

2025

Environmental statement

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Our company. Our responsibility.

**As a family-owned company
in the fifth generation, we
combine long-term corporate
planning with industrial
manufacturing expertise.**



Shaping the future with measurable environmental goals

Three decades of environmental performance – Bischof+Klein has been documenting and improving its environmental performance since 1996 in the context of the European environmental management system EMAS (registration number DE-156-00009). Our family-owned company specializes in flexible plastic packaging and technical films. Bischof+Klein develops high-quality products, from gossamer-thin portion packaging and large, protective packaging for the consumer and industrial sectors up to and including complex special films for technical applications. We are aware that scope 3 emissions along the value chain constitute a significant proportion of our overall emissions. We are therefore working specifically and continuously towards measurably reducing these climate impacts as well.

Bischof+Klein SE & Co. KG has production plants in Lengerich and Konzell. The central departments that operate for both locations belong to Bischof+Klein Holding SE & Co. KG. Further Bischof+Klein production plants are located in France, the United Kingdom, and Poland.

The Group employs a total of around 2,800 staff and supplies its products to trade and industry around the world on the basis of its strong international sales network. Bischof+Klein is wholly owned by the founding families. There were no changes to the company's form during the 2025 reporting year.

Employee figures 2025

LENGERICH *

1,378 
persons

KONZELL *

741 
persons

SUBSIDIARY COMPANIES *

642 
persons

Bischof+Klein Lengerich



Bischof+Klein's company premises are situated at the southern edge of the town of Lengerich on the Lohesch industrial estate and border a residential area to the west. The nearby A1 and A30 interstate highways ensure good long-distance transport links. Without exception, all goods are delivered and shipped via the industrial estate and the southern beltway, the feeder road to the interstates. The "Intruper Berg" and "Lengericher Osning" nature conservation areas are both located in close proximity to the plant; a drinking water protection area is situated approximately 1.3 kilometers to the west of the plant.



Main production

Industrial packaging for:

-  Agriculture + horticulture
-  Construction
-  Chemicals + petrochemicals
-  House + home
-  Food

Consumer packaging for:

-  Hygiene + care
-  Food
-  Pet products
-  Detergents + cleaning materials

Specials:

-  Pharmaceuticals + medicine
-  Metal + plastic surfaces
-  House + home
-  Tapes + liners

Bischof+Klein Konzell



Bischof+Klein's subsidiary plant in Konzell (district of Straubing-Bogen) is located to the northeast of the community's center in an industrial area with neighboring, rural settlements. All goods and commercial transportation is carried out via the A3 interstate and via federal highway B20 from Straubing. Konzell forms part of the Bavarian Forest nature park, which lies adjacent to the "Bavarian Forest national park" nature conservation area to the east.



Main production

Industrial packaging for:

-  Chemicals + petrochemicals

Consumer packaging for:

-  Hygiene + care
-  Food
-  Pet products
-  Detergents + cleaning materials

Our environmental approach

We record, evaluate,
and reduce our
environmental impacts
year by year.



Systematic environmental protection

Active and systematic environmental protection has been a central element of our corporate strategy since 1985. Our environmental policy is aimed at continuously improving our energy, raw material, and emissions management. Significant investments in modern technology such as air scrubbing and energy efficiency, for instance, form the basis for this.

30 years ago, in 1995, the Environmental Audit Act was enacted in Germany to establish the bases for the EMAS. The EMAS is the EU regulation concerning the voluntary participation of organizations in a community environmental management and corporate environmental auditing system that came into force in 1993. Bischof+Klein took part in it from the outset and has its environmental performance audited each year as part of the EMAS system.

The environmental management system that Bischof+Klein has introduced for this purpose at Bischof+Klein Lengerich was successfully audited for the first time by an independent expert back in 1996. The first EMAS audit at Bischof+Klein Konzell took place in 1999. In 2002, the corporate environmental management system was extended by the element of occupational health and safety. Changing environmental specifications necessitate continuous and systematic analysis of the requirements on corporate operations and their implementation in specific, binding obligations.

The significant legal regulations that apply to both Bischof+Klein Lengerich and Konzell particularly include:

- + the Federal Immission Control Act (BImSchG) including the respective regulations (e.g., German Clean Air Act, VOC Ordinance)
- + the German Circular Economy Act (KrWG) and the relevant waste management regulations (e.g., German Commercial Waste Ordinance)
- + the Federal Water Act (WHG), including the state water regulations and the German Regulation on Facilities for Handling Substances that are Hazardous to Water (AwSV)
- + chemicals law, especially the REACH and the CLP Regulations
- + further site- and activity-related permissions and regulatory requirements

The Packaging and Packaging Waste Regulation (PPWR) must additionally be taken into consideration when designing and manufacturing our products. Among other aspects, it defines the requirements for minimizing packaging, its recyclability, and the use of recyclates.

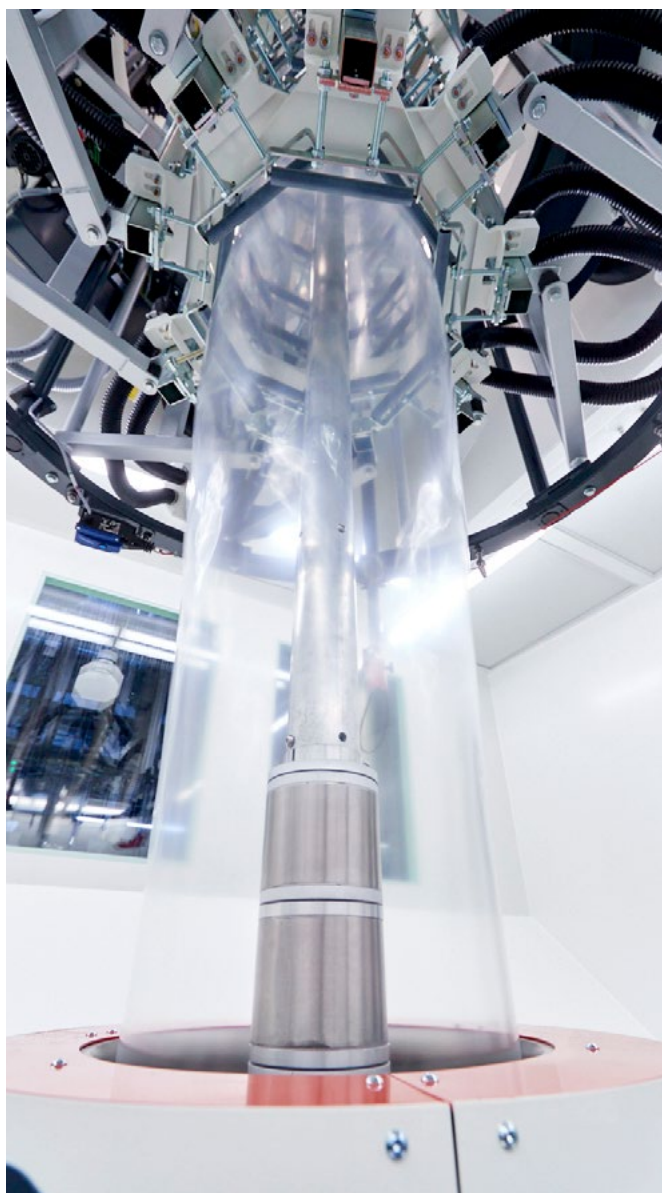
The relevant legislative requirements were met in full at both Bischof+Klein Lengerich and Konzell in 2025.



