



TÜVRheinland[®]

Precisely Right.

01 407 1516935

Audit Report as per

ISO 50001:2018

For

Papertech, S.L.

Ct. Pamplona, 2

31500 Tudela

Spain

Client	Standard(s)	Certification Number(s)	Audit Type
Papertech, S.L.	ISO 50001:2018	01 407 1516935	RA

Contents

1	Audit result	3
2	Scope.....	3
2.1	Description of the organization.....	3
2.2	Scope of certification	4
3	Changes in the management system / Contract review.....	5
4	Audit findings	5
5	Dates.....	5

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Audit Leader : Andoni Mur Herrero
Audit Team : Andoni Mur Herrero
Client's representative : Sr. Luis Miguel Calvo
Audit Date : 2022-12-14 - 2022-12-15

1 Audit result

Management system effectiveness was verified on site by means of random sampling by an appropriately selected audit team. This applies in particular to the compliance of workflows with standard requirements and the descriptions in management system documentation. [The audit objectives as mentioned in the audit plan](#), the special features of the organization's business activities, the applicable statutory and regulatory requirements and the requirements set forth in other generally applicable documents were also taken into account. This was done by means of a sampling approach, by conducting interviews and reviewing the appropriate documentation. Audit findings and recommendations regarding opportunities for improvement have been set forth in Sections 4 of this report.

<input type="checkbox"/>	The last audit revealed nonconformities which have been demonstrably corrected. The corrections and corrective actions taken in this respect have been verified.						
<input type="checkbox"/>	A stage 1 audit was performed and the organization found ready for certification. Identified weaknesses, if any, have been eliminated and the respective corrective action verified.						
<input type="checkbox"/>	The current audit revealed the following nonconformities: <table border="0" style="width: 100%;"> <thead> <tr> <th style="text-align: left;">Standard(s):</th> <th style="text-align: center;">No. of major nonconformity</th> <th style="text-align: center;">No. of minor nonconformity</th> </tr> </thead> <tbody> <tr> <td>ISO 50001</td> <td></td> <td></td> </tr> </tbody> </table>	Standard(s):	No. of major nonconformity	No. of minor nonconformity	ISO 50001		
Standard(s):	No. of major nonconformity	No. of minor nonconformity					
ISO 50001							
<input type="checkbox"/>	The major nonconformities (No. x) with individual standard elements require a re-audit to verify the effectiveness of the corrections and corrective actions (probable date:.. dd.mm.yyyy)						
<input checked="" type="checkbox"/>	The organization has established and maintains an effective system to ensure compliance with its policy and objectives. The audit team confirms in line with the audit targets that the organization's management system complies with, adequately maintains and implements the requirements of the standard(s).						

The auditor/audit team therefore recommends (provided nonconformity response has been approved):

<input checked="" type="checkbox"/>	Award of the new certificates.
<input checked="" type="checkbox"/>	Maintenance of the existing certification.
<input type="checkbox"/>	Inclusion of the changes (see Section 3) in the scope of application of existing certifications
<input type="checkbox"/>	Maintenance or issue of the certificates only after successful completion of a re-audit.

2 Scope

2.1 Description of the organization

Manufacture of paperboard from recyclable paper as a raw material and through grinding, refining and purification it turns it into a moldable fiber that dries and forms the sheet of paper. The process involves mainly water and cellulose, in addition to some reagents. The raw materials are recyclable paper (cellu-lose) and flocculants.

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Nowadays, papers of high grammage, carton and gray paper are produced, between 200 and 630 g / m². The company works 24 hours a day 7 days a week. The raw material is received and classified according to its qualities. Depending on the type of product to be manufactured, a variable proportion of one type of carton and / or paper or another is mixed. The paper comes from the “Mancomunidades” and other national managers.

The paper bullets are introduced into a pulper where they are mixed with water, producing a pulp. By means of a grid sieve, unwanted materials such as wires, plastics, corks and others are removed from the pulp.

