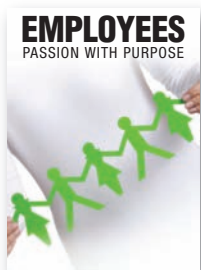




Left to right:
Sant Celoni, Spain.
Bromborough, UK.
Pedro Escobedo, Mexico

OUR GREEN TEAMS HAVE DELIVERED IMPRESSIVE RESULTS IN 2010. A SELECTION OF HIGHLIGHTS.



ENERGY EFFICIENCY/CO₂ REDUCTION

- Sant Celoni, Spain: delivered a combined energy saving of approximately 670 MWh, and an associated CO₂ reduction of 142 tonnes/year, through a range of operational energy efficiency measures
- Naarden, Netherlands: a change to the spray-drying method has seen the plant achieve an estimated gas saving of around 10%, a cost reduction of €1,200 each year, and saving 11 tonnes of CO₂ emissions
- Bromborough, UK: Lean manufacturing techniques relating to spray-drying have seen a reduction in wash down and drying times of 19%. Overall, the site has experienced a reduction of CO₂ emissions of approximately 150 tonnes
- Jigani, India: timers fitted to roof ventilation exhausts created energy savings of 51,000 kWh in 2010

WATER SAVING

- Ashford, UK: achieved a total saving of 81,000 litres of water/month by fitting motion sensors to some of the men's urinals

SUSTAINABILITY AWARENESS

- Bromborough, UK: held a behaviour change awareness week to promote energy, water and waste-saving tips and ideas
- Cuernavaca, Mexico: launched several programmes to raise awareness and promote eco-efficiency improvements
- Bangkok, Thailand: launched a Green Team of the week concept which has now been replicated in Shanghai

- Singapore: designed eye-catching 'switch off when not in use' light switch stickers which are now being used as far afield as Vernier in Switzerland



REDUCING WASTE

- Sant Celoni, Spain: reduced the use of fresh solvents in its cleaning processes, reducing waste by 100 tonnes/year and saving €129,000
- Naarden, Netherlands: recycling plastic packaging waste has saved over 150,000 kg of CO₂ emissions
- Ridgedale, US: replacement of disposable cups with mugs has helped change people's mindset and reduced waste to landfill
- Vernier, Switzerland: the extraction of copper from waste water allowed water to be treated in the site's Waste Water Treatment Plant, instead of contracting out for incineration, reducing disposal costs by 82%
- Argenteuil, France: set up a new composting facility, which saw the recycling of 4 tonnes of organic peelings from fruit and vegetables from the site's catering team

REDUCING INORGANIC GAS EMISSIONS

- Pedro Escobedo, Mexico: the burning of non-chlorinated by-product on-site has led to a reduction in the site's emissions of SO₂, NO_x and CO₂

BIODIVERSITY

- Jigani, India: found a sustainable solution for the humane removal of bees nesting on the site
- Cuernavaca, Mexico: employees took part in a major reforestation project by planting 400 trees