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Z-ECO

ZIEGLER PAPER MILL

Environmental Report 2007

ecotopic Editorial . 3

ecoeffort Environmental performance . 4

ecogoal Review and outlook . 10

ecoconsult Contacts . 12

ZIEGLER
P A P I E R

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ZIEGLER PAPER LEADS IN ENVIRONMENTAL PROTECTION

You are reading the fifth edition of Z-ECO, the annual environmental report of Ziegler Paper Mill in which the company informs its external partners about its environmentally relevant activities and achievements during 2007. The year under review was an exciting, challenging - and successful - one for Ziegler Paper.

Despite extraordinary increases in the prices of raw materials and energy, we can be pleased with our results thanks to increases in the price of paper and a marked rise in production volume.

We were also successful in improving our achievements on the environmental front. First and foremost, mention should be made of our new wastewater treatment plant, which went on line in spring. This has enabled us to achieve a dramatic reduction in the volume of solid pollutants in our wastewater. We also achieved improvements again with regard to fresh water/wastewater and energy efficiency, which in some respects exceeded our expectations. This is primarily due to the fact that the improvements were not the result of spectacular and expensive individual measures, but rather of a series of optimisation measures that often had synergetic effects in the areas of water management, runnability and press management.

In addition, 2007 saw a number of decisive moves in respect of the implementation of the government's legislation on CO₂ emissions. This requires an appropriate reduction by the year 2010 in CO₂ emissions from the use of fossil fuels as a source of energy or the payment of a CO₂ levy.

Although originally it was planned for a common solution to be developed by the Swiss paper industry under the leadership of the EnAW, the Swiss Energy Agency for Industry founded in 1999, it was decided in 2007 that an industry-wide solution should be abandoned and that each company would have to ensure the achievement of its own reduction targets in order to be exempted from the CO₂ levy.

However, the Swiss government has decreed in writing that Ziegler Paper will be exempted from the CO₂ levy as long as the agreed targets for total CO₂ emissions and CO₂ intensity are maintained at the average for the years 2008-2012. This is the first binding confirmation that the major investments and efforts we have put into reducing CO₂ will be rewarded on the fiscal front, provided that the targeted reductions are achieved.



Dr. Reinhard Jäger,
Production Manager and
Head of the Environmental
Management System

1. ZIEGLER AT A GLANCE

Ziegler Paper Mill produces premium-quality wood-free fine papers for the printing industry and customised specialty papers for industrial processing. Its headquarters and production facilities are located in Grellingen near Basel, Switzerland. Established in 1861, the mill has been family-owned for five generations. As an independent manufacturer of specialty papers we have always valued quality over quantity. We have consistently pursued a niche policy and continue to be successful – thanks also to the brand strategy we follow - in spite of the increasing concentration within the paper industry.

Our sales by region (2006 figures in brackets):

Switzerland	47%	(48%)	Austria	4%	(5%)
Germany	16%	(14%)	Italy	4%	(4%)
United Kingdom	8%	(9%)	Holland	3%	(5%)
USA	7%	(3%)	Other	11%	(10%)

Our domestic market of Switzerland continues to account for the lion's share of sales and will continue to do so in the future, too. Nevertheless, our export markets are becoming increasingly important, particularly for our specialties. Of note here in particular are our release liners with double-sided coating and our inkjet products. Ziegler is the world's leading manufacturer of papers for coloured transactional printing applications on modern inkjet printers. In the USA, where we managed to more than double sales during the year under review, we have had our own sales company marketing our papers since 2001, while in Europe and Asia we work together with international trading companies.

Our services include consulting with individual customers and complete solution support. Thanks to the high level of commitment on the part of all our staff – management and employees alike – and the manageable size of our company with its short decision-making paths, we are ideally placed to hold our own in the marketplace despite the stiff competition prevailing there.

FACTS 2007

Business	Production of premium-quality, wood-free fine papers and specialties
Product lines	Corporate Design, Natural Design, CAD/Office, Specialties
Plant and equipment	Paper machine 3 (last overhaul 2004), slitter-winder, large-format sheet cutter, small-format sheet cutter; central power plant with gas turbine / waste heat boiler (combined heat and power plant)
Annual output	69,700 tonnes (sales volume)
Wire width PM 3	331 cm (trimmed)
Weight range	40–400 g/m ²
Quality assurance system	ISO 9001:2000, Registration No. 04100 19930262
Environmental quality system	ISO 14001:2004, Registration No. 04104 20020620
FSC certificate	FSC-STD-40-004(1.0), Registration No. SQS-COC-24310
Raw stock	Market pulps from internationally recognised wood certification programmes; supplied with FSC certificate at customers' request. Transported exclusively by ship and rail.
Water	Own ground water well; high level of closed-loop recirculation
Workforce	182 people working days or shift work
Sales	CHF 117 million
Investments	CHF 6.0 million
Legal form	Family-owned corporation (AG) with share capital of CHF 1 million
Year established	1861

2. USE OF RESOURCES

The specific consumption of fresh water, raw materials and energy provides a measure for the efficiency of our utilisation of resources.

