxides.

In a second waste heat recovery boiler, the temperature is reduced again, with a further steam generation of around 10 t/hour. Some of the flue gases are returned to the post-combustion chamber, while the remainder escapes through the chimney into the atmosphere. This complex process guarantees that the stringent emission limits are met. A clean-cut affair, then – both inside and out!

Blue Circle aims to ...

- **reduce greenhouse gas emissions**
 - Minus ca 80% natural gas
 - Minus 500 trucks / year
 - Reduction of CO₂ emissions
- **reduce fossil energy consumption**
 - Substitution of gas with process residues
- **increase the share of renewable energy**
 - The process residues contain partly worn out fibers, wood, cardboard and textile that constitute biomass
- **reduce waste to landfill**
 - Reusing process residues, avoiding 12.000 tons of landfill per year
- **develop circular economy**
 - With local treatment of process residues
 - With onsite consumption of the steam produced by the new heat plant





Waste (EN22 / EN23)	
WASTE REUSED (T)	WASTE RECYCLED (T)
18,964	212,684
WASTE INCINERATED WITH ENERGY RECUPERATION (T)	WASTE TO LANDFILL (T)
90,092	11,763

TOTAL WASTE (T)
333,503

Remuneration split “equal opportunity” women and men
(LA13)



SENIOR MANAGEMENT	0.91
MIDDLE MANAGEMENT	0.93
PRODUCTION AND SUPPORT	0.92

Overview of certificates

	ISO 9001	ISO 14001/ EMAS	OHSAS 18001	ISO 50001	FSC	ECO LABEL	BRC PACK	ISO 22001
VPK PAPER	■	■		■	■	■		
BLUE PAPER	■	■	■	■	■			
VPK PACKAGING OUDEGEM					■		■	
VPK PACKAGING EREMBODEGEM					■		■	
CDW								
VPK PACKAGING RAAMSDONKVEER	■	■			■	■		
VPK PACKAGING SALONTA	■	■			■		■	
RIGID DESBOROUGH	■	■			■		■	
RIGID SELBY	■	■			■		■	
RIGID WELLINGTON	■	■			■		■	
RIGID ASTON								
RIGID LIMERICK	■							
ONDULYS LILLE	■				■			
ONDULYS ST QUENTIN	■	■			■			
ONDULYS GHEYSSENS								
ONDULYS LA LIANE	■				■			
ONDULYS ROYE					■			
ONDULYS ANDELLE	■				■			
ONDULYS LISIEUX	■				■			
ONDULYS TAILLEUR	■				■			
AQUILA GERMANY LEINEFELDE					■			
AQUILA POLAND BRZEG					■			
AQUILA POLAND RADOMSKO					■			
AQUILA POLAND WRZESNIA					■			
VPK PACKAGING POLAND					■			
PETERSON DANMARK RANDERS					■		■	
PETERSON SWEDEN BÄCKEFORS	■	■			■			
PETERSON SWEDEN NORRKÖPING	■	■			■		■	
PETERSON NORWAY SARPSBORG	■	■			■			
PETERSON NORWAY SYKKYLVEN	■				■			
CART-ONE TORRILE	■	■			■			
CART-ONE CASALE DI MEZZANI	■	■			■			
CART-ONE PONTECAGNANO	■				■			
CART-ONE NOCERA SUPERIORE	■	■			■			
CART-ONE BELPASSO	■	■			■			

