sappi

Environmental Statement 2020

Sappi Stockstadt GmbH

Environmental targets
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Results

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Meeting current challenges

Dear reader,

For us, the 2020 financial year was extraordinary and incredibly challenging in every respect. As explained in the previous Environmental Statement, the graphic paper industry is currently undergoing constant and rapid change. The market for these grades of paper has been steadily contracting for years, largely due to digitalisation. There is huge pressure on costs in this global industry and discussion within society on climate protection and sustainability is becoming hugely significant - at least in our European society - and is of course also influencing our industry. In light of this, Sappi Europe has reviewed the profitability of products, machines and locations, revised its strategy in terms of sustainability, and set out new targets for 2025 based on the UN's sustainability goals. Key targets include producing at least 50% of energy required from clean and sustainable sources, lowering the specific energy requirement by 5% and specific CO2 emissions by 25% compared to 2020. Another important goal is to increase the proportion of certified fibres in production across Europe to more than 78%.

Sappi Stockstadt GmbH focused initially on producing existing and refined products as sustainably and efficiently as possible and, in the process, on making optimal use of the regional availability of renewable raw materials, in particular beechwood, for pulp and paper production.

> We will contribute to a bio-based and more sustainable circular economy

The wood's short transport distances with minimal CO2 emissions, maximum integration of the pulp produced in paper production, and the efficient use of wood-based by-products for the production of green energy in the company's combined heat and power cogeneration plant all provide a good basis to achieving this goal.

In spring 2020, policy-making was dominated by the climate discussion, Britain's exit from the EU, increasing problems surrounding refugees, and foreign policy changes in connection with Donald Trump's US presidency - factors which consequently also dominated businesses and the citizens of this country. It was for these reasons that news of a new type of virus, first identified in China, initially failed to cause much of a stir. This would then change rapidly once it became clear that the new virus, by the unwieldy scientific name of SARS-CoV-2, spread very quickly and could have serious and potentially life-threatening consequences for all people, in particular for groups with pre-existing illnesses and for older groups in the population. Rapid and decisive action was necessary to protect the population and the significant restricting of contact between people proved essential. In time, this measure was implemented globally with significant impacts on people's social cohesion but also on work and the overall economy. Retail, tourism, the transport sector, hospitality and cultural sites, service providers and industry were all impacted worldwide - turnover and profits fell as a result. At a stroke, more than half of orders were cancelled in Stockstadt and Sappi Europe - an unprecedented fall within just a few weeks.

These developments accelerated and reinforced the decision to significantly reduce capacity for the production of coated grades. Paper machine 2, which produced the coating base paper in Stockstadt for the coating machine, was to be decommissioned and not restarted once there was a slight recovery in the markets. While the reduction in personnel associated with this was achieved in a socially responsible manner, it also meant that Sappi Stockstadt GmbH was forced to lose many competent and experienced employees as a result of early retirement or severance payment

regulations – a significant turning point, both for the employees affected as well as for the Stockstadt plant. The process of change which has been started demands a high degree of flexibility from people and from processes and machines. Successfully coated paper grades continue to be produced, paper machine 1 now produces both uncoated papers as well as coating base paper. The coating base papers are refined into high quality products on the coating machine.

The falloff in order volumes as a result of the coronavirus crisis and the changes outlined in production resulted overall in changes to specific environmental data which can only be compared to a limited extent to figures from the previous year. This is particularly evident in the key figures for energy included in our reports in this environmental statement. A new energy-related database needs to be defined for the changes in plant machinery, and new optimisation targets can be set on the basis of this. This is one of the many tasks for the 2021 financial year.

Christian Dietershagen
Managing Director Sappi Stockstadt GmbH

Despite all of the difficulties, we have been able to achieve some of the sustainability targets set over the past financial year. We made progress, for example, with plans for the decarbonisation of energy generation. We achieved our target of 39% green energy share by using biomass in the cogeneration plant. This means Sappi Stockstadt GmbH is producing approximately 40% of the biomass electricity in the district and is therefore significantly influencing the rate produced in Lower Franconia!

Commissioning of the new lamallar droplet separator meant that dust emissions from the chemical recovery boiler could be reduced, although the target set has not yet been reached. The second stage of our wastewater temperature reduction and energy recovery project was implemented. There was another round of the noise protection program and this was completed for operation of the saw mill. Noise emissions were also lowered in the generating plant and the wastewater treatment plant. Monitoring for the avoidance of odour emissions in pulp generation was improved and an extensive analysis of the system for recording near-ground odour emissions was implemented. Further measures were formulated based on these findings for odour minimization in the new financial year. These measures are of particular significance to our residents.

Times are challenging but we are continuing on our chosen path towards decarbonisation and towards sustainability in Stockstadt. We shall continue to further reduce the environmental impacts arising from our activities, not least because this is what our employees desire and expect. Sappi Stockstadt GmbH is in a position to contribute to a bio-based and more sustainable circular economy and to therefore be an attractive employer for young people!

With this in mind, happy reading!

Christian Dietershagen

Christian Dietershagen
Managing Director Sappi Stockstadt GmbH


Was kommt? Was geht? Was bleibt? Was zählt?
Das Jubiläumsmagazin der Baden-Württemberg Stiftung
VERÄNDERN

Leading the way among fine papers

Sappi Stockstadt GmbH is part of the South African Sappi corporate group, the global market leader in coated fine papers. Sappi Stockstadt has focussed on providing high quality and sustainable products and services to the specialist trade, printers, publishers and designers. Our uncoated papers and coated fine papers help our customers to achieve their goals. We produce our papers on one paper machine and one coating machine, and offer both sheet and reel products.

Our fine paper is typically used for high-quality promotional brochures, company reports, books and magazines.

Sappi Stockstadt GmbH products are sold in Germany, Europe and in many countries overseas.

An introduction to Sappi Stockstadt

A chemical pulp and paper mill for 120 years

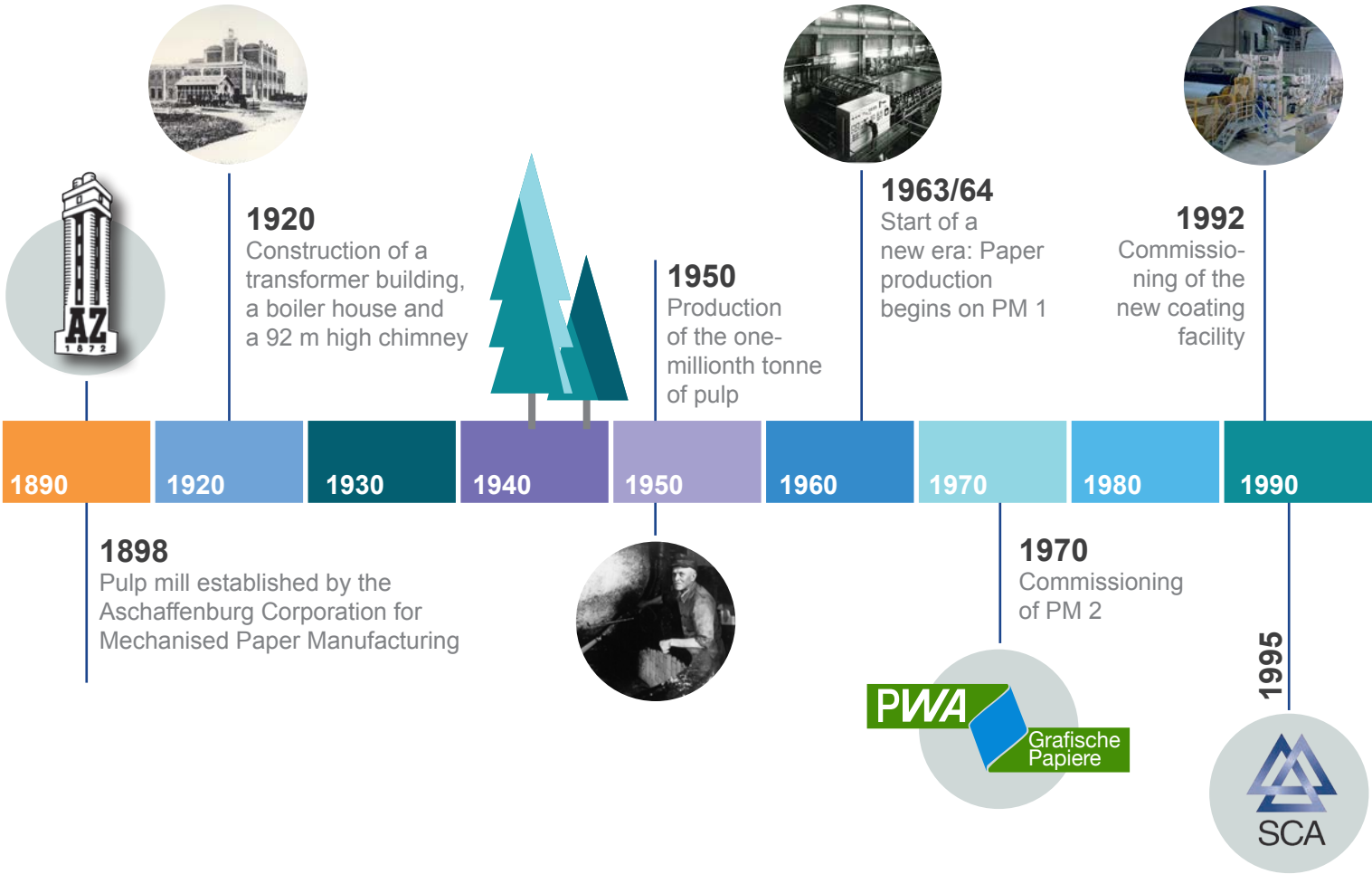
In 1898, at the time of the industrial revolution, the then "Aschaffenburg Corporation for Mechanised Paper Manufacturing" - AZ for short - commenced production in Stockstadt. Back then, as it is today, Stockstadt was ideally located as a production site. This was due to its central position for customers, its location at the centre of the regions of Spessart, Odenwald and Taunus which are rich in beechwood, and its position on the banks of the Main river which provides sufficient volumes of the process water required. In 1900, the mill recorded annual production of more than 10,000 t of pulp and was considered to be one of Europe's largest pulp plants. Much has changed since then - today this volume is equivalent to less than one month's production for Stockstadt!

AZ passed through several stages of development before becoming Sappi Stockstadt GmbH, a modern, integrated chemical pulp and paper mill with its own power plant and wastewater treatment plant, high environmental protection standards and an excellent level of health and safety.