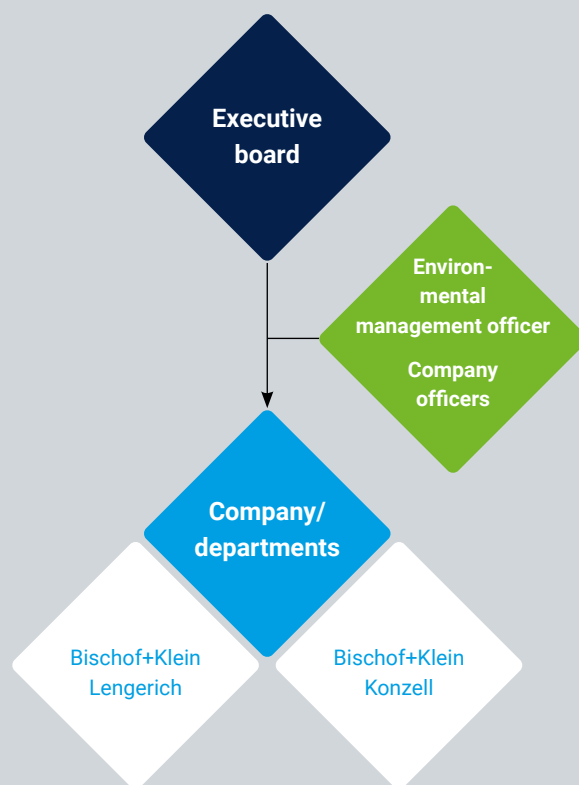
Our guiding principle: systematically integrating environmental aspects into our planning and operations.

As well as complete process documentation, Bischof+Klein's environmental management system also encompasses the definition of responsibilities and control mechanisms at departmental and corporate level. The EMAS amendments in 2017 and 2018 again led to the specific expansion of the environmental management system, focusing on four areas that form the basis of the materiality assessment for environmentally-relevant topics:

- + Effects that the company's environment can have on its success (context of the organization; see also glossary, page 31)
- + Stakeholders' expectations and requirements of the company
- + Analysis of the environmental impacts that upstream or downstream sections of Bischof+Klein products' life cycles have
- + Assessment of opportunities and risks



Bischof+Klein environmental organization



Environmental management responsibilities and coordination

The Bischof+Klein executive board is accountable for the environmental management system and responsible for its effectiveness. It provides the necessary funds and appoints the environmental management officer, who reports directly to the executive board. Together with the environmental officers and work safety specialists, he advises the executive board, the divisions, and the specialist departments on environmental and safety issues. The environmental management officer also takes part in the operational managers' meeting. Environmentally-relevant topics are discussed and evaluated there each month together with the plant managers and the heads of the logistics and quality assurance departments.

The effectiveness of the environmental management system and the company's environmental performance are additionally subjected to a systematic evaluation once a year by the executive board in the management review.

Our principles concerning safety, quality, and environmental responsibility

Our integrated management policy sums up our principles regarding work safety, quality, and environmental responsibility. It applies to all sites throughout the Group and serves as the basis for deriving specific goals.

Integrated management policy of the Bischof+Klein Group

The Bischof+Klein Group develops and manufactures high-performance and sustainable solutions for its customers at its sites in Germany, Poland, France, and the United Kingdom. Occupational health and safety as well as quality and environmental responsibility are integral elements of our corporate strategy and our operational excellence. This policy applies to all of the Group's sites, activities, products, and services, and forms the binding framework for defining and evaluating our goals.

As part of our commercial activities, the entire Group is committed to:

- + complying with all applicable statutory and other binding obligations
- + continuously improving the effectiveness of our integrated management systems
- + meeting the requirements of recognized product and food safety standards, especially BRCGS Packaging Materials, insofar as these are applicable
- + complying with our code of conduct as well as recognized standards in the areas of ethics, integrity, and acting in a responsible manner (e.g., SMETA)
- + providing the resources necessary to implement this policy
- + systematically taking climate-relevant risks and opportunities into consideration as part of analyzing the context of the organization and when evaluating the needs of stakeholders



We are committed to systematically taking climate-relevant risks and opportunities into consideration.

Safety at work and health

The safety and health of our employees are given top priority and make a significant contribution to the company's success. We protect and promote the health and performance of our employees by consistently complying with statutory requirements and also by making our workplaces safe and health-friendly on the basis of our own experience and through continuous improvements.



We are committed:

- + to providing safe and health-friendly working conditions
- + to eliminating hazards and systematically minimizing risks
- + to preventing work-related injuries and diseases
- + to consulting our employees and actively involving them in safety processes
- + to fostering an open and preventative culture of safety

Our objective is a sustainable zero-accident culture.

Quality

Our aspiration is to consistently meet and surpass our customers' expectations.

We ensure:

- + stable and controlled processes built on risk-based thinking
- + systematic avoidance of errors and sustainable elimination of causes
- + timely delivery in conformity with specifications
- + continuous further development of our organization



Product safety, hygiene, and the requirements of BRCGS Packaging Materials standard are an integral part of our quality management and our corporate culture.

Hygiene, product safety, and the requirements of the CleanFlex® GMP system are firmly anchored in our processes and are regularly audited and evolved.

We regard quality as a management task and as the responsibility of each and every employee.

Environmental management

We assume responsibility for the impacts of our business activities on the environment and the climate. Profitability and environmental protection are not mutually exclusive for Bischof+Klein, but complement and enhance one other.

We are convinced that outstanding environmental protection performance will improve our chances against the competition in the long term. Our voluntary environmental protection activities are targeted specifically at measures that are also economically sensible or which have a particularly positive impact on the protection of resources.



