



NATIONAL PACKAGING COVENANT

ACTION PLAN REVIEW

2005/6 Financial Year

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1.0 Executive Summary

Grove Fruit Juice is a privately owned company specialising in the manufacture, warehousing and selling of fresh fruit juice based beverages.

The product range includes

- Chilled Fresh Fruit Juices,
- Chilled Fruit Drinks and
- Fruit Cordials

The full Grove product range including brands and pack sizes can be viewed at our website <http://www.grovejuice.com.au/>

Grove employs 70 people and manufactures from the one site only, located in Mansfield, Queensland. Grove is primarily a manufacturer / filler within the packaging supply chain. Grove engages in some limited local distribution and also utilises the services of independent transport companies.

Grove Fruit Juice is committed to a process of continuous improvement of all of its business objectives. And is compliant to all legislation at Federal, State and local government levels.

The following NPC action plans have been developed in line with our current business objectives and in support of the principles of the National Packaging Covenant based on the NPC elements of :-

- Product /Packaging Design,
- Production,
- Distribution,
- Disposal,
- Research,
- Education and
- Labelling.

The attached action plans outline the commitments Grove Fruit Juice is undertaking to reduce the impact of packaging products and their associated manufacturing processes on the environment. To achieve these actions Grove Fruit Juice will continue to involve all suppliers, employees and customers in the implementation process and the ongoing continuous improvement of the waste minimisation process. The Action Plans for 2007/2008/2009 Financial years.

As is the outcome of cleaner production techniques and GMP, Grove has achieved a number of benefits both for the profitability of the company and for the environment in which it conducts it's business.

1.1 Entity Commitment and Scope

The following Action Plan covers only the Grove Fruit Juice entity although Grove will be working closely with all of its packaging suppliers and waste contractors to achieve the Action Plan.

1.2 Contact Officers

The nominated contact persons responsible for the Action Plan and report :

Mr Gregor Tzvetkoff

Production Manager

Ms Amy Mirtschin

Quality & Food Safety Co-ordinator

Grove Fruit Juice

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1.3 Timeframe

Grove Fruit Juice signed the Covenant in October 2001. The following Action Plan demonstrates our ongoing commitment to the National Packaging Covenant and Covers the financial periods 2007-2008-2009. Progress on the 2006 action plan will be reported to the Covenant Council by July 2006.

2.0 National Packaging Covenant Action Plans

Grove Fruit Juice through its existing company policies and processes is committed to continuous improvement of all of its business objectives as demonstrated with our third party accreditation to internationally recognised quality systems. Grove recognises the need for conservation of packaging materials and the reduction of waste material to landfill. The packaging objectives outlined in the Grove Action Plan will support the principles of product stewardship and the roles and undertakings of the signatories of the National Packaging Covenant. The Action Plan is based on continuous improvement and key performance indicators, which will allow our business to remain competitive and support current packaging cost reduction efforts.

KPIs

Goal	Performance Indicator	KPI
All packaging has been designed to use minimum materials to achieve a safe hygienic retail product	Estimated the total weight of consumer packaging sold into the Australian market 2005/6	512000 Kgs Actual 415443
	Estimated total net weight of products sold into the Australian market 2005/6	8167000 Kgs Actual 8677769
	Percentage of consumer packaging to net weight sold into the Australian market 2005/6	6.37% Target ≤ 6% Actual 5.03%
All primary packaging and most secondary packaging materials are recyclable	Estimated total weight of non recyclable material used in 2005/6 6021 Kgs PVC Tape 2389 Kgs Paper Laminate Labels 3632 Kgs	shown as % to net weight .0007% Target ≤ .0006% .0003 .0004 Actual 4522 = .00055
Provision of collection services for post consumer packaging and paper	Grove has collection facilities on site to enable the recycling of all recyclable packaging	
Increased recycling of used packaging	Estimated total consumer packaging recycled from on site collection 2005/6 Plastics 15700 Kgs Cardboard 14900 Kgs Estimated total packaging sent to land fill from on site collection 2005/6 21300 Kgs	Actual 19440kgs Actual 15600kgs .0026% Target ≤ .0023% Actual 30000 =.0036
Grove purchasing policy is to purchase recycled materials where possible	We have assessed using recycled materials for all primary and secondary packaging at this stage only cardboard cartons are suitable for use as secondary only. Estimated board used 2005/6	165500 Kgs 98% recycled board =162000 Kgs 31.6% Target ≥ 40% Actual 170992 kgs At 70% recycled board =119694kgs =28.8%
Continuous improvement process against baseline data & KPIs	27 Baseline estimates have been established	
	28 All previous reports against action plan have been completed	
	29 Improvements have been achieved over the past 4 years we hope to make further gains during 2006/9.	

