

# Environmental Stewardship Initiative Annual Report

published December 2014



## Table of Contents

Executive Summary .....	3
2013 Progress Report .....	5
Achievements.....	6
Membership Growth .....	6
Member Goals.....	7
Member Reductions .....	7
Greenhouse Gas Reductions.....	9
Cost Savings.....	11
Community Involvement.....	11
New Member Accomplishments.....	12
Program Updates .....	12
Membership .....	15
Criteria.....	15
Benefits .....	17
Conclusions.....	17
Member List .....	18

N.C. Department of Environment and Natural Resources  
Division of Environmental Assistance and Customer Service  
1639 Mail Service Center, Raleigh, NC 27699-1639  
877-623-6748 (toll-free)

Cover photos: [Top Left] DENR Secretary John Skvarla (on left) presents a plaque to recognize ASMO North Carolina for 10 years of participation at the Steward level. [Top Right] Grifols employees accept Rising Steward plaque from DENR Secretary John Skvarla (second from left), and [Bottom] DENR Secretary John Skvarla (second from left at front) presents Steward recognition plaque to North Carolina Zoo employees.

## Executive Summary

The N.C. Department of Environment and Natural Resources' Environmental Stewardship Initiative is a voluntary program that assists and encourages facilities to use pollution prevention and innovation to meet and go beyond regulatory requirements. The ESI takes a unique approach to supplement regulation by providing a voluntary, systematic and holistic approach to environmental management.

Reductions and cost savings reported by members demonstrate real results and improvements to the environment and economy in North Carolina. The ESI model addresses environmental challenges through partnerships and a voluntary, comprehensive and innovative approach that benefits both the environment and continued economic growth.

This approach combines recognition with assistance, training, mentoring and networking opportunities. A three-tiered membership structure of Partners, Rising Stewards and Stewards allows participation from a wide range of organizations. The Partner level is the entry level of the program and helps organizations address compliance issues with access to assistance, while higher tiers require organizations to be models of stewardship, as well as provide mentoring and educational resources to others within the program. In 2013, ESI had 134 member sites as shown in Figure 1 below.

### 2013 ESI Participants

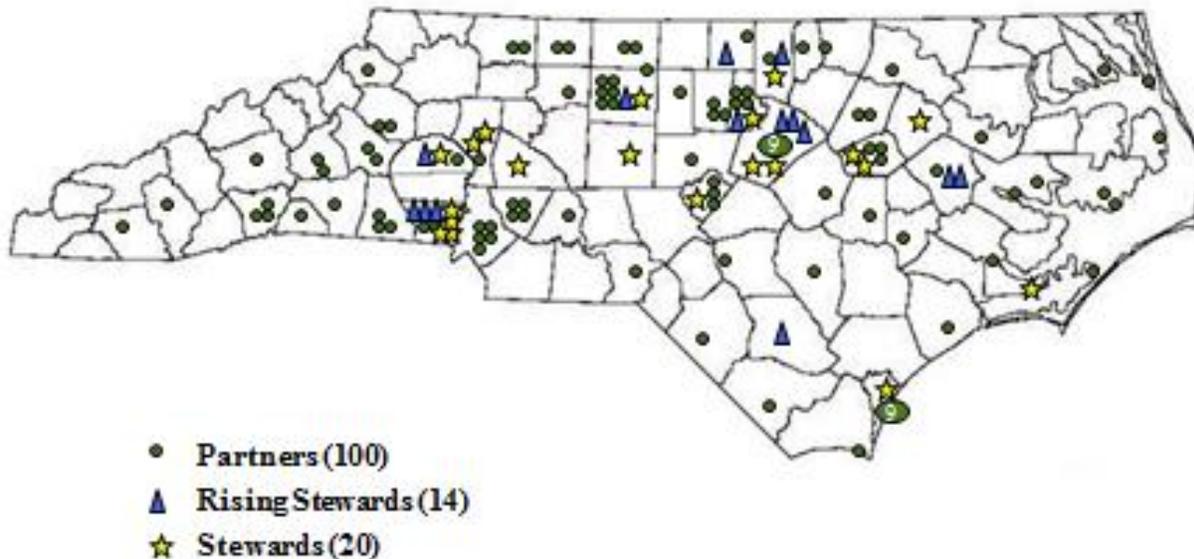


Figure 1: Map of 2013 ESI Participants

The ESI Program is open to any entity in North Carolina that commits to improving its environmental impact. (See the Membership section of this report for more information on eligibility and the three levels of the program). ESI members commit to developing environmental management systems and/or measurable goals that lead to continual improvement and stewardship. In 2013, ESI members set 255 goals covering multi-media regulated and non-regulated impacts including energy and water conservation. Seventy-five members reported progress toward these goals. Partners may apply to the program as a multi-site which allows a collection of sites to submit a single annual report. New members

must be in the program for at least one year prior to having their results included in the totals. Therefore the total reporting may be less than the total membership numbers. The following environmental impact reductions shown in Table 1 were reported for 2013.

**2013 ESI Members Reported Reductions**

	<b>Area</b>	<b>2013 Reductions</b>	<b>Unit</b>
<b>Reductions</b>	Air Emissions	72.75	Tons
	Greenhouse Gas Emissions*	2,041	Metric Tons CO2e
	Hazardous Waste	37.32	Tons
	Landfilled Waste	1,605	Tons
	Energy	8,643,348	mmBtu
	Water Use	547,725,143	Gallons
	Material Consumption	24.32	Tons
	Wastewater Pollutants	3616.37	Tons
	Wastewater Volume Reduction	16,252	Gallons
<b>Totals</b>	Biomass Recovery**	3,122	Tons
	Total Recycled Volume	46,350	Tons
	Total Cost Savings	\$ 836,536.64	

\*Indirect not reported in energy reductions

\*\*Category created for compost/mulch related goals

Table 1: 2013 ESI Members Reported Reductions

## 2013 Progress Report

“In an ideal world, regulation is replaced by stewardship, an inherent respect for the environment. In this concept of stewardship, everyone takes responsibility for their actions and the use of resources for the benefit of the community.”

