

nora® floorcoverings  
made of rubber –  
leading worldwide

## Environmental Declaration for 2006

updated Version for 2008

nora systems GmbH  
Hoehnerweg 2-4  
D-69469 Weinheim Germany

**nora**®



**EMAS**

# Certificate of Registration



Freudenberg Bausysteme KG  
Höhnerweg 2-4

69465 Weinheim


Registration-No.: D-153-00016


Date of first registration 7<sup>th</sup> March 1997

This organisation has established an environmental management system according to EU-Regulation Nr. 761/2001 to promote the continual improvement of environmental performance, publishes an environmental statement, has the environmental management system verified and the environmental statement validated by a verifier, is registered under EMAS and therefore is entitled to use the EMAS-Logo.



Mannheim, 19<sup>th</sup> November 2001

  
Dipl.-Ing. Hubert Eirich  
President

  
Prof. Dr. Franz J. Luzius  
Chief Executive Officer



# C E R T I F I C A T E

## DQS GmbH

Deutsche Gesellschaft zur Zertifizierung von Managementsystemen

hereby certifies that the company

### nora systems GmbH

Höhnerweg 2-4  
69469 Weinheim  
Germany

for the scope

Manufacture, sales and marketing of floor covering systems,  
shoe components and table mats made of rubber

has implemented and maintains an

### Environmental Management System.

An audit, documented in a report, has verified that this  
environmental management system fulfills the requirements  
of the following standard:

### EN ISO 14001 : 2004

November 2004 edition

This certificate is valid until 2009-06-29

Certificate Registration No. 053195 UM

Frankfurt am Main 2007-12-05

Ass. iur. M. Drechsel

MANAGING DIRECTORS

Dipl.-Ing. S. Heinloth



D-60433 Frankfurt am Main, August-Schanz-Straße 21



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## Foreword from the board

Dear readers,

In December 1996, Freudenberg Bausysteme KG (today nora systems GmbH) was for the first time audited under the rules of Directive No. 1836/93 (EEC), usually known as the EC's Eco-Management and Audit Scheme or EMAS. The present environmental declaration submitted was validated by an approved environmental assessor according to the new directive 761/2001. Freudenberg Bausysteme KG operates now under the name nora systems GmbH and is registered among the audited facilities through the Rhine Neckar Chamber of Industry and Commerce under Register Number D-153-00016.

In addition, we arranged for our eco-management systems to be certified since 1999 under the international DIN EN ISO 14001 standard.

This environmental declaration reports on the continuous and progressing development of our eco-management system, our corporate environmental protection program, the recording and analysis of our environmental impacts, and the implementation of our environmental goals.

If you have any further questions, please get in touch with us directly (see also 22).

Weinheim, May 16 2008



Heinz Futscher  
Managing Director  
Manufacturing and Development

Philipp Leferenz  
Managing Director  
Sales and Marketing

Christa Hoffmann  
Managing Director  
Finance and IT



**Register-No.:**  
**D-153-00016**

## Company portrait

nora systems GmbH was founded in October 2007. The company is successor in title of the Freudenberg Bausysteme KG business group, an autonomous enterprise since 1995, arisen from a division of the company Carl Freudenberg. The sales companies in some countries work independently. They form together with the production site, administration and development department the new nora system GmbH. The corporate structure involved is depicted below.

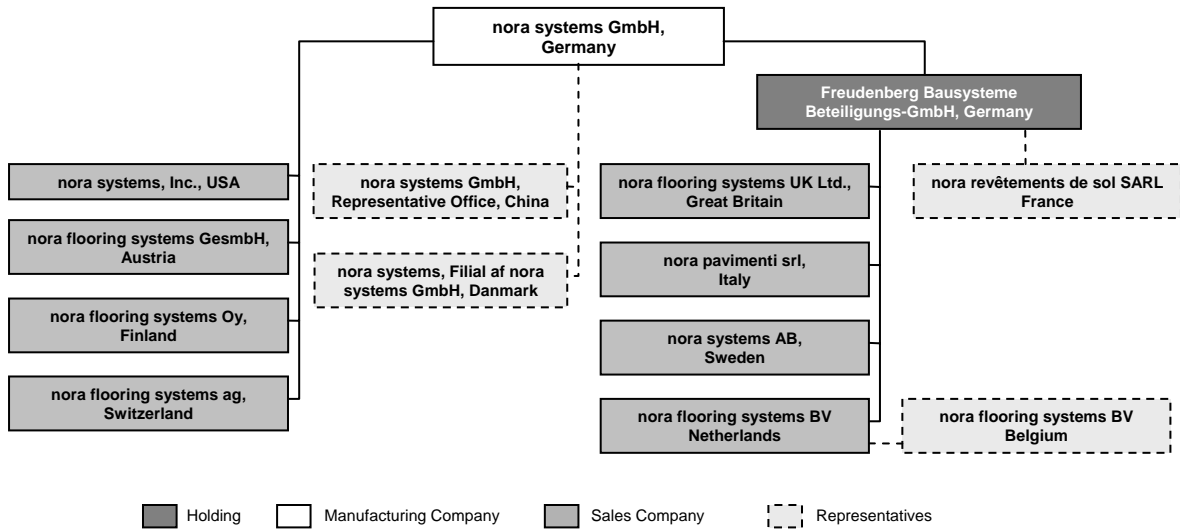


Fig. 1: Corporate structure

nora systems GmbH is a company specializing in high-quality floorcovering systems and shoe components. With a production output of more than 6 million square meters a year, nora systems GmbH is the world's market leader for resilient rubber-based floorcoverings. The noraplan<sup>®</sup> roll goods are vulcanized in an endless web on automatic continuous lines, while the norament<sup>®</sup> tiles are produced in multiplaten presses. The materials for shoe components and the expanded-material sheets for orthopedic applications are likewise manufactured in presses.

nora systems GmbH currently employs 850 people in Germany, about 550 of them in the production operation. Annual turnover in 2007 exceeded 165 million euros. Development, production, administration and sales are concentrated at the facility in Weinheim. Sales abroad are all handled by local sales organizations, with another 230 staff worldwide.