2.1 Fresh water

During the year under review, we again used considerably less fresh water in both absolute and specific terms than in the previous year. We are particularly gratified that it proved possible to reduce specific fresh water usage by almost 9%, after we had already achieved a reduction of almost 13% in the previous year. For the first time, we managed to remain

under the level of 5 litres per gross kilogram of paper produced. The main reasons for this further improvement are the on-going optimisation of water management and improved runnability on the paper machine. This latter fact has a considerable influence, since fresh water requirements increase significantly in the event of tears in the paper or interruptions to production.

Fresh water usage has a high correlation with the resultant volume of wastewater; the difference is primarily due to the water that evaporates in the dryer section of the paper machine. Every improvement in the usage of fresh water therefore leads to a corresponding reduction in the volume of wastewater.

	UNIT	2007	2006	DIFFERENCE FROM PREVIOUS YEAR
Fresh water usage	m ³	387 701	404 198	- 4.1 %
Specific fresh water usage	l/kg paper gross	4.69	5.15	- 8.9 %

2.2 Raw materials

During the year under review, 1.028 kg of raw materials was used to produce 1 kg of paper sold (without water component) as opposed to 1.035 kg in the previous year.

2.3. Energy

The sale of our four hydraulic power plants in 2007, which was one of the measures aimed at creating suitable conditions for planning the future of Ziegler Paper Mill, greatly changed the situation in respect of

	UNIT	2007	2006	DIFFERENCE FROM PREVIOUS YEAR
Specific raw material usage	kg bone dry /kg paper bone dry	1.028	1.035	- 0.7 %

When the paper machine is running normally, there is relatively little loss of raw materials. The loss that there is consists mainly of what is rejected by the cleaner and pressure screen via which contaminants are channelled off from the pulp. This cannot be used in making clean paper. Loss via wastewater is also insignificant during normal operations since excess water is filtered to recover pulp before it leaves the system.

The situation can be different, however, in the event of malfunctions, tears or interruptions to production, when circuits overflow into the wastewater. Then quite large losses of raw materials are possible within a short time. Because of this, good runnability of the paper machine and its systems is essential to ensure a low specific raw material usage. This is also the main reason for the improvement achieved in respect of specific raw material usage over the previous year.

The environmental impact resulting from the production of raw materials by our suppliers is not relevant in the representation of Ziegler Paper Mill's environmental performance. Nevertheless, we can exert a substantial influence on the overall environmental balance sheet through our choice of suppliers: as in previous years, Ziegler Paper Mill therefore made exclusive use during the year under review of pulp bleached without chlorine that is obtained from sustainable timber resources with recognised certification programmes in compliance with FSC, CSA, EMAS, PEFC and ISO 14000.

energy. Electricity is now only generated thermally using co-generation with our gas turbine. All extra power required is bought from the public grid. As the gas consumption shown in this report covers both the heating needs of the paper machine as well as power requirements for the thermal generation of electricity, the total of energy needed is made up of the sum of purchased gas and purchased electricity.

We are pleased to report that it was possible to improve energy efficiency substantially again in 2007. While specific electricity usage remained virtually constant, the specific volume of gas required was reduced by 4.9%. Specific steam consumption fell by as much as 5.4%. Absolute electricity consumption rose virtually parallel to the increase in gross paper production of 5.3%. Despite a gross increase in production of 5.3% and a 3.1% rise in thermally-generated electricity, absolute gas consumption was kept at virtually the same level as for the previous year for the second time in succession. This is the gratifying result of our endeavours to raise energy efficiency and particularly to reduce the CO₂ emissions caused by burning gas.

Nevertheless, we still believe that there is room for further improvement, as is shown by the energy study performed in 2006. The project elaborated in the year under review to make use of the heat generated in our central power plant is scheduled to be implemented during the summer 2008 overhaul. We expect this to bring about a further reduction in specific steam and gas consumption.