This quote from the DENR Principles of Enforcement is the foundation of the ESI vision. By supporting and encouraging superior environmental performance from North Carolina’s business and industrial community, the ESI seeks to assist organizations in implementing environmental management systems and making progress on environmental goals. The ESI strives to grow a community who share ideas and develop an atmosphere of collaboration while fostering a culture of continuous improvement.

The current command and control regulatory approach to environmental management is necessary in the real world and has led to significant improvements. However, it is not practical or fiscally possible for North Carolina to regulate all pollution and consumption of natural resources. The ESI seeks to reduce an organization’s impacts beyond measures required by any permit or rule to improve the environment, conserve natural resources and gain long-term economic benefits.

Each organization has committed to report annually on its progress toward meeting its goals. This annual report summarizes all of the self reported annual data collected by the ESI members in calendar year 2013. Starting in 2005, members included cost savings from implementing environmental improvements. Reporting on greenhouse gas emissions reductions was first included in 2008. A new category was created in 2010 for biomass recovery was created to capture activities related to composting and mulching as a means of diverting waste from landfills for a beneficial use. In 2012, the ESI was opened to organizations that are not regulated by DENR permits in order to increase the program’s reach and build a larger network of organizations working together to make NC a model of environmental stewardship.



DENR Secretary John Skvarla (center) at Keihin Carolina System Technology in Tarboro, NC to celebrate their achievement of the Steward level.

## Achievements

### Membership Growth

ESI membership has more than quadrupled since it began in 2002, from 24 member sites in 2002 to 134 member sites in 2013. In 2004, a middle tier, the Rising Steward level, of membership was added (Figure 2). Beginning in 2005, Partner applicants were allowed to submit one application for multiple facilities. Facilities of all sizes participate with the smallest having only one employee and the largest employing more than 74,000 (Figure 3). Sixty-eight members are registered to ISO 14001 by third-party auditors and three have been deemed functionally equivalent by ESI staff. In 2013, one facility merged with another, two sites closed, and two chose to drop out of the program.

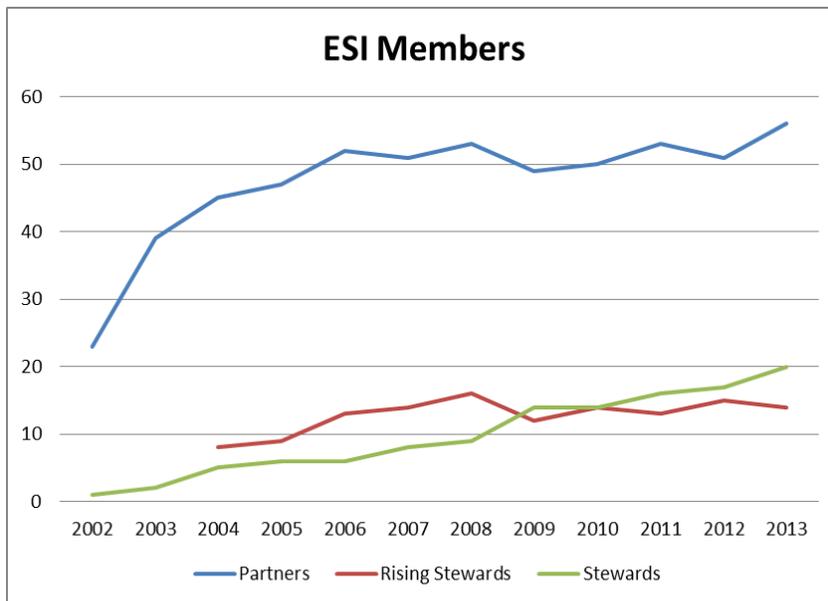


Figure 2: ESI Membership Growth, 2002-2013

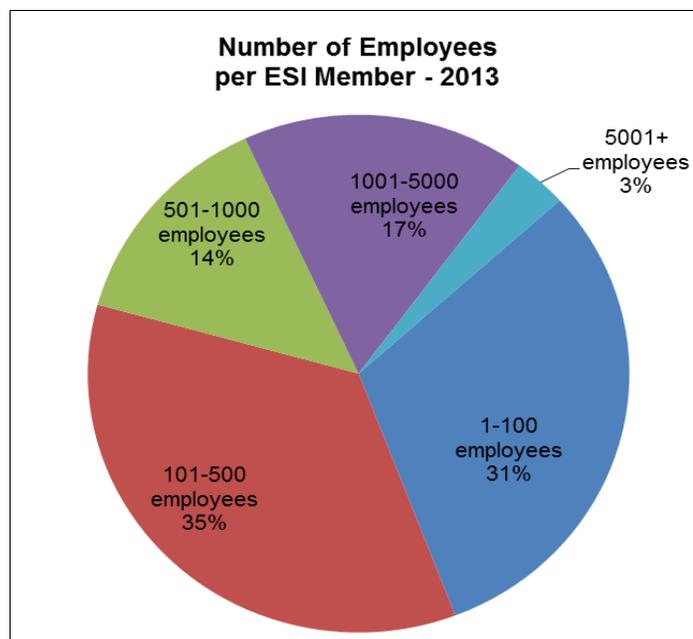


Figure 3: Graph of ESI Members by Number of Employees

## Member Goals

In 2013 ESI members reported on 255 goals that covered multi-media regulated and non-regulated impacts. As shown in Figure 4 the greatest number of goals set in 2013 were related to energy use reductions.