Thanks to ongoing technical as well as technological improvements, Sappi Stockstadt GmbH has changed significantly in the information technology age. Today, the company employs a workforce of approximately 600 employees at the site, together with approximately 40 trainees, and is able to produce up to 145,000 t of pulp and 230,000 t of paper per year.

Since 2009, the mill has been part of the South African Sappi corporate group - one of the global market leaders in coated fine paper. With its production of high-quality fine papers, Sappi Stockstadt forms part of the core activity of the group.

In 2020, we are able to look back on 122 years of pulp production and 57 years of paper production at the Stockstadt site. Since 1996, Sappi Biotech GmbH (formerly the Zellwildshausen Chemical Mill) has been operating a state-of-the-art lignin plant. Lignin not only makes materials stable, but due to its dispersing and fluidifying properties and its ability to



bind fibres, it can be used in a variety of different ways. It is also described as a "green binding agent" and can be used to manufacture products normally produced using petrochemicals, such as in the construction sector as an admixture in cement and concrete.

Pulp production

The basis for the production of pulp is beech and spruce wood which is delivered daily by truck. In the saw mill, the logs are cut to a length of 150 cm, the bark is removed in the debarking drum and the logs are then processed into wood chips. The wood chips arrive in six 'cookers' via silos. After several hours of cooking, a chemical pulping of the wood occurs and the cellulose fibres are separated from the wood composite. This reduces the lignified substances - the lignin - to 3%. Most of the internal pulp is pumped directly to the paper machines. The remainder is dried, cut into sheets and sold.

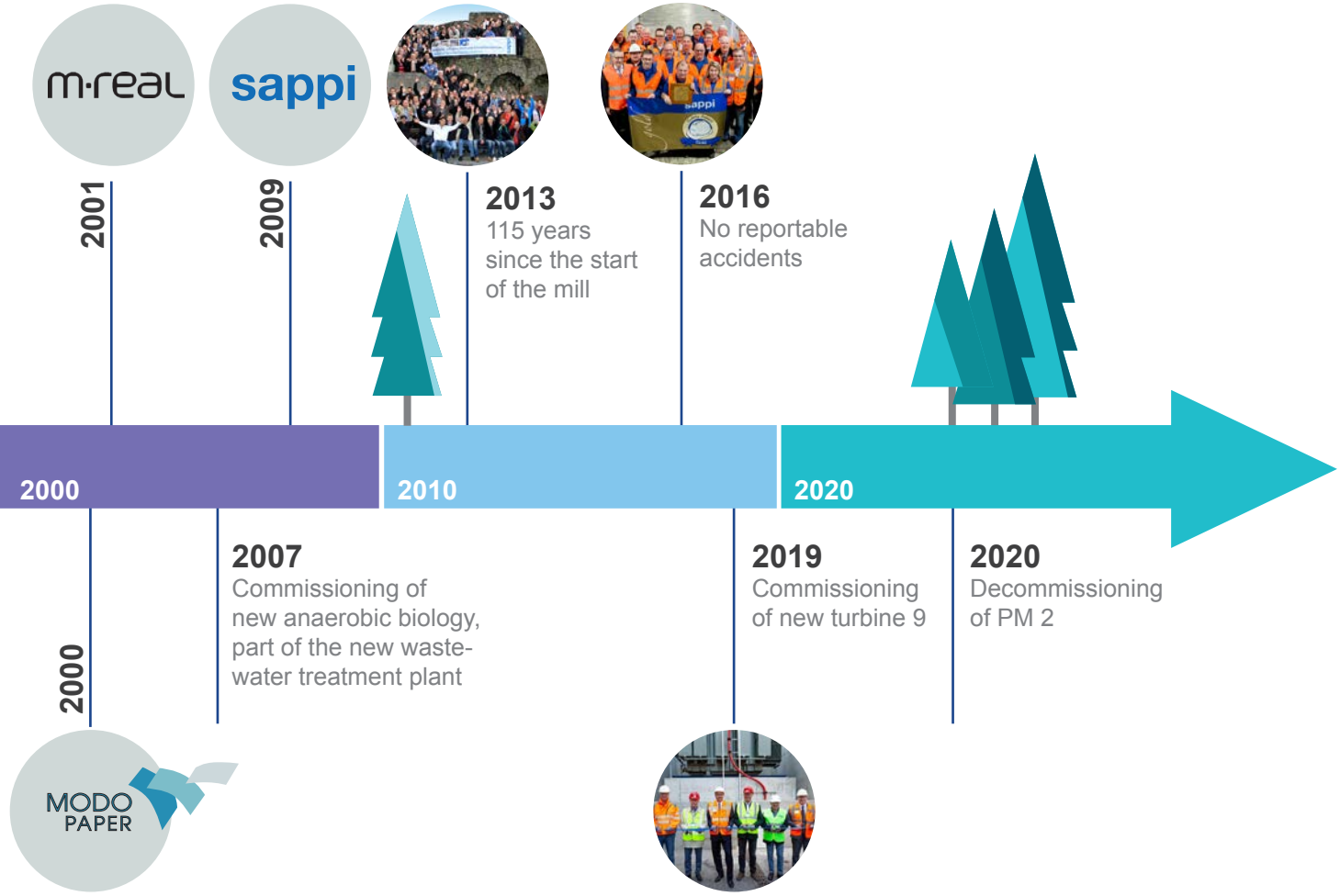
Paper production

A mixture consisting of short fibres (internal pulp) and long fibres (external pulp) is used on the paper machine according to the grade. The water is extracted from this mixture of pulp fibres, fillers and water between two screens and the mixture is then fed over the press and dryer section. The paper web is dried using steam-heated cylinders.

Paper machine 1 produces uncoated fine paper and coating base paper which is then enhanced on the coating machine. On the 100 m long coating machines, the flat fibrous structure of the base paper is covered with a pigment layer in one even application. The paper is therefore given a matte or gloss surface in two operational steps.

Equipment

In this converting department the paper reels are cut and packed. For sheet paper production, so-called 'sheeters' are used which cut the paper reels into sheets according to the individual customer's requirements. The sheets of paper are then stacked onto pallets or packed into smaller packaging units. In the dispatch warehouse, both the roll as well as the sheet pallets are prepared for dispatch to the customer.



Environmental policy and organisation

Sustainable development is a necessity for Sappi and starts with each individual employee. Sappi Limited has therefore integrated the following 3P approach for supporting the sustainable development of all business divisions within operational activities:

People

We work to promote the health and safety of all employees

Plant

We minimise environmental impact and supply recyclable products based on renewable raw materials

Prosperity

We seek to be profitable in a sustainable manner and to achieve a high level of customer satisfaction through innovation and acting ethically

Sappi Europe's sustainability strategy is based on three key pillars:

PRODUCTION
Sustainable, paper-based solutions

INNOVATION
Products supporting a bio-based circular economy

PARTNER
Accelerating change via the value-added chain

On the basis of the UN's sustainability goals, the following targets have been set for Sappi Europa for 2025:

7 AFFORDABLE AND CLEAN ENERGY

50 % Share of renewable and clean energy

5 % Improvement in energy efficiency

12 RESPONSIBLE CONSUMPTION AND PRODUCTION

15 % New products with defined sustainable characteristics

5 % Reduction in waste going to landfill

13 CLIMATE ACTION

25 % Reduction in specific CO_2 emissions

15 LIFE ON LAND

> 78 % Use of certified fibres

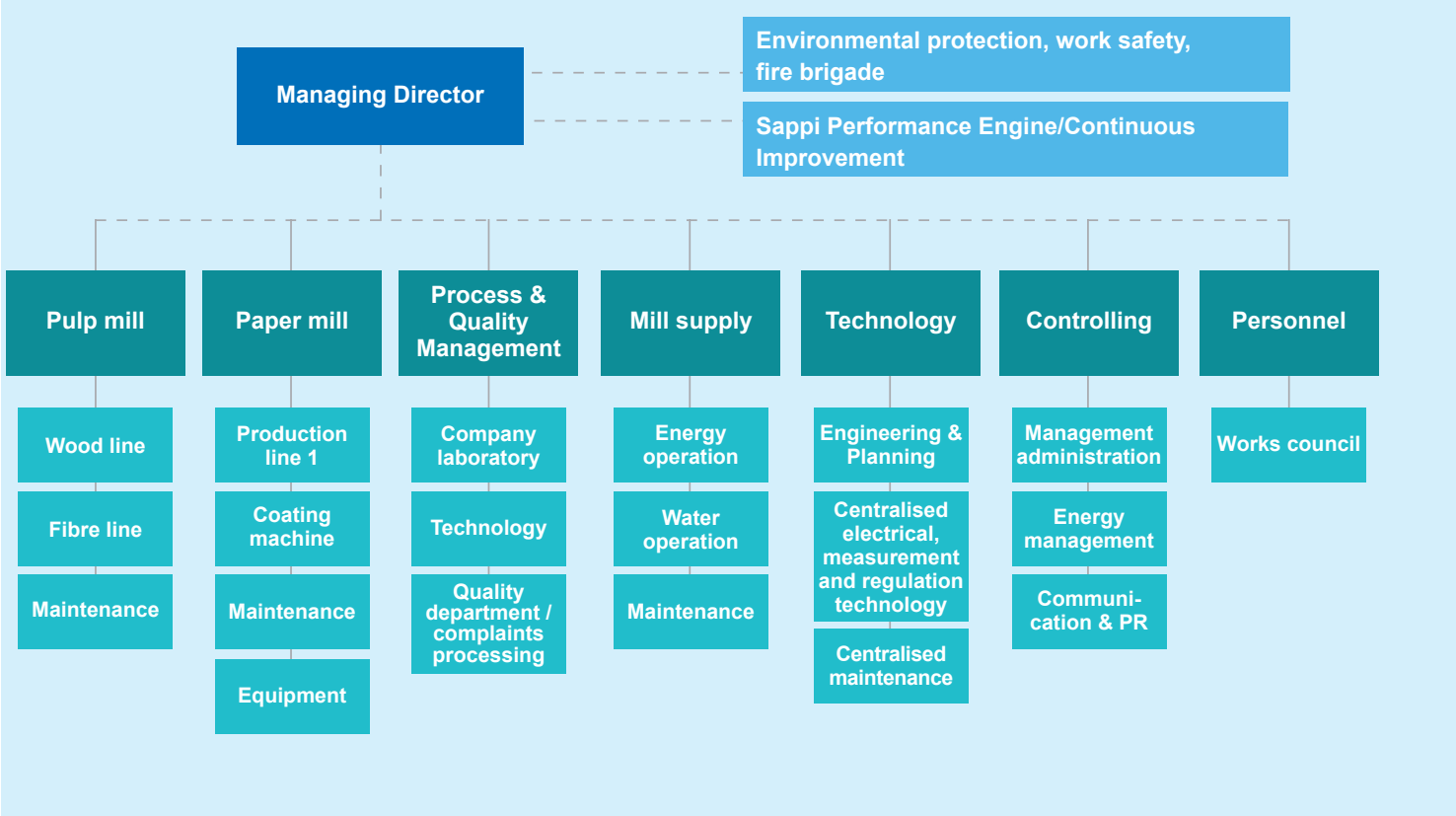
In Europe, our "eco-effective" approach has enabled us to integrate environmental protection and sustainability within our day-to-day work. We want to achieve our goals effectively and efficiently with minimal impact on the environment. This is the way we work, as employees and as a company.