Subsequently this paste is treated in centrifugal separators to remove solid particles of smaller diameter stored in tanks until their use.

The paste is then deposited on an endless fabric with a water content of 99% and the process of removing the water begins by several methods:

- In the first moments the water is removed by gravity.
- Subsequently, when its permeability decreases, it is eliminated with the application of progressive vacuum.
- When it is not possible to extract more water, it is pressed mechanically until a dryness of approximately 45% is obtained.
- To finish, the paper is placed in a drum dryer (heated with steam) where its temperature is raised and the remaining water is evaporated until a final humidity of 7% is obtained.

The steam is produced from treated water and heated with the heat produced in the boiler of natural gas combustion. The sheet of paperboard is rolled up into reels which are then cut to size of the customer, packed and stored for shipment

2.2 Scope of certification

Scope of certification: (per standard):	ISO 50001:2018 : Industrial plant for the production of paper and paperboard
ISO 9001 standard requirements which are not applicable:	
Reasons for non-applicability:	

The management representative has appropriate authority over the sites included in the multi-site organization. The audit took appropriate account of multi-shift operations and provided for representative auditing of all shifts.

The following sites and their scopes are included in the scope of certification:

Site No.	Sites included in cert. Name/address of site	No. of emp.	Standard and Scope	Audited
01 407 1516935	Papertech, S.L. Ct. Pamplona, 2 31500 Tudela Spain	60	ISO 50001:2018: Industrial plant for the production of paper and paperboard	Yes

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3 Changes in the management system / Contract review

No major changes have been made to the management system and the management system documentation since the last audit. The order details which form the basis of the audit (including number of employees, scope and sites) reflect the actual situation in the organization.

The description of the scope in the certificate appropriately reflects the scope of the management system.

A corresponding printing request is attached.

The audit plan was not changed during the audit.

4 Audit findings

The audit findings related to the audited standards are listed in the annexes to this report (see. Annex ISO 50.001:2018).

All information gained during the audit will be treated with strict confidentiality by the auditor(s) and the certification body. In view of the sampling approach applied to the audit, weaknesses and nonconformities may still exist which have not been identified during the audit.

No.	Unit/Department Site	Positive findings
1	Electricity consume	Values close to 95% of the European Benchmark in electricity consumption per ton of paper.
2	Energy total consume	Indicator of total monthly energy consumption of the plant very stable (4% variability) Baseline for the consumption forecast for 2022 with only a 0.5% deviation from the actual.
3	Base lines	Baseline for the consumption forecast for 2022 with only a 0.5% deviation from the actual.

The following recommendations and opportunities for improvement provided by the auditor(s) are intended to contribute to the continuous improvement of the management system.

No.	Unit/Department Site	Recommendations and opportunities for improvement
1	6.4	Assess the establishment of indicators by sub_process: steam generation, pasta preparation, paper machine,...or quality of paper
2	6.5	Evaluate defining shutdowns and start-ups of significant facilities in non-productive periods and define their baseline.

5 Dates

Due Date for the next audit

08.12.2023

Agreed date for the next audit

-

14/12/2022

Andoni Mur

Date

Audit Leader / Auditor(s)

