



Fruit Juices | Purees | Concentrates



ENVIRONMENTAL  
STATEMENT  
MAY 2023

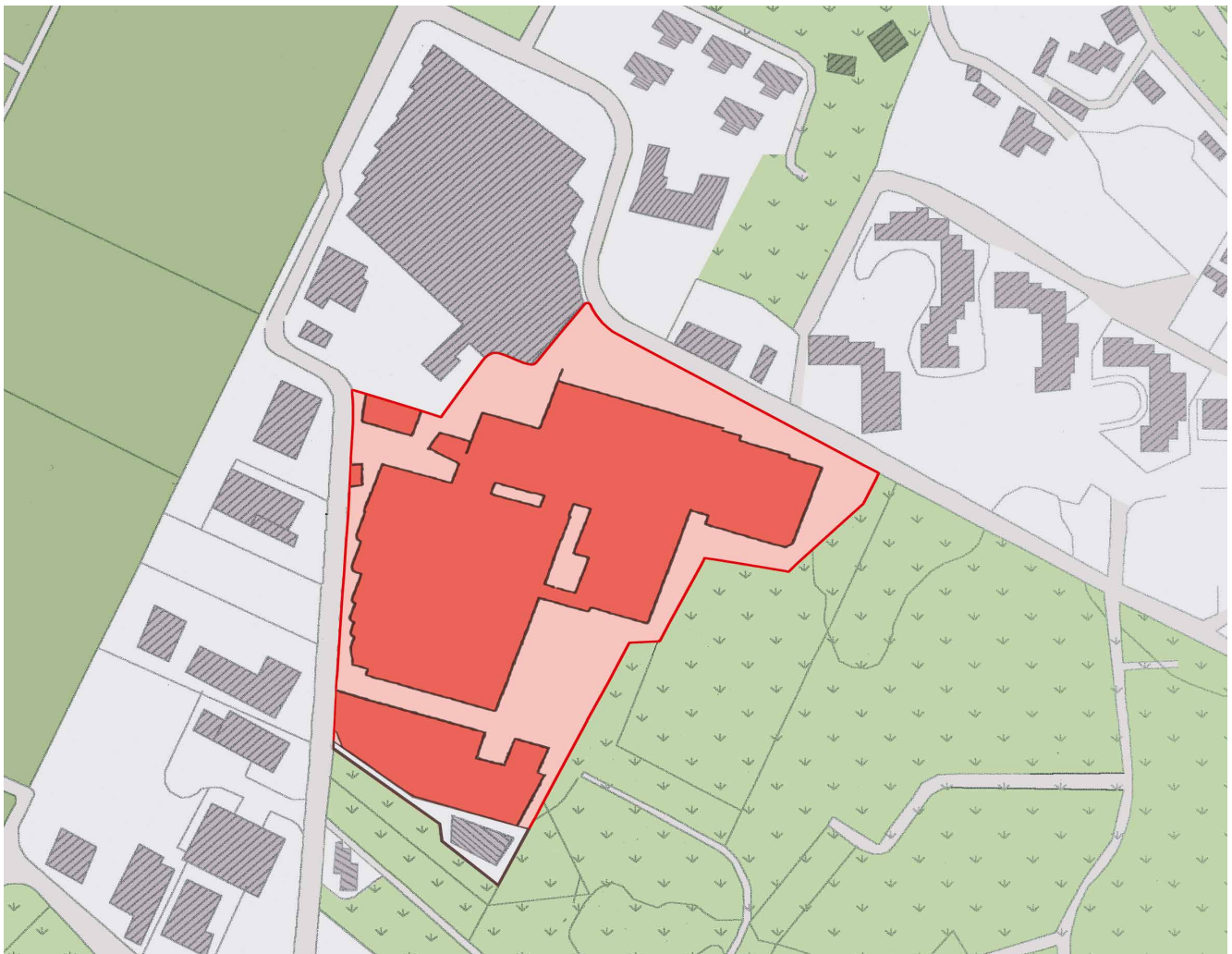


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Hans Zipperle S.p.A. is located in Merano's industrial area, with a total surface area of approx. 60,000 m<sup>2</sup> (red area), approximately 38,500 m<sup>2</sup> of which are built on. The area was previously made up of fruit orchards, which were converted into

an industrial area. Investigations and findings carried out to date have shown no trace of pollution on this site. The company site borders on a housing estate to the north east and the industrial area to the north west.







## FOREWORD

Hans Zipperle S.p.A., with registered office and production facilities in Merano, South Tyrol, produces and sells fruit juices, pulps and concentrates for the international semi-finished goods market, and bottles fruit juices and drinks for the regional market, according to NACE Rev 2.10.32.

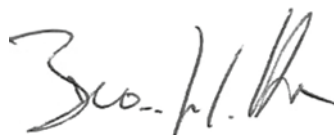
Our premises in Merano are located in one of the most beautiful Alpine regions, harmoniously nestled in the South Tyrolean mountains, in the middle of Europe's biggest fruit producing area. We therefore realise that our economic objectives can only be achieved in the long term by treating our environment with respect.

We thus support and plan measures which will continuously improve the company's efforts to protect the environment, for the benefit of nature and mankind.

In particular, we strive to:

- Develop new services and processes and take environmental issues into account in our investments.
- Prevent, reduce and – where possible – eliminate any existing environmental damage.
- Review the organisational systems for reducing environmental hazards.
- Improve our use of resources.

*We want to reduce environmental damage as far as possible using the best available methods and technology which we can economically justify.*



Dr. Brandstätter Thomas  
Managing director, Hans Zipperle S.p.A.



## INTRODUCING THE COMPANY

Established exclusively as a bottling business in 1951, the South Tyrolean company has continuously responded to market demands. Broadening the range of goods offered was the next logical step.

Other fruits were added for the production of pulp – apricots, pears, peaches, tomatoes and others; in addition to processing apple and grape juice, apple juice concentrate and coloured juices. In 1970 the company was converted to a public company still owned by the founding family, whose character and principles were to be maintained in the future.

By 1971 we were already processing 50,000 t of fruit, had a storage capacity of 8 million litres (sterile warehouse) and employed 65 people. Today, 175 permanent and approx. 30 seasonal workers process and market up to 200,000 t of fruit (2,500 t/day) for semi-finished goods each year. We have a storage capacity of around 65 million litres.

These quantities are partly due to the global 1980s trend towards non-alcoholic products. As well as the conventionally grown fruits, we now also put great importance to controlled and organically grown fruit. Our company embarked on socially responsible and environmentally friendly production early on, by investing in machinery and technology.

*Today, the company boasts state-of-the-art processing lines which ensure "fluent" operations at all stages of processing right through to storage or dispatch. They also guarantee consistently high product quality, demonstrated not least by successful participation in the Schutzgemeinschaft der Fruchtsaft-Industrie's Voluntary Control System. In addition, we are now certified according to the FSSC 22000 standard.*

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Zipperle has customers right across Europe with Germany traditionally being the main buyer for semi-finished goods. We only supply the regional market with bottled goods. Approximately 5 million reusable 0.2 and 1.0 litre bottles (10,000 units/h) are filled each year for the regional market.

*The company believes that its success is guaranteed by the high quality of its products, its customer service, our environmentally friendly production processes and our social responsibility towards our employees. All our business is handled promptly and reliably. We process fruit delivered to us within 24 hours. A maximum of 72 hours pass by between an order being placed and products being loaded.*

For many years already our investment policy has included ecological considerations. We recycle organic residue from fruit processing by drying it and using it to generate energy. We also purify industrial waste water in our internal preliminary purification plant and even recycle the slurry internally via the drying plant.

Major measures are planned with regard to water management in the next few years, as we want to reduce electricity consumption, steam and detergents.



## TIMELINE OF DEVELOPMENTS

1951	Foundation of Hans Zipperle	1980	Introduction of processing from controlled grown and organic fruit
1951	Bottling plant	1983	Construction of a press hall with migration of existing presses and press capacity increased by four additional HP 5000 Bucher presses
1953	Grape line	1984	Construction of production hall with migration of pulp and grape lines
1954	Baling press for stone fruit	1985	Flavour recovery plant with mechanical vapour compressor
1956	Construction of first building	1985/89	Expansion of storage cellar (construction of cellar 4)
1957/72	Construction of storage cellar (cellar 1)	1985	Construction of a pomace dryer and incinerator for steam production
1963	Construction of a boiler house	1985	Installation of a flue gas filter to reduce dust emissions
1964	First flavour recovery and concentrate plant	1986	Modernisation and expansion of fruit supply (apple silo) and milling station
1964	First two hydraulic horizontal Bucher HP 5000 universal presses	1987	Second puree line
1968	Production of red fruits begins	1988	Press capacity increased by four HP 5000 Bucher presses and expansion of silos with renovation of milling station
1970	Construction of an in-house metalwork and electrical workshop	1988	Construction of a cooling tower plant for recooling cooling water from juice processing
1970	Conversion to a public company	1989	Expansion of storage cellar (construction of cellars 5 + 6)
1970	Construction of the bottling hall and bottle magazine and subsequent migration of bottling plant	1989	Construction of a refrigerated cellar (refrigerated cellar 1)
1973/78	Expansion of storage cellar (construction of cellar 2)	1990	Expansion of refrigerated cellar (construction of refrigerated cellar 2)
1975	Conversion of concentrate plant from plate-type evaporator to falling film evaporator		
1975	First production line for tomatoes and fruit purees		
1978/80	Press capacity increased by four additional HP 5000 Bucher presses		
1978/80	Expansion of storage cellar (construction of cellar 3)		