	ISO 9001	ISO 14001/EMAS	OHSAS 18001	ISO 50001	FSC	ECO LABEL	BRC PACK	ISO 22001
KLINGELE GRUNBACH	■	■		■	■		■	
KLINGELE HILPOLTSTEIN	■	■		■	■		■	
KLINGELE WERNE	■	■		■	■		■	
KLINGELE DELMENHORST	■	■		■	■		■	
KLINGELE MONJOS DEL PENEDÉS	■							
KLINGELE WEENER	■	■		■	■			
KLINGELE WUNSIEDEL	■							
KLINGELE ELST	■			■	■		■	
KLINGELE EMBALAJES CANARIAS	■							
HINOJOSA XÀTIVA	■	■			■		■	■
HINOJOSA PAC DEL PENEDÉS	■				■			■
HINOJOSA VEGABAJA	■				■		■	
HINOJOSA ONDUEMBALAJE	■	■						
HINOJOSA ENVASES RAMBLENOS	■							
HINOJOSA P ALQUERIA	■	■	■		■			
HINOJOSA P SARRIA								
HINOJOSA VICUSGRAF	■						■	
HINOJOSA CIPASI	■							
HINOJOSA INDUSTRIAS SAN CAYETANO	■	■						
HINOJOSA C BERNABEU	■				■		■	■
TOTAL	42	24	2	8	42	2	17	3



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G4/13	Significant changes during the reporting period regarding the organisation's size	Aquisition of 1. Peterson Packaging in Norway, Sweden and Denmark 2. Compacto Caribe in Cuba
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Identified material aspects and boundaries

(G4-17, G4-18, G4-19, G4-20, G4-21, G4-22, G4-23)

The following table gives an overview of the scope of the BBP sustainability report by using the G4 reporting aspects which are material for the organisation (aspect matrix). Subsequently, the boundaries per company are listed in the boundary matrix (data not available, not disclosed or not consolidated).

Aspect matrix

	ASPECT MATERIAL	NOT RELEVANT	LOW IMPACT	REMARKS
ECONOMIC				
Economic performance	■			
Market presence	■			
Indirect economic impacts			■	EC7: No infrastructure investments are made or planned. EC8: At this time the indirect economic impact on the whole economy of a country is limited.
Procurement practices	■			
ENVIRONMENTAL				
Materials	■			
Energy	■			
Water	■			
Biodiversity	■			
Emissions	■			
Effluent and waste	■			
Product and services		■		EN27/EN28 Manufactured products are mainly based on reclaimed material and after usage will be reused as raw material. Used packaging materials will have only a limited effect on the environmental footprint.
Compliance	■			
Transport	■			
Overall	■			
Supplier environmental assessment	■			
Environmental grievance mechanisms	■			
SOCIAL				
LABOUR PRACTICES & DECENT WORK				
Employment	■			
Labour/management relations	■			
Occupational health & safety	■			
Training and education	■			
Diversity & equal opportunity	■			
Equal remuneration for women & men	■			
Supplier assessment for labour	■			
Labour practices grievance mechanisms	■			



	ASPECT MATERIAL	NOT RELEVANT	LOW IMPACT	REMARKS
HUMAN RIGHTS				
Investment			■	HR1/HR2 Indicators dealing with HR clauses in contractual agreements and training foreseen on human rights policies for employees is considered not to be a priority at this time.
Non discrimination	■			
Freedom of association and collective bargaining	■			
Child labour		■		HR5: BBP does not operate at this time in regions where child labour could be a risk factor. Sufficient legal instruments to abolish child labour are in place in those countries where BBP operates. The same goes for our suppliers.
Forced or compulsory labour		■		HR6: No operations or suppliers have been identified as having significant risk for incidents of forced or compulsory labour.
Security practices			■	HR7: BBP works with external security services. Nonetheless this material aspect is considered to be of low priority.
Indigenous rights		■		HR8: Since BBP does not operate in areas were this material aspect is a problem. This section is considered to be not material for our operations.
Assessment		■		HR9: BBP has not been subjected to human rights reviews or impact assessments on this subject.
Supplier human rights assessment			■	HR10/HR11: At this time these elements are considered as low priority whilst assessing our suppliers.
Human rights grievance mechanisms			■	HR12: No process of capturing grievances on human rights have been implemented; this is considered to be of low priority.
SOCIETY				
Local communities	■			
Anti-corruption	■			
Public policy		■		SO6: No political contributions are made.
Anti-competitive behaviour	■			
Compliance	■			
Supplier assessment for impact on society			■	SO9/SO10: Suppliers are not at this time assessed for their impact on society.
Grievance mechanism for impacts on society	■			
PRODUCT RESPONSIBILITY				
Customer health & safety		■		PR1/PR2: BBP products will have no effect on customer health and safety.
Product service labelling	■			
Marketing communications		■		PR6/PR7: No products are on the banned or disputed lists.
Customer privacy		■		PR8: Customer privacy is not a material issue for our operations.
Compliance			■	PR9: No history of compliance issues (only labelling linked to non regulatory requirements are used, eco labels)