We are committed:

- + to environmental protection including the avoidance of environmental pollution
- + to using energy, raw materials, and water efficiently
- + to reducing emissions, waste, and other environmental impacts
- + to giving consideration to climate-related impacts along our value chain
- + to continuously improving our environmental and climate performance

Aspects of relevance to the environment and the climate are regularly assessed and incorporated into both operational and strategic decisions. This applies to both normal operations and emergency situations, for which we implement special contingencies.

Responsibility, implementation, and communication

The Group's management bears overall responsibility for this corporate policy and makes the necessary resources available.



The site managers are responsible for:

- + implementing this policy
- + deriving site-specific target values
- + integration into operational programs
- + regular performance monitoring and reporting

Managers are obliged to actively exemplify these principles. All employees are encouraged to contribute to continuous improvement by behaving in compliance with the rules, reporting deviations, and actively getting involved.

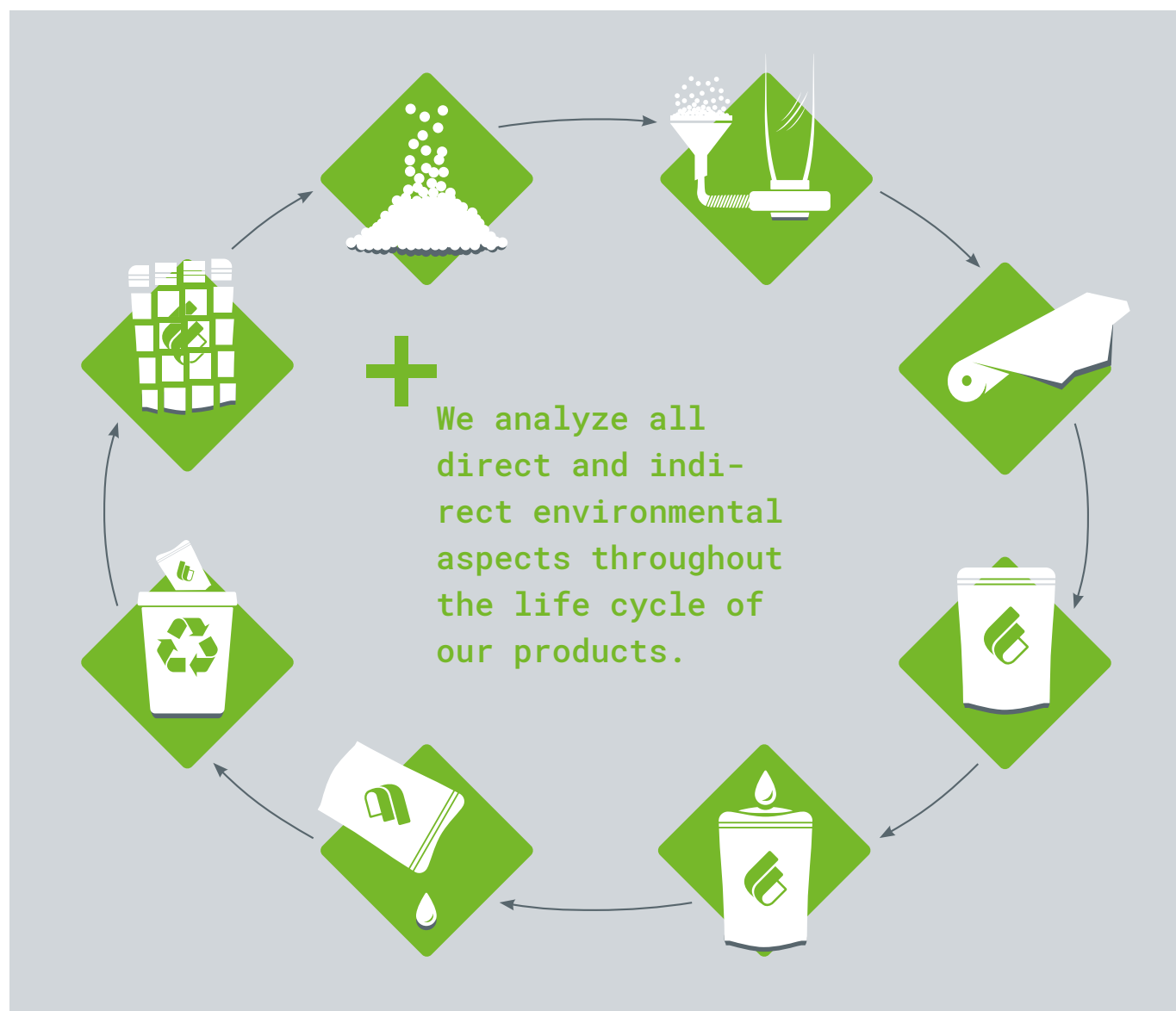
Everything in view

Environmental aspects throughout our products' life cycles

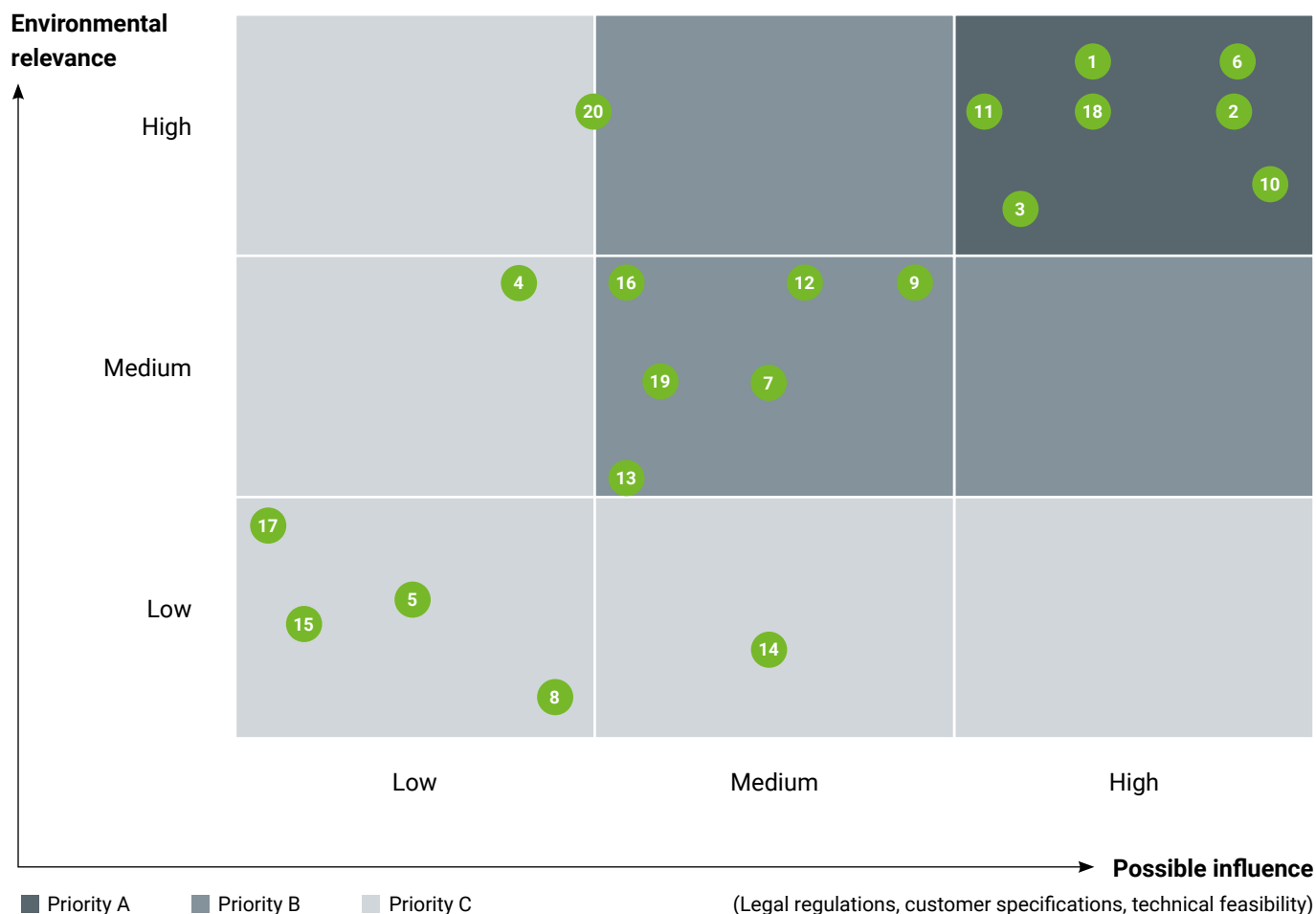
What impacts do our corporate processes have on the environment? In the context of the EMAS specifications, the approach to answering this question is set out clearly in advance:

- + Description of all relevant direct and indirect environmental aspects that lead to significant environmental impacts
- + Description of the procedure for defining the significance of the environmental aspects
- + Explanation of the impacts that the described environmental aspects have

To comply with these specifications, the Bischof+Klein environmental management officer has undertaken a comprehensive analysis together with the environmental officers at Bischof+Klein Lengerich and Konzell and the responsible member of the executive board. This analysis was focused on all direct and indirect environmental aspects throughout the life cycle of our products. The results form the basis for the activities and measures in the context of our environmental management system. The high significance of product-related impacts has been continually increasing since the re-evaluation in 2019.



Determination and evaluation of environmental aspects



- 1 Recyclability of Bischof+Klein products
- 2 Raw materials – fossil
- 3 Raw materials – recyclates
- 4 Raw materials – renewable
- 5 Auxiliary materials
- 6 Energy – electricity/gas/oil
- 7 Water
- 8 Wastewater
- 9 Waste – hazardous/nonhazardous
- 10 Risk of (environmental) emergencies
- 11 Emissions – pollutants

- 12 Emissions – noise
- 13 Emissions – odor
- 14 Shocks
- 15 Radiation
- 16 Transportation/traffic
- 17 Impacts on biodiversity
- 18 Product-related impacts*
- 19 Impacts/behavior of service providers/external companies (e.g., maintenance, repair, new construction and conversion measures, etc.)
- 20 Recycling for raw material production

* Product-related impacts refer to: environmental impacts caused by product losses, recyclability of the empty packaging, environmental pollution caused by improper disposal of packaging waste (marine litter), etc.

Environmental aspects*

Process	Description	Significance