These overarching goals are implemented using specific measures in the annual Sappi Stockstadt GmbH environment programmes.

The managing director of Sappi Stockstadt GmbH has overall responsibility for the Stockstadt site. The managing director delegates this responsibility in accordance with the simplified organisational structure presented. The management team and all employees are supported in an advisory capacity by management representatives and other experts who are appointed in the areas of work safety, quality, environment and energy.

Emergency management is described in the emergency and hazard prevention plan and also includes crisis management. Sappi Stockstadt GmbH employees receive training on a recurring basis in annual courses on general conduct in emergencies and in specific training on fire protection and first aid.

The effectiveness of the management system is regularly assessed in management committees by the managing director. The elements upon which this review is based include data and key figures from all divisions, reports from the representatives and the results of internal and external audits. Regular evaluation of operating numbers is used to monitor success and forms the basis of the management review and for determining the measures and programmes required for the continual improvement of environmental performance.



Our environmental policy

We are all responsible for the environment

We view the preservation of our environment as the basis of our work. As part of this, not only do we adhere to statutory regulations, but we are also guided by social norms and values which are continually developing. We are all responsible for protecting the environment. We therefore ensure that our employees have the necessary competencies and abilities to fulfil their responsibility to our environment.

We are constantly improving our environmental performance

In the development of our products, processes and working methods, we pay particular attention to optimising energy efficiency and improving our environmental balance sheets. Our aim in this respect is to continually reduce adverse regional and global environmental impact arising from our production activity. When developing our production processes, we therefore factor in use of the best available technology.

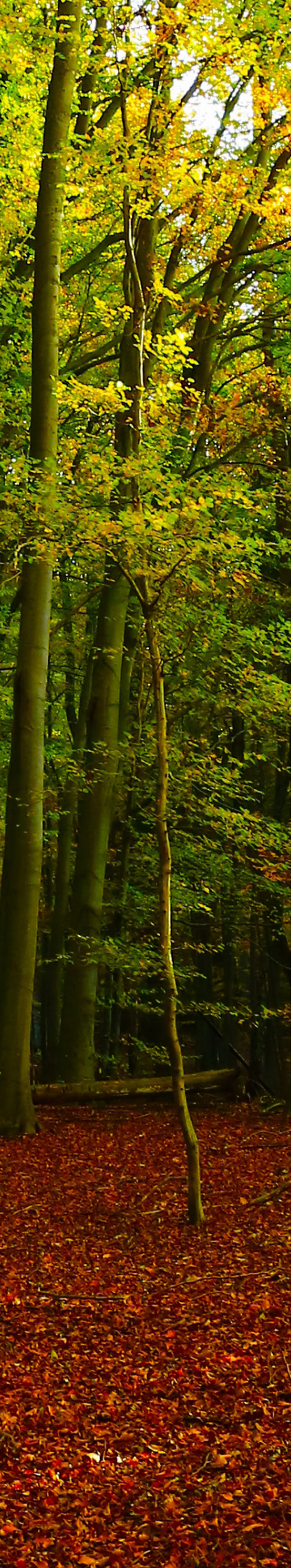
We manage raw materials and products responsibly

We conserve resources through the economical use of raw materials and energy. A particular concern for us in this respect is the safe use of chemicals. Any waste produced is primarily to be used as raw materials or used to generate energy.

We produce recyclable products which largely consist of the renewable raw material of wood. We therefore support the independent certification of sustainable forest management and continually strive to increase the percentage of certified wood in our products.

We have a policy of transparent communication

We are open and honest in the communication of our environmental performance. We publish environmentally-relevant information about our products and production processes and participate actively in dialogue about our environmental protection activities.



Sustainable forestry

Wood is a valuable and sustainable raw material and is the basis for the production of pulp and paper. The constant supply of wood for ensuring uninterrupted production is of critical importance to Sappi Stockstadt GmbH. As a company specialising in the processing of wood and pulp, we have a particular responsibility to society, woodland and the environment.

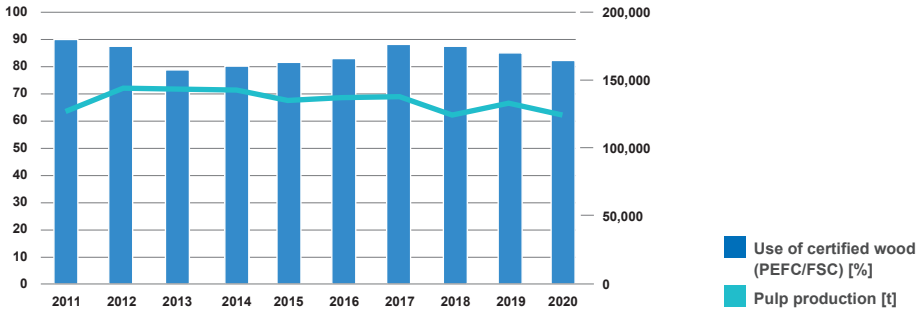
In the 2020 financial year, almost 82.1% of all wood processed in Stockstadt originated from forest managed in accordance with FSC® 1) or PEFC 2) guidelines. The extent of certification of the bought-in pulp for paper production is 67.6% PEFC and 14.5% FSC. Sappi is confident that both certification organisations - PEFC and FSC - ensure that the raw materials used come from sustainable and responsibly managed sources. Around 18% of the wood is not covered by the above and for this Sappi uses an extensive risk assessment to verify that the fundamental standards in forestry management are adhered to, i.e. that this wood originates from so-called controlled sources.

This rules out the following:

- **Illegally harvested wood**
- **Wood from regions in which forestry is managed in breach of traditional or civil basic rights**
- **Wood from forests, the particular conservation value of which is endangered by forestry management**
- **Wood taken from the transformation of natural woodland into plantations or for non-forestry uses**
- **Wood from forests which are planted with genetically modified tree species**

1) FSC® C015022 2) PEFC/07-32-76

Use of certified wood (PEFC/FSC) 2011 - 2020



proNARO GmbH, a joint undertaking of Sappi Europe and Essity, is responsible for the procurement of wood for Sappi Stockstadt GmbH.

We purchase wood in principle only from forests which are sustainably managed on the basis of national forestry legislation and preferably from suppliers who are able to demonstrate forest or Chain of Custody certification in accordance with PEFC or FSC. Both Sappi Stockstadt GmbH as well as proNARO GmbH are certified under both systems. proNARO also has Chain of Custody certification for wood and wood-based products under DIN ISO 38200. This means we have secured the complete supply chain from wood to final product.

The certifications of our forestry companies, of the wood procurement and of Sappi Stockstadt GmbH are audited on an annual basis by independent qualified and accredited certifiers. The results of this audit are published.

Saw mill with noise abatement wall

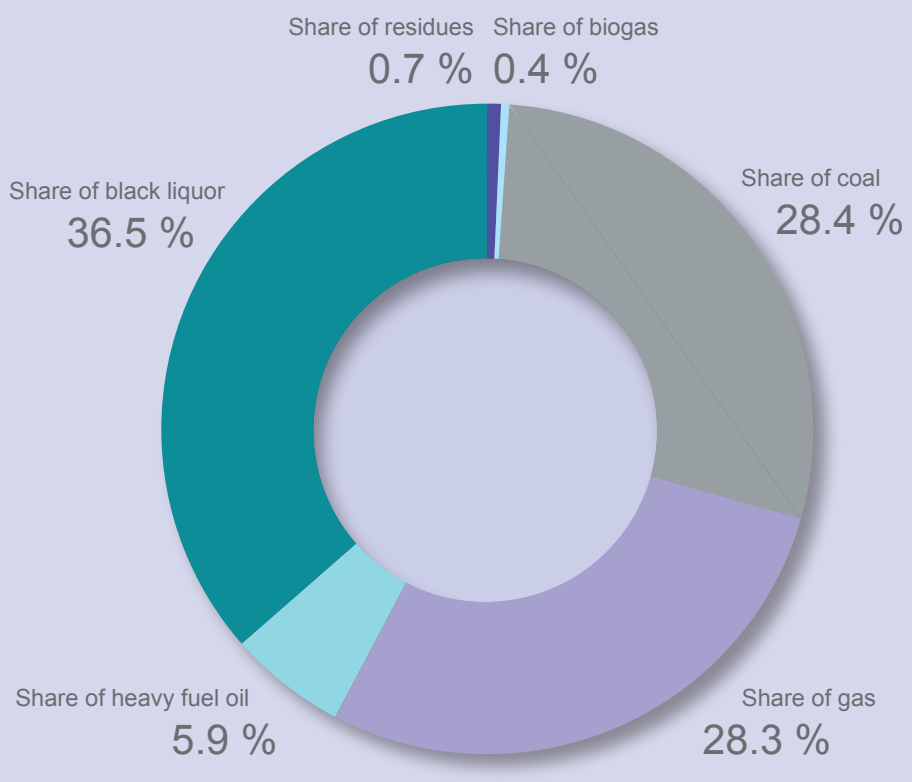
Energy management

Sappi Stockstadt is aware of its responsibilities as an energy-intensive company and is highly focussed on pursuing its energy and environmental policy through the environmentally-friendly use of raw materials and energy and by improving energy efficiency. Since 2018, Sappi Stockstadt has also been a participant in the energy efficiency network for energy intensive industries in Lower Franconia [Energieeffizienz-Netzwerk Energieintensiver Industrien in Unterfranken]. Together with other energy-intensive companies including energy consultants as well as suppliers, new and existing methods for saving energy are considered, and feasibility is discussed through the active sharing of experiences. Company tours show how the theory works in practice. The network will run from 2018 to 2021.