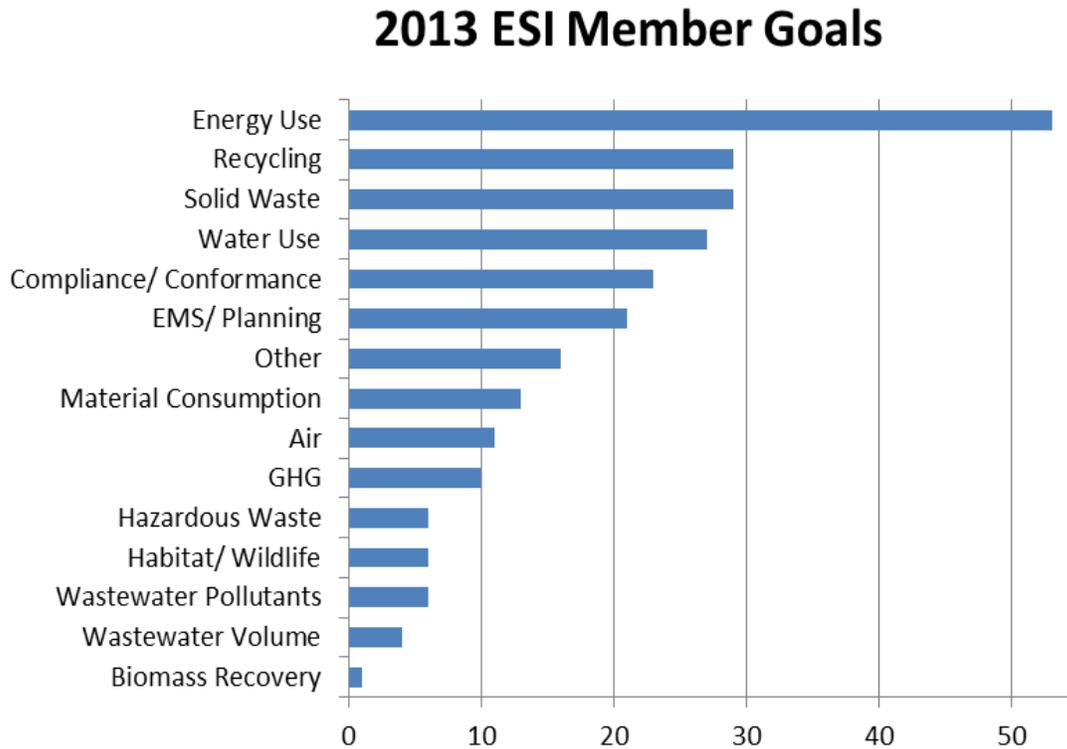


Figure 4: Graph of 2013 ESI Member Goals

## Member Reductions

ESI members are required to report on performance toward environmental goals and reductions in environmental impacts. While there are 134 sites in the program, there are seven multi-site members reporting. Therefore, seventy-five members reported progress toward these goals, resulting in the following environmental impact reductions (See Tables 2 through 5). Members' reductions are included in the final compilation after being in the program for one full year. All reduction data are self-reported by member facilities and are not verified by N.C. DENR. While reductions are only counted in the first year of their occurrence, most are permanent reductions.

Year	Total Cost Savings
2004	NA
2005	\$ 12,721,772
2006	\$ 10,393,930
2007	\$ 2,961,039
2008	\$ 4,523,391
2009	\$ 3,070,439
2010	\$ 3,270,504
2011	\$ 13,292,968
2012	\$ 5,262,972
2013	\$ 836,537
<b>Totals</b>	<b>\$ 56,333,552</b>

Table 2: Total cost savings from environmental projects reported 2004-2013

*ESI members saved enough money on environmental projects in 2013 to pay the salary of more than 27 people earning \$30,000 per year.*

*ESI members saved enough energy in 2013 to power over 113,575 average North Carolina homes for a year.*

Year	Energy Reductions	GHG Emission Reductions *	Air Emission Reductions**
2004	11737	NA	296.84
2005	48451	NA	208.14
2006	123821	NA	231.63
2007	28527501	9370	243.08
2008	9196666	5466	29.46
2009	1549175	64224	155.41
2010	598591	1444	46.11
2011	1626534	18677	4.27
2012	547878	1277	12.89
2013	8643348	2041	72.75
<b>Total</b>	<b>50873702</b>	<b>102499</b>	<b>1300.57</b>
<b>Units</b>	<b>mmBtu</b>	<b>Metric Tons CO2e</b>	<b>Tons</b>

\*Indirect not reported in energy reductions

\*\*Not including GHG emission reductions

Table 3: Energy and air emission reductions 2004-2013

Year	Water Use Reductions	Wastewater Volume Reductions	Wastewater Pollutant Reductions
2004	369529216	NA	379
2005	54201286	85566162	527
2006	591356273	106092200	400
2007	83929264	881690	0
2008	183587248	202701	105
2009	1444617822	18304480	138
2010	41895325	20449660	4
2011	347399898	5904175	7210
2012	455656908	10,862,255	230
2013	547725143	16,252	3616
<b>Totals</b>	<b>4,119,898,384</b>	<b>248,279,575</b>	<b>12,608</b>
<b>Units</b>	<b>Gallons</b>	<b>Gallons</b>	<b>Tons</b>

Table 4: Water and wastewater reductions

*ESI members saved enough water in 2013 to fill almost 25,000 average-sized swimming pools*

Year	Hazardous Waste Reductions	Landfilled Waste Reductions	Material Consumption Reductions	Total Biosolids Volume	Total Biomass Recovered*	Total Recycled Volume
2004	12.31	997	508.73	NA	NA	10015
2005	119.00	82453	37728.00	7208691	NA	8047
2006	405.16	59441	973.20	2720350	NA	12594
2007	12.52	205169	59.60	18410000	NA	23986
2008	200.32	737	2135.70	Not Reported	2783	4777
2009	10.10	4072	639.46	Not Reported	258635	34233
2010	5.77	10245	1792.20	Not Reported	333375	36667
2011	14.90	3755	115.37	Not Reported	346437	1824238
2012	4.27	3071	665.55	Not Reported	2959	33837
2013	37.32	1605	24.32	Not Reported	3122	46350
<b>Totals</b>	<b>821.66</b>	<b>371,545</b>	<b>44,642</b>	<b>28,339,041</b>	<b>947,310</b>	<b>2,034,745</b>
<b>Units</b>	<b>Tons</b>	<b>Tons</b>	<b>Tons</b>	<b>Gallons</b>	<b>Tons</b>	<b>Tons</b>

\*Category created for compost/mulch related goals

Table 5: Solid and hazardous waste reductions, material consumption reductions, and beneficial use totals 2004-2013

Reducing energy use, recycling, and solid waste were consistently the most common goals of ESI members in 2013.

- Fifty-three goals related to reducing consumption of energy (natural gas, propane, oil and electricity) were reported with a reduction of almost 8643348.46 mmBtus (million BTUs).
- Twenty-nine goals related to recycling and twenty-nine related to solid waste were reported with a reduction of over 3,000 tons of waste going to landfill and a total of over 46,000 tons of material being recycled.

