



**GMUND**



## What Is Sustainability?

For us, sustainability means preserving natural resources and thinking carefully before throwing anything away. Gmund Paper has been a family-owned business for over 110 years. We've manufactured our papers in Bavaria's idyllic Mangfall Valley since 1829. All of our products are genuinely "made in Bavaria".

Part of our commitment to the environment includes maintaining our mill. We look after our machinery so it can serve us longer: for example, our oldest paper machine is over 130 years old. By continually augmenting our machinery with the latest, most energy-efficient, high-tech components, we keep our equipment up to date and prepared to face the challenges of the future. This saves precious resources and ensures that our products are always of consistently high quality.

Wherever possible, we work with local suppliers to keep transport distances as short as possible. We take good care of our buildings. And we are especially proud of our traditional mill site in Gmund. New buildings are designed and built in accord with ecological considerations and are unobtrusively integrated into the landscape beside the Mangfall River.

Products made with papers from Gmund also meet sustainability requirements – people like to keep greeting cards, brochures and photos printed on Gmund paper, simply because they are beautiful. The Swiss philosopher Franz Marter was one of many who noticed this quality. In 1974, he commented that he had found the "first non-throwaway paper" in Gmund.



## How Pure Is The Water?

The water that we use in production comes from a mountain spring which rises near our mill site in the Mangfall Valley.

We invested over one million euros in the world's first ozone-based purification plant. We did this voluntarily and without any economic incentive. Thanks to this unique system, we have reduced our water consumption from circa 70 litres per kilogram of paper to circa 20. The water is cleansed and re-used up to seven times during the production process. Then it is cleansed a final time: all residual dye is removed in a complicated in-house process. After that, it is pumped to the local water-purification plant, where it is restored to drinking-water quality before being piped into the meadows around the river. Gmund has not fed any wastewater into the river since 1965.

Because of its location in the Mangfall Valley, the mill in Gmund lies within a water-protection zone. The city of Munich draws 80% of its water supply from this area.



## Are Our Raw Materials Running Out?

We only buy pulp from forests that are certified as sustainably managed, where new trees are planted to replace those which are felled. We use pulp that is FSC® certified (FSC® Mixed).

This means that the wood used to make the pulp does not come from regions where land rights are abused, trees are illegally felled, or forests are subject to special protection. The wood does not come from genetically manipulated trees, plantations built on cleared natural forests, or natural forests that were cut down so the land could be used for other purposes.

At Gmund, we have also been using alternative raw materials, such as cotton linters and hemp fibres, for many years. These plants renew themselves annually, providing new supplies in a short period of time.

Pre- and post-consumer recycling has a long tradition at Gmund. This means that every scrap of paper which does not go for sale – edge pieces, the paper at the beginning and end of the machine, and waste from cutting – is collected and carefully sorted according to colour. This material is then recycled separately using only water, but no chemicals, and returned to the paper pulp in the next appropriate production run. As a result, all the paper produced in Gmund has a pre-consumer recycling proportion of 20 to 25%.



### What About Energy?

Gmund is well supplied with energy. We generate up to 75% of our power needs ourselves, so we are not dependent on the national grid.

Like our forefathers over 180 years ago, power for our plant is “homemade”, i.e. generated in the traditional way, using the renewable resource of water. We do not *buy* environmentally friendly energy, we *make* it.

Gmund Paper consumes about 3.5 million kilowatt hours of energy per year. Of this, circa 2.5 million kWh are currently supplied by our three water turbines, which are driven by the Mangfall River flowing by our site. This energy is supplanted by a high-performance combined heat and power plant and by solar panels on our roofs.



### How Clean Is Gmund, Really?

Like other businesses, we also generate a certain amount of waste. But we don't just sweep it under the rug. We operate a system of waste sorting and recycling. And wherever possible, we try to prevent waste from occurring in the first place.

An in-house environmental program ensures that we maintain strict environmental standards throughout our company. And we constantly monitor our progress. This has enabled us to reduce to a minimum the amount of waste that occurs in all areas of our business.



## The Future

By what they purchase, customers decide whether companies that are run on an environmentally sustainable basis survive or not. Paper is no different here from other products and other economic sectors.

Our enthusiasm for protecting the environment goes back many generations, and we are now passing it on to our children. We are concentrating on sustainability primarily for their benefit. That's what we stand for at Gmund – now and in the future.

We really care.



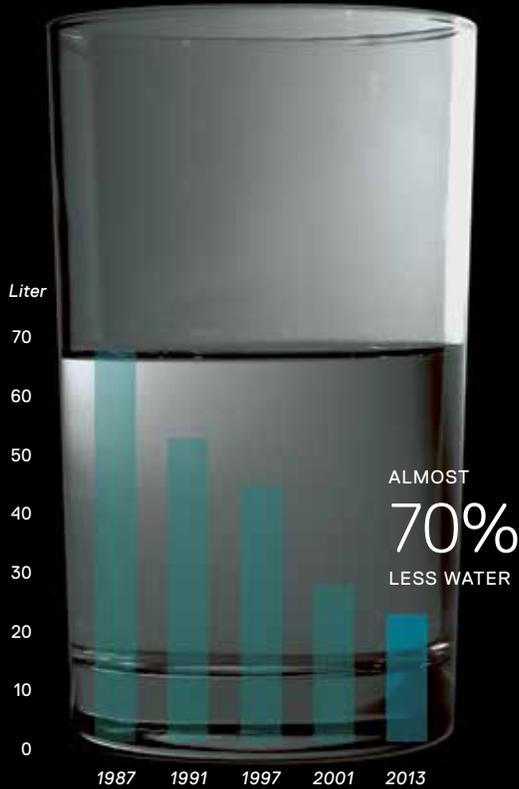
For Gmund Paper



The mark of  
responsible forestry

## Saving Water

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Twenty-five years ago, it took 68 litres of water to produce one kilogram of paper.

Today, that figure is down to around 20 litres. Our investment in new water-saving technologies has paid off for the environment.

## Sustainable Raw Materials

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We take special care to ensure that the pulp we process comes only from forests that are certified as sustainably managed — and from suppliers who respect the environment and treat their employees in a responsible way.

Over 70% of our pulp is FSC®-certified. Less than 30% comes from controlled fibres, in accordance with the FSC® standard for controlled wood (FSC®-STD 40-005).

Five percent of our total production is based on cotton, hemp and other fibres that are not derived from wood.

## Generating Our Own Energy

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UP TO  
**75%**  
HOMEMADE  
ENERGY

We rely on energy that we generate ourselves from the renewable resource of water.

- approx. 52% of the energy we use is generated by our own water turbines
- approx. 19% comes from combined heat and power generation for steam production
- approx. 3% comes from solar energy
- approx. 26% comes from a Bavarian energy company

## Reducing Waste

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Thanks to a broad-based waste-avoidance initiative, we have been able to reduce the incidence of residual waste in our company by 82%.

In paper production, the proportion of waste is now below 2% – of which 99% is recycled. But we are not content to stop there. Our aim is to become even more effective at minimizing waste!

We Really Care