New investments have enabled significant progress to be made towards energy efficiency. In February 2019, the new counter pressure steam turbine 9 was commissioned. This replaces the current turbine 7 and, due to its new design, is able to generate significantly more electricity with the same volume of high-pressure steam. This measure is particularly relevant for the environment because the turbine enables electricity to be generated from renewable energies - our biomass. The amount of heat required in the pulp mill was also reduced significantly. A new group of heat exchangers was installed in the bleaching plant process which means that 45,000 t of steam per year can now be saved. A further steam saving of around 70,000 t per year was achieved by means of heat recovery from the wastewater from the HC press (high consistency press in the bleaching plant).

A new auxiliary metering system was installed in the area of paper production and while this did slightly increase power required, it achieved a more than proportionate steam saving of 13,000 t per year.

Energy use 2020



In addition to the investment measures, possibilities for saving energy by changing the way the plant operates are constantly being sought. For example, around 405 MWh of electrical energy per year were saved by switching off exhaust air systems using a time control without jeopardizing the exchange of air required. As part of team board meetings in the individual departments, many measures are considered in terms of their opportunities and risks and decisions made on their implementation.

The past financial year was significantly impacted by partial load operation and by downtime as a result of the coronavirus pandemic. However, in pulp generation and production on paper machine 1 there was specific energy saving. Due to the stop-and-go operation coupled with, in some cases, very long down times on the coated production line, the successful savings made were then eroded. An increase in specific total energy consumption of just 1.9 % means that despite the difficulties we have completed the financial year well.

Emissions

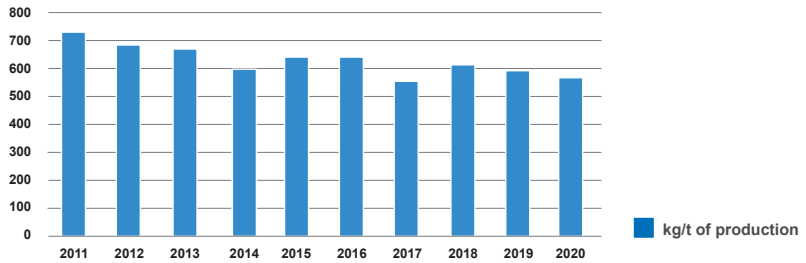
External view of the new turbine 9

Sappi Stockstadt GmbH operates its own cogeneration plant with three boilers for power generation. The highly efficient power plant is run using the so-called combined heat and power process which means steam is used for both supplying heat as well as generating power. This produces a higher rate of use of approx. 85% of the fuels used. Both fossil fuels (energy and gas) as well as biogenic fuels (lignin from the pulp production, biogas, and dry material from the wastewater treatment plant) are used to produce energy in the three boilers. Emissions are created from the combustion in the boiler which comprise mainly carbon monoxide and dioxide, nitrogen dioxide and sulphur dioxide as well as dust. European and in some cases even stricter national regulations (e.g. Federal Control of Pollution Act with regulations and The Technical Instruction on Air Quality) require costly flue gas cleaning. Dust extraction systems (electrostatic air filter), a flue gas desulphurization system, low NOx burners and a denitrification plant - a so-called SNCR system - ensure that emissions are cleaned in accordance with state-of-the-art technology. Compliance with air quality limit values is monitored continually using online measurement equipment.

An important strategic sustainability target for Sappi Stockstadt GmbH is the reduction in greenhouse emissions, i.e. minimising CO2 emissions through to the major target of the decarbonisation of pulp and paper production. Three different ways are being used in Stockstadt to achieve this target. Our energy management system ensures that the energy utilised in all areas is used as efficiently as possible and that potential energy savings are identified and exploited. The second priority is making maximum and efficient use of the biomass created in the course of production at the site for the purposes of energy generation. In the 2020 financial year, approximately 40% of the steam required was produced using biomass. In 2019, a new highly efficient turbine was installed to ensure optimal utilisation of the fuels used. The turbine replaced three old units. The higher level of efficiency meant that the production of green electricity was increased by 20%. This electricity no longer has to be bought in externally. The third way involves the move away from coal as a fuel. Over the past financial year, the gas boiler and the coal boiler were operated on an alternating basis and in this way CO2 emission levels were further reduced. Plans were also started to fully replace coal with lower CO2 fuels.

Over recent years, one focus of the emissions optimisation was the reduction of dust emissions on the so-called pulp production recovery boiler. This was due to the need to adhere to stricter limits. In coordination with the monitoring authorities, an external expert was consulted for this purpose. As an initial measure, a new lamallar droplet separator was installed, nozzles in the gas scrubbers were replaced and trials with additional injection lances were carried out. The dust values were lowered, however it was not possible to fully achieve the target. In the 2021 financial year, Sappi Stockstadt GmbH therefore plans to commission a test facility (combination of a wet electrostatic filter and a gas scrubber) to be able to complete the final step in the reduction of dust emissions.

Specific CO_2-emissions (fossil) 2011 - 2020



Total annual CO_2 emissions
(no emissions of the following gases: CH_4, N_2O, HCFC, PFC, NF_3, SF_6)

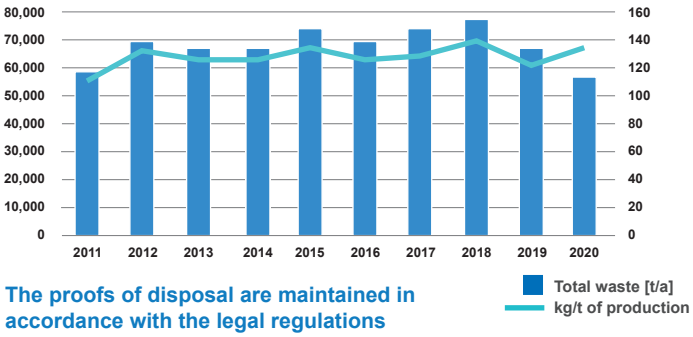
Waste management

In the 2020 financial year, a total of 57,485 t of waste was accumulated for disposal. This is equivalent to a volume of 157 t per day or, as a specific value, 133.4 t per ton produced (of paper and pulp). This value also includes wood by-products from pulp production which represent a recyclable material and generate revenue in the market. The overall volume of waste has reduced significantly compared to the previous year; a result of the reduced production due to the coronavirus crisis. The specific waste volume increased compared to the previous year. This is due in particular to the increased specific accumulation of wood by-products in pulp production. In freshwater treatment and in the wastewater treatment plant work was undertaken on reducing the accumulating sludges. Positive outcomes are achieved in the accumulation of Main river sludge which meant a significant reduction in specific Main river sludge accumulation. Due to the reduced operation of the coal boiler in the generating plant, more sewage sludge for external disposal was accumulated. Compared to the previous financial year, approximately half of the coal volume was used for energy generation. There was therefore an equivalent reduction in fly ash and FGD gypsum for utilisation. The specific accumulation of fly ash per ton of coal used also improved compared to 2019.

A key environmental factor in the context of waste management is transporting waste. Short transportation distances to users reduce emissions and transport costs. It is therefore important to Sappi Stockstadt GmbH to work together with certified, local and regional disposal contractors. When conducting audits of disposal contractors, we look for a high level of work safety in addition to issues such as disposal reliability and transparency. Our business partners are frequently in our mill on a daily basis and are therefore also able to have a positive influence on work safety performance.

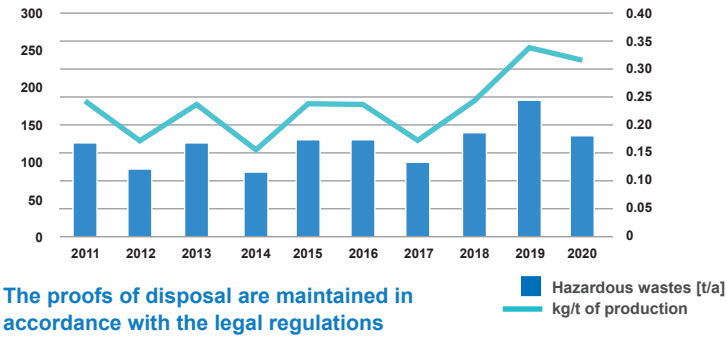
The utilisation rate has remained at a consistently high level. It has been possible to utilise 99.7% of waste. Only 0.3 percent by weight has been disposed of in landfill or in specialist waste disposal facilities. This is due, among other things, to the well-functioning waste separation of the individual fractions and efforts made in general to identify the highest quality utilisation method possible for the waste streams accumulated.

Waste volumes 2011 - 2020



The proofs of disposal are maintained in accordance with the legal regulations (Recycling Law and Ordinance on Waste Recovery and Disposal Records)

Hazardous wastes 2011 - 2020



The proofs of disposal are maintained in accordance with the legal regulations (Recycling Law and Ordinance on Waste Recovery and Disposal Records)

Water

Pulp and paper manufacturing is an energy and water intensive process. Water is used as a solvent, a means of transport and as a coolant, as well as in the form of steam for supplying energy to the mill. It is no surprise, therefore, that energy and water management are given a high priority at the Stockstadt Mill.

Since the construction of the wastewater treatment plant in 1994, significant investment and a great deal of expertise has been committed to the ongoing modernisation of the plant. The last major project for reducing the wastewater load went into operation in 2018. The washing filters in the pulp production were replaced and modified using modern technology which meant that more efficient pulp washing was possible and the COD concentration was reduced in a wastewater stream. In the area of water, the focus of measures in the last financial year was on heat recovery. New heat exchangers were installed in two wastewater streams - in pulp production and in paper production - in order to lower wastewater temperatures. On average, approximately 45,000 tons of steam per year were saved. A new biomonitoring pool for monitoring the toxicity of wastewater was put into operation in 2019 to meet a new regulatory requirement.

Biomonitoring pool

Water treatment

An average of more than 40,000 cubic metres of water are taken from the river Main each day and very carefully treated for the different uses for which it is required. The first cleaning stage ensures that suspended sediment is removed from the Main river water using two filter lines. For subsequent use in the generating plant, the water must be softened and deionised in order to prevent calcification and corrosion.

Depending on the level of contamination, the water is reused several times in production areas for different purposes before being fed into the highly efficient wastewater treatment plant for cleaning. For example, in the pulp washing process, the least contaminated wastewater from the last washing stage is reused in the first washing stage. Uncontaminated cooling water is circulated within its own loops and reused. Proactive water management is necessary for reducing the use of freshwater and costs, and for preserving the environment. The specific freshwater volumes per ton produced (pulp and paper in total) which have been increasing since 2017 are a result of product developments. In the previous financial year in particular, specific values increased due to low utilisation of PM2 and SM2. Increasing down times are associated with system cleaning for start-up and shutdown operations and this negatively impacts water consumption. In this context, the thermal management of water streams in the plant is becoming increasingly important for keeping the temperature of the wastewater low for the wastewater treatment plant and for recovering energy. The cleaning or cooling of wastewater following use of the water in the wastewater treatment must only be the final step required in the overall process.