Facilities also reported reductions in water use, material consumption, hazardous waste, wastewater volume, wastewater pollutants and greenhouse gas emissions in 2013.

- Twenty-seven goals reported water usage reductions of over 547 million gallons through improved efficiency, reuse, leak repair, and installation of low-flow fixtures.
- Thirteen goals reported reductions in material consumption including reductions in the use of raw materials, office paper, material substitutions, and the reduction of scrap generated.
- Six goals reported on hazardous waste reduction with an outcome of 37 tons reduced. The main contributor to this reduction was a distillery installation at a facility to recover paint solvent.
- Eleven goals reported on air pollutant reduction goals including HAPs, VOCs, SO<sub>2</sub>, and Ozone depleting substances.
- Four facilities reported wastewater volume reductions of almost 11 million gallons.
- Six facilities reported wastewater effluent pollutant reductions.
- Ten facilities reported on reduction activities in indirect greenhouse gas emissions that were not included in the energy reductions.

### **Greenhouse Gas Reductions**

Energy reductions can be converted to greenhouse gas reductions. Table 6 and Figure 5 show the breakdown of fuel usage and the metric tons of CO<sub>2</sub> equivalent from each type of energy source. They also include the greenhouse gas reductions that were reported separate from energy reductions. The

Simplified GHG Calculator tool provided by the EPA Climate Leaders program was used to convert the heating values to metric tons of CO<sub>2</sub> equivalent. This tool can be found under Popular Technical Resources here: <http://www.epa.gov/climateleadership/>.

### 2013 Reported Greenhouse Gas Reductions

	mmBtu	metric tons CO <sub>2</sub> e
Electricity	7,947,320.52	1,140,430.60
Nat Gas/Propane	101,933.80	5,435.38
Residual Oil	-	-
Distillate Oil	594,094.13	48,659.99
Coal	-	-
E-85	-	-
Gasoline	-	-
Diesel	-	-
All Other (multiple types combined)	-	-
GHG (not reported in energy reductions)	NA	18,677.40
<b>Total Energy</b>	<b>8,643,348.46</b>	<b>1,213,203.38</b>

Table 6: Greenhouse Gas Reductions Reported for 2013

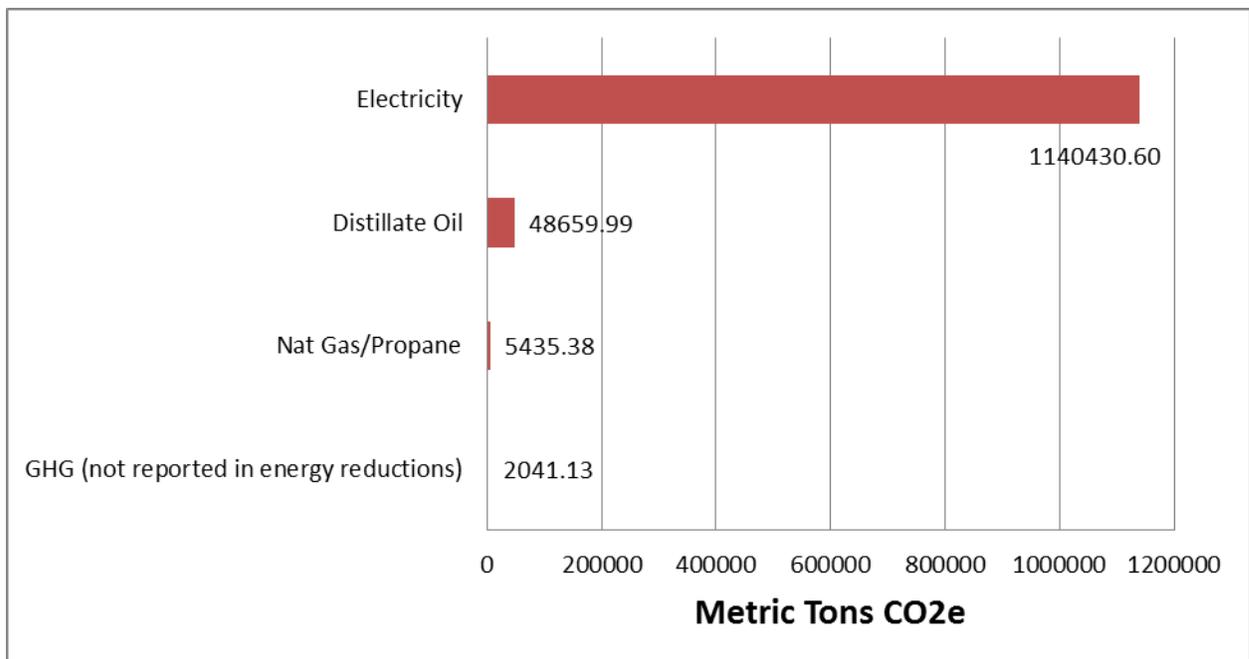


Figure 5: 2013 Greenhouse Gas Emission Reductions by Energy Source in Metric Tons CO<sub>2</sub>e

*In 2013 ESI members reduced greenhouse gas emissions equivalent to almost than 252,000 passenger vehicles!*

### **Cost Savings**

More than \$836,000 in cost savings were reported by the ESI members for projects conducted in 2013. Savings were reported on 20 facility goals with more than half being saved through recycling projects. Significant savings were also reported from energy and wastewater reductions. Figure 6 shows the breakdown of cost savings by goal type.