Product development and design (indirect) 	The development departments design the product, in close coordination with customers in some cases, to reliably protect the packaged product. Suitable raw materials are tested on laboratory systems, Bischof+Klein production lines, and customer lines (e.g., filling lines) in close coordination with suppliers.	Recyclability, fossil raw materials, recyclates, energy, waste, product-related impacts
Raw material procurement (indirect) 	The central purchasing department procures raw materials in coordination with the sales, development, and production departments. The main raw materials are polyolefins, produced using crude oil constituents.	Fossil raw materials, recyclates, transportation/traffic
Extrusion – film production 	PE granules are melted and homogenized in an electrically heated extruder. After emerging from the nozzle, the plastic solidifies on water-cooled rollers or by means of air cooling. The melt can either be blown out in the form of a tube using annular nozzles (blown film extrusion) or cast in the form of a flat sheet using wide-slit nozzles (cast film extrusion – Lengerich only).	Recyclates, fossil raw materials, energy, noise emissions
Gravure and flexographic printing 	Printing of paper or plastic with up to ten solvent-based or water-based colors using gravure printing (Lengerich only) or flexographic printing. The energy required to dry the ink is provided by production/heating oil which is heated primarily by a heat recovery system or – if further energy is required – using gas- or oil-fired boilers. All printing presses are subject to mandatory approval according to the Federal Immission Control Act (BImSchG).	Fossil raw materials, energy, emissions, waste, risk of (environmental) emergencies
Lamination/coating – production of laminates/surface protection films 	Depending on the intended purpose, material sheets are bonded using solvent-based, solvent-free, or water-based adhesives (adhesive lamination) or molten plastics (extrusion coating – Lengerich only) to manufacture holohedral laminates. The adhesive or surface protection films are manufactured via the holohedral application of a solvent- or water-based adhesive onto a plastic film. The lamination and coating lines are subject to mandatory approval according to the Federal Immission Control Act (BImSchG).	Fossil raw materials, energy, emissions, waste, risk of (environmental) emergencies

Process	Description	Significance
Conversion 	Mono films and laminates in the form of material on reels are adapted to customer requirements by cutting or sawing, or are processed to produce single- or multi- ply sacks and bags. The material sheets are formed into packaging on special machines by means of sealing, lasering, or gluing.	Waste, energy
Warehouse 	Raw materials, semi-finished, and finished products are stored in various warehouses at the plants. Solvent-based raw materials and other hazardous materials or hazardous waste are stocked in specially protected areas or tank farms. Storage tanks for liquefied gas are additionally located in both Lengerich and Konzell.	Risk of (environmental) emergencies
Air scrubbing 	Solvent-contaminated exhaust air from the drying processes is cleaned in thermally-regenerative oxidizers. In Konzell, a concentration wheel (duplex system) ensures constant and optimized combustion conditions in the air scrubbing system. At both plants, part of the energy which is released is recovered and used to heat the production/heating oil or for heating buildings. The emission limit values of the underlying permits apply and are monitored using measuring technology.	Emissions, energy