The nora systems GmbH is located in the industrial park Weinheim ("Zwischen Dämmen"). The production lines and administrative buildings are essentially located in the south-west corner, where the "Alte Weschnitz" river arm forms the area's southern boundary. The buildings are rented from Freudenberg Immobilien Management GmbH.

Weinheim is conveniently situated in the Rhine valley, on the edge of the Odenwald Forest, in the vicinity of Mannheim and Heidelberg. The autobahn is only a few kilometers away.

On terms of European economic classification, the facility is assigned NACE Code 22.19.

## Environmental policy

nora systems GmbH is fully conscious of its responsibilities to the natural environment. Environmental protection enjoys equal priority with other important corporate goals.

Environmental protection is handled at boardroom level in nora systems GmbH. The goals of supporting and fostering eco-awareness among our staff, and continuously improving corporate environmental protection with the best available technology which is also financially viable, are an integral constituent of corporate policy-making.

nora systems GmbH develops, makes and sells products which are as eco-compatible as possible in terms of their manufacture, utilization and disposal.

## Guidelines

The management and staff of nora systems GmbH are working systematically to assure continuous improvement of corporate environmental protection. The aim is to use the best available technology, provided this can be reconciled with adequate cost-efficiency.

We focus on long-term goals: economical husbandry of all resources, utilization of a cooling water circuit, and the use of secondary raw materials show that ecology and economy are by no means mutually exclusive.

We practice preventive environmental protection: compliance with environmental legislation is a *sine qua non*, and is not restricted to the statutory minimum. Above and beyond the legal requirements, internal guidelines are enacted and appropriate action is taken to ensure our continuous improvement in terms of corporate environmental protection.

We regularly monitor the success of our environmental protection initiatives by means of internal and external audits, measurements and analyses, together with mutual feedback in internal working groups and on external bodies. Sustained success is possible only by involving all staff in line with their qualifications and responsibilities. Environmental protection is therefore an essential constituent of training and information.

We keep our customers informed about the eco-responsible production and utilization of our long-lived products, and provide guidelines on how they can be recycled after the end of their useful lifetimes. One defined objective of our processes is to minimize the impact on human beings and the natural environment.

We involve our business associates in implementing our environmental policies. Raw and process materials, plus packing materials, are also selected and used in line with environmental criteria.

We keep the public informed of our eco-relevant activities, and also of improvements and goals already achieved or currently planned in our company, through this environmental declaration and through further publications on the subject of environmental protection.

## Eco-management

Overall responsibility for environmental protection at nora systems GmbH is vested in Heinz Futscher, the management director, manufacturing, development and administration. He is simultaneously the company's eco-management officer. The body entrusted with formulating environmental protection goals and action plans is the Environmental Protection Committee. Environmental policies and the eco-programs are implemented on all levels of the line organization.

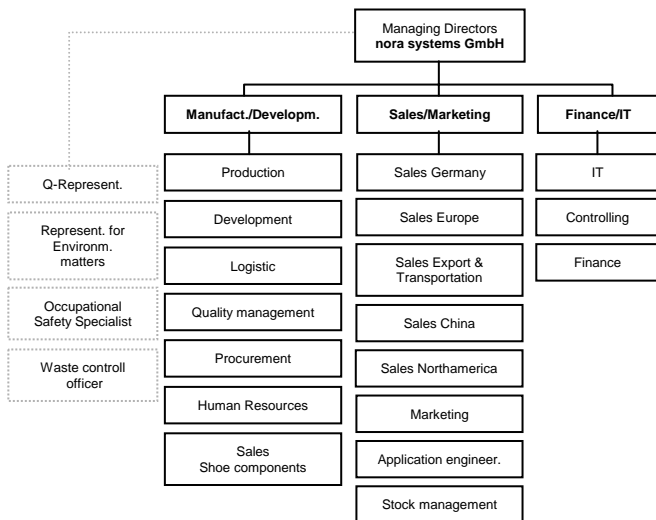


Fig. 3: Organigram of nora systems GmbH

A detailed description of how corporate environmental protection has been organized is provided in an Eco-Management Manual, which is written and updated by the Plant Officer for Environmental Protection.

The eco-management system is regularly monitored by internal and external auditors. This ensures that all elements of the Directive (EC) 761/2001 (EMAS) are being appropriately complied with. Any deviations from the rules discovered are discussed in the Environmental Protection Committee, and eliminated by appropriate measures taken in consultative coordination with the board.

Occupational safety management (according OHSAS 18001) is closely linked to the environmental protection management. The committee for occupational safety meets four times a year.

In order to integrate all employees in the continuous process for improvement of the occupational safety, there are regular meetings of the heads of the departments, foremen, shift men, safety representatives and the engineering division.

Since 2003 the occupational safety management is audited.

Special remits in terms of environmental protection are handled by the following functions:

- The Head of Development is responsible for the substances used in our products.
- The Head of Engineering is responsible for planning, installation and maintenance of lines and equipment.
- The Plant Officer for Environmental Protection coordinates and monitors all environmental protection activities.
- The Hazardous Goods Officer is an employee of Freudenberg Service KG appointed by contractual agreement.
- The Freudenberg Service KG operates the Industrial Estate in Weinheim. The following of the environmentally relevant tasks are handled there under contractual arrangements on behalf of nora systems GmbH:
  - full-time plant fire brigade for emergencies
  - supplying energy and water
- The commissioning of an employee as immission control officer is not necessary according to legal regulations.

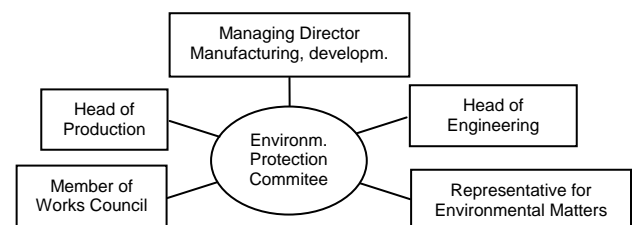


Figure 2: Composition of the Environmental Protection Committee

## Environmental impacts / Substance and energy utilization

The diagram below shows in simplified form the process used for manufacturing floor coverings from rubber.