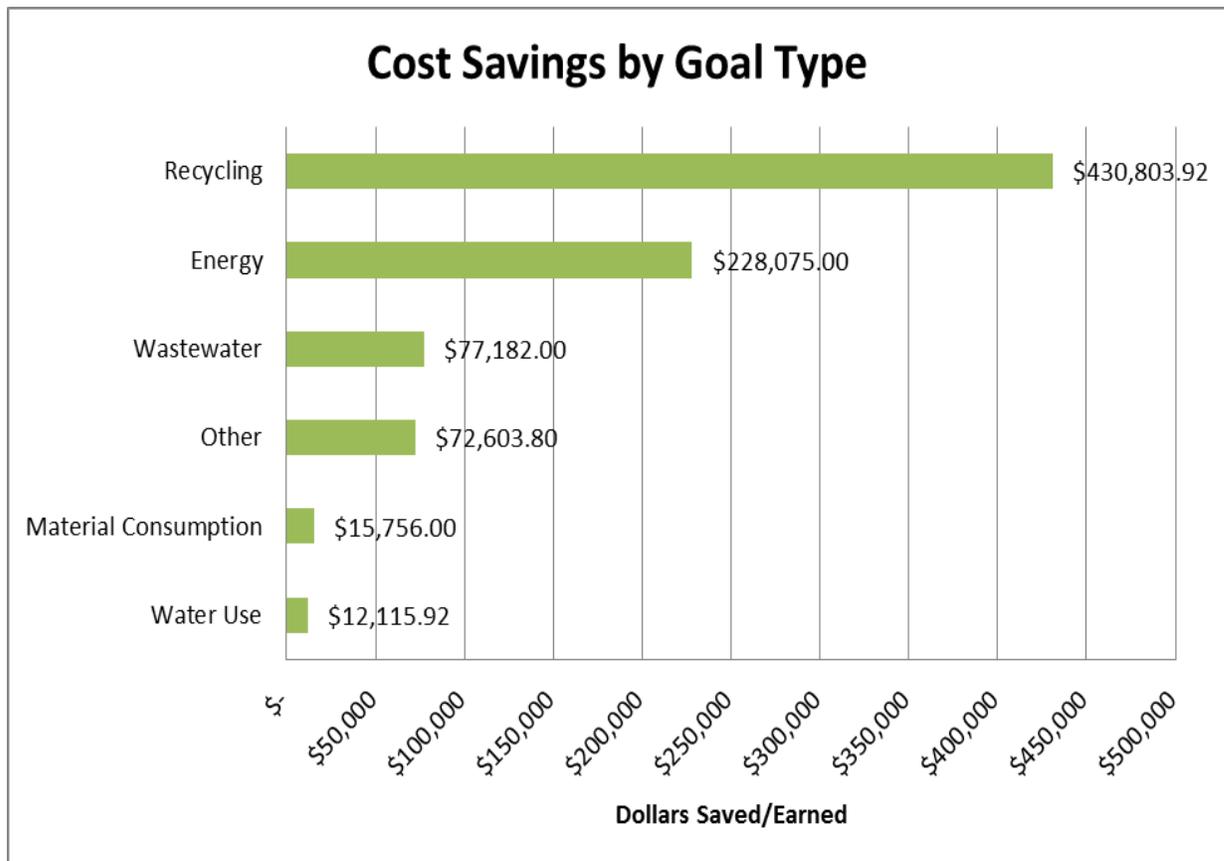


Figure 6: 2013 ESI Member Cost Savings by Goal Type

### **Community Involvement**

In addition to reporting on goals, the participants also submit information on their environmental involvement in the community. ESI Stewards are required to communicate with their communities about their environmental performance. Although only the Stewards are required to report these activities, other participants may choose to report their activities as well. For 2013, 214 activities were reported by 38 members. The following graph in Figure 7 shows the breakdown of activities.

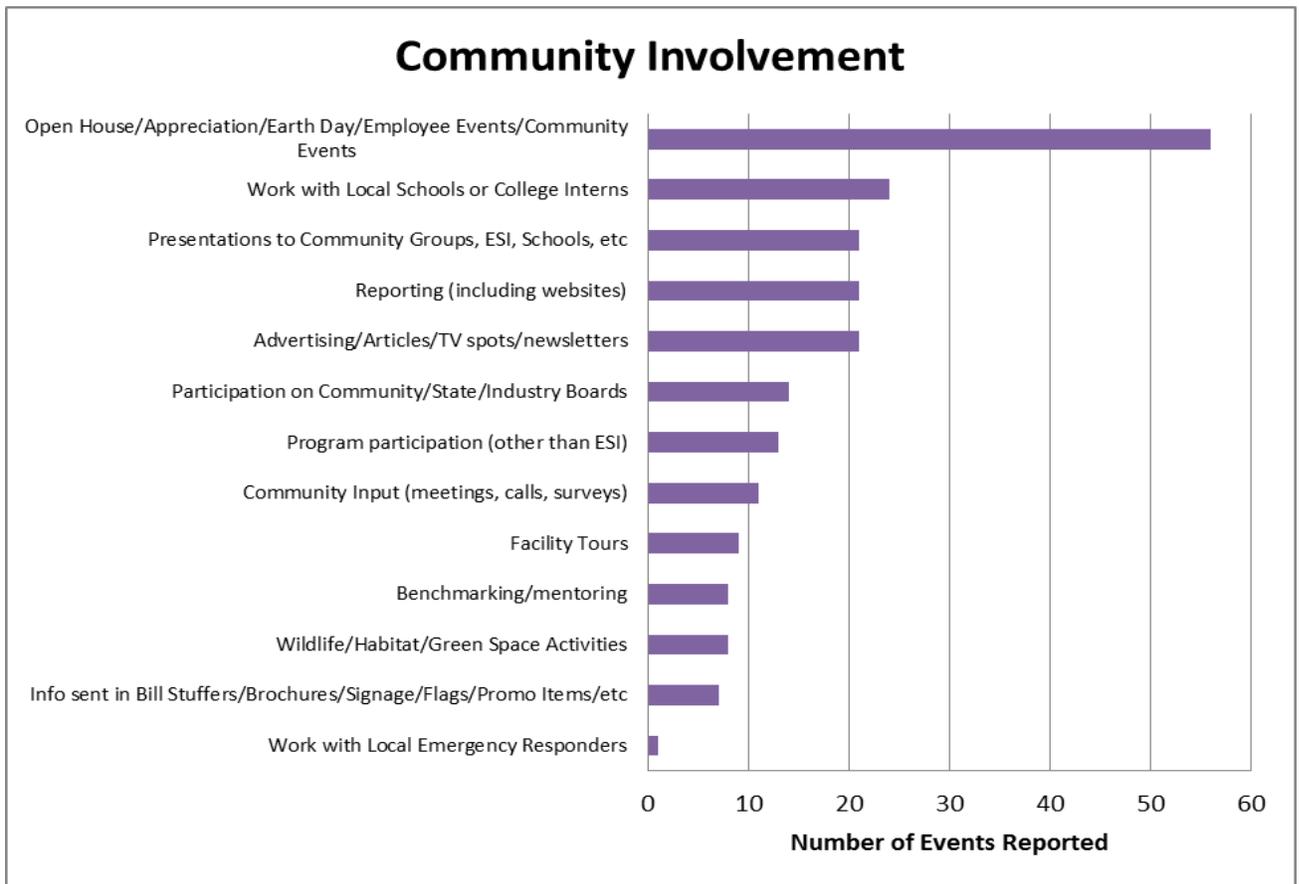


Figure 7: 2013 ESI Member Community Involvement

## New Member Accomplishments

Members who have been in the ESI program for less than one year do not have any results included in the reduction sections of this report and are not required to report since baseline data is included in their application. No additional data from new members was reported for 2013.