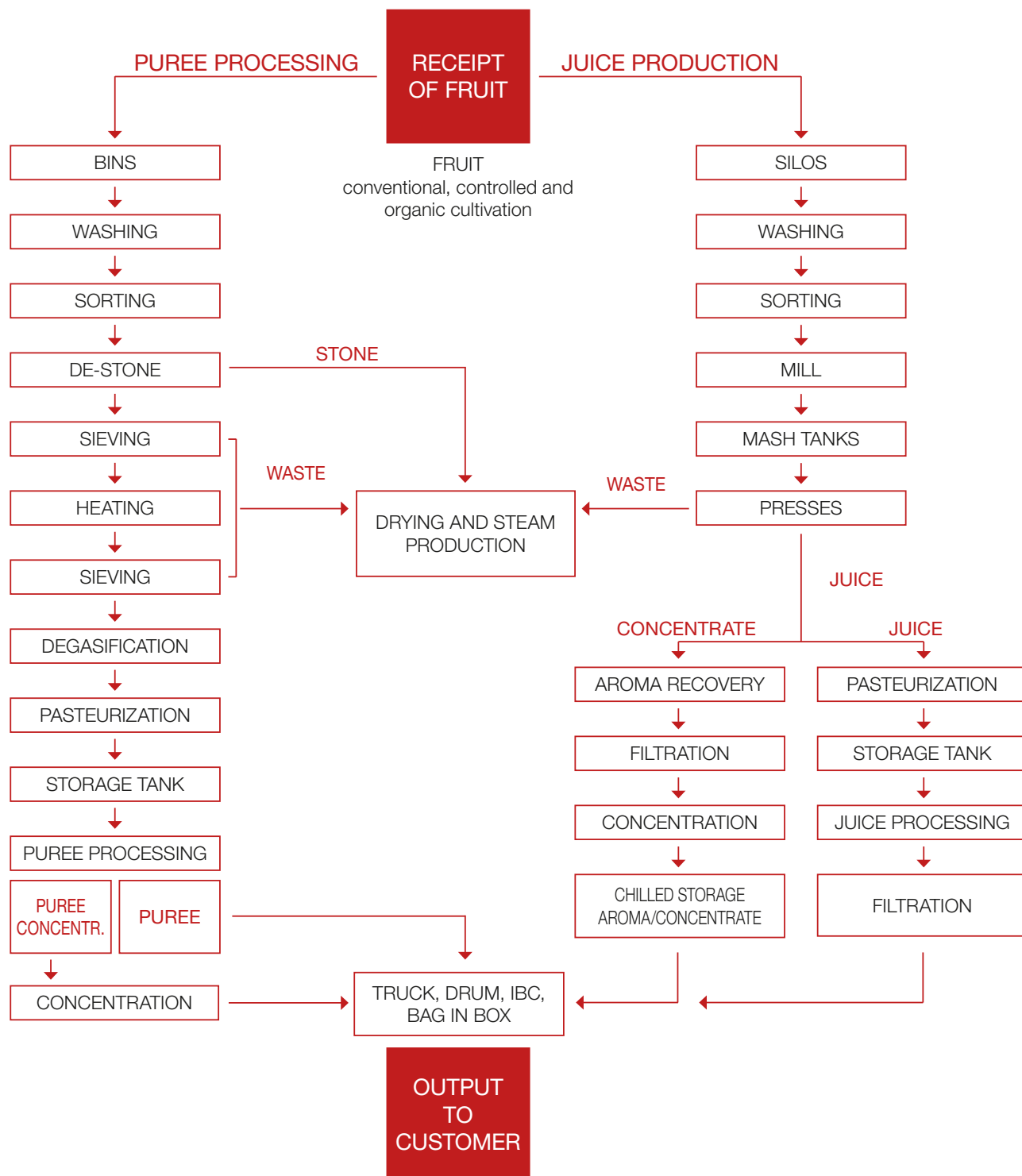
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| 1993 | Partial conversion of filtration to membrane filtration (UF)  | 1996 | Construction of a cooling tower to recool cooling water (tepid water), and for partial recycling in the production process  |
| 1993 | Migration of boiler house and simultaneous modernisation of incinerators, as well as conversion to methane gas      | 1996 | Construction of an underground waste water preliminary purification plant with mixing pond and regulating reservoir, neutralisation, filtration and slurry drainage to reduce settleable substances |
| 1993 | Construction of a new pomace dryer with solid fuel combustion (organic waste)                                       | 1996 | Construction of a bio-filter system with chemical washer and charcoal filter for reducing odour emissions   |
| 1993 | Modernisation of solid fuel combustion for steam extraction   | 1997 | Compilation of an environmental handbook as per EN ISO 14001 and regulation EEC 1836/93 (eco audit)   |
| 1993 | Expansion of flue gas filter to reduce dust emissions   | 1998 | Construction of a new fruit unloading station, with reconstruction of milling station, mash heating and rest time optimisation  |
| 1994 | Introduction of an organisational structure for quality assurance, occupational safety and environmental protection | 1998 | Commissioning of a new concentrate plant, with reduced steam and energy consumption   |
| 1994 | Construction of a new staff complex with changing rooms, training rooms and a lounge for lorry drivers              | 1999 | Renovation and automation of dry stage in bottling, conversion to new packaging as well as 0.2 and 1.0 litre bottles and enclosure of conveyor belts from bottle-washing machines to pasteuriser    |
| 1994 | Commissioning of aseptic barrel filling machine   | 1999 | Climate control in storage cellar 1   |
| 1994 | Expansion of refrigerated cellar (construction of refrigerated cellar 3)  | 1999 | Start of construction on refrigerated cellar 4, with three large tanks  |
| 1995 | Expansion of storage cellar (construction of cellars 5 + 6)   | 2000 | Construction of eastern hall for loading and unloading fruit  |
| 1996 | Two state-of-the-art universal HPX 5005i presses with extra capacity and low energy consumption                     |      |   |
| 1996 | Third puree line, with reduced electricity and water consumption  |      |   |





2001	Increased cooling capacity for cooling/mixing, as well as reconstruction for level recording, control and monitoring	2015	Setting up of SEU (district heating plant – Zipperle)
2001	Reconstruction of drying and incinerator systems to reduce emissions	2015	Introduction of organisation model according to DL 231, and establishment of code of ethics
2002	Completion of refrigerated cellar 4	2016	Halal Certification
2003	Extension of fruit unloading station for stone and pip fruit for puree processing	2016	Commissioning of a new bottle washing machine
2004	Expansion of UF plant, with stabilisation and filtration	2016	Replacement of a 1,000-kVA transformer with a 2,000-kVA transformer
2004	Roof added to loading point	2016	Commissioning of a new washing system for large crates
2005	Cellar 1 converted and extended by approx. 2 million litres	2017	Expansion of the blending capacity by 2 tanks with a capacity of 100,000 liters each
2005	Sanitization of Cellar 3 sewage	2018	Construction of a new hall with deepfreeze cells and cooling cells for the storage of barrels, as well as a commissioning hall with loading ramps for trucks
2006	Restructuring of white water channels, plus hoppers, in the juice preparation hall	2019	Installation of a new filtration and stabilisation plant for the clarification of the fruit juices
2006	Entire pomace drying and incineration plant modernized according to ATEX	2019	Commissioning of a new separator
2007	Connection to the Azienda Energetica S.p.A. district heating plant for the supply of steam	2020	Commissioning of a new filling plant for 5-20kg-containers (bag in box)
2007	Laboratory modernisation	2020	Extension of the storage cellar (building of cellar 7)
2008	Installation of a 618.77 kWp photovoltaic system	2021	Addition of a cold storage (storage hall south) with a high rack storage
2009	Two new high-tech fruit puree lines were installed to replace two older plants	2022	Construction of an underground storage for wooden chips
2010	Certification according to the IFS, BRC, ISO 9001 and ISO 22000 (energetic rehabilitation) standards	2023	re-building of the biomass burner for wooden chips and fruit residues with a production capacity of 15 t/h of steam
2010	Kosher Certification		
2013	Installation of a concentrate plant for highly viscous products, with pasteurisation and barrel filling		
2014	Construction of a high-bay warehouse with room for around 1,300 pallets		

# OUR PRODUCTION PROFILE







A wide range of conventional, controlled and organic fruits is used to produce and distribute fruit juices, puree and fruit juice concentrates for the semi-finished product sector at the Merano site.

Our in-house agricultural service deals with the organic and controlled cultivation of crops on the producers' land. Most of this fruit is processed between June and November in four shifts, three of which run right around the clock, with the fourth taking the form of a standby team.

*The existing plants have a production output of juice from seeds and berries of around 1,800 tons of fruit/day, grape juice around 600 tons of fruit/day, and pulp around 800 tons of fruit/day. The storage capacity is 53.5 million litres at a room and cooling temperature*

*of +11°C for the sterile storage of juice and pulp, 11.5 million litres at around +4°C for concentrates and flavourings, and a barrel warehouse with up to 50,000 aseptically filled 200-litre barrels. The most important thing is that all fruit delivered is processed directly on the day of delivery. There are several refrigeration plants.*

Bottled products are only supplied to the regional market (Trentino-South Tyrol).

Approx. 5 million 0.2 and 1.0 litre bottles are produced annually for this region. In 1999 we switched from 0.7 to 1.0 l reusable glass bottles. We again opted for reusable glass bottles for environmental and quality reasons. Disposable PET bottles were not considered for the above reasons. The semi-finished product range is shipped in road tankers, stainless steel containers and 200 litre drums.







*Fruit processing creates approx. 30,000 t of pomace and fruit residue each year, which is dried in a drying plant and then recycled. The energy generated in this way is used to produce steam and also supplies the amount of heat required for the drying plant.*

The dust in the exhaust air is cleaned using a dust filter with an emission value which is significantly

lower than the legally prescribed level. Fruit processing also creates up to a maximum of 400 m<sup>3</sup>/h of waste water, which is treated in the in-house waste water preliminary purification plant. The sludge gathered during filtration is drained off using a decanter and transported to the power room, where it is dried and recycled together with the fruit waste.





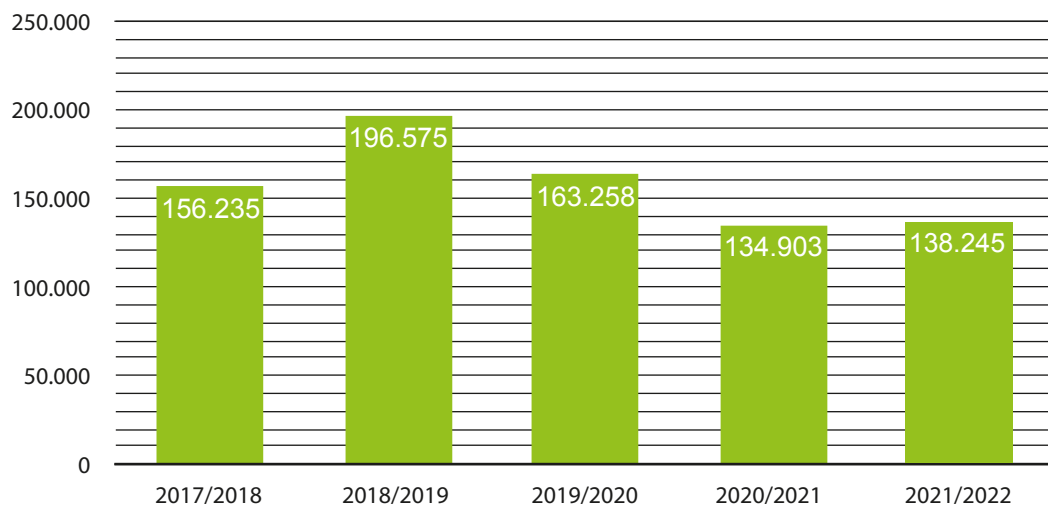


Fig. 1: Production quantity for all fruit (t)

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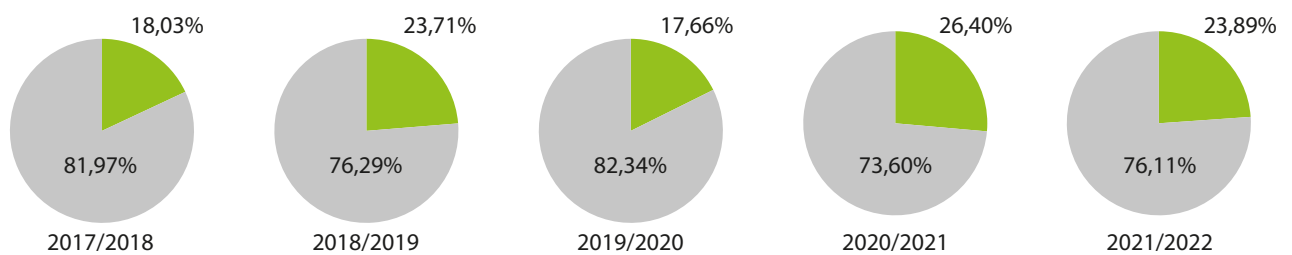


Fig. 2: ■ Organic and controlled cultivation compared to ■ conventional cultivation



## MISSION STATEMENT

*We are a family company with many years of experience in producing juice, puree and concentrate from conventional, controlled and organic cultivation. This also applies to our high-quality fruit juices, nectars and drinks for the regional market. Our future depends on satisfied customers. We supply good quality at competitive prices.*

*We feel responsible for our staff, and therefore strive to continuously improve and produce premium quality on a daily basis. Our company organisation aims to protect natural resources and reduce energy consumption and environmental damage.*

*In order to achieve this, we conduct regular audits to discover weaknesses and eliminate them.*