Boundary matrix

This matrix gives an overview of the material aspects boundaries. In this report we did not assess the impact and limitations outside of the organisation.

	VPK PACKAGING GROUP	CART-ONE	HINOJOSA PACKAGING SOLUTIONS	KLINGELE PAPIERWERKE
Economic performance (STD)	■	■	■	■
Market presence (EN8)	■	■	■	■
Procurement practices (EC9)	■	■	■	■
Materials (EN1)	■	■	■	■
Energy (EN3)	■	■	■	■
Water (EN8)	■	■	■	■
Biodiversity (STD)	■	■	■	■
Emissions (EN15-EN21)	■	■	■	■
Effluent and waste (EN22-EN23)	■	■	■	■
Compliance on environmental aspects (EN24-EN29)	■	■	■	■
Transport (EN30)	■	■	■	■
Supplier environmental assessment (EN 32)	■	■	■	■
Environmental grievance mechanism (EN34)	■	■	■	■
Employment (LA1)	■	■	■	■
Labour/management relations (LA4)	■	■	■	■
Occupational health & safety (LA5)	■	■	■	■
Training and education (LA9)	■	■	■	■
Diversity & equal opportunity (LA12)	■	■	■	■
Equal remuneration for women & men (LA13)	■	■	■	■
Supplier assessment for labour (LA14)	■	■	■	■
Labour practice grievance mechanism (LA16)	■	■	■	■
Non discrimination (HR 3)	■	■	■	■
Freedom of association & collective bargaining (HR 4)	■	■	■	■
Local communities (SO 1)	■	■	■	■
Anti corruption (SO 4)	■	■	■	■
Anti competitive behaviour (SO 7)	■	■	■	■
Compliance on society aspects (SO 8)	■	■	■	■
Products & service label (PR5)	■	■	■	■

■ Data reported in full ■ No data available ■ Data not disclosed ■ Data not consolidated

Sustainability prospects – WE ACT

In the first BBP sustainability report, we reflect on how the four partners of the Pan-European alliance contribute to a sustainable circular economy and how they assume corporate social responsibility. We have elaborated a number of essential sustainability aspects that form the cornerstone of our sustainability strategy. The specific focus topics in this context are work-life balance, employee professional development, economic success as well as occupational safety and health protection. Additional aspects deemed to be highly relevant include energy and process efficiency services, energy consumption and CO₂ reduction as well as waste and resource management.



Our goal is to closely align our business activities along our entire value-added chain with the principle of sustainability. We want to expand our sustainability strategy with our processes and our actions and continuously improve and optimise it. Using resources economically and responsibly is one of our key values and also a daily task in which we seek to achieve even better results.

The aspect of occupational safety is also fundamental. We are constantly working to protect our health. Also, our stakeholders are important partners for us, and we exchange our experiences and ideas with them on a regular basis. We want to identify their needs and expectations. We also want to understand where they are coming from and, to the extent we are able to do so, we want to take these factors into account when we make our business decisions.

Our sustainability efforts are really never complete. It is an important milestone for BBP to begin now with our intentions in getting better in the future. We want every step we take along that path to make us better, step by step.



About this report

(G4-17)

1st sustainability report of Blue Box Partners EEIG

This report is published in January 2018.

We report in accordance with the 'core' option of the Global Reporting Initiative (GRI) G4 guidelines.

It is our intention to report every two years.

Colophon

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