## Program Updates

The ESI operates on a limited budget that is partially funded by a federal grant and partially funded by appropriations from the N.C. General Assembly. From 2002 through 2005, 560 actions were recorded by DENR employees related to EMS development and assistance. These activities included site visits, presentations, meetings and other technical assistance. See Figure 8 below for a breakdown of 2006 through 2013 actions. Outreach includes training classes provided by ESI staff, speaking engagements, booths at various events and other program marketing activities. Site visits are visits made specifically to ESI or potential ESI member sites. Assistance provided includes all other information provided through email and phone calls including the electronic newsletter to our ESI members.

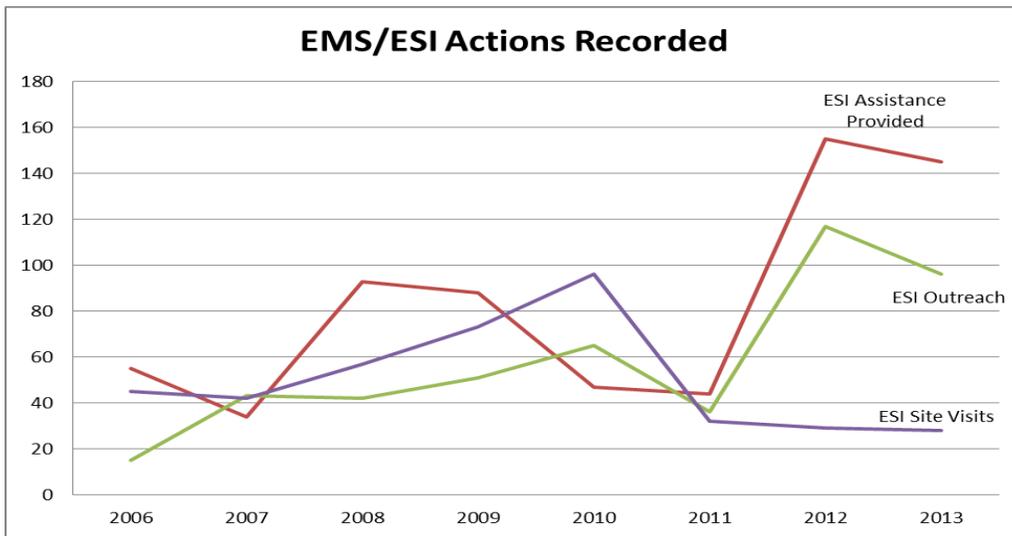


Figure 8: ESI Actions 2006-2013

Partner applications are accepted year-round and reviewed monthly. In 2012, ESI began accepting Steward and Rising Steward applications year-round as well. The Advisory Board meets to review applications and site visit reports twice per year. While applications at the higher levels are in process, the applicants are processed as Partners in order to begin receiving benefits such as newsletters and training notifications.

Following receipt of an application, an environmental compliance check is completed to determine if the facility has been under environmental criminal indictment or been convicted within the last two years, as well as identify any compliance issues (Figure 9).

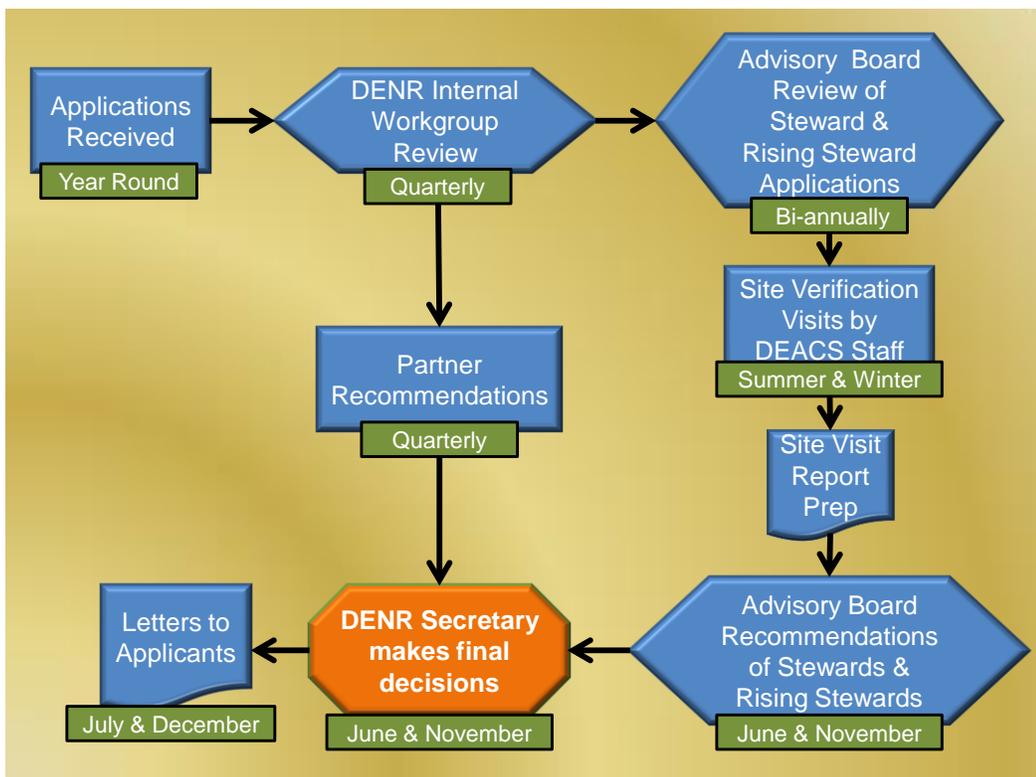


Figure 9: Application Process Diagram

The DENR Internal Workgroup reviews all Partner applications and makes a recommendation to the Secretary regarding acceptance into the program. The internal workgroup reviews Rising Steward and Steward applications to provide regulatory and compliance information to the ESI Advisory Board. The internal workgroup is comprised of the following representatives (Table 7) from regulatory divisions within DENR:

### 2013 DENR Internal Workgroup Members

<b>Name</b>	<b>Primary/Secondary</b>	<b>Division</b>
Bernard McKee	S	DAQ
Vanessa Manuel	P	DWQ
David Lee	P	DEACS
Joe Harwood	S	DEACS
Paula Hemmer	P	DAQ
Shawn Mckee	P	DWM
Sushma Masemore	S	DAQ
Linda Culpepper	S	DWM
Toby Vinson	P	DEMLR

Table 7: 2013 DENR Internal Workgroup Members

Following the compliance review by the Internal Workgroup, the Rising Steward and Steward applications are presented to the ESI Advisory Board.

The DENR Secretary established a volunteer advisory board to oversee program development and implementation. Membership consists of manufacturers, industries, industry trade groups, environmental and citizen nongovernmental organizations, small businesses, representatives of city and county government, DENR representatives and others as deemed appropriate. A DENR employee appointed by the Secretary chairs the board. Whenever possible, Environmental Stewards are given priority for membership for the business, government and at-large seats. Membership on the advisory board rotates every four years and is capped at 15 members. The 2013 Board is listed in Table 8 below.

### 2013 Advisory Board Members

<b>Name</b>	<b>Organization</b>	<b>Representation</b>
Jennifer Adams	Corning Inc. – Wilmington Optical Fiber	Steward - Large Business
Daniel Bagnell	The Scrap Exchange	Small Business
Bob Bruck	N.C. State University	Academia
Tim Fasolt	EMC	Steward - Large Business
Joe Harwood	DENR	NC DENR - Chair
Steve Jenkins	Engineered Sintered Components	Steward - Large Business
Kimberly Killian	GKN Sanford Precision Forming	Steward – At Large
Dan Miller	FRCE	Steward - Federal Facilities
Timm Denning	Smithfield Packing – Wilson	Steward - Agribusiness
David Shellenbarger	City of Gastonia	Local Government
Robin Smith	N.C. League of Conservation Voters	Environmental and Citizen NGO
Steve Street	Hickory Manufacturing Technology Center – Corning Cable Systems	Steward – At Large

Table 8: 2013 Advisory Board Members

Rising Steward and Steward applicants receive an on-site verification visit by DENR staff to ensure the EMS is functioning and to gather observations supporting the organization's application. All information obtained through the application and the on-site verification visit is documented and collated into a report that is presented to the advisory board for review.

The DENR Secretary reviews recommendations made by the advisory board and makes the final decisions. Organizations accepted into the program are usually announced in December.

## Membership

Using pollution prevention and other innovative approaches, this voluntary effort offers benefits to members for developing and implementing programs to meet and go beyond regulatory requirements.

Any company or organization that operates one or more facilities in North Carolina and whose activities impact the environment is eligible to participate in ESI. This includes, but is not limited to, manufacturers, businesses, agribusiness, service providers, government agencies, schools and nonprofit organizations. Members can enter the program at any of three tiers: Environmental Partner, Rising Environmental Steward or Environmental Steward. Membership criteria in the ESI vary depending on the tier. In 2012, changes were made to open the Partner level to a wider range of interested organizations while still maintaining the integrity of the program at the Steward and Rising Steward levels.

### **Criteria**

The "**Environmental Partner**" level is designed for adoption by a broad range of organizations that are interested in beginning the process of developing a systematic approach to improving their environmental performance. In 2012, Partners were given the option to implement measurable goals in place of implementing an environmental management systems. Additionally, Partners are no longer required to be regulated by DENR to apply. Partner applications may include multiple sites. By year end of 20132013, the program had 100 Environmental Partner sites.

To be considered at the Partner level the following criteria must be met:

- Demonstrate commitment to compliance.
- Set environmental performance goals that include pollution prevention and are appropriate to the nature, scale and environmental impact of the organization and/or commit to developing, implementing and maintaining an environmental management system based on ISO 14001 or a functionally equivalent model.
- Not be under any environmental criminal indictment or conviction.
- Agree to report annually on progress toward the organization's environmental performance goals, reductions in environmental emissions and/or discharges of releases, solid and hazardous waste disposal, use of energy and water and any reportable non-compliance events.

The "**Rising Environmental Steward**" level is designed for those organizations that have a mature environmental management program. Rising Steward applications must be for a single site. The program had 14 Rising Environmental Stewards by December 31, 2013.

Rising Environmental Steward applicants must meet all Partner criteria and the following:

- Set **measureable** environmental performance goals that are adopted into the framework of the EMS, and must demonstrate annual **improvements** to performance.
- Demonstrate a **mature** EMS based on ISO 14001 or a functionally equivalent model. The EMS for the site must be ISO 14001 third-party certified or be reviewed on-site by DENR staff.
- Have current or past regulatory oversight.
- Demonstrate commitment to meet and **go beyond** compliance.



**Employees of Hickory Manufacturing and Technology Center, Corning Optical Communications – LLC accepts tree recognizing their 5-year renewal at the Steward level from John Skvarla (back center), DENR Secretary.**

The “**Environmental Steward**” level is for those organizations that display a commitment to exemplary environmental performance beyond what is required by law. Steward applications must be for a single site. By year end of 2013, the program had 20 Environmental Stewards.

Environmental Steward applicants must meet all Partner and Rising Steward criteria and the following:

- Set **aggressive** environmental performance goals.
- Have a process for **communication with the local community** on program activities and progress toward performance goals.
- Demonstrate how the **EMS is integrated into core business functions**.
- Agree to be a **mentor** to Environmental Partner and Rising Environmental Steward participants.

Rising Stewards and Stewards are reassessed after five years of membership for renewal at their current level. Partner participants are reviewed annually, through their annual report submissions, to assess progress made toward environmental performance and overall program goals.