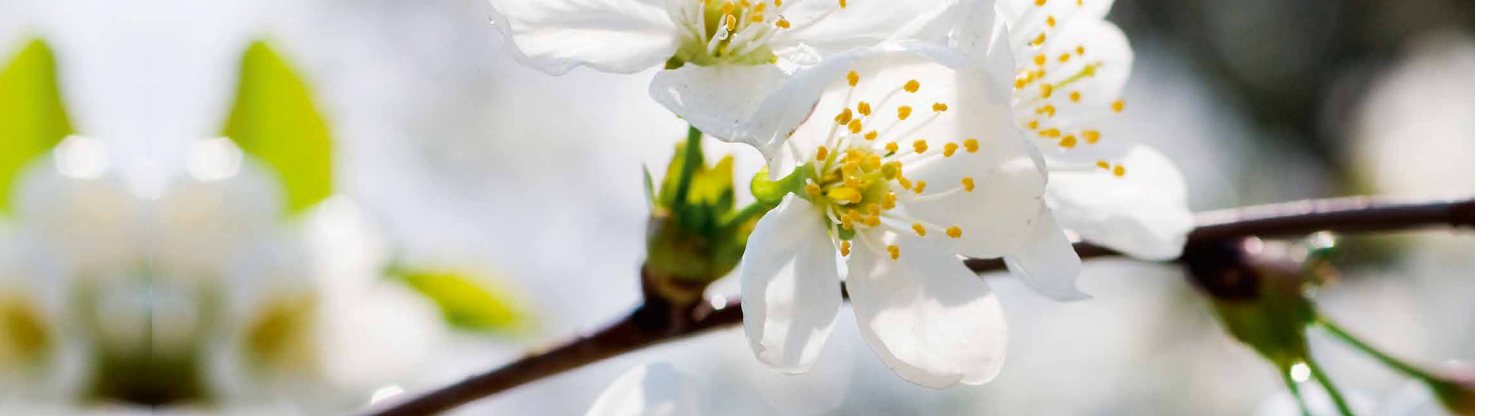
### **We want to fulfil our customers' expectations in every way**

- We guarantee the quality and legality of our goods
- Smooth procedure from ordering to delivery (according to schedule)
- Production based on food legislation, high standard of technology and regular monitoring of equipment
- We offer friendly and competent advice
- We take our customers' wishes and requirements seriously
- Complaints are a matter for the management; they are analysed and corrected with lasting effect
- Supply according to specifications at competitive prices
- High degree of operational flexibility

### **Our staff adheres to our mission statement because we**

- Encourage the team and each individual to do their very best
- Promote their qualifications and enthusiasm with constant training





- Assign them clear areas of competence and responsibilities
- Continuously improve safety in the workplace and equality for all our employees, as well as supporting and promoting a pleasant working environment
- Implement their suggestions and ideas as far as possible
- Take their wishes and requests seriously

#### **We work closely with our suppliers**

- We strive for long-term, reliable and fair cooperation
- By continuously monitoring our suppliers, we incorporate them into our quality, environmental and occupational safety awareness

#### **We are conscious of our responsibility towards society and the environment, because**

- When purchasing new technologies and developing new processes, we take care to optimise environmental protection concerns as far as possible that can be achieved through a balance of investments and the best available technology

- We strive to continuously improve all processes and thus protect resources and the environment. We also try to reduce the number and quantity of hazardous substances and increase the use of reusable packaging and, in doing so, we exceed the legal requirements
- We constantly monitor and record emissions produced by the company which affect the environment. This information is exchanged with the public authorities in an open dialogue
- We provide regular information about our efforts to protect the environment and ensure safety at work
- When buying raw materials, we constantly try to increase the proportion of controlled contracted cultivation and the proportion of organic raw materials in our products

**We want to remain the most reliable partner to our customers, staff and suppliers. The management guarantees for this mission statement.**

ZIPPERLE'S  
ENVIRON-  
MENTAL  
PROTECTION  
STRUCTURE





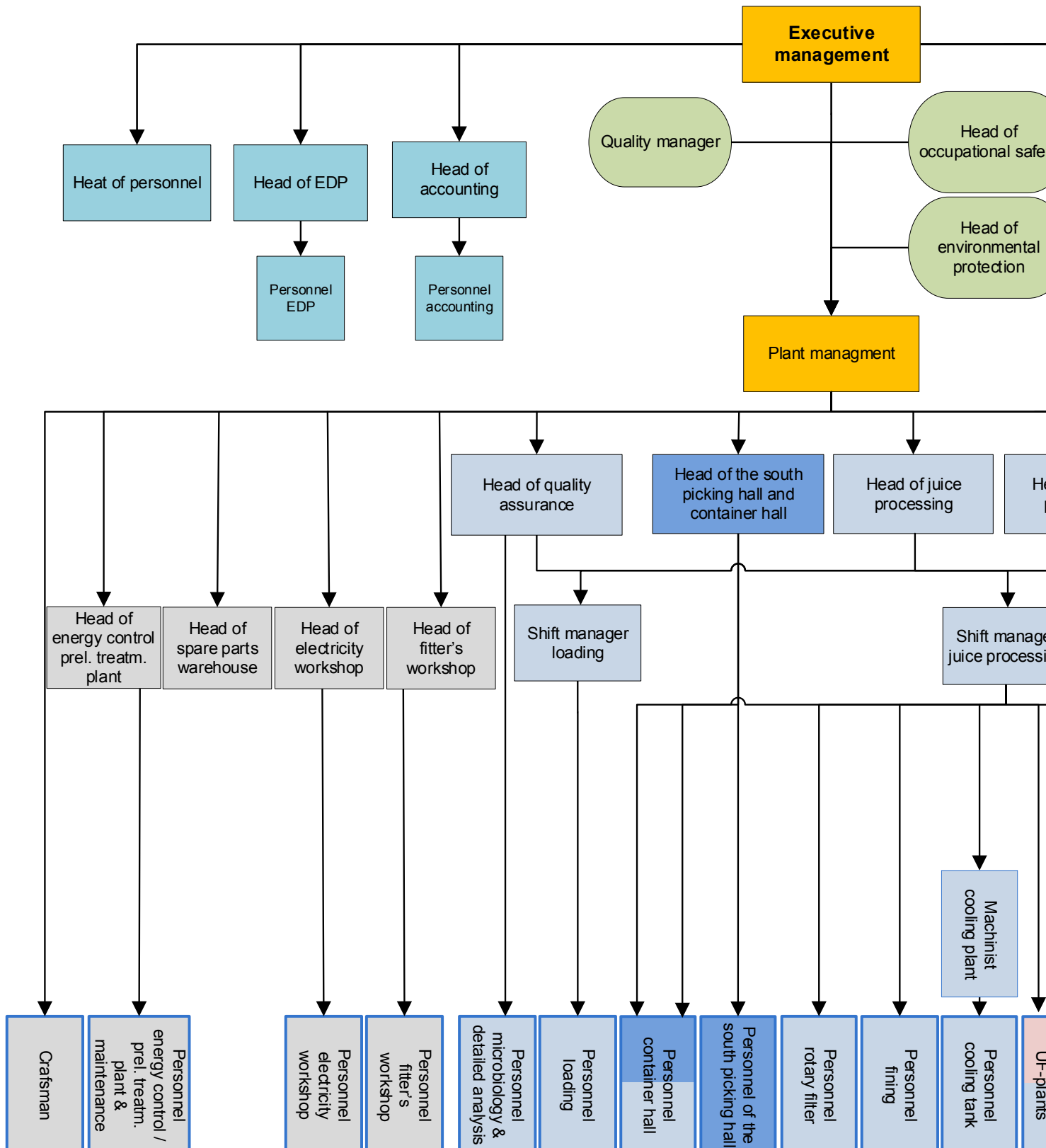


*We take environmental protection very seriously, both as a managerial responsibility and as integral part of our corporate philosophy. We therefore believe that the commitment of the staff to our business is the most important basis for industrial environmental protection. We believe that as many employees as possible from all departments must be involved in the environmental decision-making processes, to achieve a high level of environmental motivation and thus achieve sparing use of natural resources.*

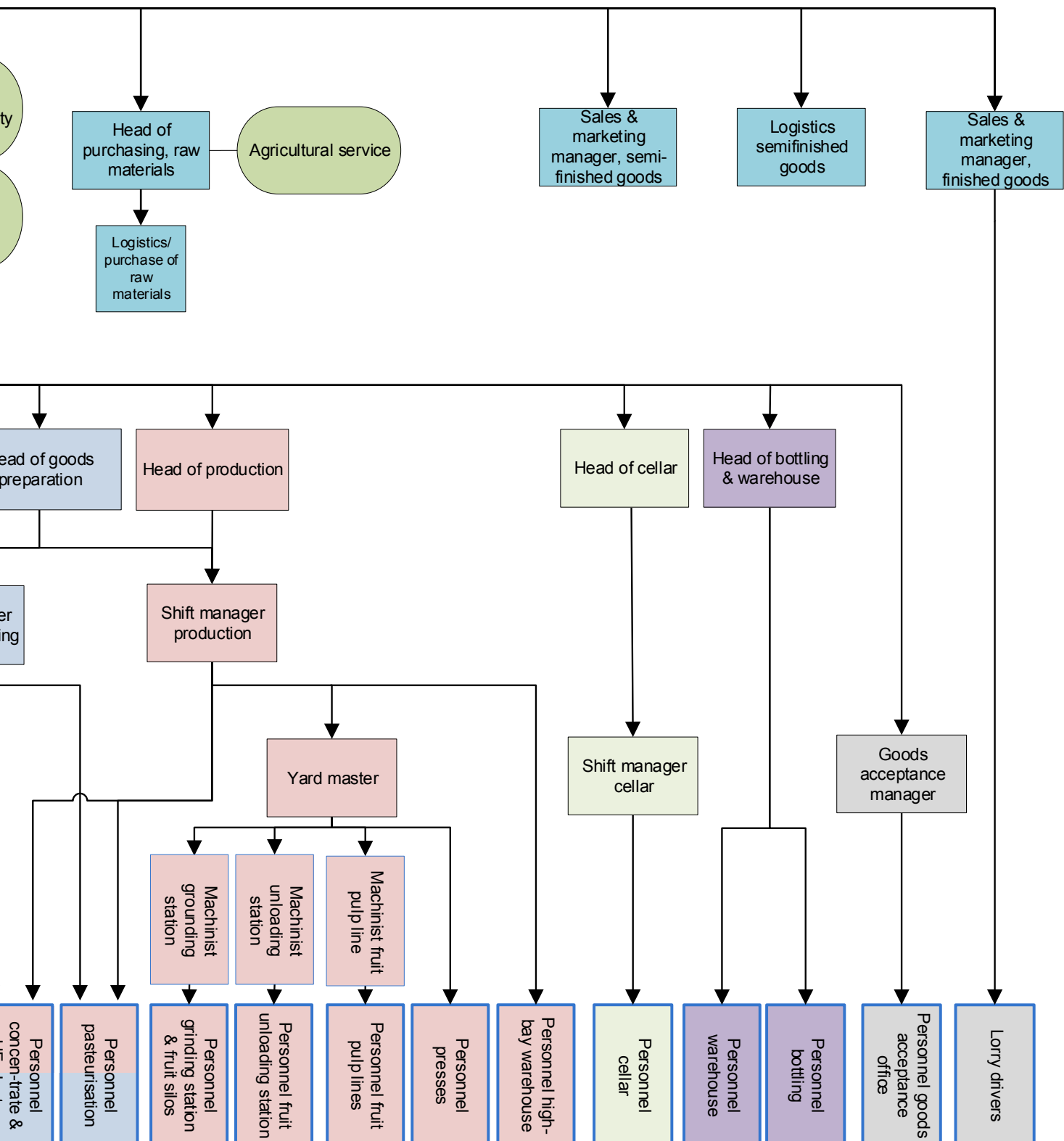
The management promotes environmental protection at all levels and releases the funds for the objectives defined together with the plant managers, process owners and the operational structure improvement working group. The environmental impacts at the site are regularly recorded and analysed by the environmental officer and his delegates as well as the process owners. This data forms the basis for improving and reorganising environmental systems, and provides the stimulus for targeted economies where resources are concerned. Deviations give rise to corrective and preventative measures. Weaknesses in the eco-management system are identified and documented, as a result of which safeguards for effective corrective measure, or changes to procedures as necessary, are implemented and analysed.