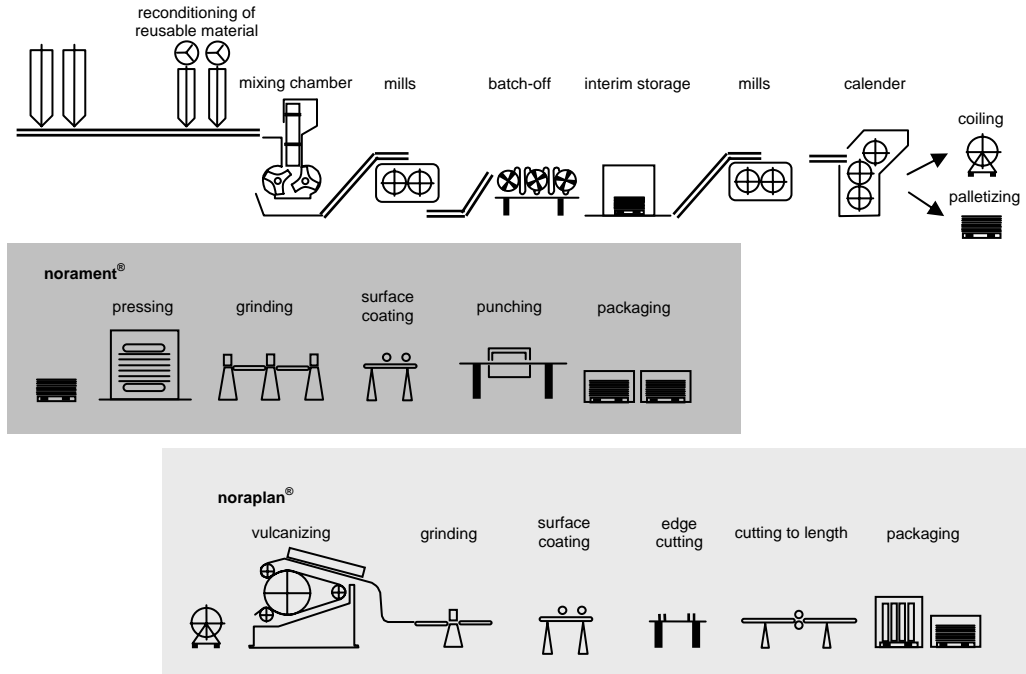


Figure 4: Process diagram for the manufacturing of floorcovering

On the basis of a recommendation by the European Commission (2001/680 EC), the environmental impacts attributable to nora systems GmbH have been determined. The results are summarized in the table below.

Assessing environmental impacts		
STAGES OF THE ECONOMIC CYCLE		
Activities	Nature of environmental impacts	Influencing options
<b>Procurement</b>		
Purchase of starting materials for processing, distribution and marketing		
Purchasing of raw materials for the production process	Exhaustion of non-renewable raw materials Exploitation of raw material resources Energy consumption for raw material production and transport	Purchase renewable raw materials Use geogenic fillers Be alert for renaturation options Purchase recyclable materials Minimize the quantity of hazardous substances and hazardous goods Minimize transportation distances
Purchasing of process materials like paper, cardboard and other packing material	Wood consumption, water pollution	Purchasing of recycled paper and cardboard Re-usability / recycable materials
<b>Development</b>		
Product development		
Development of new products / design enhancement of existing ones	Indirect effects: raw material selection product design health aspects	Minimize the use of hazardous substances, re-usability / disposability Minimize emissions

<b>Production</b>		
Product manufacture		
Storage of raw and process materials	Pollution of the environment with chemicals Fire risk with emissions of conflagration gases	Avoid discharging unwanted substances into the environment
Mixing the raw rubber mixture	Pollution of the air by emissions Disposal of waste mixtures (defective batches, cleaning rubber) Removal of groundwater for cooling purposes	Dust arrestance units Minimize the cleaning cycles and multiple use Avoid preparation errors Ensure waste is recovered
Calanderizing blank rolls	Disposal of waste mixtures Removal of groundwater for cooling purposes	Minimize start-up and shut-down losses Ensure waste is recovered Reduce amount of groundwater removed for cooling purposes
Vulcanization in presses	Emissions into the air Disposal of edge trim waste Removal of groundwater for cooling purposes	Minimize lateral waste Ensure waste is recovered Reduce amount of groundwater removed for cooling purposes
Vulcanization on continuous machines	Emissions into the air Disposal of waste, start-up and shut-down losses, grinding dust Removal of groundwater for cooling purposes	Minimize start-up and shut-down losses Ensure waste is recovered Reduce amount of groundwater removed for cooling purposes
Coating of products	Disposal of waste (faulty coating)	Ensure waste is recovered
Finishing (punching, grinding)	Disposal of waste (punching waste, grinding dust) Removal of groundwater for cooling purposes	Ensure waste is recovered Reduce amount of groundwater removed for cooling purposes
Order-picking	Disposal of waste (sorting losses)	Ensure waste is recovered
<b>Marketing and administration</b>		
Sales promotion and marketing of products and services		
Informing customers about our products	Reduction in amount of waste entering the environment	Communicate appropriate information on installation, cleaning, disposal
Office activities involving use of energy, paper and office equipment	Reduction in amount of waste entering the environment	Separate the waste collected in the offices
<b>Distribution</b>		
Road and air transportation of products from their place of manufacture to wholesalers and customers		
Use of cardboard and films for transport packing	Reduction in amount of waste entering the environment Reduced consumption of materials	Use PE films, cardboard and wood Take back packing material
Road and air traffic	Global warming and local air pollution; exhaustion of mineral oil reserves; traffic jams and noise pollution	Use sea freight Optimize freight quantities per transportation trip

<b>Disposal</b>		
Waste disposal by the company	Possible waste entering the environment	Ensure that as much as possible is recovered
Disposal of product packaging and installation residues by client	Increased amount of commercial waste	Use packaging made of recyclable material and recoverable substances
Disposal of removed floorcoverings	Waste entering the environment	Offer to take back products after removal

Table 1: Environmental impacts

Environmental impacts within the specific meaning of the EMAS Directive cover not only the consumption of energy and natural environmental goods like raw materials, but also the emissions into air and water, waste and noise, insofar as their impacts extend beyond the site's boundaries. They are quantified and explained in the sections below.

