K-C Beech Island – largest plant worldwide.

- In Operation since 1968.
- 1200 K-C and 700 3rd party contract employees.
- EHS Team – 9 members (4 environmentally oriented, with a full-time Recycle Coordinator).
- Member of the SC Environmental Excellence Program.
- 5 basesheet tissue machines and 9 diaper and training pants machines.
- Manufacturing Site for:
  - Huggies® Diapers
  - Pull-Ups® Training Pants
  - Scott® Bath Tissue
  - Cottonelle® Bath Tissue
  - Scott Extra Soft® Bath Tissue
  - Kleenex ® Facial Tissue
  - Cottonelle® Fresh Moist Wipes
  - Viva ®Towels and Scott ® Towels

Recycling at K-C Beech Island

- Waste Hierarchy (from most to least desirable)
  - Don't produce it!
  - Recycle within process.
  - Recycle offsite.
  - WTE.
  - Landfill.

Mill and Enterprise goal is to be 100% landfill diverted by 2022.

A site this large produces a lot of waste!

- **3000 metric tons of waste are produced each month:**
- Mixed polymers
- Nonwoven material
- OCC
- Metals
- Short fiber from WWTP
- Cartons
- Core stock
- Moist Wipes

A small percentage is destined for waste-to-energy.

We are constantly scanning the globe for new opportunities for beneficial reuse of our secondary products

We review our solid waste performance standard annually to ensure we have the right systems in place to maximize waste recycling

- Some of our materials are difficult to recycle, so WTE makes the most sense.
- No local WTE options in the Augusta River Region.
- Partnerships with facilities near Columbia and Atlanta.

Moist Wipes Bales

- Moist Wipes are difficult to recycle
  - Damp
  - Salt content

  Can be utilized for waste to energy if metered in with other combustible wastes.

  Current partnerships with fiberboard and absorbent manufacturers.

Poly/Fiber Wastes

- One of our tissue manufacturing processes creates several polyethylene/fiber mixed wastes.
  - Wet
  - Salt content
  - Like Moist Wipes, can be metered in with other wastes.
  - Exploring partnership with cement kiln for WTE disposition.

Coated Cores

- A corrugated core coated with a plastic coating.
- Cannot physically separate layers.
- Can be chipped or chopped and readily burned.
- Exploring partnership with WTE option in Columbia.

Beyond Difficult Waste Streams… The Future

- WTE for site energy generation – Cogeneration.
- Municipal Trash solutions – composting?
- Feasibility will be determined by economics.