Process	Description	Significance
Recycling system 	Production of recyclates from mono film residues (Lengerich only).	Energy
Central supply facilities 	Bischof+Klein operates gas- and oil-fired heating systems in Lengerich and oil-fired heating systems in Konzell, a central compressed air generation system at both plants as well as cooling circuits and humidification systems for machines and hall areas.	Energy, water, noise emissions
Transportation/traffic (indirect) 	Service providers usually deliver raw, auxiliary, and process materials to the plants by truck. They use specific approaches defined away from residential areas to do this. Bischof+Klein uses industrial trucks with gas or electric motors for internal transportation between the production stages. Trucks are additionally used at Bischof+Klein Lengerich. Goods shipments are undertaken exclusively by haulage service providers. Due to poor local public transportation links, employees primarily use passenger cars to drive to work or – distance permitting – travel by bicycle. Company cars are available for business trips. Use of local public transportation takes priority here as per the internal regulations.	Energy, emissions
Implementation of third-party services (indirect) 	External companies and tradesmen perform servicing, maintenance, and construction work. Their employees are briefed on potential hazards and safety measures before starting work. This is confirmed by their signing a document. Bischof+Klein expects its contractors to provide well-trained personnel, something that is set down in the contract.	Effects of third-party services
Recycling/disposal of the products after use (indirect) 	Once the end consumer has used it, Bischof+Klein packaging is sent for material or energy recycling via take-back and recycling systems (e.g., dual systems); this occurs in the majority of cases in Germany and is frequently the case in Europe. In some European countries and outside of Europe, packaging waste is often dumped in landfill sites.	Recycling, product-related impacts



This part belongs to
Bischof+Klein SE & Co. KG.



This part belongs to
Bischof+Klein Holding SE & Co. KG.

* The production processes for manufacturing the packaging and films are described universally for Bischof+Klein SE & Co. KG at Bischof+Klein Lengerich and Konzell and for Bischof+Klein Holding SE & Co. KG (administration and central departments).



Our environmental performance

We optimize processes and products, as demonstrated by key figures and certifications.



Environmental performance that shows possible solutions

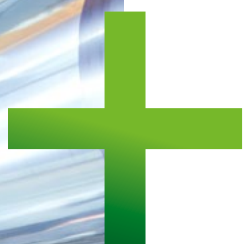
As a manufacturer of plastic packaging and technical films, we transform our responsibility into specific measures at both the product and the process level. The following examples document the status of our work.



Worldwide pollution of the environment due to waste that has been disposed of improperly has been the subject of increased public scrutiny in recent years. Increasing volumes of waste consisting of materials such as glass, metal, paper, plastics, or laminates are leading to problems in the oceans and on land. Due to their use in cosmetics or as a result of tire wear, large quantities of microplastics are also entering the environment and, in a second step, the food chain.

Plastic packaging is also part of the global waste problem. As a manufacturer, we are working to reduce our contribution to this problem by designing products that are more recyclable and by implementing more efficient processes.

We evaluate our environmental performance according to the categories of "product responsibility" and "energy and emissions" and also according to the further aspects of water consumption, noise protection, traffic, and contingency planning. These are shown in the following, broken down into the areas of "products" and "processes".



Environmental performance in the product area

Product responsibility: material input and recyclability

Packaging design and recyclability: developments at Bischof+Klein

Plastic packaging recycling is continuing to evolve in Germany. According to [sicherverpackt.de](https://www.sicherverpackt.de), around 71 % of plastic packaging put into the recycling bin were recycled in 2024. Separability remains a technical challenge for laminated packaging and beverage cartons. Items that are incorrectly disposed of in recycling bins, such as combustible rechargeable batteries, make sorting even more difficult.

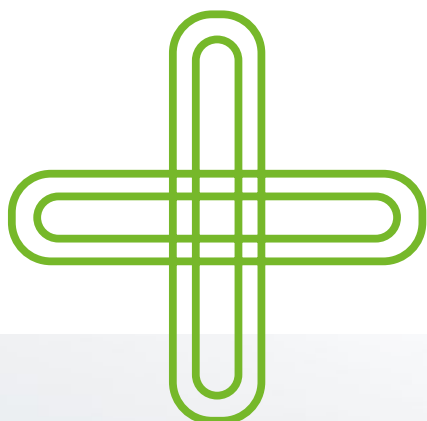
In multiple product lines, Bischof+Klein has switched the material structure to mono material laminates.

Two award-winning examples from our daily work:

U-Pack® for pet food (WorldStar Award, PackTheFuture Award): switch from PET-PE laminates to pure PE laminates while maintaining the technical barrier properties. This packaging is classified as recyclable according to cyclos-HTP criteria.

Barrier film for coffee (WorldStar Award): replacement of multi-material laminates with PE or PP laminates. The single-origin material structure improves the requirements for material recycling – the actual recycling rate depends on the available sorting infrastructure.

The EU Packaging and Packaging Waste Regulation (PPWR) will introduce binding requirements for the recyclability of packaging as of 2030. The above described material changes are aimed at meeting these regulatory requirements early on.



WorldStar Packaging Award 2025 for mono material packaging for coffee

Bischof+Klein won a WorldStar Packaging Award for its plastic packaging in the coffee segment in 2025. The World Packaging Organisation (WPO) award was won in the "Packaging Materials and Components" category. CSO Erik Edelmann and Sales Area Manager Italy Andrea Staltari accepted the award at an event in Milan.

"This award confirms our development team's work on mono material solutions for demanding barrier applications," said Erik Edelmann.

Bischof+Klein is an established supplier on the German coffee packaging market and manufactures films for applications ranging from coffee inner wrappers and vacuum packs to packaging for whole beans, up to and including pads and cappuccino sticks. Over the past few years, the company has been working systematically towards replacing non-recyclable laminate structures such as PET/ALU/PE or PETmet/PE with mono material laminates consisting of PE or PP.