These precautions are intended to prevent a repeat of negative environmental impacts. Professional repairs and preventive maintenance and inspections of the environmental systems at the site by specialist staff or external firms ensure that environmental damage is kept to a minimum or, even better, eliminated. The company has established procedures which allow it to respond quickly and appropriately to incidents which may adversely affect the environment.

## Organization chart







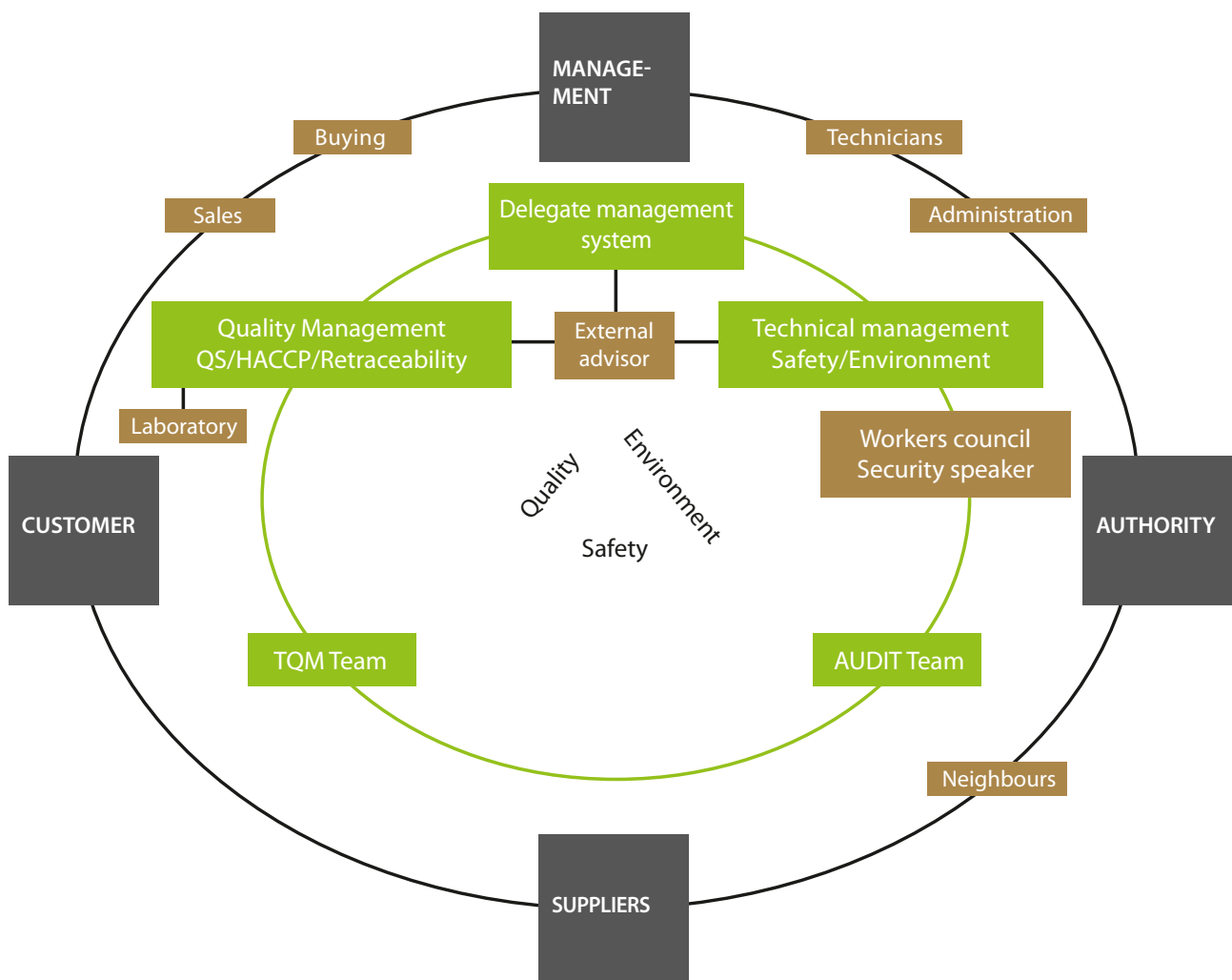
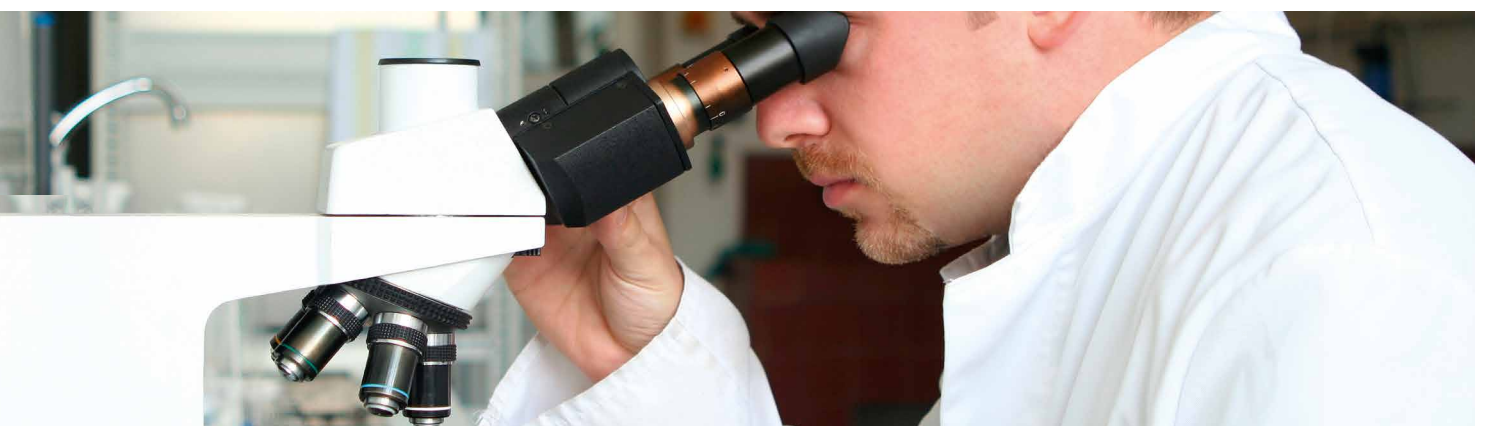


Fig. 3: Circle of continuous improvement







We identify deviations from normal operations at an early stage, keeping harmful environmental impacts low. Annual internal training and briefings put our employees in a position to realise the significance and content of the on-site eco-management system and to implement it.

By creating tailored training programmes, we motivate our staff at all levels and provide them with qualifications in the most important environmental aspects and basic principles of environmental protection techniques. The appointed officers also take part in regular external training courses. The training requirement is assessed by way of regular and planned internal audits. The internal audits are also designed to help to expose weaknesses in the eco-management system, analyse their causes and implement the appropriate corrective measures. The company undergoes regular eco audits by independent organisations to assess the eco-management system that is in place, compliance with the relevant environmental regulations and to ensure that the company's mission statement corresponds to the implemented and planned environmental programmes. The auditors must be independent and possess the necessary knowledge and experience in order to be able to professionally assess the eco-management system operated by the company.

Measurement and control procedures have been introduced to determine the exact impact of production on the environment. The data obtained is recorded in special registers and serves as the basis for improvements and renovations to environmental systems, as well as initiatives for specific potential for savings and resource preservation. The management of Hans Zipperle S.p.A. assesses the installed eco-management system at regular fixed intervals. The review serves to assess the environmental protection targets achieved by the company and the need to introduce corrective measures to adapt to changes in the business environment. In this way, it is intended to guarantee a continuous and constant improvement in the company's environmental performance. The whole eco-management system was also certified to ISO 14001 at the same time. The company also has a HACCP system, which provides for various quality and hygiene controls and measurements.

*Compliance with the relevant environmental laws, both national and local, is one of the main starting points for the whole eco-management system. All the environmental laws and the resulting obligations relevant to the company are outlined in a specific folder in the form of a dedicated register. This register states the obligations derived from each individual group of laws and how they are fulfilled within the eco-management system.*



## MAIN ENVIRON- MENTAL IMPACTS

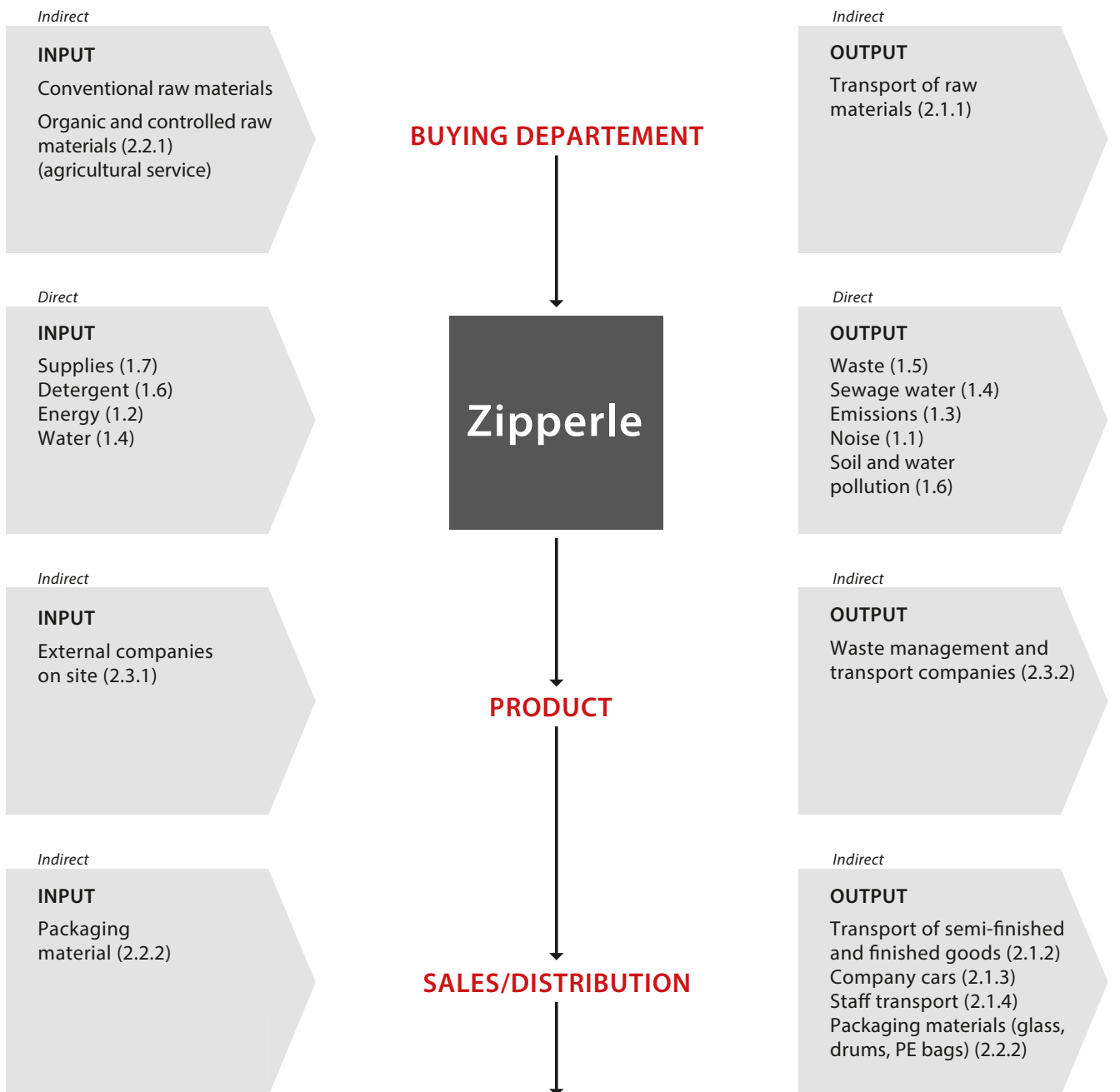
Hans Zipperle S.p.A. and all its employees put great importance to optimising and safeguarding internal processes in order to prevent accidental emissions and consequent adverse effects on the environment.