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Annex ISO 50001:2018

Item	Audit result									
Context of the organization	<p>The organization has determined internal and external issues related to the following topics:</p> <ul style="list-style-type: none"> • Increase in the cost of CO2 emissions • Electrical and Natural Gas energy cost variability • Legal restrictions Water use efficiency (electricity related) <p>The organization has identified interested parties and the requirements of these parties. Examples for such parties are:</p> <ul style="list-style-type: none"> • Internal: <ul style="list-style-type: none"> ○ Share holders ○ Group SONOCO ○ Energy & Plant Manager • External <ul style="list-style-type: none"> ○ • Clients ○ • Energy Suppliers / Market ○ • Administration <ul style="list-style-type: none"> <input type="checkbox"/> EU & National: CO2 emission <input type="checkbox"/> Regional & Local: licenses 									
Policy/objectives	<p>The energy policy established by top management was communicated, implemented and is available to interested parties, as appropriate, in the organization at last on 18/03/2019. It is suitable and includes the commitment to continual improvement and compliance with the applicable energy laws, regulations and requirements. It provides the framework for establishing and reviewing energy objectives. The organization has implemented and maintains a program for realizing the energy objectives and targets.</p> <p>Quantifiable key energy targets, which based on the organization targets, are:</p> <table border="1" style="margin-left: 40px;"> <tr> <td>IND_Natural Gas</td> <td></td> <td>1,074</td> </tr> <tr> <td>IND_Electricity</td> <td>MWh/t paper</td> <td>0,247</td> </tr> <tr> <td>IND_Energy total</td> <td></td> <td>1,318</td> </tr> </table>	IND_Natural Gas		1,074	IND_Electricity	MWh/t paper	0,247	IND_Energy total		1,318
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Energy performance and their changes since the last audit	<p>Essential energy uses are identified and their significance and impact on products and services are reviewed and updated at regular intervals (energy review last defined 14/12/2022, energy baseline from 01/01/2019 to 31/12/2021).</p> <p>The total energy consumption for the period from 01/01/2022 to 31/11/2022 amounts to the total sum (kWh) of:</p> <table border="1" style="margin-left: 40px;"> <tr> <td>Total Energy</td> <td>MWh</td> <td>71.832</td> </tr> </table> <p>and was divided into the following energy sources:</p> <table border="1" style="margin-left: 40px;"> <tr> <td>Electricity</td> <td>MWh</td> <td>13.440</td> </tr> <tr> <td>Natural Gas / Boiler</td> <td>MWh</td> <td>43.499</td> </tr> </table>	Total Energy	MWh	71.832	Electricity	MWh	13.440	Natural Gas / Boiler	MWh	43.499
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	<table border="1"> <tr> <td>Natural Gas/ Cogeneration</td> <td>MWh</td> <td>14.892</td> </tr> </table> <ul style="list-style-type: none"> The significant energy uses (SEUs) are (share of total energy consumption in %) : <ul style="list-style-type: none"> Gas Natural: 80% <ul style="list-style-type: none"> Steam production: 100% Electricity: 20% <ul style="list-style-type: none"> Paper raisin preparation: 50% Paper Machine: 37 Seawage: 14% <p>The production volume of the important products from 01/01/2022 to 31/11/2022 amounts to:</p> <table border="1"> <tr> <td>Paper</td> <td>t</td> <td>54.369</td> </tr> </table> <ul style="list-style-type: none"> Adequate energy performance indicators were determined (according to locations, if applicable): <table border="1"> <thead> <tr> <th>Year</th> <th>IND_ET</th> <th>IND_GN</th> <th>IND_EL</th> </tr> </thead> <tbody> <tr> <td>2022</td> <td>1,324</td> <td>1,076</td> <td>0,248</td> </tr> </tbody> </table> <p>The main planned measures in the action plans with the expected savings are:</p> <ul style="list-style-type: none"> Improvement of sewage aerators (improvement from 294 KW a 122 KW) <p>Other with less impact</p> <ul style="list-style-type: none"> Purchase of paper drying motor reducer. TEM_SEC and moisture meter Double acting pneumatic actuators in dry valves. Fan heaters in winding warehouse <p>The continual improvement of the energy performance has been determined identified by the following indicators and amounts to (e.g. development of energy performance indicators):</p> <p>Las línea base que define el consumo de gas natural se ve afectado por el % de Gas Natural aportado por la cogeneración. En la tabla siguiente se indica valores para minino, máximo de aportación y la realizadas en el periodo 1/01/2022 – 31/11/2022.