The award-winning packaging is the result of this development work. It is based on a mono material laminate that combines product protection, durability, and outstanding barrier properties. One of the central challenges involved in this was to replace the aluminum with a recyclable barrier. To achieve this, Bischof+Klein uses alternative barriers that meet the requirements of the packaged products in long-term tests. In addition, the polyester printing substrate films have been replaced with elongated PE or PP films and the inner layers with PE or PP layers with a low sealing temperature in order to achieve the highest possible temperature difference between the outer and the inner layer. The laminates are available with or without metallization.



According to the cyclos-HTP Institute's standard, the mono material laminates achieve a recyclability rating of up to 95%. The troublesome materials PET and aluminum have been removed from the laminate, and the printing inks contain no nitrocellulose or carbon black. The remaining deductions are attributable to printing inks, adhesives, and any EVOH and peel additives that are present. The actual recycling rate is dependent on the collection and sorting infrastructure that is available in each case.

Bischof+Klein additionally offers the option of using ISCC PLUS-certified material – chemically recycled or bio-circular – in the laminates as per the mass balance. In the mass balance approach, the recyclate content is proportionally allocated across the total production volume; the physical recyclate content of individual items of packaging can deviate from this.

The WorldStar Packaging Award is presented each year by the WPO and honors packaging solutions that have already qualified in regional competitions.

Bischof+Klein receives Best Managed Companies Award 2025

Bischof+Klein received a Best Managed Companies Award in 2025. CEO Dr. Tobias Lührig (until 6/30/2025) and CSO Erik Edelmann accepted the award at an event in Frankfurt.

"For us, packaging is more than an outer shell – it protects products, informs consumers, and has to be designed so that it fits in with existing recycling systems. We are working towards evolving our solutions with a clear strategic framework," explained Dr. Tobias Lührig at the award ceremony.

The Best Managed Companies Award is an international quality program for medium-sized companies that was initiated by Deloitte in Canada in the 1990s and is now implemented in over 45 countries. The independent jury evaluates strategy, governance, employee development, and innovation.



We are working towards evolving our solutions with a clear strategic framework.

ISCC PLUS certification: mass balancing of input materials

Bischof+Klein is certified according to the ISCC PLUS (International Sustainability and Carbon Certification) standard. ISCC PLUS is an independent certification system that defines requirements for the traceability of input materials based on the mass balance.

Both German production plants have been certified by SGS: Lengerich (certificate ISCC-PLUS-Cert-DE100-11658126) and Konzell (certificate ICSS-PLUS-Cert-DE100-11659126), each valid until January 2027.

The certification confirms that Bischof+Klein meets the ISCC PLUS requirements for the documentation and mass balancing of its input materials. This means that certified raw materials – such as bio-based or recycled plastics – along the supply chain can be proportionally allocated to the end product.



Recyclate rather than new materials – PCR contents in Bischof+Klein packaging

Use of recyclate in packaging production

At both Bischof+Klein Lengerich and Konzell, the company is showing how post-consumer recyclates can be used successfully in packaging production. Our plants focus on efficient processes, high-quality recyclates, and tested quality.

Both production plants have been certified by PlastCert according to RecyClass for the production of defined products with a certified recyclate content: Lengerich (certificate RC442-BPK-08-26-PLS-KH) and Konzell (certificate RC195-BPK-08-26-PLS-KH), each valid until August 2026.

At Bischof+Klein Konzell, we produce printed bags with a PCR content of up to 70% – while maintaining the same functionality and brand impact.

In Lengerich, we produce surface protection films with a PCR content of up to 40%; these combine reliable protection with reduced primary raw material input.

Bischof+Klein therefore offers its customers demonstrable progress in the use of recycled materials – a documented step towards the use of post-consumer recyclates in our production segment.



Environmental performance in the process area

Reducing primary raw material input thanks to raw material cycles

Using raw materials sparingly, recycling residual materials wherever possible, reducing emissions, saving energy: These are the principles according to which we structure our production processes.

Material cycles at both Bischof+Klein Lengerich and Konzell are closed thanks to the distillation of printing ink and solvent waste. The solvent recovered in this way is primarily used for cleaning machines and parts. In the reporting year, 4.3% of requirements in Lengerich (2024: 3.8%) and 16.5% in Konzell (2024: 19.4%) were met with recovered solvent. Natural gas was also saved in Lengerich by injecting recovered solvent into the air scrubbing system.

We record nonhazardous production waste separately in a collection system encompassing 28 material groups so that they can be recycled properly. This detailed recording enables a high recycling rate of 95.7% in Lengerich and 95.0% in Konzell. At Bischof+Klein Lengerich, some of the polyethylene production waste is processed internally to produce recyclate and then sold on the secondary

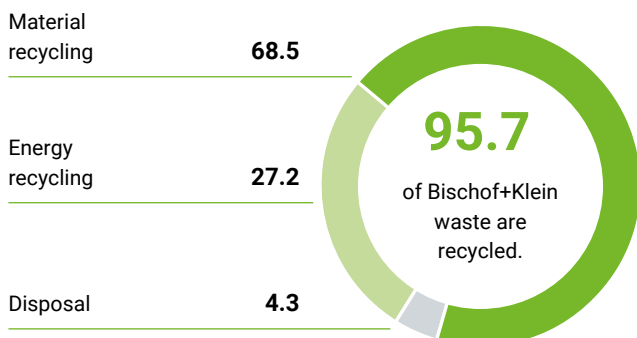


The recording of nonhazardous production waste in a collection system encompassing 28 material groups enables proper recycling

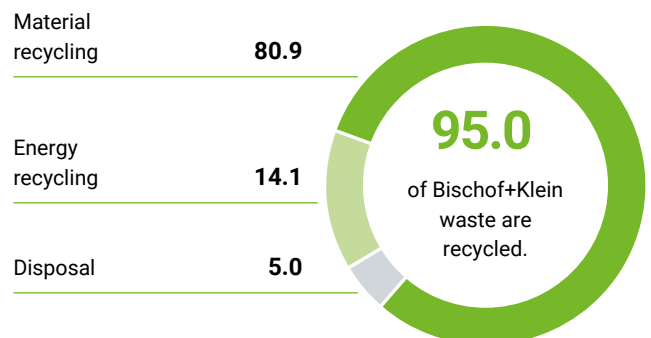
raw materials market or reused in our own products. We forward hazardous waste exclusively to certified specialist disposal companies according to the statutory requirements. The rate of material recycling during the reporting year was 68.5% in Lengerich (2024: 69.9%) and 80.9% in Konzell (2024: 84.6%).