The figures given below are from time-series covering several years. The data given are relative data, since they are always referenced to the quantity mixed of the year concerned. Experience has shown that this is essential if the annual figures are to be meaningfully compared. The quantity mixed is the total masses of all raw and process materials made into raw mixtures in the mixing chamber.

## Water and wastewater

Water consumption per ton of quantity mixed

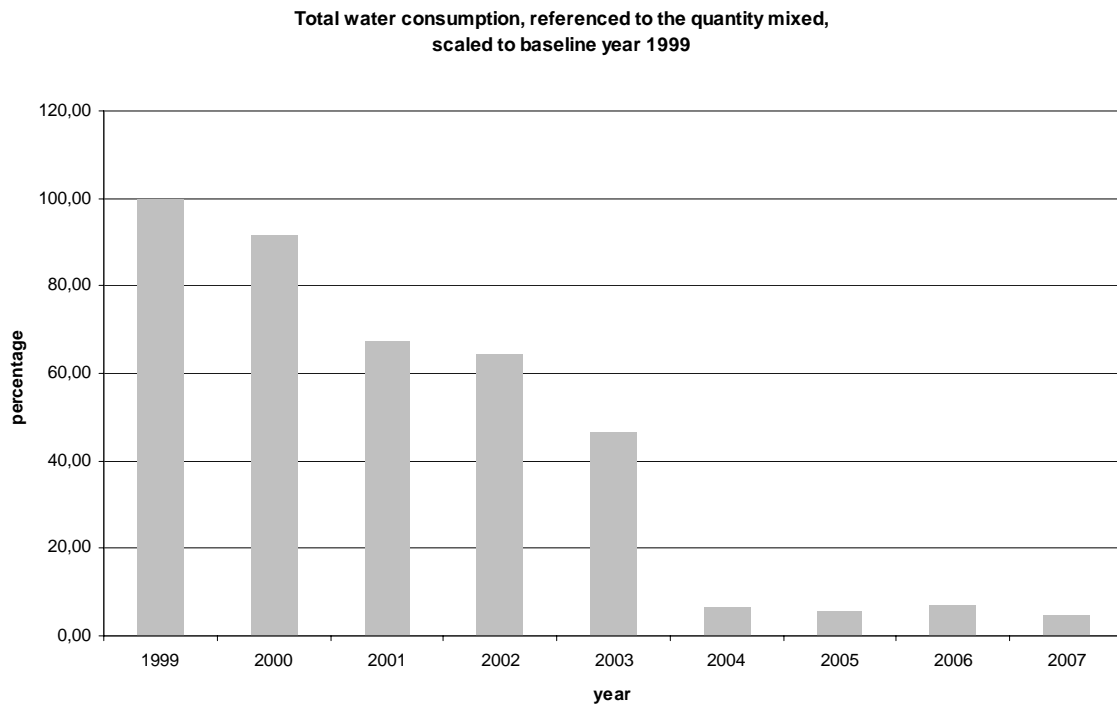


Figure 5: Water consumption

The total water quantity is composed of several different water qualities. The breakdown of water categories for 2007, for instance, was:

Well water (cooling water)	42 %
Municipal water (drinking, sanitary water)	32 %
Demineralized water	26 %

In total the water consumption could be reduced to 5 % in comparison to the year 1999. In substance this is caused by the decrease of well water; therefore the percentage of demineralized water (for cooling towers) and municipal water (sanitary) has increased respectively.

Well water, which is provided by the Freudenberg Service KG on the industrial estate "Zwischen Dämmen", is used for toilet flushing and in the beginning of 2007 as additional cooling system. Else the production line is cooled via own cooling towers and thermal/electrical generated cooling energy from the power plant of the Freudenberg Service KG.

The municipal water from the public supply is used as drinking water and in the sanitary facilities; the resultant wastewater corresponds to domestic wastewater in terms of its composition.

Demineralized water is used in processes and machines where deposits of salts dissolved in water absolutely have to be avoided, especially in cooling towers.

All the wastewater produced, essentially consisting of sanitary wastewater is purified in the sewage plant, which is operated by Freudenberg Service KG. The four-stage process used also eliminates nitrogen compounds, which may contribute towards eutrophication of the surface water.

Dirty water and rainwater (surface drainage) on the site are passed into separate drainage systems. The rainwater is discharged into the river Weschnitz.

## Energy

The time-series diagrams below provide a visualized depiction of our energy consumption. As a reminder: due to the targeted comparability, the data are referenced to the quantity mixed, the baseline year (100 %) is 1999.