*To ensure this, we have developed instruction manuals for all systems and operating instructions for hazardous substances and auxiliary materials. We carry out fire prevention inspections and fire drills and organise inspections by the operational structure improvement working party. We conclude maintenance agreements for all environmental systems and encourage our staff to further develop in-house preventative measures.*

The last five years have been selected to show the result. The data was obtained by recording weights and measurements and will continue in the years to come to enable us to set up environmental performance figures in the future. Given that Zipperle's business year runs from 1 July to 30 June, the environmental data refers to this period. As the energy (gas, oil, and electricity), water/waste water and CO<sub>2</sub> output data and other extraction parameters have been recorded every month, we can compare it with previous years. The previous annual data can be found in the environmental statements for recent years.







# 1. DIRECT ENVIRONMENTAL IMPACTS

## 1.1 Noise

The following guide values apply to our site. In recent years the company has made continuous improvements to reduce noise experienced by the nearby residential area.

Subdivision and threshold values according to IPPC licence*	Threshold values		Values recorded in 2021	
	day	night	day	night
General residential area	60 dB(A)	50 dB(A)	46,5 - 49,7 dB(A)	48,5 - 45,7 dB(A)
Industrial zone	65 dB(A)	55 dB(A)	53,5 dB(A)	46,7 dB(A)

Table 1: Noise guidelines for the site

\*IPPC protocol no 147336 of 13.03.2009 with modifications from 12.06.2015, protocol no 354648 and 26.01.2016, protocol no 44094

## 1.2 Energy

*Our main energy sources are electricity and natural gas, electricity to operate our plant and natural gas to generate process steam and to heat some areas of our buildings. The fruit residues generated by production are dried and incinerated in-house to generate process steam.*

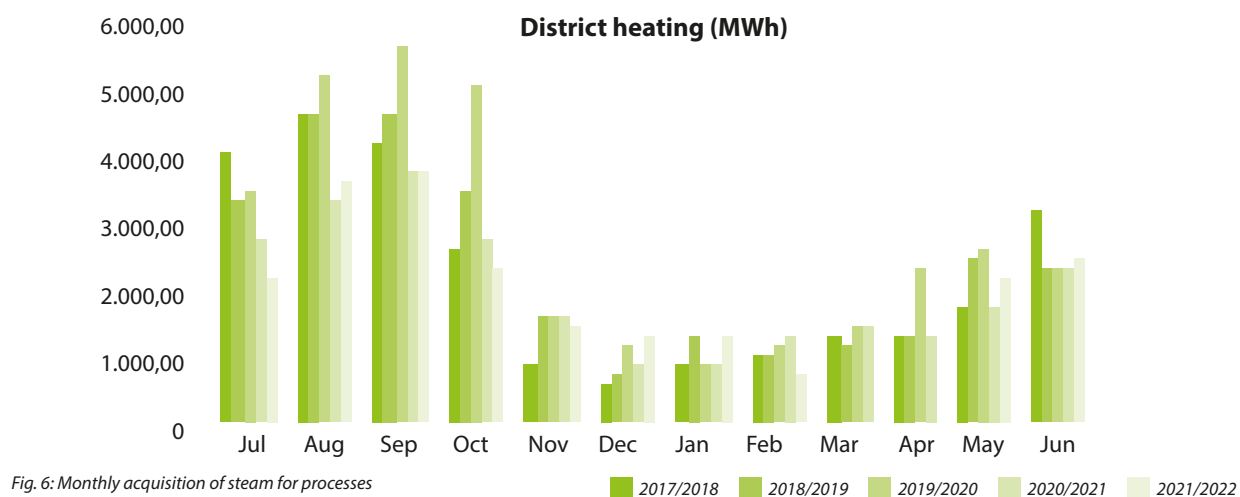
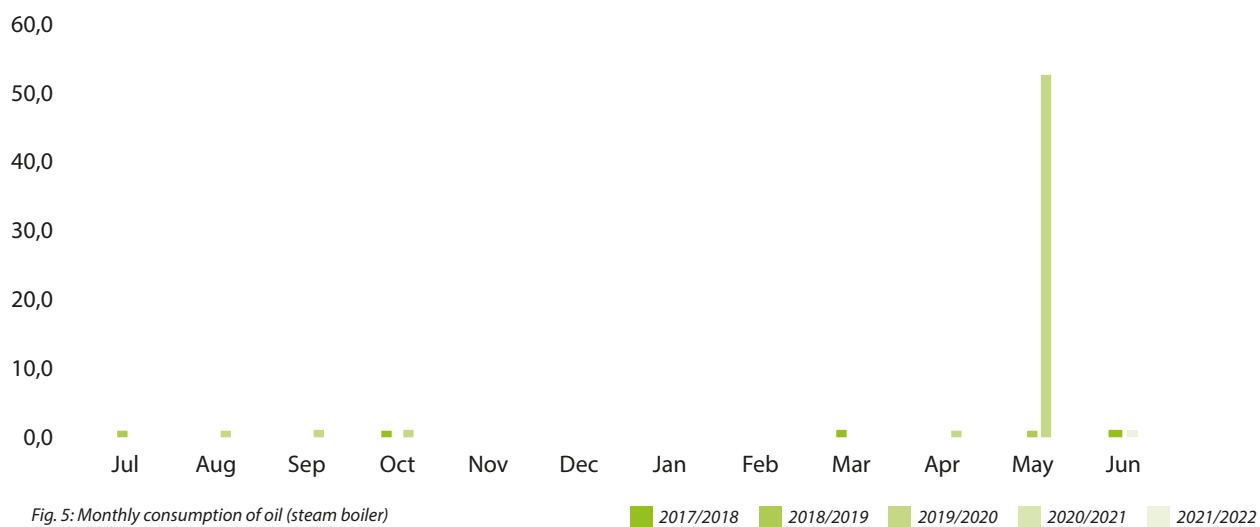
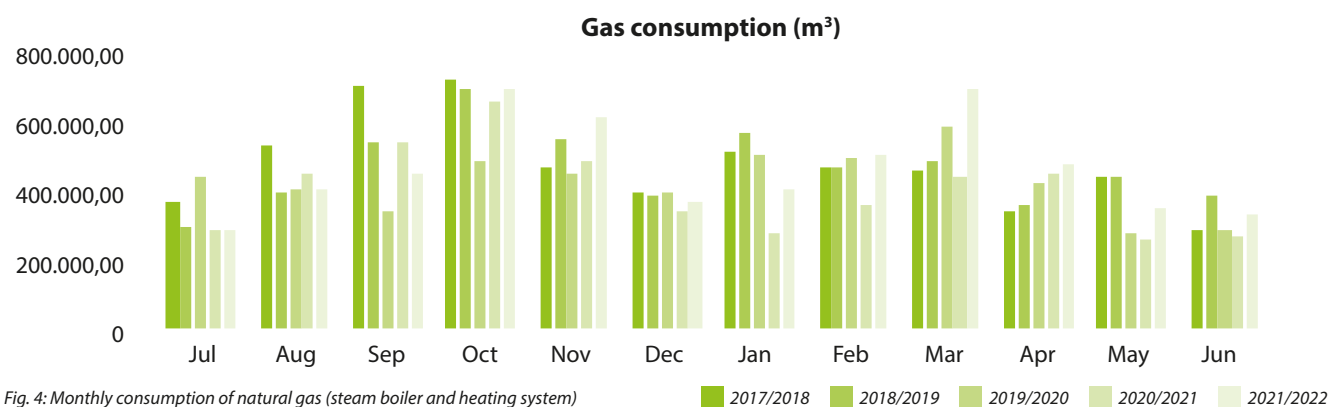
Since April 2007 we have been buying process steam from a district heating power station, which produces electricity and district heating using a gas turbine. To meet the remaining steam requirement we operate 3 boilers, each with an output of 10 t steam per hour. To guarantee the continuity of production in the case of a gas shortage, the three boilers can also run on fuel oil; up to 31.12.2015, heavy oil was used.

### 1.2.1 Thermal energy

Process	Consumption in MWh				
	2017/18	2018/19	2019/20	2020/21	2021/22
Steam boiler (gas and oil)	57.883,6	59.700,1	49.836,2	47.259,5	57.244,3
Drying and incineration plant (biomass (waste), renewable energy)	13.525,4	12.513,0	12.052,2	7.687,1	6.560,0
District heating (purchase of process steam)	26.988,2	28.609,3	33.552,3	24.573,3	21.768,2
	98.397,2	100.822,4	95.440,7	79.519,9	85.572,5

Table 2: Process steam produced for the fruit processing







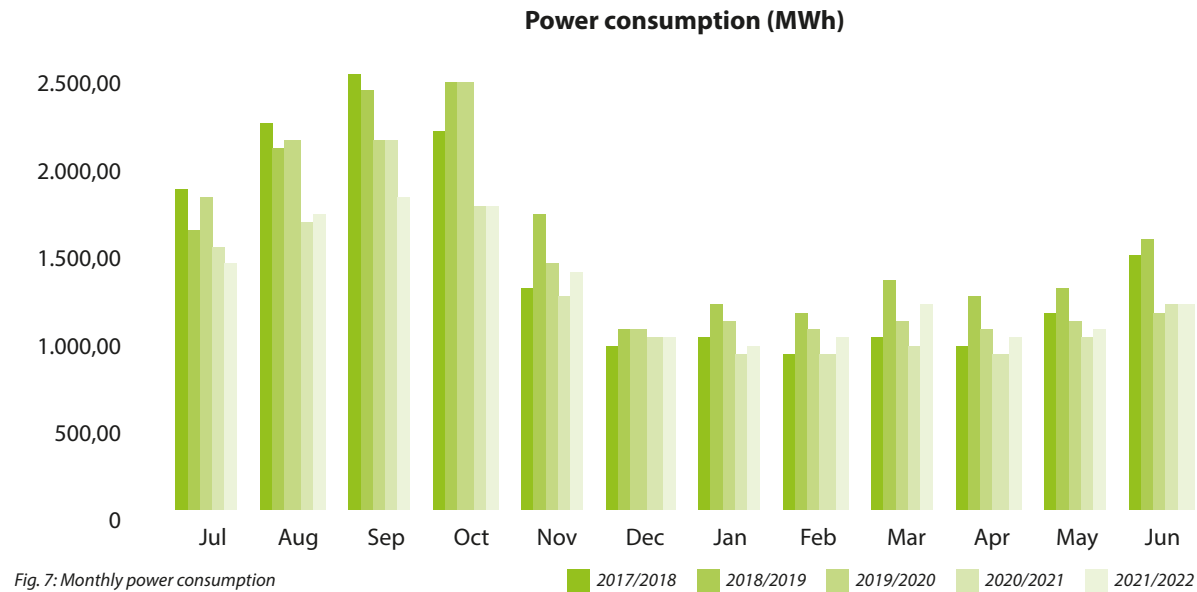


### 1.2.2 Electrical energy

Thanks to the agreement stipulated between Hans Zipperle S.p.A. and Alperia S.p.A. (SEU – Efficient Systems for Users), since January 2015, all electrical energy needed has been supplied by the nearby co-generation plant (district heating plant). Only in the event of a malfunction of the gas turbines is mains electricity used.