Wastewater treatment

The wastewater streams are separated, depending on where they come from, into three different wastewater treatment lines in order that cleaning can be optimised according to the level of contamination.

Some of the wastewater from the pulp production is initially pre-treated in the high-load moving bed facility consisting of three 1,000 cubic metre chambers. The concrete basins are filled up to around 40 percent with specialist substrate material which floats in the pools. Bacteria lives on the substrate material and “dissolves” the harmful

suspended matter in the water and cleans it in the process. The oxygen required is fed in via a special air distribution system.

Another wastewater stream from pulp production originates from the thermal wastewater treatment and is anaerobically treated (oxygen free). This stage is highly complex. It reduces pollutants in the wastewater using microorganisms and generates biogas as a metabolic product which is used for thermal recovery in the cogeneration plant. The facility consists mainly of a steel container with a capacity of approximately 1,300 m³. Via an inflow distribution system in the floor, the wastewater flows through the container from bottom to top. In the upper area of the container, the biogas, the pellet sludge containing microorganisms and the water are separated from one another. By recovering the biogas, the use of fossil fuels can be reduced. In the subsequent treatment stages (oxygenation and secondary purification), pollutants are further reduced and biomass is retained in the system.

The wastewater from paper generation is cleaned following a preliminary purification stage in an anaerobic, biological fixed bed filter. The wastewater containing calcium carbonate from the coating machine is prepared by keeping the different wastewater streams separated in such a way that the maximum amount of carbonate can be reused in production.

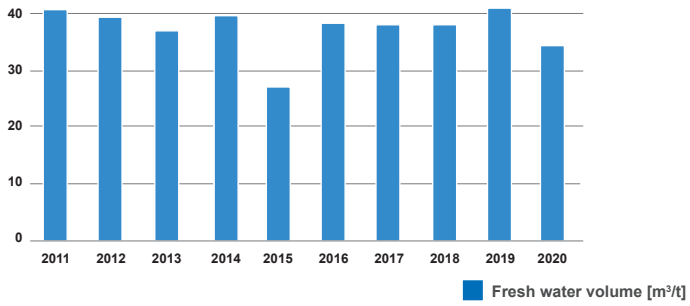
In this way, the wastewater is discharged to the wastewater treatment plant, a raw material is recovered for production and less waste is disposed of.

The wastewater from the area of the generating plant is largely contaminated with minerals, it is cleaned in a chemical and physical treatment plant and then fed to the river Main.

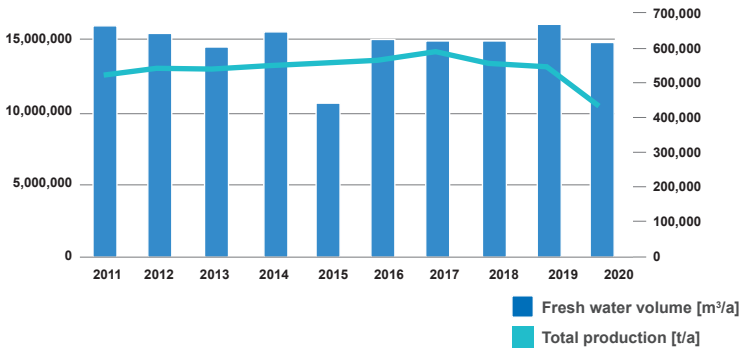
All treated wastewater is monitored using a complex online measurement system, additional laboratory measurements and by means of measurements conducted by the authorities. This is then ultimately fed back to the river Main.

This ensures adherence to all legal requirements of the Water Resources Act [Wasserhaushaltsgesetz], the Wastewater Ordinance [Abwasserverordnung] and the Self-Monitoring Ordinance [Eigenüberwachungsverordnung].

Fresh water volumes, specific, 2011- 2020



Fresh water volumes, absolute, 2011- 2020

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Transport und logistics

Sophisticated logistics are required to supply a company operating around the clock and almost 365 days a year with raw materials and supplies. In total, more than 600,000 t of different materials and products have to find their way into the mill and, on average, each working day around 1,200 t of paper is supplied to customers.

As a result of its central location in Germany and in Europe, and of its excellent connections to the motorway, railway and the river Main, the location of Stockstadt offers all that is needed to ensure effective logistics. Materials required in large volumes are supplied by barge (pulp, calcium carbonate, coal). Chemicals used in larger quantities in production, or which present a heightened level of risk when being transported, are supplied by rail. In the 2020 financial year, 53% of raw materials and supplies for paper production were supplied by barge, 28% by rail and 20% by truck. Wood is delivered almost entirely by truck because the regional availability of the beechwood used means that the transport distances involved are comparatively short. The average distance travelled for transporting our wood is approximately 100 km. Pulp from Stockstadt is therefore undoubtedly a regional product. Pulp is highly integrated internally for paper manufacturing and other types of pulp produced in Germany are also used. This means that, in terms of the fibre element, the number of kilometres which the paper - the final product - needs to be transported is comparatively low.

Sappi Stockstadt GmbH supplies paper globally to its customers, however the German and European market represents one of the main areas. Due to the size of most of the orders, our products are mainly delivered by truck. The hauliers which transport our paper to our customers are contractually required to comply with the Euro 6 emissions standards.

However, it is not only external transport which impacts on the environment. Internal transfers, business travel and the travel to work and back home of our employees causes emissions which we therefore wish to minimise as much as possible. This means that "small-scale" environmental protection measures such as the provision of electric vehicles as company cars and the opportunity to lease a company bicycle also minimise environmental impact and increase the awareness of environmental protection among our employees. The company bicycle leasing in particular has been taken up enthusiastically by Sappi employees. A total of 313 e-bikes and traditional bicycles were acquired and their use for travelling to the plant means that, on a daily basis, CO_2 emissions are avoided as well as benefiting the health of our employees.

Environmental Balance Sheet 2020

Raw materials and supplies

Energy		
Total fuels	**1,442**	**GWh**
Specific fuels	**3.35**	**MWh/ t prod.**
Natural gas, energy generation	383	GWh
Natural gas, process	25	GWh
Total natural gas	408	GWh
Heavy fuel oil (2.8%)	86	GWh
Coal	408	GWh
Fossil Fuels	**902**	**GWh**
Black liquor	525	GWh
Residues	10	GWh
Biogas	5	GWh
Biogenic fuels	**540.242**	**GWh**
Proportion of renewable energies	**37.5**	**%**
Spec. biogenic fuels	**1.25**	**MWh/ t prod.**
External generation	139	GWh
of which physical purchase	67	GWh
of which EEG standby power	71	GWh
Overall land use	375,000	m^2
Land built over	295,000	m^2
Land near natural	80,000	m^2
Total freshwater	**14,900,884**	**m^3**
of which Main river water	14,886,985	m^3
of which mains water	13,899	m^3
of which cooling water	6,643,172	m^3
Specific freshwater	**34.6**	**m^3/ t**
Total wood purchases	**268,354**	**t atro**
Proportion of round wood	173,214	t atro
Proportion of wood chip	95,140	t atro
PEFC certified	67.6	%
FSC certified	14.5	%
Total certified	82.1	%
Total pulp consumption	**177,145**	**t atro**
Own pulp (integration)	102,242	t atro
Third-party pulp	74,903	t atro
Total chemical consumption	**145,674**	**t atro**
Pigments and fillers	101,586	t atro
Binders	11.123	t atro
Other chemicals	32,965	t atro
Fuels (energy content)	**1.52**	**MWh**
Petrol	2,276	l
Diesel	172,827	l
Auto gas	8,404	kg
Packaging materials (not including pallets and sleeves)	1,647	t

Production

Freshwater treatment

Cogeneration plant

Production of electricity/steam/ compressed air

Pulp production

Wood yield
2.17 t wood / t pulp

Total pulp

Own pulp (integration)

Total energy consumption	**1,727**	**GWh**
Spec. tot. energy consumption	4.01	MWh/ t prod.
Total steam consumption	1,643,538	t (120 bar)
Total compressed air consumption	**82,436**	**TSD Nm^3**

Waste products and emissions

Residues		
Total residues	**57,485**	**t**
Specific residues	**133.4**	**kg/ t prod.**
Total utilised	57,316	t
Total thermal utilisation	30,537	t
of which therm. utilisation int.	2,674	t
of which therm. utilisation ext.	27,863	t
Recycling	8,072	t
Total disposal	114.1	t
of which disposal to landfill	28.4	t
Hazardous waste	136.6	t
Specific haz. waste	0.32	kg/ t prod.
Utilisation ratio	99.7	%
Disposal ratio	0.2	%
Hazardous waste ratio	0.2	%

Of which material residue fractions

- Bark
- Fibrous material
- Millings
- Fly ash
- FDG Gypsum
- Sewage sludge
- Main river water sludge
- Chemical recovery residues
- Recycled paper, cardboard
- Total

Internal generation

Electricity	218	GWh
Steam	1,643,538	t (120 bar)
Compressed air	82,436	TSD Nm³

Wastewater treatment

123,694 t

102,242 t atro

Paper production

Pulp yield
0.58 t pulp / t paper

Total electricity consumption	**285**	**GWh**
Specific electricity consumption	0.66	MWh/ t prod.
of which electricity consumption, process	216	GWh
of which internal consumption, power plant	69	GWh

Products

Market pulp	**7,852**	**t**
PEFC certified	67.6	%
FSC certified	14.5	%
Total paper	**307,179**	**t**
Uncoated paper	196,737	t
Coated paper	110,442	t
PEFC certified	56.0	%
FSC certified	27.0	%
Total production (paper and pulp)	**430,873**	**t**
Black liquor sales	12,953	t

Energy

Electricity fed to EEG	71	GWh
Electricity fed to third parties	1.32	GWh

	22,539	t
	5,110	t
	6,168	t
	5,471	t
	2,969	t
	8,104	t
	2,883	t
	1,269	t
	724	t

Emissions into atmosphere

	absolute		specific	
SO_2	384.5	t	0.89	kg/ t prod.
NO_X	380.4	t	0.88	kg/ t prod.
Dust	37.7	t	0.09	kg/ t prod.
CO_2 fossil	246,868	t	573	kg/ t prod.
CO_2 biogenic	168,685	t	391	kg/ t prod.

Wastewater

	absolute		specific	
Total quantities	13,923,433	m³	32.3	m³/ t prod.
COD	3,622	t	8.4	kg/ t prod.
BOD_5	299.8	t	0.7	kg/ t prod.
Total nitrogen	68.8	t	0.16	kg/ t prod.
Total phosphorus	18.4	t	0.043	kg/ t prod.
Solids	267.1	t	0.62	kg/ t prod.
AOX	0.84	t	0.002	kg/ t prod.