Recycling of Bischof+Klein waste in 2025

Bischof+Klein Lengerich in %



Bischof+Klein Konzell in %



Cleanliness and care as a prerequisite

We motivate our employees to carefully separate waste and to avoid material losses:

- + Participation in the association initiative "zero pellet loss"
- + Technical measures that prevent granules used in production from entering the environment
- + Bischof+Klein again organized a clean-up day in 2025: Trainees and employees collected garbage in the public area around the plant premises. The neighboring local senior high school once again took part. Its pupils collected waste in the area surrounding the school and on the paths leading to Bischof+Klein. Bischof+Klein additionally conducted a presentation on the advantages and disadvantages of plastic packaging.

Diverse measures for reducing energy consumption

Reducing energy consumption is a central lever for decreasing our greenhouse gas emissions. Processed centrally by the energy officers at the plants and our energy teams, and with the support of external service providers and institutions, our focus still remains set on:

- + optimizing the use of cold and cooling water
- + increasing the heat recovered from the air scrubbers
- + the energy-efficient centralization of supply facilities
- + extending combined, plant-wide networks

By means of ongoing process optimizations and targeted energy saving measures, we are working towards further reducing our energy consumption and the related emissions. The key figures from page 26 onwards show how we are doing in this regard.



Reducing energy consumption is a central lever.

Among others, the following energy efficiency measures were implemented in 2025:

- + Lengerich: renewal of the heating technology and replacement of the chimney in a boiler house
- + Lengerich: optimization of the heating circuits by connecting the heating systems
- + Lengerich: measuring technology is being used to systematically trace and eliminate compressed air leaks
- + Konzell: reduction of production scrap and therefore energy by using an edge strip extruder



Investments that reduce emissions

We are gradually switching our production processes to solvent-free printing ink and adhesive systems. Bischof+Klein is working towards minimizing diffuse VOC emissions when using solvents.

- + During the reporting year, the thermally-regenerative air scrubbing systems achieved an average annual value of $3\text{mg/m}^3 \text{ C}_{\text{tot}}$. The statutory limit value is a daily average of 20mg/m^3 .
- + The network of water, electricity, and other media meters was extended to over 500 measuring points. It is to be successively extended over the coming years.

Since 2011, Bischof+Klein has been using a bonus/malus system for the use of company cars in order switch the vehicle fleet over to lower-emission vehicles.

The malus payments are additionally donated to the "I Plant A Tree" organization. Together with the 2025 Christmas tree planting campaign, a total of 16,757 trees have been planted; according to Stiftung Unternehmen Wald, comparable mixed forests in Germany bind an average of 10 – 25 kg CO₂ per tree per year, irrespective of tree species, age, and location. As some of the trees that have been planted are only a few years old, the amount of CO₂ that has actually been bound so far is lower than the long-term average – a reliable overall balance is only possible after several decades. The trees that have been planted are not counted towards our scope 1/2/3 reduction targets.

Further environmental aspects

Water consumption: Compared to the previous year, water consumption in Lengerich decreased significantly by around 14,000m³. This is primarily attributable to the low outside temperature, a slight decline in production, and, above all, the optimization of the re-cooling plants.

Water consumption in Konzell again fell by around 1,000m³ compared to the previous year.

The water required for production and the social areas at both plants is obtained exclusively from the local utility companies. Around 38 % of the water consumed in Lengerich and 40 % of that used in Konzell evaporate during air humidification in the plant halls or in the cooling processes. Clean evaporation water was therefore released back into the atmosphere.

Noise protection: As Bischof+Klein Lengerich is located in the immediate vicinity of a residential area, protecting residents from disturbances caused by noise is of particular importance here. Bischof+Klein is working continuously on a systematic noise baffling concept for which specialists are identifying noise emissions and their sources – for both new and existing equipment. Three complaints concerning noise were received from residents in 2025. These were cleared up through technical and organizational measures.

No complaints about noise were received in Konzell in 2025.

Contingency plan: Bischof+Klein stores and processes numerous combustible materials, which necessitates corresponding contingency planning for emergencies.

If necessary, thermal, optical, and mechanical fire alarm sensors supply 24/7 information to central hazard alarm systems and support comprehensive monitoring.

Universal sprinkler and gas extinguishing systems in relevant production and storage areas automatically extinguish fires even as they are breaking out and therefore ensure a high level of fire safety.

Sewer shut-off systems and inlet covers as well as absorptive materials at relevant points throughout the plant premises serve to protect the environment from escaping water-endangering fluids. Our contingency concept with a constant standby team includes well-trained employees and specialists from critical areas throughout the company. An emergency folder containing all important information on particular hazards, internal and external contact persons, and overview plans is available.

The crisis management team members in Lengerich have been using the DIVERA 24/7 smartphone app since 2025, enabling them to respond even faster in the event of relevant incidents. In 2025, hydrant function and performance tests, evacuation exercises, and emergency training courses were conducted in Lengerich and the evacuation alarm was tested throughout Bischof+Klein Lengerich. The annual fire department inspection was conducted with the entire Lengerich fire house and delegations from the Federal Agency for Technical Relief (THW) and the German Red Cross. Parts of the fire alarm system were additionally renewed.



Our key environmental data in detail

We bear responsibility for our actions as a company. We therefore consistently monitor and document the parameters of material areas in which Bischof+Klein impacts on the environment.

Each year, we collate all quantitatively measurable environmental impacts at our plants in the Bischof+Klein input/output statement. This serves as the basis for assessing our environmental performance. The statement is compiled using data from process data recording, meter and invoicing data as well as weighing slips. Direct greenhouse gas and pollutant emissions are determined using emission factors from the GEMIS database (version 5.0) on the basis of consumption figure measurements. Values based on the electricity mix which is supplied are available to us from our electricity suppliers for indirect greenhouse

gas emissions. The key figures which are determined are evaluated in absolute terms and with reference to the location in comparison with the previous year as part of the management review. Comparison of these core indicators in accordance with EMAS Regulation 1221/2009 (EMAS III) only enables limited conclusions to be drawn due to constantly changing product structures and conversion levels at Bischof+Klein. Direct comparison of the core indicators with companies in the same or other industries is not possible due to divergent production processes and techniques.