ACTION PLAN 2005/6 REVIEW

PRODUCT STEWARDSHIP ELEMENTS	ACTIONS / COMMITMENTS	PROGRESS TO DATE	OBJECTIVES – 2007 - 2009
DESIGN / RESEARCH	<ul style="list-style-type: none"> Annual product and raw Materials audit to ensure adherence to the Environmental Code of Practice for Packaging and Good Manufacturing Practices. [Code of Practice is documented in our Food safety Programs [HACCP / SQA / Woolworth's QS] and no package introduction bypasses environmental considerations] 	<ul style="list-style-type: none"> All primary and secondary packaging Materials currently being used are recyclable eg. HDPE [2] or PET [1] –For bottles LDPE [4] or HDPE [2] For closures , stretch-wrap Paper/corrugated fibreboard - cartons On pack promotional material has been reduced to a minimum The majority of our major RM Suppliers are NPC signatories eg. Amcor, Logan Moulders and purchasing policy is to give priority to NPC and Quality / Environment System certificated suppliers 	<ul style="list-style-type: none"> It is unlikely that any further Light - weighting of bottles or cartons is possible without compromising quality and causing product degradation, damage and food safety concerns because of our cold room environment. Bottles and cartons have been light-weighted during the life of the covenant and our grams RM : Litre product ratio has reduced accordingly, however we will be discussing the possibilities and engaging the support of suppliers for light weighting and new technology alternatives again in 2006 Ongoing – no alternatives to date
PRODUCTION	<ul style="list-style-type: none"> Production generated waste measurement We are not limiting our process to packaging control but extending stewardship to full product life cycle 	<ul style="list-style-type: none"> Product efficiencies are reported Daily by our 'MFGPRO' data system and reviewed by the Prod. Manager. Our system generated wastages are 2.9%, for the financial year 2004/5 % calculated by unit not weight. Water usage for the same period was 2.7L/L 	<p>KPIs.</p> <p>Our target waste reduction for 2005/6 is less than 2.5% Actual wastage 2.6% for 2005/6</p> <ul style="list-style-type: none"> Water/Effluent KPIs is to be at world class standards of 1.3L / L product and actioned Actual rate is 2.44L/L Effluent charges to be addressed and KPI set Measurement and KPI yet to be set.
DISTRIBUTION	<ul style="list-style-type: none"> Tertiary packaging reduction Review current methods of transport both incoming and outgoing 	<ul style="list-style-type: none"> There continues to be a very limited Amount of tertiary LDPE pallet wrapping used apart from longer haul distribution after the 10.5% reduction in 2003. No pallet glue or twine is used Completed – limited scope for alternatives given the need for refrigerated units and bulk deliveries to major supermarket chains All incoming fruit and concentrates are purchased in bulk bins or drums 	<ul style="list-style-type: none"> Ongoing and a watching brief Ongoing pallet space utilisation
DISPOSAL	<ul style="list-style-type: none"> Review administration waste disposals Review production waste disposals 	<ul style="list-style-type: none"> Completed – good segregation of papers by colour coded bins. GM memo to staff posted Completed – Collex waste management contract. Colour coded bins and skips for material separation <ul style="list-style-type: none"> Cartons/paper on-sold sold to Visy Closure cartons sold to Recycler Bottle waste on-sold to Visy Plastic wrap on-sold to Visy Coding ink cartridges recycled to supplier All waste fruit peel to cattle feed – yields of fruit crush are calculated daily and attempts to improve evaluated 	<ul style="list-style-type: none"> Ongoing Discussions with Collex and other Waste management companies re continuous improvement. All waste weights to be posted monthly for renewed staff awareness
EDUCATION / LABELLING	<p><u>INTERNAL</u></p> <ul style="list-style-type: none"> Review NPC information in employee induction procedure Train current and new 	<ul style="list-style-type: none"> Completed 	<ul style="list-style-type: none"> Ongoing – in HACCP documentation Ongoing – this document to be posted as will KPI achievements Ongoing and include

	<p>employees in Grove NPC action plan</p> <p>EXTERNAL</p> <ul style="list-style-type: none"> NPC action plan and commitments on Grove web site Consumer recycling and disposal messages on product labels 	<ul style="list-style-type: none"> Completed – documented in HACCP training records A good employee incentive has been introduced by the GM which includes a waste and RM efficiency component in the formula Currently investigating by first newly employed IT manager All primary packaging [bottles] displays recycling logo and plastic type ID 90% of secondary packaging [cartons] displays recycling logo 	<p>monthly explanation of performances and new KPIs in monthly production meetings</p> <ol style="list-style-type: none"> Production efficiencies RM yields pack waste Fruit yields Electricity Water / effluent Incentive progress Disposals charge / income from recyclables sales Costs Employee involvement and suggestions <ul style="list-style-type: none"> Reference to environmental and NPC commitment on web site and reference to action plan internet address of Packaging Council of Aust. And / or NPC preferably in a new company "Environmental Policy" [Responsibilities DM / GW] Carton suppliers to be instructed to add logo to remaining cartons
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PACKAGING MATERIAL USED

MATERIAL TYPE	Description And Size	DISPOSAL	USE
HDPE	0.25L, 0.5L, 1L, 2L, 3L, 4L, 5L.	Segregated and recycled	Bottles product primary packaging
PET	1L, 2L.	Segregated and recycled	Bottles product primary packaging
LDPE	38mm Cap Stretch Wrap Bottle Bags	Segregated and recycled General Waste Segregated and recycled	Closures product primary packaging Pallet Wrap Supplier bottle protection
PVC	Self Adhesive tape Labels	General waste recycled	Product carton secondary packaging
Fibreboard	Various sizes	Segregated and recycled	Product secondary packaging
Steel drums	200L	Returnable	Bulk ingredients
Paper	Documents Labels	Segregated and recycled General waste	Administration / ingredient bags secondary packaging
PE Bulk bins	1m3	Reused	Fruit bins
Coding ink		Cartridges recycled and reused	Date coding primary and secondary packaging