Key environmental data 2011 - 2020

Each Sappi Stockstadt GmbH financial year begins in October and ends in September. However, the annual data differs from statistics showing the data for a calendar year.

Production:

The production volumes of paper and pulp reduced significantly compared to previous years as a result of the fall in orders due to the coronavirus pandemic and the shutting down of paper machine 2 at the start of September 2020. More frequent machine down times were therefore also a feature of the financial year which meant negative trends in some of the specific data.

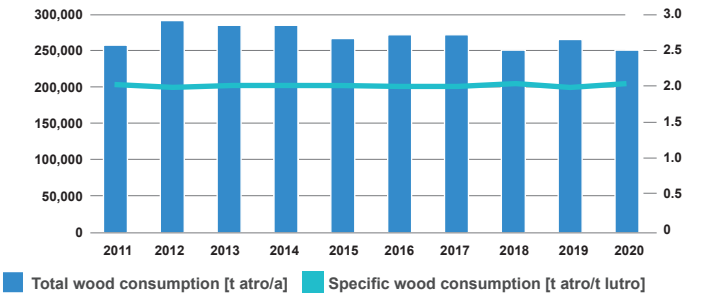
Wood procurement and sustainable forest management:

The strategic procurement goal of 75% certified wood for pulp generation was significantly exceeded in the 2020 financial year with an overall total of 82.1%. The proportion of PEFC wood was 67.6%, while the proportion of FSC wood was 14.5%. The reduction in certified volumes compared to 2019 is a result of slight reduction in FSC wood volumes being purchased. In this case, use for the first time of a proportion of spruce wood, among other things, contributed to the reduction in certified volumes. The proportion of non-certified wood complies with the FSC standard for controlled wood sources. This is verified by means of a risk management system.

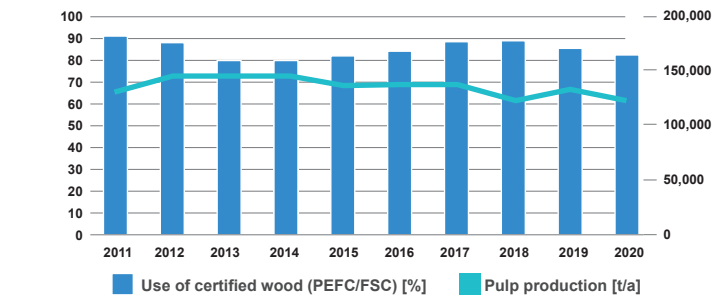
Wastewater:

Absolute wastewater volumes reduced due to the falling production. However, the more frequent starting up and shutting down of the paper machines in the financial year resulted in a negative trend in terms of specific wastewater volume because of the increased cleaning requirement. In terms of COD load and average COD concentration in total wastewater as a measure for contamination of the Main outlet channel, the lowest values of the previous 10 years were achieved.

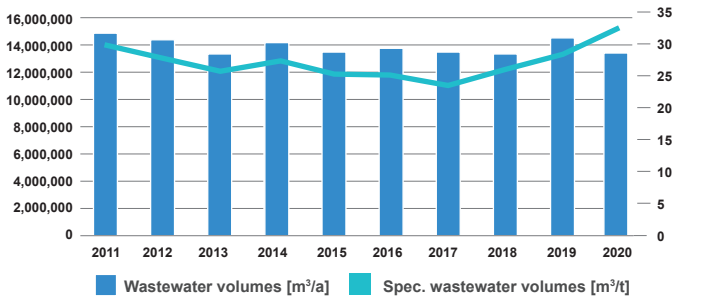
Wood consumption 2011 - 2020



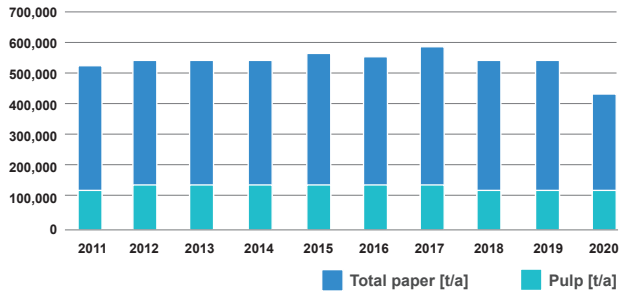
Total use of certified wood (PEFC/FSC) 2011 - 2020



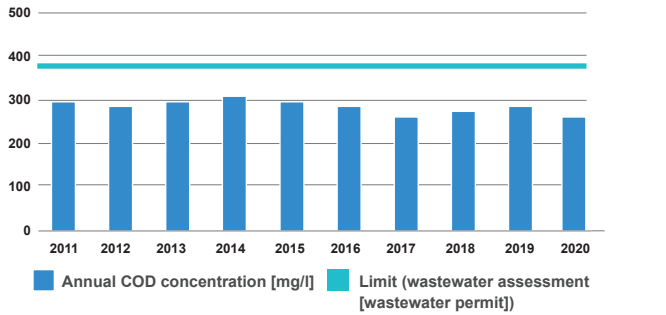
Wastewater volumes 2011 - 2020



Production volumes 2011 - 2020



Average annual COD concentration 2011 - 2020



Waste:

The total waste volume has significantly reduced and therefore also reflects the falling production. By contrast, there was a slight rise in the specific waste volumes.

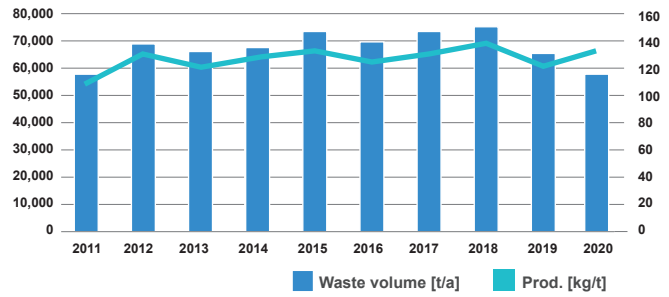
Energy/emissions into atmosphere:

Reduction in fossil CO2 emissions is a key strategic sustainability target which also has consequences for the business. As an energy intensive company, Sappi Stockstadt GmbH is subject to carbon offsetting and must purchase certificates for fossil CO2. The positive trend in absolute but also in specific CO2 emissions was continued.

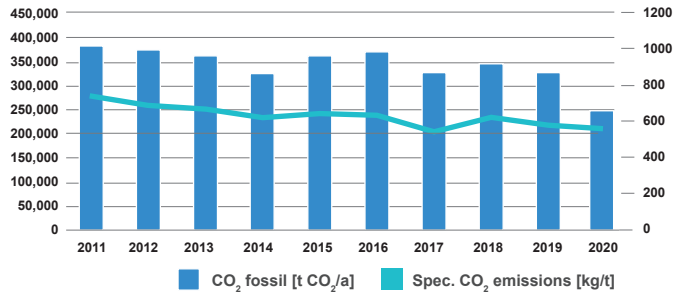
Sulphur dioxide emissions are mainly dependent on the use of sulphur dioxide in pulp production for the digester house and on the use of waste lye for energy generation. The maximum utilisation of waste lye as biogenic fuel for heat generation and for the production of green electricity is a key pillar for Sappi Stockstadt GmbH on the path to decarbonisation.

Absolute nitric oxide emissions have been reducing continually since 2012, although the reduction for the 2020 financial year is explained by the fall in production. There was a slight increase in specific NOx emissions.

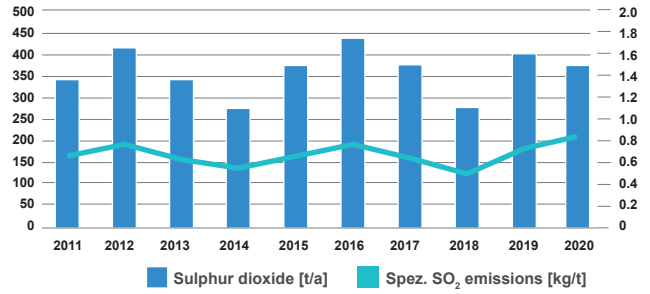
Waste volumes 2011 - 2020



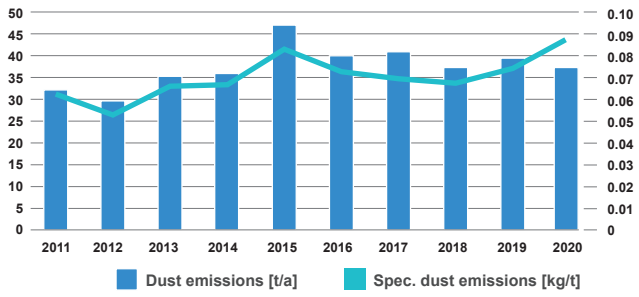
CO_2 emissions (fossil) 2011 - 2020



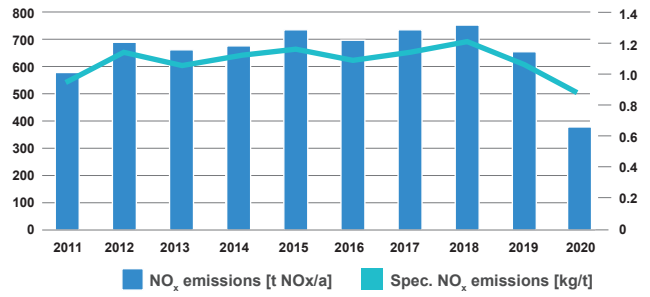
Sulphur dioxide emissions 2011 - 2020



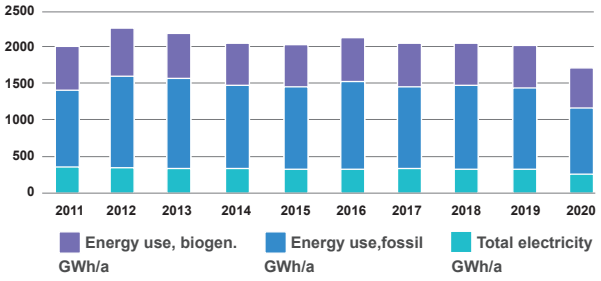
Dust emissions 2011 - 2020



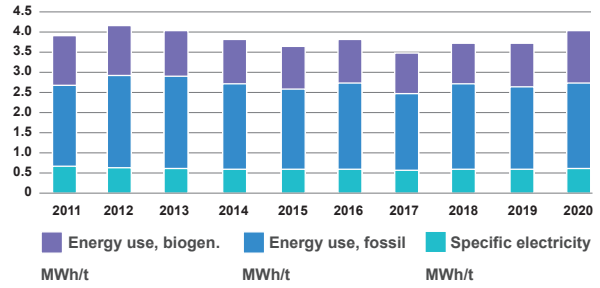
NO_x emissions 2011 - 2020



Energy consumption, absolute



Specific total energy consumption



Focus on people

Neighbours

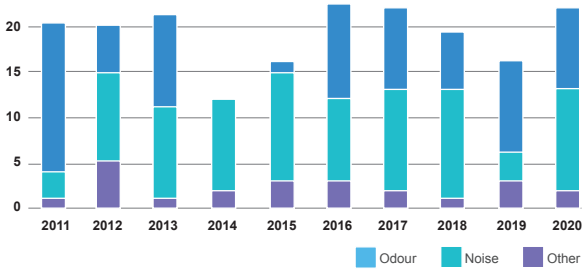
Sappi Stockstadt GmbH was started as a pulp mill in 1898 and has been an established part of the market town community of Stockstadt - a stone's throw from the neighbouring community of Mainaschaff - ever since. Over time, it has developed into an industrial company of regional and national significance. This brings advantages and disadvantages both for residents as well as for employees. For example, a large number of employment and training positions are available, the distances for employees to travel to work are short and are ideally covered in a CO_2 neutral manner on foot or by bicycle. Further examples are the high level of added value and purchasing power in the region.