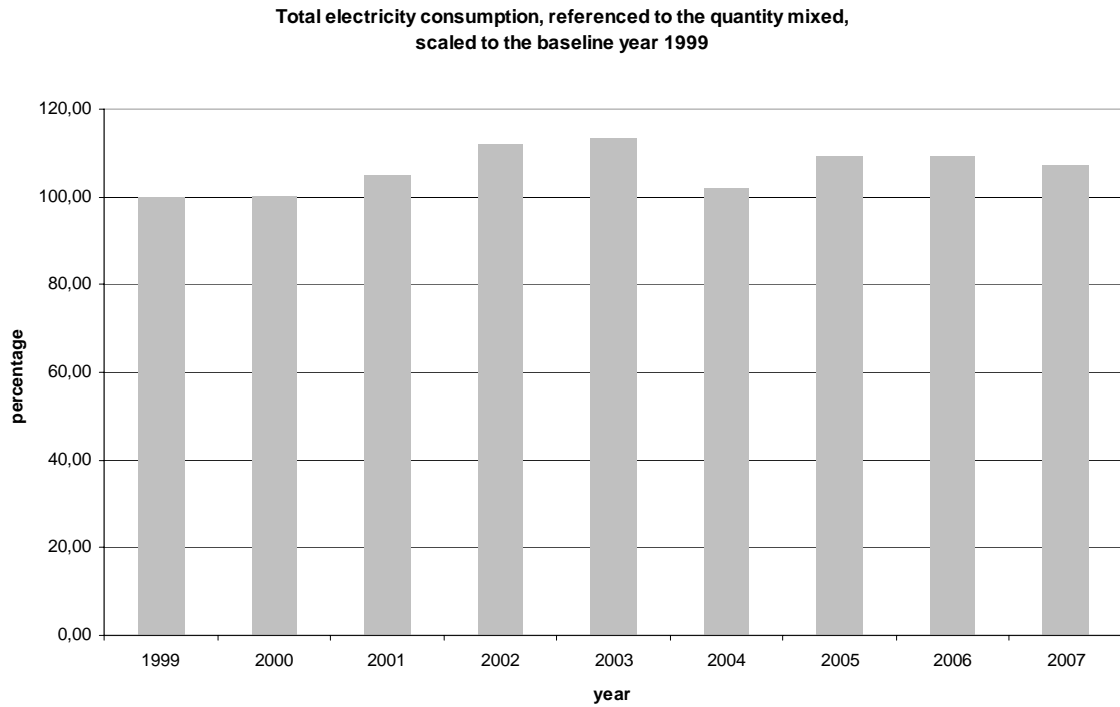


Figure 6: Consumption of electricity

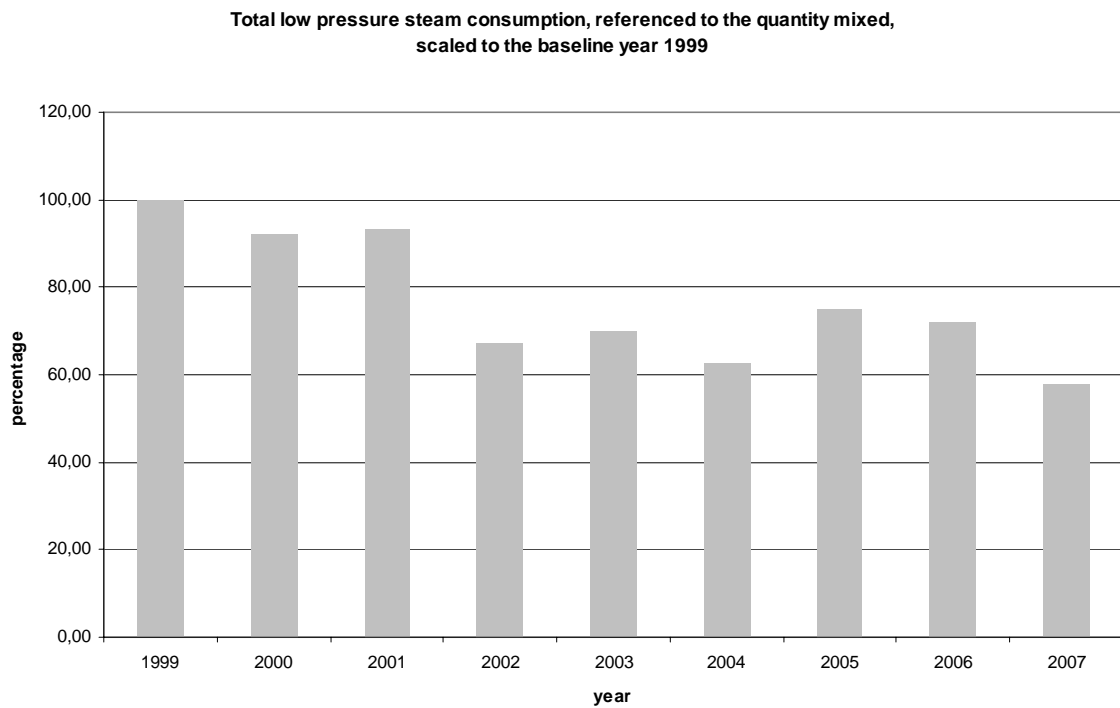


Figure 7: Consumption of low-pressure steam

Total medium pressure consumption, referenced to the quantity mixed,  
scaled to the baseline year 1999