	UNIT	2007	2006	DIFFERENCE FROM PREVIOUS YEAR
Thermal power production	MWh	30 538	29 632	+ 3.1 %
Power consumption	MWh	38 651	36 626	+ 5.5 %
Specific power consumption	kWh/kg paper gross	0.468	0.467	+ 0.2 %
Gas consumption	MWh	150 026	149 755	+ 0.2 %
Specific gas consumption	kWh/kg paper gross	1.815	1.909	- 4.9 %
Specific steam consumption	kg steam/kg paper gross	1.786	1.887	- 5.4 %
Total specific energy consumption (purchased electricity + gas)	kWh/kg paper gross	1.914	1.997	- 4.2 %

3. WASTE EMISSIONS

Every industrial activity generates waste products and paper making at Ziegler Paper Mill is no exception. With our certification in compliance with ISO 14000, we have committed ourselves to a sustainable reduction in our emissions through a process of continuing improvement.

3.1 Wastewater

The fresh water obtained from the company's own groundwater catchment system is used over and over again thanks to in-house recycling. After having been used repeatedly, the water is cleaned in the mill's own new mechanical treatment plant which went into operation in spring 2007. Although the flocculation of the solid materials that is important for its cleansing efficiency has not yet been optimised and the old treatment plant was still being used for the first three months of the year, it nonetheless proved possible for the solids content of our wastewater to be reduced by no less than 43% and specific waste solids by as much as 46% as a result of the higher gross

production volume.

Once again, we achieved a reduction in absolute terms of almost 10% in the volume of wastewater produced in comparison with the previous year – corresponding to the reduction in the amount of fresh water used. With a level of 3.51 l/kg, specific wastewater was clearly under the 4 lt/kg of paper gross for the first time. This is a figure that is exemplary for the sector as a whole. During the year under review, the Office of Environmental Protection and Energy once again took random samples to check the composition of our wastewater and found in all cases that our waste treatment plant and the composition of the wastewater samples conformed to requirements.

Before the clarified wastewater is returned to the ecosystem through surface water, it is also treated biologically at the municipal treatment plant. The cleaning efficiency of the downstream municipal biological treatment plant was ensured at all times.

3.2 Waste air

Significant quantities of waste air are produced by the:

- Ventilation and air-extraction of the paper machine and manufacturing halls:

Random samples taken from the air extracted from the paper machine have shown that although the presence of organic pollutants resulting from pulp and other raw materials is measurable it is irrelevant as an emission.

- Generation of electricity and heat in the central power plant through the combustion of natural gas:

This is very relevant as a source of emissions. As it has been shown that the central power plant demonstrates very constant emission values when in continuous operation, emissions are only measured every two years on the authority of the Basel Air Pollution Control Office or when any changes are made to the power plant. These measurements were last performed in September 2006 by a certified company. The next are scheduled for January 2008.

	UNIT	2007	2006	DIFFERENCE FROM PREVIOUS YEAR
Wastewater	m ³	290 043	321 635	- 9.8 %
Specific wastewater	l/kg paper gross	3.51	4.10	- 14.4 %
Waste solids	kg	55 670	98 231	- 43.3 %
Specific waste solids	g/kg paper gross	0.674	1.252	- 46.2 %

When talking about the waste air from our central power plant, a distinction must be made between

- the emission of the air pollutants carbon monoxide (CO), sulphur dioxide (SO₂), nitrogen oxides (NO_x) and soot, all of which tend to have a regional impact and
- the release of the greenhouse gas CO₂ from fossil fuels, which has a global impact.