## **Benefits**

All levels of ESI members are eligible for the following:

- Technical assistance on developing an EMS, pollution prevention approaches, environmental management and treatment technologies, and achieving and maintaining compliance with local, state and federal regulations;
- Specialized training;
- Networking opportunities;
- Recognition of program participation;
- Use of a program logo for the achieved level;
- Coverage by U.S. EPA and DENR self-reporting policies;
- A single point of contact within DENR; and
- Other benefits as deemed appropriate by the Secretary based on recommendations from the advisory board.

Partners and Rising Stewards have the additional benefit of access to Stewards as mentors where appropriate. Environmental Stewards have the following additional benefits:

- Formal public recognition from the Secretary of DENR that may include an on-site award ceremony, public announcements and press releases.
- Participation in the Steward Forum chaired by the Secretary.
- Priority membership on the ESI Advisory Board when appropriate positions are available.

During the annual members' meeting, facilities accepted into the program at the Environmental Partner level receive a certificate of recognition signed by the DENR Secretary and Rising Environmental Stewards receive a plaque recognizing their achievement. Environmental Stewards accepted into the ESI receive a personal letter signed by the DENR Secretary. The Secretary also presents Stewards with a large plaque during an on-site ceremony. DENR highlights members' participation in press releases, the ESI website, newsletters, and social media posts.

## **Conclusions**

The results from the ESI annual report show that an approach that goes beyond the regulatory requirements can garner results that have positive impacts for not only regulated pollutants, but also for non-regulated environmental and economic factors. This DENR program is unique in its ability to collect environmental data across media, including monetary savings associated with the environmental improvements made. These savings to the financial and environmental bottom line aid North Carolina businesses and municipalities to be resilient and lead toward economic growth. The Environmental Stewardship Initiative encourages North Carolina industries and municipalities to share their environmental success stories with each other across sectors in order to provide a better environment for everyone in the state.

## 2013 ESI Members

### Stewards:



- **ASMO North Carolina Inc. - Statesville**
- **Bridgestone Americas Tire Operations LLC - Wilson**
- **City of Gastonia Crowders Creek Water Resource Recovery Facility**
- **City of Gastonia Long Creek Water Resource Recovery Facility**
- **City of Gastonia Water Treatment Plant**
- **Corning Inc. – Wilmington**
- **Daimler Trucks North America LLC – Cleveland**
- **EMC Corporation – Apex**
- **Engineered Sintered Components - Troutman**
- **Firestone Fibers & Textiles Company, Kings Mountain**
- **Fleet Readiness Center East - Cherry Point**
- **GKN Driveline- Sanford Precision Forming Facility – Sanford**
- **Hickory Cable Facility, Corning Cable Systems**
- **John Deere Turf Care**
- **Keihin Carolina System Technologies**
- **N.C. Zoological Park**
- **Santa Fe Natural Tobacco**
- **Smithfield Packing Co. – Wilson**
- **Thomas Built Buses, Inc.**
- **United States Environmental Protection Agency – RTP Campus**

### Rising Stewards:



- **ASMO North America Inc. – Greenville**
- **AW North Carolina Inc.**
- **Bridgestone-Bandag, LLC**
- **City of Gastonia Wastewater Treatment Division Biosolids Program**
- **Daimler Trucks North America LLC – Gastonia**
- **Eaton Corporation - RPO**
- **Eaton Corporation - YPO**
- **Firestone Fibers & Textiles Company, Gastonia**
- **GKN Driveline - Roxboro Facility**
- **GKN Sinter Metals**
- **Grifols Therapeutics**
- **NACCO Materials Handling Group**
- **RF MicroDevices**
- **Smithfield Packing Company Inc. Tar Heel Division**

# Partners:



- **18th Airborne Corps and Fort Bragg**
- **Alliance One International Inc. (5)\***
- **Baker Furniture (2)\***
- **B/E Aerospace, West Point**
- **Borg Warner Thermal Systems**
- **Burt's Bees Inc.**
- **Cape Fear Public Utility Authority (9)\***
- **Cascades Tissue Group – North Carolina Inc.**
- **Caterpillar BCP Sanford**
- **Caterpillar Precision Seals**
- **Charlotte-Mecklenburg School System**
- **City of Gastonia Public Works Division**
- **City of Hendersonville Water Treatment Plant**
- **City of Shelby First Broad River Wastewater Treatment Plant**
- **City of Shelby Water Treatment Plant**
- **CommScope Inc. - Claremont Operations**
- **Crown Equipment**
- **Daimler Trucks North America LLC - Mt Holly**
- **Domtar Paper Company, LLC**
- **Duke University**
- **Eaton – Capital Blvd**
- **Elk Knob State Park**
- **Eno River State Park**
- **Enterprise Leasing Company-Southeast, LLC**
- **Falls Lake State Recreation Area**
- **Freudenburg Nonwovens**
- **General Dynamics AIS**
- **General Electric Company – Industrial Solutions**
- **Hanging Rock State Park**
- **High Point Furniture (2)\***
- **International Paper - Riegelwood Mill**
- **Kao Specialties Americas**
- **Kapstone Kraft Paper**
- **Kerr Lake State Recreation Area**
- **Leggett & Platt ON64 High Point Furniture**
- **Marine Corps Base, Camp Lejeune**
- **Mayo River State Park**
- **Mecklenburg County Solid Waste Operations (3)\***
- **Medoc Mountain State Park**
- **Momentive**
- **MVP Group International**
- **N.C. DOT Ferry Division (9)\***
- **N.C. Zoological Park**
- **NIEHS**

# Partners:



- **Performance Fibers, Inc. - Moncure**
- **Pfizer**
- **Pilot Mountain State Park**
- **PSNC Energy Carolinas Inc. (21)\***
- **RedViking Group LLC**
- **Siemens Medical Solutions – CSG Service Headquarters**
- **Smithfield Clinton Plant**
- **Smithfield Foods Clayton**
- **The Summit Environmental Education Center at Haw River State Park**
- **Tredegar Film Products**
- **Universal Leaf North America US Inc. (2)\***
- **USCG-Support Center Elizabeth City**
- **WSACC- Interceptor System**
- **WSACC- Mt. Pleasant Water Treatment Plant**
- **WSACC- Rocky River Regional Wastewater Treatment Plant**