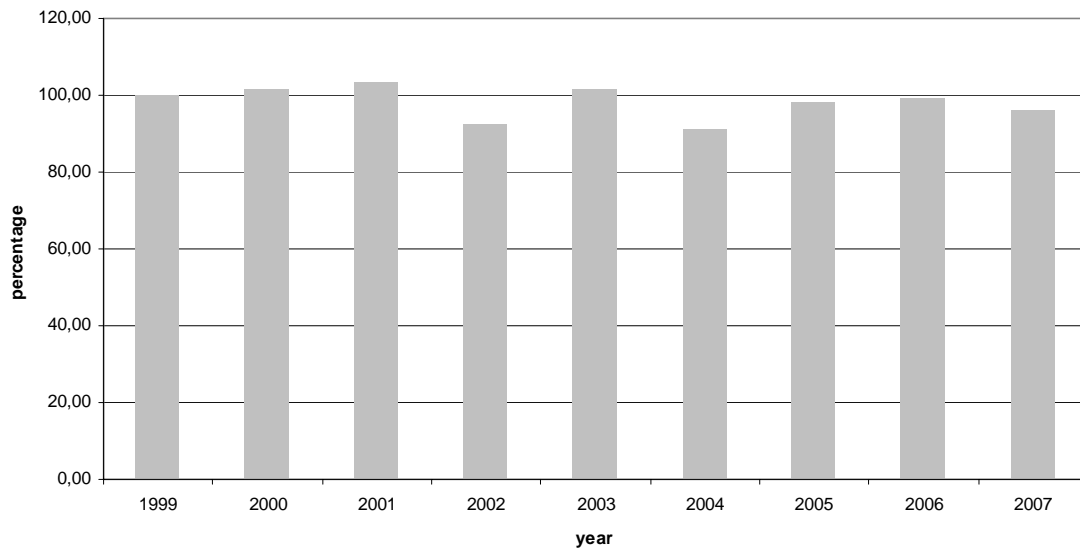


Figure 8: Consumption of medium-pressure steam

nora systems GmbH is supplied with all forms of energy by the energy department of Freudenberg Service KG. Electricity and medium-pressure steam as the principal energy carriers for the processes are generated from natural gas in a cogeneration power plant, located in the industrial park with an efficiency of about 85 %, for maximized eco-compatibility.

The low-pressure steam consumed is utilized for heating production halls and offices. The decrease of the consumption since 1999 has its cause in better heat insulation of the used buildings and automated gates (especially in the cold seasons). The differences in the last four years depend on the variability of the yearly temperatures.

**Total compressed air consumption, referenced to the quantity mixed, scaled on the baseline year 1999**

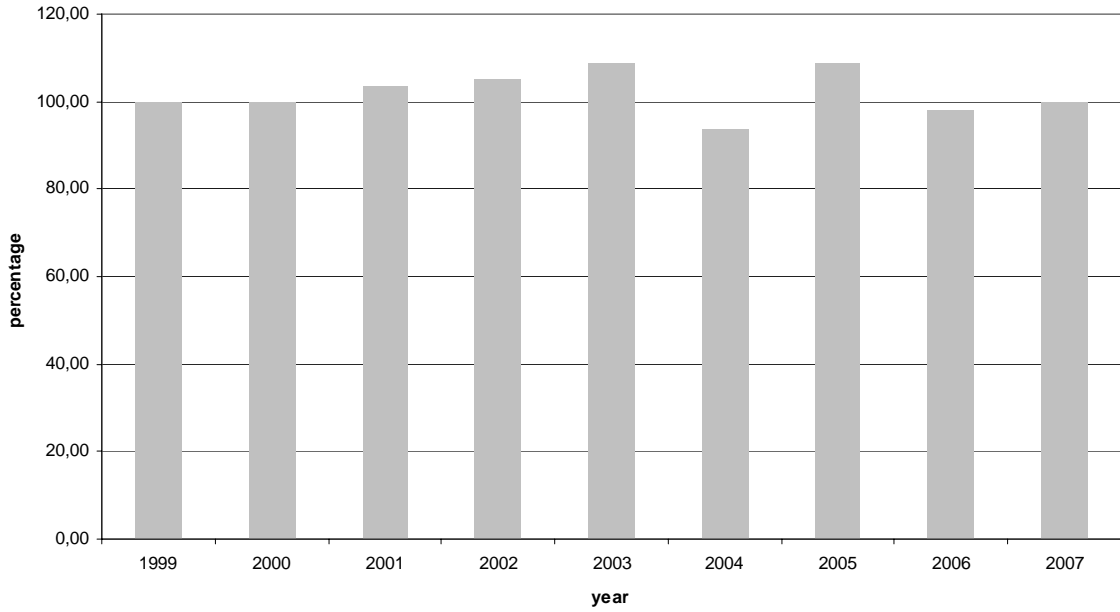


Figure 9: Consumption of compressed air

The compressed air for all main parts of the production line is also provided from the Freudenberg Service KG. In substance it is used for the machine control and for re-blowing of particle filters.

**Natural gas consumption for dual press equipment, referenced to produced area (m<sup>2</sup>), scaled on the baseline year 2002**

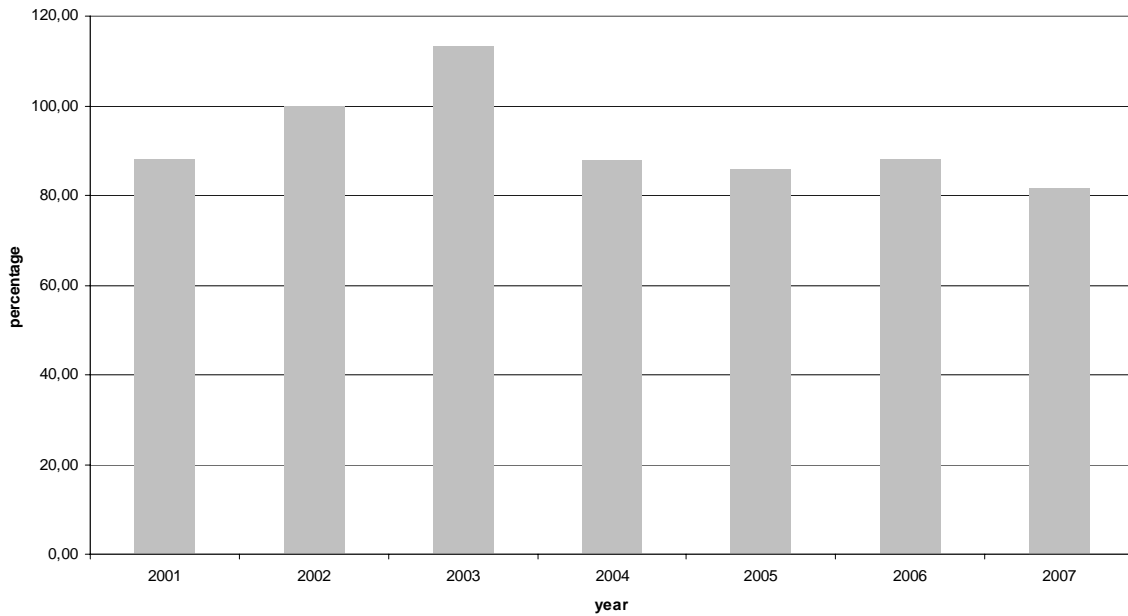


Figure 10: Consumption of natural gas for dual press equipment



## Reusable material management system

### Internal recovery of production waste

Grinding dusts from the norament<sup>®</sup> end processing are separated by colour before being collected, and after a sieving process are admixed to appropriate products in the mixing process as a high quality filler.

