

Cardinal SGIG Environmental Performance

- Hired a third party environmental engineer to conduct an environmental impact assessment of our facility and process. This was conducted in March 2009. The results of the assessment, or Register of Legislation, identified two areas of focus. Level 1 Improvements are improvements with significant or legal impacts. Level 2 Improvements are improvements that warrant immediate study. In addition, a recurring reports and records worksheet was developed. The Register of Legislation quickly identified our current position regarding environmental compliance, but also provided the tools necessary to establish an environmental management system (EMS).
- Using the Register of Legislation, we created the Spring Green Insulated Glass (SGIG) Environmental Management System. The purpose of the SGIG EMS is to establish the processes and practices that enable SGIG to increase its operational efficiency, reduce its environmental impacts, and ensure regulatory compliance. The SGIG EMS team consists of the following programs:
 - Pollution Prevention
 - Energy Management
 - Raw Material Certification
 - Water/Waste Water Management (new program)
- The SGIG EMS is built around the “Plan, Do, Check, Act” model to ensure that environmental matters are systematically identified, controlled, and monitored. This will help ensure that SGIG environmental performance benefits the plant and improves over time.

- Employee communication about our EMS efforts and progress is shared quarterly during our weekly employee communication meetings. Results and progress is also displayed on our break room information monitors.
- The SGIG EMS team developed the SGIG EMS Compliance Program. The EMS Compliance Program has addressed each of the Level 1 and Level 2 improvements that were identified in the Register of Legislation. The Program was developed from the Register of Legislation by breaking down the Level 1 and Level 2 improvements into specific areas of responsibility throughout or facility.
- The EMS Compliance Program utilizes an internal (the SGIG Continuous Improvement (CI) team) and external (3rd party environmental engineer firm) audit program to ensure compliance with all environmental requirements.
- The focus and direction for the EMS team is provided by our annual strategic plan. The strategic plan outlines specific goals for each of the EMS programs. As part of our EMS program, we developed the SGIG Sustainability Board. The board meets quarterly to review the progress of environmental projects and also the efforts towards accomplishing the EMS strategic objectives. The EMS strategic goals for 2010 are as follows:
 - Pollution Prevention- Reduce waste to the landfill to 0.30 lbs/square foot produced
 - Energy Management- Reduce energy consumption (KWH/square foot produced) 25% from the 2008 baseline by the end of 2013.
 - Raw Material Certification- Develop an audit and measure supplier sustainability programs.
 - Water/Waste Water Management- New program

- Pollution Prevention projects completed or in progress
 - Decreased waste to the landfill by 50%, over 300 tons per year reduction.
 - Implemented extensive recycling program separating and collecting over 25 different items throughout the facility, internally consolidated and packaged for shipment.
 - Conducted paperwork reduction events (decreased paperwork on outgoing finished racks by 75%, paperwork to the production lines by 60%).
 - Began backhauling program from customers in order to re-use packing material.
 - Started collection program for customers to recycle unusable product.

- Energy Management projects completed or in progress
 - 4 x VFDs installed on tempering furnace blowers.
 - Custom modification to our tempering furnace to be more energy efficient.
 - Installed 248 occupancy sensors throughout the facility.
 - Installed 15 new and more efficient HVAC units.
 - In the process of installing a HVAC control system to better manage our HVAC system.
 - In the process of replacing all front office windows to improve insulated value and reduce solar heat gain.
 - Conducted a compressed air system leak audit and repaired all leaks.
 - In the process of upgrading/updating our compressed air system to improve efficiency and reduce energy use.
 - In the process of metering all processes used during the peak demand hours to identify opportunities to shift processes to off-peak hours.

- Raw Material Certification program progress
 - Developed and fielded a supplier self-assessment report card for our suppliers to grade themselves on sustainability.
 - Developing a report card grading program to rate all current suppliers on their sustainability performance.
- Water/Waste Water Management program- The program is in development with a manager to be identified in the next two weeks.
- Additional goals for 2010 consist of develop a community sustainability outreach program and to be certified by the Wisconsin DNR Green Tier program (Tier 1).