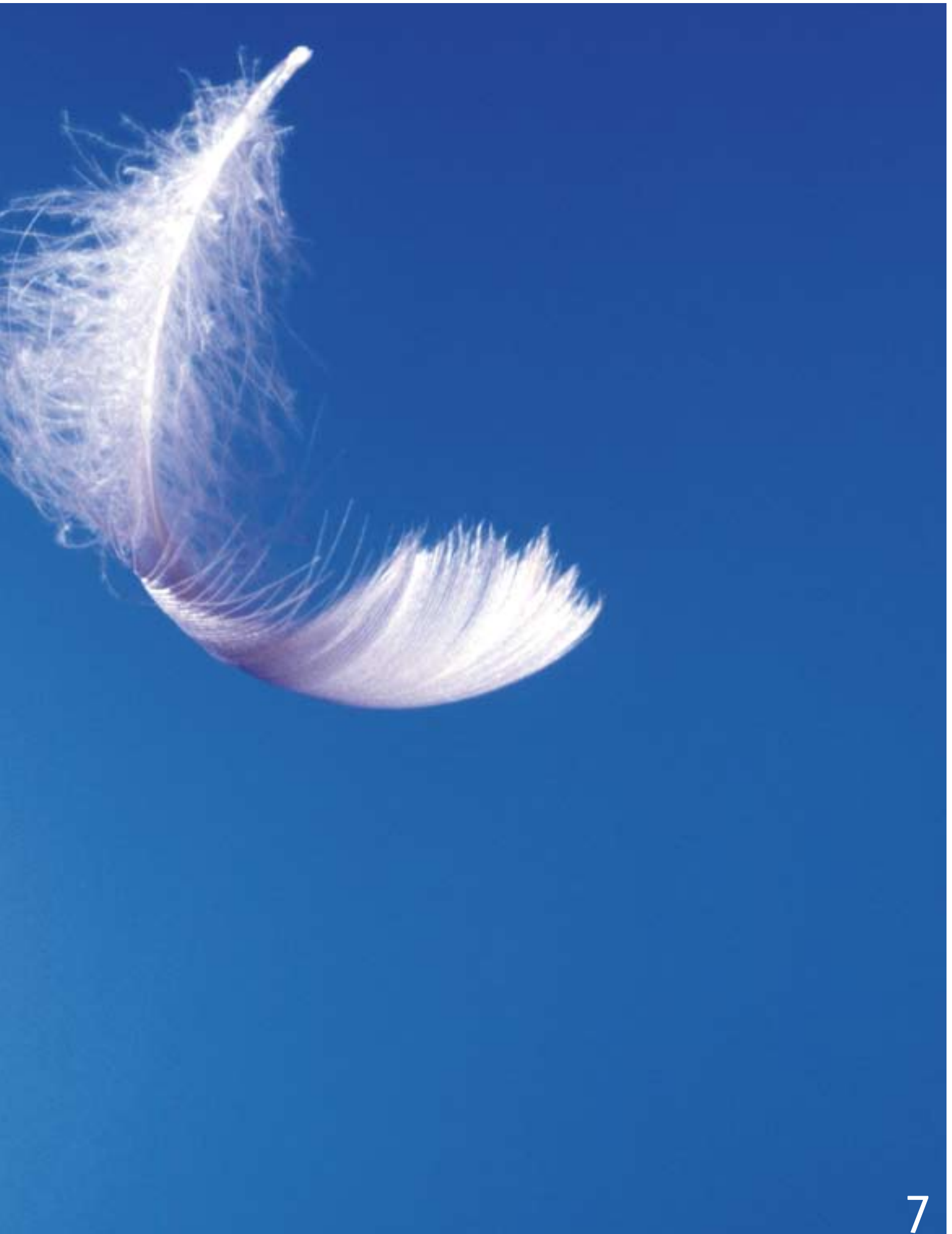
3.2.1 Air pollutants CO, SO₂, NO_x, soot

The report of the last measurements carried out can be summed up as follows:

- CO concentration and soot volume are less than 10 % of the permitted limit.
- The natural gas that we use as a fuel contains virtually no sulphur, which means that SO₂ concentration is under the detection limit.
- The NO_x content of waste air emissions amounts to only some 60–70% of the permitted limit when water injection is running automatically.

3.2.2 Release of fossil CO₂

Heat and electricity are generated in the Ziegler mill by burning natural gas. This produces CO₂ emissions.



As alternative technologies that do not depend on fossil fuels are not likely to be available in the near future, Ziegler Paper Mill relies on the solution that is best for the environment at the present time: a natural-gas-based combined heat and power plant with a gas turbine for generating electricity and a waste heat boiler for producing steam with emphasis on the best possible energy efficiency.

The release of CO₂ is one of the most important environmental issues in the area of climate protection. For this reason, the Swiss government has passed legislation governing CO₂ emissions which requires that by 2010 fossil fuel emissions of CO₂ resulting from energy generation are reduced by 15% in absolute figures compared with the 1990 level. This should be achieved by means of voluntary agreements on the part of users of fossil fuels aimed at reducing their emissions to a set target. Users that do not enter into these agreements or do not reach the targets set have to pay a levy in respect of CO₂ from fossil fuels.

