



Flambeau River Papers 2014 Environmental Management System Report

Green Tier, Green Masters, and ISO 14001 certified Flambeau River Papers continues to be guided by environmental and energy policies that ensure continuous improvement and that resources are used wisely. The mill's dedication to making sound environmental and energy decisions continues to be a priority. A summary of the mill's ISO 14001 status and the water, air, and solid waste issues the mill is dealing with follows.

Water

The management of high flows, one of the causes of the only exceedance of 2014, continues to be a focus. A water leak was able to be repaired shortly after the event. Watertech, a company with a long history of helping the mill with incoming water treatment, also introduced the mill to new technology late in 2014 that uses remote monitoring and reporting. This tool will be used in 2015 to give the mill more information on water use which will lead to better management of flows to the wastewater treatment plant and to help mitigate future exceedances.

Air

Late 2014 saw the installation of a new pre-quench section and new duct work at the mill's main boiler. A significant reduction of particulate matter emitted is expected with these improvements to the flow condition and velocity profile of the boiler. 2015 stack testing will determine what further steps are needed for Boiler MACT compliance.

Solid Waste

The mill continues to work towards sustainable solutions especially with the solid wastes that are generated. 2014 marked another year where no treatment plant residuals had to be landfilled. The landspreading of residuals from the mill's wastewater treatment plant continues to provide farmers with the nitrogen and other nutrients their fields need. Ashes continue to be used under the DNR's beneficial reuse rules. Solutions for other residuals including knots continue to be worked on. The baskets shown below, ornaments, and placemats are a few examples of items made from the turn up tape used on one of the paper machines. Anyone interested in receiving some of the tape can stop into the mill's security entrance and ask for a sample.



ISO 14001

The non-conformances to the ISO 14001 standard of the November 2014 audit by QSR, the mill's registrar, have been closed out. As always, a target of 100% compliance is made with the following main focuses for 2015:

- Strategy for Compliance with the Upcoming Boiler MACT Air Rule
- Storm Water Impacts
- Engagement With Suppliers

Other

The mill's first full growing season with the Flambeau River Community Growing Center, the greenhouse on its property, was a success. With an idea that originated from the mill's focus on wellness and with the help of a grant, support from the University of Wisconsin, and much community involvement, vegetables got off to an early start. The public was invited to workshops last year with more planned for the 2015 growing season. 4H, schools, and other community groups continue to benefit from the greenhouse. The mill's first water fountain with bottle filler has saved over 9,000 plastic bottles.

Flambeau River Papers managed the challenges of 2014. The mill's commitment to being a responsible environmental and energy steward hasn't changed. If you have questions or concerns about our environmental performance please contact us during office hours at (715)762-5375 or by calling our 24-hour community concerns hotline at (715)762-5239. Please visit flambeauriverpapers.com to see the mill's environmental policy and for more information about the mill.