For special applications (e.g. installation in golf club buildings, large-animal clinics and indoor rifle ranges), we produce norament<sup>®</sup> tiles, which in addition to a top layer of new material, exhibit a thick underlay of recycled materials.

For design creating decorative granules are used. Originally this design has risen out of the idea to reuse web flashes, which accrue during production. Due to the demand of granules and colour shades they are not sufficient any longer. Compact material is vulcanized, which is then processed to granules.

### Reusable material and Wastes

The following allocation into various classifications has been arisen out of the present figures (2007).

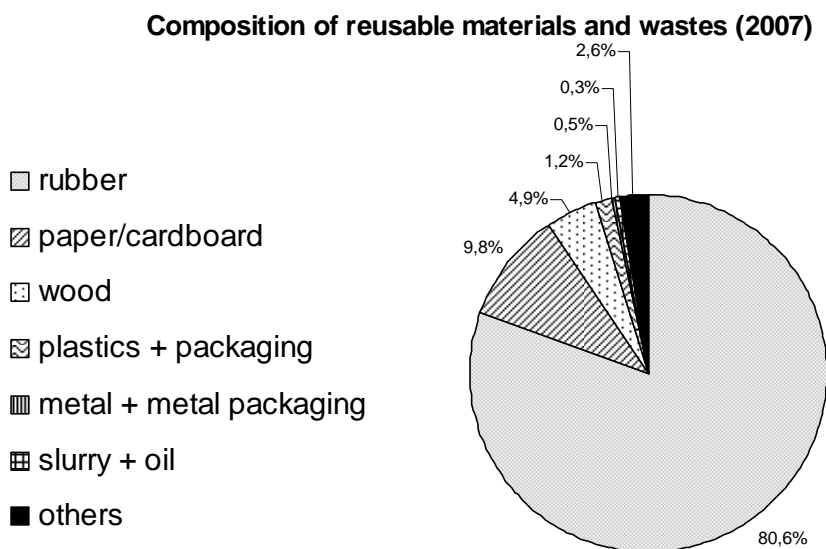


Figure 11: Composition of reusable materials and wastes

The data given above contain the quantities leaving the company for recovery and disposal. The recovery rate of reusable materials and wastes is meanwhile running at over 99 %. This means that the material is either recycled or converted into electrical and/or thermal energy by means of a thermal recovery process.

Internally processed substances are not included in this figure.

The largest waste quantity is the grinding dust created when the floorcovering's installation side is ground and rubber pieces. For this substance, incineration in cement plants is the suitable method of disposal: the combustion heat of the entire organic material is utilized for burning the cement clinker. The inorganic ash remaining from the fillers is an ideal raw material for Portland cement, so that not only heat, but also a useful substance is recovered.

Grinding dusts suitable as filler material and for other purposes are also passed to outside processing companies.

Re-use and further use of paper and cardboard is meanwhile routine. The wood used as packaging for raw materials is, after being comminuted, either used again in the chipboard industry, or also incinerated.

The small quantity of hazardous waste (special waste) consists predominantly of cleaning cloths soiled with oil and grease, which are incinerated.

The category waste constitutes, in quantitative terms, the largest environmental impact from the company. However, it is precisely the high-volume waste that is increasingly being recovered, so that the net quantity of substances discharged into the environment by landfilling has been steadily reduced.

Waste from office areas is not included in the above figure. They are disposed centrally by an office cleaning service.

## Substances used

The following substance quantities have been processed into rubber mixtures in the past few years.

Year	Rubber [t]	Fillers [t]	Process materials Cross-linking chemicals Pigments [t]
2000	12 800	18 500	5 500
2001	11 900	17 300	5 100
2002	11 550	17 500	4 950
2003	11 400	17 200	4 900
2004	12 780	18 000	4 350
2005	11 770	17 200	5 600
2006	12 500	19 500	4 700
2007	12 600	19 600	4 700

Table 2: Substance quantities since 2000

The alteration of the proportions of the substance quantities is substantiated by a commercial adjustment within the allocation of the goods groups.

Raw and process materials are stored in the central warehouse. We pay particular attention here to hazardous substances, particularly those which are a threat to water. Storage of water-hazardous substances has been audited by an approved assessor organization. Substances whose storage is governed by the German Plant Safety Ordinance are kept in an approved VbF (German Ordinance on Flammable Liquids) store until they are used.

Almost all raw materials used to produce the rubber mixtures are processed in the mixing shop. To save on packing material, the raw materials used in large quantities are stored in silos, and dosed into the process from there.

For packing our products, we take re-usable or recoverable materials like wooden pallets, PE films and cardboard. For the pallets, we offer a return scheme with a financial incentive.

## Our eco-program for continuous improvement of 2003

The essential content of the EC Eco-Management and Audit Scheme is continuous improvement of corporate environmental protection. For the three-year interval up to revalidation 2006, we had set ourselves the following goals. After a phase of numerically major improvements, we began the fine-tuning work on our environmental protection goals. All figures given are referenced to the quantity mixed.