The consumption of electricity is as follows:

- 1) SEU: electric current from the nearby co-generation plant (CAR certified) + solar energy from the photovoltaic plant with an output of 618.77 kWp, installed on the roofs of our premises.
- 2) MAINS: 100% electricity from renewable sources.



Process	Consumption in MWh				
	2017/18	2018/19	2019/20	2020/21	2021/22
Whole plant	17.995,5	19.606,1	17.982,6	15.632,0	15.863,5

Table 3: Annual electricity consumption

### 1.3 Air emissions

Natural gas is used to generate process steam; use of oil-fired furnaces is minimal. In December 2015, all plants were converted from heavy oil to fuel oil to improve atmospheric emissions. Approximately one-third of the energy requirement can

be met by drying and incinerating the pomace, fruit residues and sludge. The dust in the exhaust gases is removed using a dust filter. The threshold values below are adhered to as a result of regular inspection and optimisation of the burners carried out within the scope of maintenance agreements.

Type of emission	Statutory limit values with regard to IPPC licence*			
	Total dust	Nitrogen oxides	Sulphur oxide	Carbon monoxide
Drying and incinerating (E1.1)	30 mg/m <sup>3</sup>	400 mg/m <sup>3</sup>	200 mg/m <sup>3</sup>	250 mg/m <sup>3</sup>
Steam boiler (E 3.1, E 4.1, E 5.1) „natural gas“	/	200 mg/m <sup>3</sup>	/	80 mg/m <sup>3</sup>
Steam boiler (E 3.1, E 4.1, E 5.1) „heating oil“	50 mg/m <sup>3</sup>	250 mg/m <sup>3</sup>	/	80 mg/m <sup>3</sup>
Result of measurements carried out by external agents in 2022				
Drying and incinerating (E1.1)	0,7 mg/m <sup>3</sup>	232,5 mg/m <sup>3</sup>	6,3 mg/m <sup>3</sup>	150,3 mg/m <sup>3</sup>
Steam boiler 3 (E 3.1) „natural gas“	/	184,7 mg/m <sup>3</sup>	/	0,4 mg/m <sup>3</sup>
Steam boiler 4 (E 4.1) „natural gas“	/	186,7 mg/m <sup>3</sup>	/	1,2 mg/m <sup>3</sup>
Steam boiler 5 (E 5.1) „natural gas“	/	123,9 mg/m <sup>3</sup>	/	2,9 mg/m <sup>3</sup>
Steam boiler 3 (E 3.1) „heating oil“	1,8 mg/m <sup>3**</sup>	207,6 mg/m <sup>3**</sup>	/	0,2 mg/m <sup>3**</sup>
Steam boiler 4 (E 4.1) „heating oil“	0,9 mg/m <sup>3**</sup>	212,7 mg/m <sup>3**</sup>	/	6,4 mg/m <sup>3**</sup>
Steam boiler 5 (E 5.1) „heating oil“	1,2 mg/m <sup>3**</sup>	109,1 mg/m <sup>3**</sup>	/	1,4 mg/m <sup>3**</sup>
Total	<b>0,14 t/Jahr</b>	<b>56,99 t/Jahr</b>	<b>1,3 t/Jahr</b>	<b>/</b>

Table 5: Emission measurements 2022

\*IPPC protocol no 147336 of 13.03.2009 with modifications from 12.06.2015, protocol no 354648 and 26.01.2016, protocol no 44094

\*\*Emission measurement from 2019 („reserve combustion plant“; measurements are carried out every 3 years)

CO <sub>2</sub> emissions (t)	2017/18	2018/19	2019/20	2020/21	2021/22
Natural gas (in-house production of process steam)	11.433	11.170	10.215	9.721	11.302
Oil (in-house production of process steam)	12	5	156	0	1
District heating (purchase of process steam)	6.253	6.634	7.781	5.704	5.160
Electrical energy (purchase of electricity)	3.594	3.899	3.413	3.132	2.947
CO <sub>2</sub> equivalent deriving from emissions from the refrigeration plants	672	627	123	310	398
Total	<b>21.964</b>	<b>22.335</b>	<b>21.688</b>	<b>18.868</b>	<b>19.809</b>

Table 5.1: Annual total emissions of greenhouse gases expressed in tons of CO<sub>2</sub> equivalent

CO <sub>2</sub> reduction	2017/18	2018/19	2019/20	2020/21	2021/22
Through the combustion of fruit residues for process steam production (with zero CO <sub>2</sub> emissions)	7.738	6.894	5.514	5.326	5.080
Through the purchase of CO <sub>2</sub> -neutral electricity	398	644	774	675	991
Total	<b>8.136</b>	<b>7.538</b>	<b>6.288</b>	<b>6.001</b>	<b>6.071</b>

Table 5.2: Annual CO<sub>2</sub> savings through the use of renewable energy





Trocknung Fruchtrückstände  
20 t / h - 400 t / Tag





#### 1.4 Water/Waste water

The company's fruit processing and purification processes require a lot of water. Fresh water is drawn from our four deep wells and is supervised by the local public health authorities. Information on daily volumetric rates per well is collected and recorded at a central measuring point.

*We treat any waste water in our in-house, underground waste water preliminary purification plant and then feed it into the public sewage system.*

*tem. We continuously monitor waste water from the preliminary purification plant in-house and it is analysed every year by an external laboratory instructed by us. The public sewage system operator is responsible for the analytical inspections and transmission of the corresponding data to the competent authorities.*

Exhaust gases from the tanks and room exhaust is fed into a bio-filter to reduce odour emissions. An active charcoal filter has also been installed for safety reasons, which is operated as required.

Fraction	2017/18	2018/19	2019/20	2020/21	2021/22
Freshwater in m <sup>3</sup>	1.767.452	1.987.949	1.894.037	1.724.870	1.828.069
Cooling and rain water in m <sup>3</sup>	691.996	854.441	784.179	724.066	925.956
Process sewage in m <sup>3</sup>	1.254.082	1.368.299	1.320.956	1.167.334	1.242.489
COD in t/a	2.399	2.982	2.334	1.865	1.842

Table 6: List of water quantities and their classification

#### 1.5 Waste

*The company operates a collection system for all scrap iron, aluminium, ash, residual waste, glass, filter waste, etc. These valuable substances are collected separately. Organic waste, such as pomace or sludge, is disposed of in the company's own dryers and incinerators, and this process demonstrably meets the corresponding thresholds.*

Essential maintenance work means that the plant shuts down for approx. 3 months in the winter, and during this period the organic waste is predominantly used as animal food or recycled in biogas plants. Any special waste is disposed of in accordance with regulations. We try to reduce other residual waste through further organisational measures such as employee training and awareness campaigns. We constantly strive to reduce waste, or to find new ways of disposing of it.





Waste fractions	Waste volumes in t				
	2017/18	2018/19	2019/20	2020/21	2021/22
Total	2.680,8	2.034,7	1.903,8	1.595,5	1.768,7
Residual waste	147,7	157,5	154,8	125,0	148,7
Cardboard	58,3	57,7	59,1	47,7	54,4
Mixed glass	39,2	24,0	19,5	17,7	20,7
Scrap iron	16,3	19,2	28,6	39,4	20,6
Stainless steel	52,9	7,5	11,0	9,5	0,0
Wood	127,7	123,6	130,1	107,0	87,9
Plastic packaging	34,4	66,8	109,2	64,0	22,0
Aluminium and fastenings	6,4	5,8	4,4	2,9	5,6
Electric cable	1,3	1,5	0,6	0,0	0,6
Mixed construction and demolition	11,4	18,7	35,6	27,8	21,9
Ash	329,2	352,9	396,7	268,0	233,1
Filtration residues	714,9	169,7	0,0	0,0	0,0
Waste water preliminary treatment plant sludge*	1.041,5	895,2	806,6	687,4	832,8
Special waste					
Total	22,1	14,3	9,0	21,9	9,8
Lead batteries	2,449	4,752	0,042	8,819	4,400
Paints and coatings	0,000	0,435	0,000	0,227	0,000
Used oils	1,900	2,562	2,820	0,420	1,280
Absorbent material	0,173	0,286	0,228	0,230	0,116
Laboratory reagents	0,015	0,007	0,020	0,000	0,014
Neon tubes	0,045	0,072	0,046	0,053	0,043
Waste from oil separators	13,180	0,000	0,000	6,160	0,000

Table 7: Total quantity of waste disposed of, including details of the main fractions

\* Calculated at a TS of ~24%

Description	Quantities in t				
	2017/18	2018/19	2019/20	2020/21	2021/22
Fruit residues (pomace)	5.843,2	7.414,0	5.694,5	5.070,3	7.203,7
Filtration residues	1.003,0	1.301,4	629,6	300,5	235,6

Table 8: Fruit and filtration residues used as animal feed or in biogas plants in compliance with regulation (EC) no 183/2005



### 1.6 Soil and water contamination

The companies site consists of former fruit orchards, which were turned into an industrial zone. Previous findings and investigations have shown that the plot is not contaminated, as has been confirmed by the authorities. All the activities and systems or storage which could contaminate the soil and water in the event of a breakdown are operated separately. Risk and

probability is analysed using organisational measures intended to prevent the above breakdowns.

### 1.7 Operating materials

Various auxiliary materials, additives and operating materials are used to process the fruit and clean the equipment. The table below sets out some of the statistics.

Auxiliary materials, additives and operating materials	Volumes in t				
	2017/2018	2018/2019	2019/2020	2020/2021	2021/2022
Bentonite	69,0	76,1	61,9	12,9	12,9
Colloidal silica	118,4	110,1	98,5	8,9	20,2
Protein	2,0	24,0	3,6	2,7	0,9
Carbon	119,5	149,4	96,8	36,4	98,5
Diatomite and perlite	305,6	299,3	144,1	67,6	79,7
Detergents	737,5	748,9	739,7	592,7	728,4
Caustic soda for neutralising waste water	288,2	294,6	254,8	138,6	112,1
Hydrochloric acid for neutralising waste water	24,8	23,0	15,6	7,4	36,3
Caustic soda for water treatment plant	5,2	3,9	2,2	5,5	6,2
Hydrochloric acid for water treatment plant	0,1	0,1	0,1	0,1	0,0
Cationic flocculants for waste water preliminary treatment plant	15,6	20,3	17,1	13,3	13,4
Anionic flocculants for waste water preliminary treatment plant	2,4	3,0	3,0	3,4	2,3

Table 9: List of various auxiliary materials, additives and operating materials



## 2. INDIRECT ENVIRONMENTAL IMPACTS

We constantly improve our external image. We want to be a good neighbour and, of secondary importance, develop our positive public image.

The main indirect environmental impacts caused by our company's activities can be grouped in the following categories:

- Traffic, which mainly occurs as a result of deliveries of raw materials, semi-finished and finished products;
- The product, its composition and properties, and the corresponding packaging;
- The third-party firms which we instruct to carry out various activities on our behalf.