Sappi Stockstadt GmbH is a company which thinks sustainably and is therefore also aware of the disadvantages of an industrial operation for the surrounding neighbourhood, e.g. volume of traffic, noise emissions and odours. Due to the proximity to residential developments and the size of the company, noise pollution and nuisance odours cannot be ruled out in every situation.

For complaints received, an established process exists in terms of internal and external communication and for documentation. Over the past financial year, a total of 22 complaints were received which included eleven complaints relating to noise and nine relating to odours.

This means complaints increased compared to 2019 which was in part due to specific one-off events, for example in the area of noise. The noise reduction programme, started in 2017 and due to run until 2022, resulted in further improvements in the 2020 financial year. The noise protection limits (in accordance with the Technical Instructions on Noise Abatement (German: TA-Lärm)) in the operation of the pulp production saw mill were adhered to. A further priority for the noise reduction measures was in the area of the generating plant. The installation of a noise protection wall on the turbine building roof, silencers for the wall ventilators, the acoustic decoupling of the steam lines and the insulation of the oxygen lines in the wastewater treatment plant enabled further noise reductions to be achieved. Further investment in the coming financial year will also be made in order to drive forward the noise protection programme. Complaints about odours created mainly as a result of the pulp generation process form another focus of activities. A specialist company prepared an extensive analysis and evaluation of the extraction system installed. The proper functioning of the system was confirmed, however two potential improvements to avoid over pressurising the system were specified and these have been adopted in the current environmental programme.

Complaints 2011 - 2020



In the resident magazine entitled "Your neighbour", Sappi Stockstadt GmbH has reported, and continues to report twice a year on all relevant issues such as the noise protection measures referred to, investments, employment and training positions and large-scale mill shut downs. The emergency brochure is also important for our neighbours. This has been distributed and is made available via the internet on the Sappi Stockstadt GmbH website. We are in close contact, and communicate openly and transparently with representatives of the market town community of Stockstadt and of the Mainaschaff community. We are of course delighted to receive any feedback.

Our environmental officer, Martin Schilha is happy to respond to any issues relating to our environmental themes.

Work safety

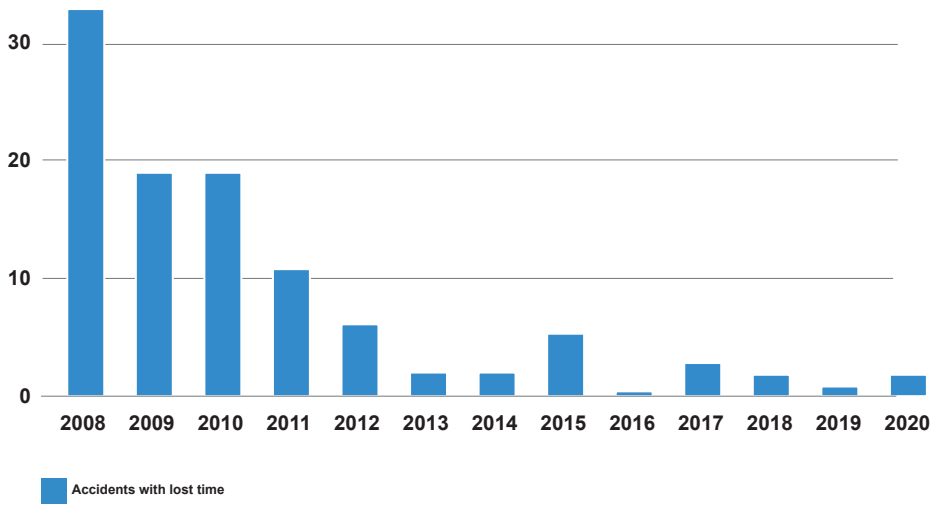
Our vision for work safety is referred to as "Zero Accidents". We have continued to work tirelessly toward this goal over recent years. Following a long and challenging time over the 2020 financial year, our concentrated efforts have finally taken us a step forward. We shall take an in-depth look at the incidents, moving away from accidents involving lost working hours (LTI = Lost Time Incident) towards less serious incidents and preventative messaging. Incidents requiring medical treatement were halved compared to previous years. A further welcome success is achieving 1,000,000 hours without an accident involving downtime. For this we have received the Gold Sappi Safety Award for the fourth time.

We have also been focused on the ongoing participation of each individual employee for the purpose of strengthening our safety culture. The goal for each employee is to contribute multiple safety ideas or measures which they can implement themselves, and to document these on the team board. The level of hazard must be determined immediately before the activity by means of a brief risk assessment and protection measures must be defined. This is an individual goal for each employee and our intention is that it will increasingly become a routine part of everyday work.

Awarding of the fourth Safety Award

The number of accidents in our partner businesses fell slightly. However, we continue to see the need here to intensify protection measures together. The aim is for all people on the Stockstadt site and in our neighbourhood to remain accident free and healthy every day.

Sappi - Key safety data 2008 - 2020



Health management

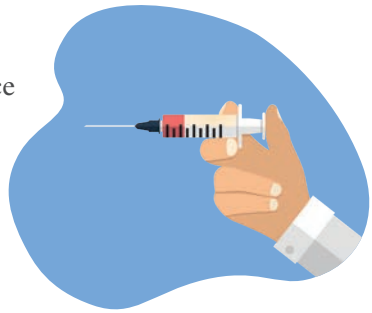
Probably the most well-known definition of health is that provided by the World Health Organisation (WHO): "Health is a state of complete physical, mental and social well-being and not merely the absence of disease or infirmity."

The fair treatment, care and support of employees as well as ensuring the best possible work safety and maintaining the health of employees are all enshrined within company policy at Sappi Stockstadt GmbH. The fact that everybody's health is a precious asset which is deserving of particular attention has become particularly clear over the period of the coronavirus pandemic. In order to fulfil this responsibility, health management is implemented with a range of standard offers for all employees in the mill and over the past financial year was supplemented by the operational pandemic plan.

In addition to measures for preventing accidents at work and occupational illnesses through awareness-building, regular work safety training and examinations by company doctors in the internal health centre, a huge emphasis is placed on company-based health promotion. The targeted measures are aimed at strengthening health and in doing so, at providing preventative measures to avoid illnesses. A health circle [Gesundheitszirkel] has been created for this purpose in order to conduct analyses in coordination with different areas such as the personnel department, the company doctor, the works council and the health insurance funds. Some examples are listed below.

Flu vaccination

The annual flu vaccination in autumn has been standard practice for many years and is taken up very widely.



Workplace ergonomics

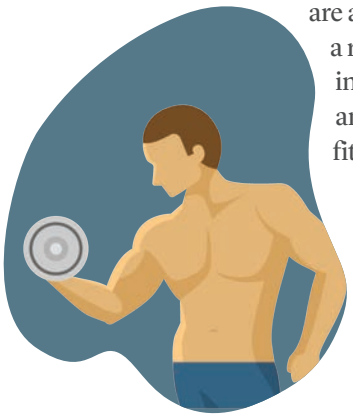
The connection between back disorders and extended periods of incorrect sitting in the office on office furniture and in front of screens which are not correctly adjusted to one another has been scientifically proven. In order to address this we run training regularly on setting up the workplace correctly and are currently continuing with our programme to procure height adjustable desks. The back investigation planned in collaboration with a health insurance fund unfortunately had to be abandoned due to the coronavirus pandemic.

Bicycle leasing

Sappi Stockstadt GmbH, as the employer, has been offering bicycle leasing for some time now and this has been extremely well received by employees. More than three hundred bicycles and e-bikes have been leased by employees and this ensures that travel to work is healthy and environmentally friendly.

Fitness

We are working together with a fitness studio based locally to ensure that our employees are able to train at a reduced membership rate and in this way we are maintaining and supporting their health and fitness.