No.	Environmental goals	Improvement planned, with action required	Goal
1	Reduce rubber waste by a total of 5 %, distributed over the next 3 years	<ul style="list-style-type: none"> <li>● Reduce the waste quantity of unvulcanized material</li> <li>● Multiple use of cleaning rubbers</li> <li>● Reduce the number of faulty mixtures</li> </ul>	End of 2005 responsible: Head of Production
2	Reduce the cooling water quantity by another approx. 50 %, referenced to the quantity mixed	<ul style="list-style-type: none"> <li>● Change over the machinery to cooling with cold water</li> <li>● Optimize cooling water control</li> </ul>	End of 2004 responsible: Engineering
3	Expansion of raw material provision in silos	<ul style="list-style-type: none"> <li>● Build new silo systems as required</li> </ul>	End of 2004 responsible: Engineering
4	Save on PE film material in the production operation	<ul style="list-style-type: none"> <li>● Try out separation of blanks by aqueous preparations</li> <li>● Replace the films wherever possible</li> </ul>	Mid-2004 responsible: Head of Production

Table 3: Environmental goals of the 2003 eco-program

In order to achieve these goals, and implement the eco-program of 2003, a detailed action plan was drawn up in the Environmental Protection Committee, specifying the persons responsible and a time schedule. The program forms part of the documentation package for our eco-management system, and is handled in accordance with our specifications.

## Implementation of the eco-program of 2003

### Goal 1 Reduce rubber waste by a total of 5 %

Alas this goal has not been achieved. In absolute figures a reduction (total rubber waste) of 3 % has been achieved. Referenced to the quantity mixed only a reduction of 0,7 % has been obtained compared to 2003. In substance, the decline is caused due to multiple use of cleaning rubber. The positive effect is compensated by losses due to starting-up and finishing-processes and production of smaller batches.

### Goal 2 Reduce the cooling water quantity by another approx. 50 %, referenced to the quantity mixed

The quantity of cooling water could be reduced more than the planed 50 % even up to 90 %. This goal has therefore been more than just achieved. Reason of this effect is the installation and utilization of cooling towers and external provided cooling power.

### Goal 3 Expansion of raw material provision in silos

The substruction for the installation of additional silos has been build up and the according infrastructure has been installed. Currently there was no demand, so that further silos were not build up yet.

### Goal 4 Save on PE film material in the production operation

**Save on PE film  
(scaled on baseline year 2002)**

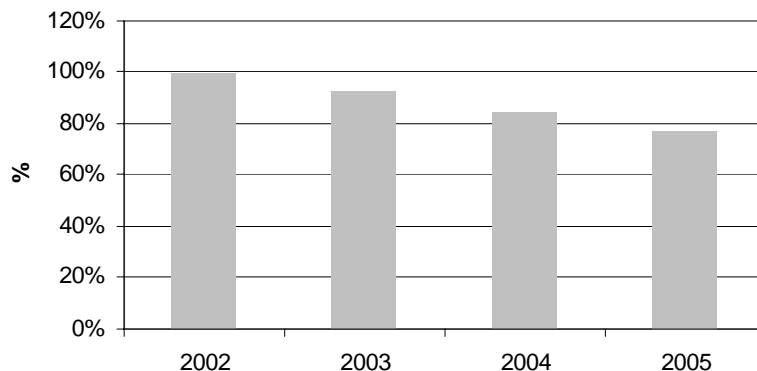


Figure 12: Deposited PE film

Figure 12 shows that the total amount of deposited PE film in the last years was obviously reduced. In the year 2004 we achieved a reduction of 16 %. The actions in the production line were even more effective, as in this case the quantity of PE film is recorded statistically over the whole company (not referred to the quantity mixed).

## Discuss old environmental goals, find new ones

For the three-year interval up to revalidation 2009, we have set ourselves the following goals.

No.	Environmental goals	Improvement planned, with action required	Goal
1	Detailed analysis of the energy consumption	<ul style="list-style-type: none"> <li>● Structuring of the energy grid</li> <li>● Breaking down to the consumer</li> <li>● Online-data-registration and correlation with production protocol</li> </ul>	End 2008 responsible: Engineering
2	Qualification of two internal environmental auditors	<ul style="list-style-type: none"> <li>● Training of further employees as substitutes for retired staff</li> </ul>	End 2008 responsible: Plant officer for Env. Protection
3	Material recovery of rubber waste	<ul style="list-style-type: none"> <li>● Increase of the rate of material recovery of both vulcanized and unvulcanized rubber waste of at least 50 %</li> </ul>	Mid 2009 responsible: Head of reusable material management
4	Updating of emission register	<ul style="list-style-type: none"> <li>● Measurements on all chimneys with relevant emissions</li> <li>● Summary of data in a register</li> <li>● Investigation of total emission of the company referred to the quantity mixed</li> </ul>	Mid 2008 responsible: Plant officer for Env. Protection and engineering

Table 4: Environmental goals of the 2006 eco-program

## Major changes up to 2005

New equipment for surface coating of roll goods was installed end of 2005 and commenced producing at the beginning of 2006. Due to consequent usage of solvent free coating the emission of this plant is minimized. Solvents are only used in small amounts for cleaning reasons. The used quantity falls far below the specified limits of the German directive concerning solvents (31. BImSchV).

## Contact person

Our perceived responsibilities for the natural environment include a free and frank dialog with the public. If you have any queries, suggestions, or requests for further information, please get in touch with the Plant Officer for Environmental Protection.

nora systems GmbH  
Hoehnerweg 2-4  
D-69469 Weinheim

Dr. Gerhard Heidecke  
Plant Officer for Environmental Matters  
Building 33  
D-69469 Weinheim  
Telephone +49(0)6201/80-3509  
Telefax +49(0)6201/88-3509

## Statement of validity

On the basis of the facility assessment conducted by myself as an independent environmental assessor, and following an examination of the data and information provided,

- I confirm that the environmental policies, the eco-program, the eco-management system, the environmental auditing procedure and the environmental declaration of nora systems GmbH, Weinheim Facility, meet the requirements of Directive (EEC) 1836/93;
- I confirm that the statements in the updated environmental declaration for the Weinheim facility are reliable, and that the environmental issues relevant at this facility have been adequately addressed;
- I hereby validate the Environmental Declaration.

Weinheim, May 16 2008



Dr. Bernd Frei

Environmental Assessor

DE – V – 0015

Hadaeckerstr. 27  
D-70597 Stuttgart

Deadline for the next environmental declaration:

We shall be presenting our next validated Environmental Declaration in May 2009.

Weinheim, May 16 2008