Ziegler Paper was therefore actively involved in developing an industry-wide solution for the Swiss paper manufacturing sector from the outset under the leadership of the Energy Agency for Industry (EnAW), a Swiss organisation that was founded in 1999, which formulated reduction targets throughout the industry. Unfortunately, it became clear in 2007 that this industry-wide solution had failed, and each company that had worked on the joint solution became individually responsible for achieving its own reduction objectives and by so doing for obtaining exemption from the CO₂ levy. In view of this, Ziegler Paper therefore submitted its company-specific reduction goals in the year under review. We consider it to be a genuine milestone that in December 2007 the Swiss government accepted in writing these reduction targets as being in line with legal requirements and assured us that we would be exempted from the CO₂ levy if we succeeded in achieving them.

As mentioned above, Ziegler Paper sold off its four hydroelectric plants in the course of 2007 for the reasons explained. This means that, unlike the previous situation, the reduction targets must be attained without correction for hydroelectric generation of electricity. The figures are shown in the table below; as far as the law is concerned, only the over-all CO₂ emissions target and the CO₂ intensity target are relevant for exemption from the CO₂ levy.

Thanks to the reductions in over-all energy usage achieved through concrete measures and the reductions in CO₂ freight, which are well in excess of those agreed in the targets, we had markedly better results as far as CO₂ intensity and energy efficiency are concerned than those targeted for 2007 and in our target agreement for 2010. This is also evident in the substantial improvements in specific electricity and gas consumption over the past few years.

As far as the absolute CO₂ freight target is concerned on the other hand, we are approx. 3% behind the 2007 target and approx. 1.8% behind the target agreed for 2010. This is because we exceeded the production target for saleable products on which the agreement was based by more than 20% in the year under review.

The further measures we have planned based on the energy study, such as the use of waste heat from the central power plant, make us optimistic that we will be able to achieve the targets for 2010 in respect of overall CO₂ freight, as well; particularly as the government has stipulated that the CO₂ freight target is to be adjusted for growth in production as from 2008.

3.3 Solid waste

Our waste management programme is governed by the motto: "Prevent – recycle – re-use!"

- The major waste product in paper production and finishing is the manufacturer's own paper scrap. Virtually all our scrap is recycled internally and forms a component in all our fibre recipes.
- The mechanical treatment plant also produces waste in the form of paper sludge. This sludge consists primarily of fibres and fillers and represents a loss of valuable raw materials. For this reason, it is our constant endeavour to minimise this loss by means of appropriate process controls. The year under review saw the production of 366 tonnes of paper sludge bone dry compared with 469 tonnes for the previous year (with an average dryness content of approx. 50%).

This means that we succeeded in reducing paper sludge by more than 20% over the 2006 level. Since 2007, the paper sludge we produce has been fermented to create valuable, environmentally-neutral biogas in a newly-opened biogas plant located near the mill.

TARGETED REDUCTIONS AT ZIEGLER PAPER MILL [BASED ON EnAW CALCULATION MODEL WITHOUT CORRECTION FOR COMBINED HEAT AND POWER GENERATION]

	LEVEL	ACTUAL	TARGET	ACTUAL	AGREED TARGET
	2000	2007	2007	2006	2010
CO ₂ freight in metric ton/year	27 992	29 705	28 826	29 651	29 184
CO ₂ intensity ¹ in %	100.0	82.9	98.6	83.5	98.0
Energy efficiency ² in %	100.0	119.0	102.9	121.2	104.0

¹] 100 x CO₂ freight / (CO₂ freight + reduction CO₂ freight)

²] 100 x (OAE + reduction OAE) / OAE; OAE = over-all energy usage

- Waste from packing paper, cardboard, printed matter and spool cores is recycled externally as waste paper.
- Stretch film waste is also recycled externally.
- Wood waste from shipping and packaging is treated externally in a CO₂-neutral thermal process.
- The vast majority of waste materials from maintaining the infrastructure are separated, collected and recycled externally.
- Our paper products can be completely recyclable after use by our customers and contribute to the recovered fibre that is essential for maintaining the waste paper fibre cycle.
- Packaging materials from our paper shipments can also be dealt with by our customers using the same means of recycling and re-use cited above.

reported on in Z-ECO. This was also largely confirmed by the results of a survey carried out among our employees during the year under review.