</p> <table border="1"> <thead> <tr> <th>Base Lines</th> <th>% Cogeneration</th> <th>MWh/t</th> </tr> </thead> <tbody> <tr> <td>Natural Gas</td> <td>0%</td> <td>1,150</td> </tr> <tr> <td></td> <td>40%</td> <td>1,050</td> </tr> <tr> <td></td> <td>26%</td> <td>1,115</td> </tr> </tbody> </table>	Natural Gas/ Cogeneration	MWh	14.892	Paper	t	54.369	Year	IND_ET	IND_GN	IND_EL	2022	1,324	1,076	0,248	Base Lines	% Cogeneration	MWh/t	Natural Gas	0%	1,150		40%	1,050		26%	1,115
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	Year	IND_GN_ Base line	IND_GN_ 2022	Var.
	2022	1,115	1,076	-3,50%
	<p>The verification was provided by the document / the documents :</p> <ul style="list-style-type: none"> 2022 Control de indicadores.xls of 14/12/2022 			
Identification and monitoring of legal and other requirements	<p>The organization identifies the relevant energy related legal and other requirements at regular intervals and makes them accessible to all relevant functions.</p> <p>The following requirements are mainly relevant for the organization (by site, where appropriate):</p> <ul style="list-style-type: none"> AAI resolution 338R-2018. Compliance with BATs documents Energy efficiency outdoor lighting: RD 1890/08 Light pollution: LF 10 / 05.OK Use of refrigerants (HCFCs). R 1005/2009 Steam boilers: RD. 2060/098 Low Voltage installations. Rd 842/02; d 2413/7 High voltage installations: RD3275 / 82; ed 223/2006. Gas Network (ERM): of 425/09; RD 919/2006 Energy Audit. RD 26/2016 <p>A Second part legal compliance report carried out by AIN was provide: 12.02.2022 AIN Papertech Legal requirements verification report..pdf</p>			
Leadership, responsibility and authority and communication	<p>The top management demonstrates commitment with respect to the energy management system and integrates its requirements into the organization's business processes.</p> <p>The management system-related requirements regarding competence, of the people working for or on behalf of the organization as well as the roles, responsibilities and authorities are defined, documented and communicated.</p> <p>The organization has set up an effective communication process for both internal and external communication.</p>			
Operational planning and control, design and procurement	<p>To comply with the energy policy and the energy objectives and targets, the organization identifies all energy-relevant operations and activities. Operations are planned and monitored.</p> <p>The organization maintains documented information for analyzing and including the impact of design (processes, products, equipment, etc.) and of procurement activities on organizations energy performance.</p>			
Control of documented information	<p>The ongoing control and maintenance of documents and records regarding the energy management system is appropriate.</p>			
Internal audit and management review	<p>The organization measures the implementation, maintenance and effectiveness of the management system by means of annually scheduled system audits. The organization reliably carries out these audits.</p> <p>Top management reviews the organization's management system at regular intervals and in line with the requirements to ensure its continuous suitability, adequacy and effectiveness. The management review was carried out in accordance with the requirements and was effective.</p>			

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	Date of last management review: 14 /3/ 2022
Use of certificate and logo	The organization uses the logo and the certificate (e.g. on business cards, company brochures, websites etc.) in compliance with the requirements.

Chapter of standard	4.1	4.2	4.3	4.4	5.1	5.2	5.3	6.1	6.2
Rating*	1	1	1	1	1	1	1	1	1
No. of nonconformity									
Chapter of standard	6.3	6.4	6.5	6.6	7.1	7.2	7.3	7.4	7.5
Rating*	1	1	1	1	1	1	1	1	1
No. of nonconformity									
Chapter of standard	8.1	8.2	8.3	9.1	9.2	9.3	10.1	10.2	
Rating*	1	1	1	1	1	1	1	1	
No. of nonconformity									

***Rating:** 1 = conforming
2 = nonconformity (see nonconformity report)