### 2.1 Traffic

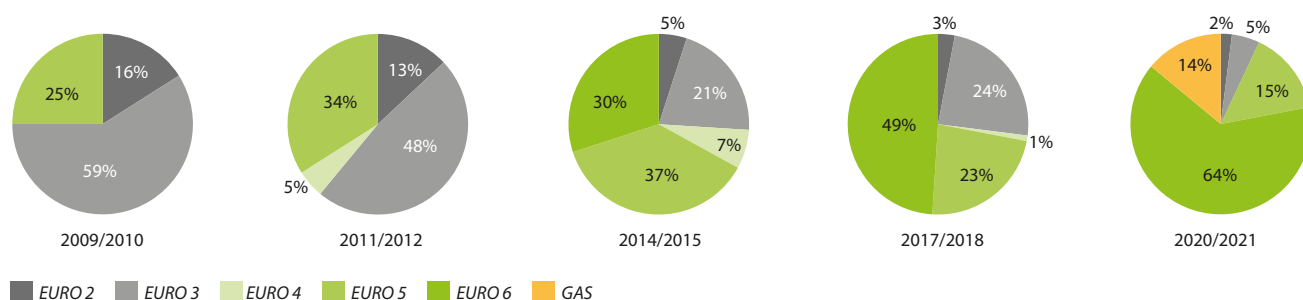
The traffic indirectly caused by our company is generated on the one hand by shipments of goods by lorry (receipt of raw materials and deliveries of semi-finished and finished products) and on the other by employees and others using their cars.

#### 2.1.1 Shipment of raw materials

80% of Zipperle's raw materials originate from Italy, 15% from South Tyrol and approx. 5% from other countries. They are bought delivered to Merano, which is why we normally have little influence on the shipping companies chosen by our suppliers.

In addition some suppliers also transport their own goods, and these suppliers change depending on the weather and the market situation, for example.

In order to conduct an initial assessment of the environmental impact caused by these shipments, we asked the main carriers (approx. 10) about the EURO category of the lorries they use. This research produced the following data:



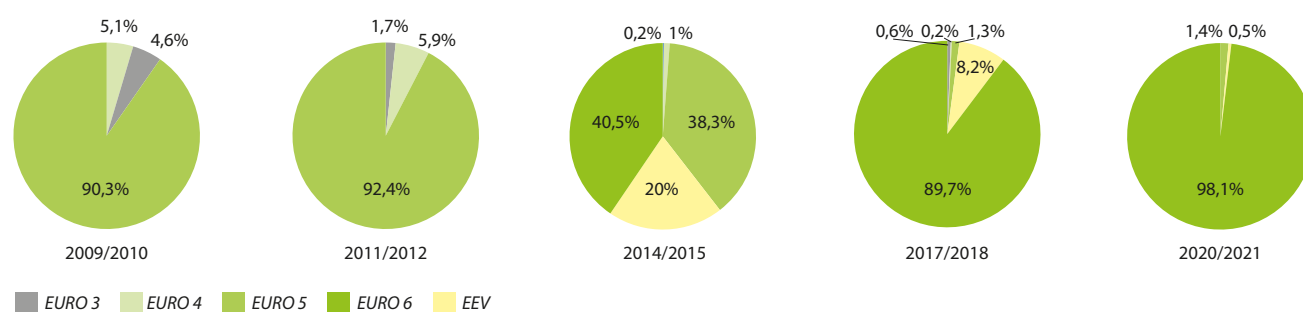
We expect a gradual improvement in this situation depending on the legal position.



### 2.1.2 Transport of semi-finished and finished goods

We use a limited number of approximately 10 transport companies to deliver our semi-finished and finished goods. This selection has been made on the basis of rigorous past assessments.

We made the aforementioned enquiries among these suppliers, asking about the EURO categories of the lorries they use. This research produced the following data:



### 2.1.3 Company cars

*Some employees have a company car, these being those who work in management, purchasing, the agricultural service, sales and customer service. In total, the company owns 12 motor vehicles, of which two electric vehicles, eight Euro 6 cars, one Euro 6 truck, one Euro 3 truck and one Euro 2 car.*

Because these are also available for personal use, it is difficult to quantify how many kilometres have been driven and the air emissions that have ensued. Their environmental impact is, however, low compared to the lorry traffic.

### 2.1.4 Employee transport

The majority of employees (approx. 80%) working for Zipperle live within a 5-10 km radius. It is difficult to quantify the air emissions generated by the kilometres driven, as the employees use different methods of transport and car pools depending on the weather and time of year (car, motorbike, moped, and bicycle). The remaining 20% of employees live within 20 km and share cars, as far as possible and if hours of work permit. As for company cars, the environmental impact of these methods of transport is rated as low compared to lorry traffic.





## 2.2 Product

The diagram on page 25 shows the main indirect environmental impacts caused by our products. On the one hand, fruit growing per se affects both the quality of the end product (residues) and potentially contaminates soil and pollutes ground water through the use of pesticides and fungicides. For some years our agricultural service has been geared to buying more and more organically grown and controlled goods (see Point 2.2.1).

On the other hand, the type of packaging we use for our semi-finished and finished goods has an impact on the environment. By "consuming" our product, the customer may cause an indirect impact on the environment (see Point 2.2.2).

### 2.2.1 Agricultural service

It must be possible to guarantee product traceability from field to customer where both organic and controlled cultivation are concerned. Every single measure and each stage of processing must be recorded to achieve this, and this is ensured by the software programme our company has developed. We also guarantee our customers who manufacture baby food that the raw materials we sell them comply with statutory regulations and meet the customer's specific requirements.

We provide on-the-spot cultivation advice to obtain suitable raw materials for processing. The agricultural service is responsible for providing cultivation advice to producers/co-operatives and/or inspecting cultivation techniques as necessary prior to the fruit being processed in Merano.

*Organic cultivation: we mainly check that fruit grown organically meets the legal criteria and particular attention is paid to mycotoxins.*

*Rigorous adherence to all the legal provisions is important when organically-grown fruit is being processed (certificates, conformity, etc.).*

*Controlled cultivation: all the agronomic measures and plant protection used is recorded, so that the agricultural service is always in a position to read the history of a plot like a book. The plant protection measures are applied with the aim of achieving harvested fruit which contains the minimum residues from plant protection agents and substances created by their decomposition.*



Where controlled cultivation is concerned, we place great emphasis on selection of areas, as we want to prevent any kind of problem (contamination, pollution from previous cultivation/previous years, and drift from near by cultures). We work with accredited laboratories to obtain an effective analysis, so we are constantly at the cutting edge

of technology. The agricultural service is in contact with plant protection agent manufacturers in order to better assess the risk of contamination from them, and thus has the possibility of carrying out more efficient analysis of residues. The percentage of organic and controlled cultivation has risen steadily in the last years.

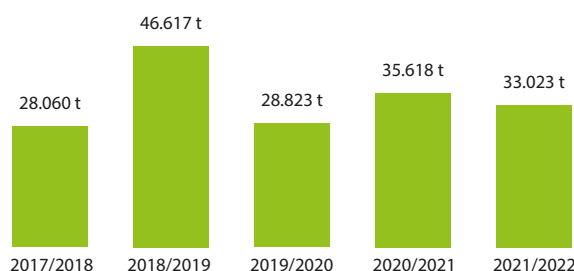
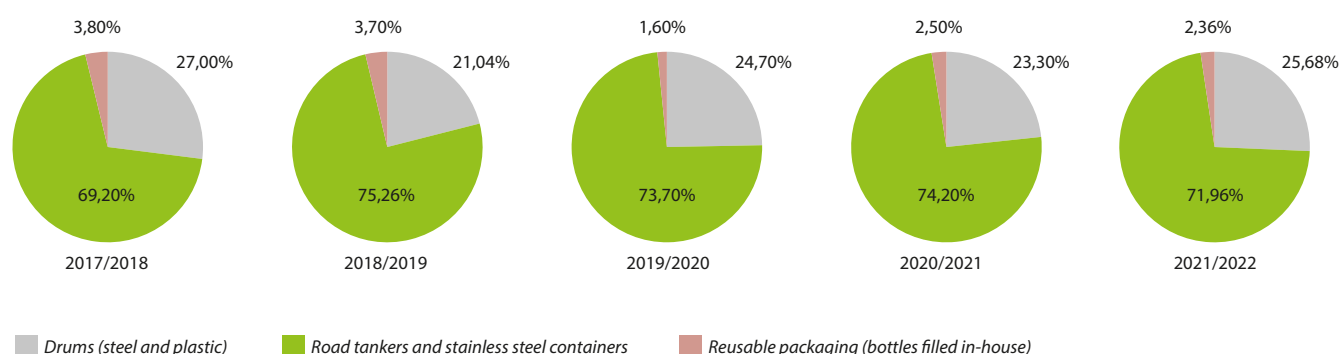


Fig. 8: We continually endeavour to increase the proportion of organic and controlled produce

## 2.2.2 Packaging

Our products are either sold as finished goods to end customers via wholesalers, or as semi-finished goods. We only supply the regional market with finished goods. We have decided to use reusable glass bottles, so we are not introducing any new packaging materials onto the market.

*The global environmental impact of glass bottles is very reasonable. The semi-finished goods are shipped by road tankers, in large stainless steel containers (approx. 1,000 litre) or in disposable containers (that is iron 200 litre drums). The percentage of total volumes sold was taken as the basis for global assessment of the packaging types used:*

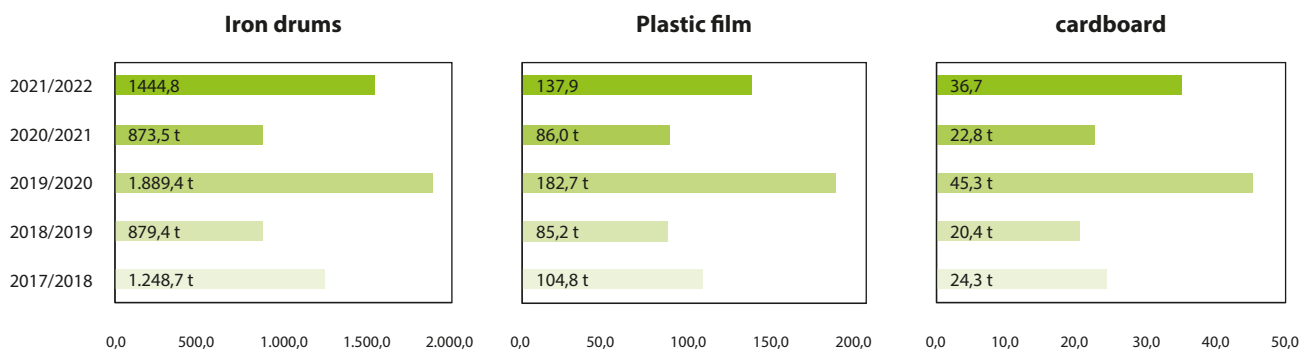






In this field we are only able to advise customers. The decision lies with the customer, who chooses the type of packaging according to production logistics. For reasons of hygiene, when the product is delivered in iron drums, they are lined with

a plastic film or combi-bag, which is the only disposable packaging used. As a result the following volumes of packaging materials have been introduced onto the market:



These types of packaging have been developed on the basis of many years of qualitative experience, and thus represent the optimum solution

for us. The majority of our packaging can be re-used by customers.



## 2.3 Third-party companies

*The activities of third-party companies can result in the following impact on the environment:*

- Services rendered by third parties
- Disposal of the companies own waste

### 2.3.1 Local third-party companies

(Suppliers of hazardous substances and maintenance companies)

The choice of detergents and disinfectants must meet our quality and environmental technology requirements. Hazardous substance suppliers must fulfil our parameters. Suppliers are rated according to these and other criteria, such as service (periodic calibration and maintenance of automatic dosing systems for detergents and disinfectants), punctuality of deliveries, logistics (conversion from small to large containers), etc.