5.2 Work safety

In the area of work safety, the focus in 2007, as in the year before, was on preventative measures. Together with other companies in the Swiss paper industry, a number of campaigns were again carried out aimed at drawing attention to a variety of potential accidents. To include members of staff more closely in accident prevention measures, all areas of our operations were rigorously examined with the assistance of middle management for possible sources of danger, which were then

	UNIT	2007	2006	2005	2004
Industrial accidents	Number	10	22	14	17
Non-work-related accidents	Number	13	17	29	13
Time lost due to industrial accidents	%	0.36	0.89	0.17	0.34
Time lost due to non-work-related accidents	%	0.26	0.59	0.60	0.11

3.4 Noise

In the year under review, no complaints were received from local residents. The last measurements taken show full compliance with noise emission limits along the perimeter of the mill site.

4. ACCIDENTS

Here mention must be made of the flooding that occurred on 2007, 8. August. As a result of persistent heavy rain in the catchment area of the Birs, the river flooded its banks and caused substantial damage to several hydroelectric power plants. Our production was not, however, affected and the damage to wastewater facilities was relatively minor.

Apart from this, there were no other accidents or other incidents that might have resulted in contamination of the soil or water (River Birs, groundwater) in the year under review.

5. ENVIRONMENTAL IMPACT AND WORK SAFETY

Our employees are our company's most important economic agents. They also guarantee that Ziegler Paper Mill performs top-quality work. In compliance with our legal obligations, but also out of respect for our people and their health, we ensure the best possible standards of work safety and protection against pollution within the mill.

5.1 Protection

As far as protection against environmental impact is concerned, there is currently no need for any action to be taken after the measures implemented over the past few years, which we have

documented photographically and worked through systematically. As every year, an area of work safety was also dealt with during the periodic training sessions held for our shift workers; in 2007, the subject was "Safety equipment".

After the severe setback in respect of accidents suffered the previous year, we were very pleased to see that both accidents and working time lost demonstrated a positive trend once more in 2007.

6. AUDITS AND LEGAL REQUIREMENTS

In addition to a number of internal audits carried out during the year under review as part of our audit plan, there was a second successful monitoring audit of our combination quality assurance system in accordance with ISO 9001:2000 and environmental management system in accordance with ISO 14001:2004 by the TÜV Nord in March 2007.

In addition, a maintenance audit for the chain-of-custody standards FSC-STD-40-004 (1.0) and FSC-STD-40-005 was performed by the SQS, CH-3052 Zollikofen, in October 2007. This authorises Ziegler Paper Mill to continue supplying FSC products with the FSC label in accordance with the mixed-credit system. These have been subjected to thorough monitoring and come from forests run in compliance with the principles and criteria of the Forest Stewardship Council (FSC). The written decision from the federal government in respect of our agreement target on CO₂ emissions reduction represented a relevant change in respect of legal stipulations for the exemption of Ziegler Paper Mill from the CO₂ levy. This is described in greater detail in section 3.2.2 above.

ACHIEVEMENT OF GOALS

The Management had set the following concrete environmental goals for 2007:

- Successful commissioning of our new wastewater treatment plant for the elimination of undissolved materials.

The new wastewater treatment plant went on line successfully in spring and is fulfilling all demands in respect of both quality and quantity to our complete satisfaction. See section 3.1 Wastewater for further details.

- Reduced loss of raw materials (fibrous and filler materials) in our wastewater.

Although the loss of solids, representing the sum of paper sludge and solids content of wastewater, was reduced by a total of 145 tonnes dry weight (- 25.6%) in comparison with the previous year, we failed to achieve the maximum target figure of 200 tonnes that the management had set. A new target figure is therefore being set for the coming year.

- Revision of existing environmentally relevant criteria.

The ISO 14000 standard requires evidence of on-going improvement in the environmental balance sheet. As the existing environmentally relevant criteria, which had existed in the same form since the implementation of the standard in our processes, had proved to make insufficient distinction and provided inadequate information, it was decided that they were in need of revision.

Our environmentally relevant criteria have been revised accordingly. Wherever possible and wherever this makes sense, we are now working with benchmarks. In addition to risk assessment in accordance with environmentally relevant criteria, our environmental relevance matrix now records trends in respect of each criterion which show whether improvement, deterioration or stagnation has occurred.

FUTURE OBJECTIVES

We have set the following new concrete environmental goals for 2008:

- The reduction of specific gas consumption by 3% in comparison with the previous year after overhaul of the waste heat boiler (see also section 3.2.2).
- The reduction of specific solids loss (as the sum of paper sludge and solids in our wastewater) by 15% over the previous year.
- Publication of frequently requested paper-specific environmental key figures (CO₂ footprint, paper profile, etc.) on our website. These key figures are calculated periodically in accordance with the appropriate guidelines and also contain environmental information on the raw materials that are used by Ziegler for making its paper.





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