Environmental targets 2020

AREA / PROCESS	TARGETS	MEASURES	STATUS
Mill / air pollution control	External complaints < 5	- Analysis of complaints and development of technical/organisational measures - Creation of an odour emission source cadastre and development of organisational and technical measures for odour reduction - Compliance with noise emission of max. 60 dB(A) daytime operations - Implementation of noise protection measures for the generating plant - Noise protection projects in all departments (reduction of night values by 2 dB(A)) - Annual reporting, internal/external	Number of complaints = 22 (target not achieved) Completed Completed Various measures have been implemented. Reduction of night values by 2 dB(A) was not achieved Annual reporting, internal/ external, was implemented.
Mill utilities / air pollution control	Reduction of CO_2 emissions	- Planning for the future operation of boiler 9 without coal and heavy fuel oil. Increase in proportion of bioenergy in energy generation to 39% on boiler 6	Target achieved, increased proportion of bioenergy in energy generation = 40.2%
Mill utilities / air pollution control	Compliance with the new emission targets	- Planning and implementation of measures for the operation of the black liquor boiler with respect to compliance with dust emissions and SO_2 emissions for the acid operation (installation of new droplet separator and other measures)	Installation of new droplet separator and other measures for plant optimisation; dust values were reduced at partial load; the new limits are not yet being achieved
Mill / risk and emergency management	Improvement of emergency management	- Implementation of three emergency drills	Due to the coronavirus pandemic only fire service exercises were carried out, without evacuation exercises
Mill / waste management	Reduction of spec. waste volumes for external disposal (not including wood by-products) by 1% compared to BY2019	- Testing and implementation of reduction measures in all departments - Testing of alternative utilisation and disposal methods	Reduction of spec. waste volumes (not including wood by-product) by 11.1%
Pulp production / sustainable forest management	Procurement of PECF-/ FSC-certified wood > 75%	- Procurement contracts with certified suppliers, and monthly balance sheets	Proportion of PEFC/FSC certified wood = 82.1%
Pulp production / wastewater	Reduction of overall wastewater temperature < 35°C	- Planning and installation of a heat exchanger for the wastewater in paper production	The heat exchanger was installed. Reworking is needed.
Mill / wastewater	Reduction of phosphorus concentration in waste-water	- Planning of a new wastewater load project to reduce the concentration of phosphorus in wastewater (Project: SAPHIR)	SAPHIR planning was completed and presented to the authorities.
Mill / wastewater	Compliance with the COD limits (concentration and freight) < 365 mg/l	- Monitoring of wastewater loads - Regular discussions of current values in the wastewater work group	The official monitoring was adhered to.
Mill / energy efficiency	Reduction of spec. ener-gy consumption by 1% compared to financial year 2019 according to priorities (electricity, gas, steam) taking into account new energy-related base lines	- Updating of energy saving plan - Implementation of energy efficiency measures in production departments - Detailed analysis and monthly report on energy costs	Target was not achieved due to the coronavirus pandemic downtimes.
Mill utilities / energy efficiency	Proportion of bioenergy for steam generation > - 39%	- Optimal use of bioenergy in boilers 6 and 9	Proportion of bioenergy for steam generation= 40.2%
Mill / environmental product label	Introduction of regional label “Wood from here” for uncoated paper	- Set up project organisation, kick-off and implementation of a new process - Certification	The technical prerequisites for the “Wood from here” label were established. The certification audit takes place in December 2020

Environmental targets 2021

AREA / PROCESS	TARGETS	MEASURES	DATE
Mill / air pollution control	External complaints < 5	- Analysis of complaints and development of technical/ organisational measures - Implementation of measures for odour reduction (black liquor containers, flash steam condensate container) - Compliance with noise emission of max. 60 dB(A) daytime operations - Implementation of noise protection measures for the generating plant - Compliance with night values - Annual reporting, internal/external	09/2021
Mill utilities / air pollution control	Reduction of CO_2 emissions	- Planning for phase-out (boiler 9 rebuild) - creation of PPC pack	03/2021
Mill utilities / air pollution control	Reduction of Emissions	- Planning and implementation of measures for the operation of the black liquor boiler with respect to compliance with dust emissions and SO_2 emissions for the acid operation (installation of wet electrostatic filter pilot installation/SO2 washer / checking of other short-term measures)	09/2021
Paper production / emissions protection	Reductions of furnace plant SM2 emission values	- Measures for reducing total C emissions - Monitoring of compliance with formaldehyde emissions	03/2021
Mill supply / waste management	Disposal reliability for sewage sludge	- Prepare concept for sewage residue utilisation without operation of boiler 9	03/2021
Mill / risk and emergency management	Improvement of emergency management	- Implementation of three emergency drills	09/2021
Pulp production / sustainable forest management	Procurement of PECF-/FSC-certified wood > 75%	- Procurement contracts with certified suppliers, and monthly balance sheets	09/2021
Mill / wastewater	Reduction of phosphorus concentration in wastewater	- Planning of a new wastewater load project to reduce the concentration of phosphorus in wastewater (Project: SAPHIR)	09/2021
Mill / wastewater	Improvement to monitoring of wastewater limits	- Monitoring of wastewater loads - Regular discussions of current values in the wastewater work group	09/2021
Mill / energy efficiency	Reduction of specific energy consumption by 2% compared to new reference consumption - taking into account new energy-related base lines	- Updating of energy saving plan - Implementation of energy efficiency measures in production departments - Detailed analysis and monthly report on energy costs	09/2021
Mill / legal compliance	Improvement to monitoring a fulfilment of legal regulations	- Use of the new GEORG system - Addition of requirements from assessments	09/2021
Mill / environmental product label	Introduction of regional label “Wood from here” for uncoated paper	- Printing of an initial “Wood from here” reference object with a customer	09/2021

Glossary

Anaerobic wastewater treatment
Term used to describe the chemical reaction which occurs with an absence of oxygen.

AEO certification
"Authorized Economic Operator" AEO certification sets requirements for safety in the supply chain and provides customs simplifications in return.

BOD (biological oxygen demand)
A measure for the amount of oxygen necessary to break down organic material present in a sample of water.

BAT (Best Available Techniques)
The concept of 'best available techniques' is an EU-wide central control scheme within the law governing the authorisation of installations. The terms are equivalent to the concept of state-of-the-art technology used in Germany. In this case, 'techniques' refers "both to the technology used as well as the way the installation is designed, built, maintained operated and decommissioned". The best available techniques are developed for each sector concerned as part of a process of information sharing between member states, industry and environmental associations. They are stipulated in BAT instruction sheets and regularly updated.

Calcium Carbonate
Term used to refer to chalk or limestone. Important product in paper manufacturing as a filler or as a pigment in the coating colour.

COD Chemical Oxygen Demand
A measure for the amount of oxygen necessary for the full chemical decomposition (oxidation) of organic matter present in wastewater.

Evaporation facility
Facility for evaporating and reducing the cooking acids used during pulp production. The black liquor created is used for heating purposes and is part of the chemicals recovery plant.

EMAS
Abbreviation for "Eco-Management and Audit Scheme". European system for environment management and environmental auditing.

Emission
Solid, liquid or gaseous substances; heat, noise or vibrations which escape into the environment from a facility e.g. pollutant emissions, heat emissions or noise emissions.

Forest Stewardship Council (FSC)
The Forest Stewardship Council is an international non-governmental, non-profit-making organisation. The council created the first system for the certification of sustainable forestry, operates the system and continues to develop it.

Green electricity
Green electricity, also known as eco-power, is electrical energy obtained from renewable energy sources. Solar energy, wind energy and biomass are examples.

GSAD Global Safety Awareness Day
The purpose of the annual safety day which is celebrated globally at all Sappi sites is to heighten the awareness of all Sappi employees and business partners with respect to the theme of work safety and health protection. This is achieved jointly using organised campaigns for people to come and look at or take part in.

Wood from here
Holz von Hier is an ISO Type I ecolabel similar to ISO 14024. This means that it has been developed and updated with stakeholder participation, it is externally monitored, neutral, transparent and has a high quality standard that goes beyond the applicable norms. It is a certificate of origin that comprehensibly records and documents the material flows along

the entire processing chain to the product. It is the only environmental label that records and quantifies the actual transports and the associated environmental impacts.

Wood-free paper
Paper produced exclusively from pulp. The term "wood-free" actually means "free of lignin".

Immission
Air pollution, noise, vibrations and similar environmental influences which impact on people animals or plants.

Lignin / lignosulfonates
An element of wood which is released from the wood during pulping (cooking process). The cooking acids used are evaporated and burned to generate energy and for chemical recovery. Excess lignin is sold and used, for example, in the concrete industry as a concrete plasticiser.

Sustainability
Fundamental principle of forestry management. It requires that no more wood is cut down than can be regrown.

Uncoated paper
General term for wood-free paper or paper containing wood which, in contrast to coated paper, is not finished by having a coating applied.

Programme for the Endorsement of Forest Certification Schemes (PEFC)
International forest certification system, the aim of which is to ensure the continual improvement of sustainable forest management while guaranteeing ecological social and economic standards.

FGD Flue Gas Desulphurisation Plant
Plant for removing sulphur compounds from power plant emissions.

SNCR plant
A flue gas cleaning plant which minimises the nitrogen oxide in emissions by means of selective non-catalytic reduction.

REACH Registration, Evaluation, Authorization and Restriction of Chemicals
REACH is used to describe a regulation which is directly applicable in the EU and is entitled "Regulation (EC) No 1907/2006 of the European Parliament and of the Council of 18 December 2006 concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH), establishing a European Chemicals Agency". It regulates the registration, evaluation authorisation and restriction of chemicals with the aim of filling gaps in information relating to the majority of chemicals.

TCF Totally Chlorine Free
The bleaching process for pulp in which no chemicals containing chlorine are used.

Pulp
Fibrous material obtained from plant based fibre as raw materials by means of chemical pulping.

Declaration of the environmental surveyor on the survey and validation activities

The undersigned, Bernhard Zechel, EMAS Environmental Surveyor, registration number D-V-0214, accredited or licensed for Group 17.1: manufacture of wood and pulp, paper, card and cardboard, confirms that he has surveyed whether the site as stated in the environmental statement of the organisation Sappi Stockstadt GmbH, Obernburger Straße 1-9, 63811 Stockstadt with registration number DE-103-00012, complies with all requirements of Regulation (EC) No 1221/2009 of the European Parliament and of the Council of Europe dated 25 November 2009 concerning the voluntary participation by organisations in a Community eco-management and audit scheme (EMAS), amended by regulations (EU) 2017/1505 of 28 August 2017 and 2018/2026 of 20.12.2018.

On signing it is confirmed that

- the survey and validation have been carried out in full compliance with the requirements of Regulation (EC) No. 1221/2009, (in combination with the regulations (EU) 2017/1505 and 2018/2026 of 20.12.2018)
- the results of the survey and validation confirm that there is no evidence of non-compliance with applicable environmental regulations,
- the data and information of the Environmental Statement for the site provide a reliable, credible and truthful representation of all activities of the site within the scope specified in the Environmental Statement.

This Statement is not equivalent to an EMAS registration.
EMAS registration can only be performed by a responsible body in accordance with Regulation (EC) No. 1221/2009 (in combination with the regulations (EU) 2017/1505 and 2018/2026 of 20.12.2018). This Statement may not be used as an independent basis for public information.

Munich, 01 February 2021

B. Zechel

Bernhard Zechel, Grad. Engineer, Environmental Surveyor, D-V-0214

Environmental contact

Do you have any questions regarding Environmental Protection at Sappi Stockstadt? If so, please call us!

You can contact the environmental officer Martin Schilha directly on

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Our EMAS brochure was printed on Magno Natural 250 g/m² (Cover) and 150 g/m² (interior part) from Sappi Stockstadt.

Sappi Stockstadt GmbH is a registered member in the network of the climate and environmental label Holz von Hier©.

The paper used for printing the EMAS brochure meets the criteria of Holz von Hier© for particularly climate-friendly products from sustainable forestry.

The next update of the environmental statement will be published in Spring 2022.