Maintenance companies are either contracted from us or called as required. All the maintenance and other third-party companies are reviewed by the occupational safety manager. He verifies the companies' technical suitability, notifies them of existing risks and codes of conduct and coordinates their work procedures.

### 2.3.2 Waste management and waste removal companies

The company's waste, which has a direct environmental impact (see Point 1.5) is managed or disposed of by third parties. It is difficult to provide a quantitative assessment of the ensuing environmental impact, but Zipperle strives to exert as much control as possible over these suppliers, which is why all waste management and waste removal companies are subject to an annual evaluation. Supplier audits have also been carried out in the past.



## CORE ENVIRONMENTAL PERFORMANCE INDICATORS

The table below shows the most significant environmental aspects and effects in relation to production volumes.

(The data provided is not expressed in relation to the annual total gross value added as these are

partly strongly dependent on seasonal fluctuations in the purchase and sales prices, on which we have only a partial influence. This data, and also the overall output volumes are thus not meaningful).

Indicators	Input/Output	Unit	2017/2018	2018/2019	2019/2020	2020/2021	2021/2022
Material	Annual processed fruit	t	156.235	196.575	163.258	134.903	138.246
Energy	Total direct energy consumption	MWh	116.392	124.368	113.423	95.152	101.436
		kWh/kg	0,745	0,633	0,695	0,705	0,734
	Total renewable energy consumption	MWh	13.525	12.513	15.372	10.576	10.724
		kWh/kg	0,087	0,064	0,094	0,078	0,078
	Total renewable energy generation	MWh	13.525	12.513	12.052	7.687	6.560
		kWh/kg	0,087	0,064	0,074	0,057	0,047
Water	Total annual water use	m³	1.767.452	1.987.949	1.894.037	1.724.870	1.828.069
		lt/kg	11,313	10,113	11,602	12,786	13,223
Waste	Total annual generation of waste	t	2.681	2.035	1.904	1.596	1.769
		kg/kg	0,017	0,010	0,012	0,012	0,013
	Total annual generation of hazardous waste	t	22	14	9	22	10
		kg/kg	0,00014	0,00007	0,00006	0,00016	0,00007
Land use with regard to biodiversity	Total use of land	m²	59.000	59.000	59.000	59.000	59.000
		m²/t	0,378	0,300	0,361	0,437	0,427
	Total sealed area	m²	56.500	57.000	57.000	57.000	57.000
		m²/t	0,362	0,278	0,349	0,423	0,412
	Total nature-oriented area on site	m²	2.500	2.000	2.000	2.000	2.000
		m²/t	0,016	0,010	0,012	0,015	0,014
	Total nature-oriented area off site	m²	/	/	/	/	/
		m²/kg	/	/	/	/	/
Emissions	Total annual emission of greenhouse expressed in tonnes of CO2 equivalent	t	21.964	22.335	21.688	18.868	19.809
		kg/kg	0,141	0,114	0,133	0,140	0,143
	Sulfuroxide	t	0,000	8,800	4,600	3,500	1,291
		mg/kg	0,000	44,767	28,176	25,945	9,336
	Nitrogenoxide	t	72	34	67	70	57
		mg/kg	460	174	410	516	412
	Total dust	t	0,240	0,240	0,800	2,400	0,144
		mg/kg	1,536	1,221	4,900	17,791	1,038

Number corresponds to the input/output ratio of annually processed fruit.



## ENVIRON- MENTAL GOALS ACHIEVED

**Below are some of the measures already completed between 2020–2022:**

Environmental objective	Programme
Energy saving	<p>Renewal and automation of a concentrate plant (Turbo) with WINCC control.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• Reduced consumption of fresh water</li> <li>• Reduced volume of waste waters</li> <li>• Energy saving</li> </ul>
	<p>Replacement of the fluorescent tubes installed in cellar 1 and 6 and in the corridor between the cellars with 49 energy-saving LED lamps.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• Optimum illumination of the entire area, at the same time saving energy</li> <li>• Increased illumination from 100 to 300 LUX</li> <li>• An energy saving of around 38,000 kWh/year</li> </ul>
	<p>Installation of a new UF plant (XXL) for the filtration of fruit juices.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• An energy saving of around 3,000 kWh/year</li> <li>• Saving of process steam of around 80,000kWh/year</li> <li>• Reduction in consumption of fresh water by around 8,000 m<sup>3</sup>/year</li> <li>• Reduction in waste water by around 8,000 m<sup>3</sup>/year</li> </ul>
Prevention of soil and water contamination	<p>Refurbishment of the black water ducts (Line 100) according to the action plan „Plant C3“ in the juice preparation hall and in front of the break rooms (2 shafts and around 40m of inliner).</p>
	<p>Refurbishment of the industrial flooring in the warehouse in order to prevent any soil and water contamination (around 300m<sup>2</sup>).</p>
	<p>Video screening of the black water ducts and creation of a level plan to refurbish the ducts in the break room area up to the waste water pre-treatment plant and juice preparation area.</p>





Water saving	<p>Retrofitting of the pasteurisation plant (PA 5) to SPS control.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• Reduced consumption of fresh water</li> <li>• Saving of cleaning agents and disinfectants</li> <li>• Reduced volume of waste water</li> </ul>
Air emissions	<p>Exchange of a burner in the existing steam vessels.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• Reduction of the NOX emissions due to the installation of a low-NOX- burner</li> <li>• Electricity savings due to the installation of a frequency controlled fan</li> </ul>
	<p>Replacement of a freon-operated (R22) refrigeration plant with ammonia-operated refrigeration plant.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• An energy saving of around ~1,600 kWh/year by improving the COP of the new plant</li> <li>• Replacement of an ozone-depleting refrigerant by a natural and environmentally-friendly refrigerant, which does not contribute to the depletion of the ozone layer or global warming</li> </ul>
	<p>Elimination of two deep-freeze cells that were operated with the greenhouse gases R422D and R404A. The products stored there should be moved to a cooling cell that is operated with an existing CO2 refrigeration plant.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• An energy saving of around 26,000 kWh/year</li> <li>• Elimination of two refrigeration plants that were operated with refrigerants having a global warming potential and full utilisation of the existing environmentally-friendly refrigeration plant, which is operated with the natural and environmentally-friendly refrigerant, CO2</li> </ul>
Further Aspects	<p>Installation of a high-bay warehouse in the storage area.</p> <p>Improvements:</p> <ul style="list-style-type: none"> <li>• Creation of free areas through better use of the volume (in height)</li> </ul>



NEW  
ENVIRON-  
MENTAL  
GOALS





We strive to continuously improve our environmental protection measures and to reduce use of natural resources in order to achieve our environmental

policy aims. We therefore set ourselves objectives, big and small, at every level and for all processes. Here is a selection of the main process-related aims:

Programme	Environmental objective	Responsibility	Deadline
Refurbishment of the black water ducts (Line 100) according to the action plan „Plant C3“ in the break room area up to the inlet of the waste water pre-treatment plant and juice preparation area (11 shafts and around 16m of inliner).	<ul style="list-style-type: none"> <li>• Prevention of soil and water contamination</li> </ul>	EM	31/12/2023
Retrofitting and expansion of biomass combustion plant for the production of steam in connection with the integration of an electricity generator with 1 MW power	<ul style="list-style-type: none"> <li>• Reduction in the CO<sub>2</sub>-emissions by around 80% (~8.000 t CO<sub>2</sub>/year) by reduction in the fossil fuels used</li> <li>• Increase in plant efficiency from 80% to 90%</li> <li>• Auto-production of electricity from renewable sources</li> </ul>	EM	31/12/2023
Replacement of a burner in one of the existing steam boilers.	<ul style="list-style-type: none"> <li>• Reduction in the nitrogen oxide emissions through installation of a low NO<sub>x</sub> burner</li> <li>• Energy saving through frequency-controlled fans</li> </ul>	EM	31/12/2023
Audited measuring of the CO <sub>2</sub> emissions following SCOPE 2	<ul style="list-style-type: none"> <li>• Detailed measuring of the CO<sub>2</sub> emissions and supervision of reduction from implemented actions and analysis of any additional potential actions for further reducing the emissions of CO<sub>2</sub></li> </ul>	EM	31/12/2023
Refurbishment of the pasteurisation facility (PA 6) to SPS control.	<ul style="list-style-type: none"> <li>• Reduction in consumption of fresh water</li> <li>• Saving of detergents and disinfectants</li> <li>• Reduction in amount of waste water produced</li> </ul>	EM	30/6/2024
installation of a heat exchanger with a power of 6 MW (and connection to the district heating central of Alperia)	<ul style="list-style-type: none"> <li>• Energy saving due to thermal recovery</li> </ul>	EM	30/6/2024
Installation of a further high-bay warehouse in the storage area	<ul style="list-style-type: none"> <li>• Creation of free areas through better use of the volume (height)</li> </ul>	EM	31/12/2025
Refurbishment of the industrial flooring in the warehouse in order to prevent any soil and water contamination (around 450 m <sup>2</sup> )	<ul style="list-style-type: none"> <li>• Prevention of soil and water contamination</li> </ul>	EM	31/12/2025

The external auditor has checked the availability of financing required to achieve these aims.

THE  
FUTURE





We have achieved a lot on the way of environmental protection, we have set new targets, described how we are going to achieve them and talked about implementation. Our efforts also centre on people as well as nature and the environment. In our opinion a successful business has to take into consideration production factors, the environment, and its employees.

*We want to embark on these changes decisively and with the full commitment of all our employees.*

We have already set up an internal operational structure into which all the management systems (environment, occupational safety, quality) will be integrated in future, in order to have clear ideas and objectives on these levels too.

Employees have the opportunity to submit suggestions relating to environmental targets direct to the eco-management officer or the operational structure improvement working party.



VALIDATION





# Environmental Verifier's Declaration

on verification and validation activities  
according to Annex VII of the Regulation (EC) No 1221/2009 and  
amending regulation 2017/1505 and 2018/2026

The undersigned, **Dr. Reiner Beer**, EMAS environmental verifier with the registration number DE-V-0007, accredited or licensed for the scope 10.32 (NACE Code Rev. 2), declares to have verified whether the site or the whole organisation as indicated in the environmental statement/updated environmental statement

**Hans Zipperle AG**

**Max-Valier-Str. 3, 39012 Meran (BZ) – South Tirol**

(Registration No. IT-00-0005)

meets all requirements of Regulation (EC) No 1221/2009 of the European Parliament and of the Council of 25 November 2009 and amending regulation 2017/1505 of 28 August 2017 and 2018/2026 of 19 December 2018 on the voluntary participation by organisations in a Community eco-management and audit scheme (EMAS).

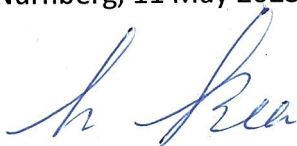
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By signing this declaration, I declare that:

- the verification and validation have been carried out in full compliance with the requirements of Regulation (EC) No 1221/2009 and amending regulation 2017/1505 and 2018/2026,
- the outcome of the verification and validation confirms that there is no evidence of non-compliance with applicable legal requirements relating to the environment,
- the data and information of the *updated* environmental statement/the *updated* environmental statement of the organisation/site reflect a reliable, credible and correct image of all the organisations activities, within the scope mentioned in the environmental statement.

This document is not equivalent to EMAS registration. EMAS registration can only be granted by a Competent Body under Regulation (EC) No. 1221/2009. This document shall not be used as a stand-alone piece of public communication.

Nürnberg, 11 May 2023



Dr.-Ing. Reiner Beer  
Environmental Verifier



EDITORIAL





#### EDITORIAL DETAILS

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