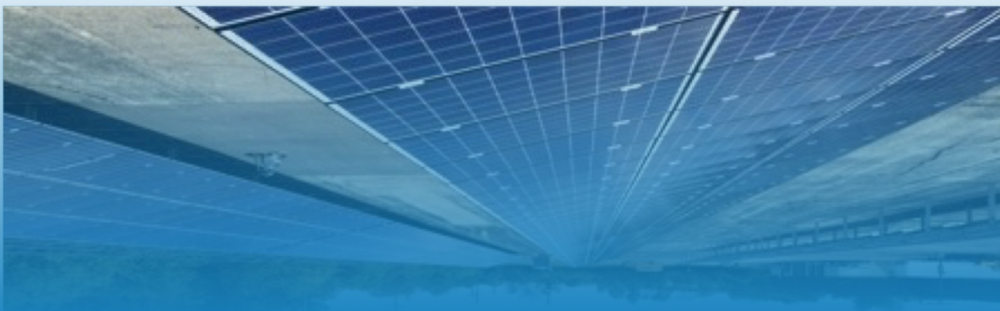


LETTERHEAD PRESS

# Sustainability



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## Stewardship

At our core, we believe we must act as stewards of our environment. We do not simply recycle our scrap, we've taken resource utilization to a new level. We have repeatedly invested major capital expenditures in consuming less, while producing more.

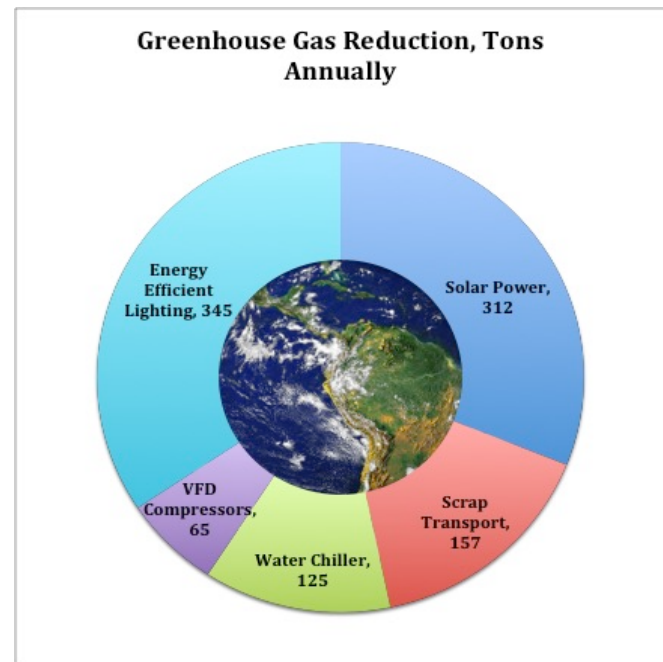


## Savings, not just for our planet...

Our five largest resource projects since 2009 have reduced our greenhouse gas emissions by over 1,000 metric tons, annually.

That's the equivalent of greenhouse gas emissions from 212 passenger vehicles driven for one year, or the equivalent of CO<sub>2</sub> emissions from over one million pounds of coal burned.

But the savings are not just for our planet: by controlling our energy consumption, these five projects have reduced our energy costs by 1,400,000 kw/h, annually.



Project	Time Frame	Energy Savings kw/h	Greenhouse Gas Reduction
337-kw Solar Array	Oct, 2016	443,000	312 t
Paper Scrap Transport System	May, 2015	223,000	157 t
Replace 16 A/C Units	April, 2012	177,000	125 t
Install new VFD Air Compressors	May, 2011	92,000	65 t
Energy Efficient Lighting	June, 2009	490,000	345 t
	Total	1,425,000	1,004 t

- 1) **Our 337-kw Solar Array** is Wisconsin's tenth largest solar project. 1,300 solar panels on our footprint produce an average of 75% of our electric needs during daylight, and 25% of our overall needs annually.
- 2) **Paper Scrap Recycling** transport system - via direct pneumatic transfer. Stations installed at scrap and trim locations throughout the plant carry material directly to the balers, avoiding the shredders. Scrap and trim is shredded as it's produced, while it's transported in the system's tubes. This efficient system allows us to easily recycle over 1,600 tons of paper scrap annually. That's in addition to over 250 tons of plastic, 36 tons of fuel pellets, and 20 tons of metal.
- 3) **Replaced 16 Air Conditioning Units (210 tons)** with a new 60 ton water chiller and air turnover units. Substituting evaporation for compression as the cooling method resulted in the elimination of 16 A/C compressors.
- 4) **Replacement of Air Compressors** with new Variable Frequency Drive units. The compressed air needs of all our production equipment is now supplied by new energy-efficient compressors. These VFD units avoid the motor running at continuous speeds, and instead regulate the speed according to the demands of the application. A 20% reduction in motor speed leads to a 50% energy savings.
- 5) **Energy Efficient Lighting** installed throughout the office and plant. New efficient lighting directly reduced energy consumption from lighting by 50%. What's more, with the new lighting systems generating 40% less heat, we have reduced our energy usage for cooling.