Input

	Lengerich			Konzell		
	2023	2024	2025	2023	2024	2025
Raw materials (such as granules, paper, aluminum, printing inks, adhesives, solvents, etc.) [t]	45,778	49,303	48,773	43,490	43,260	40,812
Of which non-renewable raw materials [t]	43,199	47,989	47,480	38,810	37,401	34,856
Spec. raw material use [t/t]	1.35	1.35	1.36	1.42	1.43	1.48
Transportation packaging material [t]	5,567	5,302	4,590	3,915	3,822	3,655
Water [m³]	32,254	39,556	24,860	11,429	11,299	10,320
Spec. total water consumption [m³/t]	0.87	1.00	0.64	0.37	0.37	0.37
Energy [MWh]	70,483	71,812	70,940	39,638	36,711	38,705
Of which electricity [MWh]	49,761	46,369	45,585	36,519	33,878	34,881
Of which gas/oil/power gas [MWh]	20,722	25,442	25,355	3,119	2,833	3,824
Spec. total energy consumption [MWh/t]	1.91	1.81	1.83	1.29	1.21	1.40
Volume of renewable energy [MWh]	28,463	27,219	24,023	36,519	19,886	18,382
Percentage of renewable energy in total energy consumption [%]	40	38	34	92	54	47
Total area usage [m²]	206,220	206,220	206,220	120,476	120,476	120,476
Percentage of paved areas (buildings, traffic areas) [%]	68	68	68	58	58	58
Percentage of unpaved areas (green areas, others) [%]	20 ¹	20 ¹	20 ¹	14 ¹	14 ¹	14 ¹
Percentage of semi-natural areas (ditch, extinguishing pond, forest) [%]	12 ¹	12 ¹	12 ¹	28 ¹	28 ¹	28 ¹

Output

	Lengerich			Konzell		
	2023	2024	2025	2023	2024	2025
Finished product [t] (incl. recycle) ²	36,958	39,688	38,744	30,671	30,305	27,548
Non-hazardous waste [t] (plastics/plastic laminates, paper, other waste such as wood, metals, industrial waste, etc.)	7,751	8,231	7,945	8,013	6,808	6,558
Spec. occurrence of nonhazardous waste [t/t]	0.23	0.23	0.22	0.26	0.22	0.24
Hazardous waste [t] (printing ink and adhesive residues, distillation sludges, absorptive materials, used lyes, rinsing water, processing emulsions, oil separator contents, used oil, lead batteries, spray cans, contaminated packaging, insulating material)	725	742	777	723	867	940
Spec. occurrence of waste (hazardous waste) [t/t]	0.02	0.02	0.02	0.02	0.03	0.03
Total waste [t] ³	8,476	8,973	8,722	8,736	7,675	7,498
Of which composting [t]	25	24	13	16	17	16
Of which reuse [t]	0	0	0	0	0	0
Of which recycling [t]	4,457	4,897	4,655	7,495	6,298	6,011
Of which recovery [t]	4	29	15	98	179	39
Of which thermal recycling [t]	3,102	3,161	3,183	841	871	1,056
Of which other recycling [t]	690	360	356	0	0	0
Of which combustion (disposal) [t]	173	143	156	283	301	371
Of which other disposal [t] ⁴	21	358	341	2	8	5
Of which depositing [t]	4	1	2	1	1	2
Waste water [m³] ⁵	14,508	18,081	14,461	6,674	6,814	5,799
Emissions [t]						
Total greenhouse gas emissions CO₂ eq [t] ⁶	25,267	27,036	83,722	4,035	14,142	40,496
Of which from combustion processes (primary energy, solvents from air scrubbing, plant traffic) [t]	11,631	12,891	14,445	3,957	3,841	4,049
Of which due to use of electricity (indirect) [t]	13,535	14,096	16,684	0	10,299	12,767
Of which from refrigerant losses [t] ⁷	101	49	389	78	2	139
Spec. total greenhouse gas emissions [t/t]	0.68	0.68	0.81	0.13	0.47	0.62
Emissions along the value creation chain	–	–	52,243 ⁸	–	–	23,540 ⁸
Total pollutant emissions into the air [t]	125	166	181	247	269	281
Of which VOC [t]	105	149	170	246	268	280
Of which carbon monoxide (CO) [t]	15.5	13.7	7.3	0.1	0.1	0.2
Of which nitrogen oxides (NO _x) [t]	4.1	3.7	3.9	0.4	0.3	0.4
Of which sulfur dioxide (SO ₂) [t]	0.1	0.0	0.0	0.3	0.3	0.3
Of which particulates [t]	0.00	0.00	0.00	0.01	0.01	0.01
Spec. total pollutant emissions into the air [t/t]	0.003	0.004	0.005	0.008	0.009	0.010

1 Re-evaluated.

2 In addition to packaging materials and films, the recyclates produced from film residues are also contained in the finished product.

3 All waste for which Bischof+Klein is defined as the waste producer is recorded.

4 Other disposal: chemical/physical treatment, fermentation, soil treatment.

5 Indirect routing to the communal sewage works.

6 No additional greenhouse gases such as methane (CH₄), nitrous oxide (N₂O), perfluorocarbons (PFC), partly fluorinated chlorinated hydrocarbons (HCFC),

nitrogen trifluoride (NF₃), or sulfur hexafluoride (SF₆) are emitted as a result of our production processes.

7 Emissions of fluorinated refrigerants (as per the German Chemicals Climate Protection Ordinance (ChemKlimaschutzV)) from cooling and refrigeration systems.

8 First recorded for the base year 2025 with material emissions from: purchased goods and services, fuel- and energy-related activities, transport and sales, waste incurred within the company.



Our environmental program

We set ourselves
quantified goals and
report transparently
on our progress.



Our environmental program

The fifth environmental program from Bischof+Klein contains the economic, ecological, and social objectives and measures for the company's individual divisions and departments for the 2023 to 2025 period. These have been defined based on the company's strategic goals.

The environmental program for the 2023 to 2025 period commenced in 2023 with 35 goals and respective measures. So far, the program has been extended by an additional goal for reducing emissions. The implementation status will be evaluated once a year in the management review by the executive board.

The following lists show an excerpt of the Bischof+Klein environmental program from the areas of ecology and the environment.



Ecological objectives

Bischof+Klein Lengerich

Aspect	Objective	Measures	Date	Responsible	Status	Remark
Waste	Reduction of adhesive and printing ink waste containing solvents by 20%	Installation of an additional distillery for solvent-based adhesives and printing inks	2026	Supply technology		
Energy	Reduction of electricity consumption for generating low temperatures by 15%	Extension of central cooling system T6 incl. installation of an adsorption chiller for converting the thermal energy from exhaust air to low temperatures during the summer months	2026	Supply technology	In progress	
	Reduction of gas consumption for heating by 50%	New German Clean Air Act-compliant heating technology incl. piping and shutting down the central heating system at gate 5; operation of the plant 1 heating system only as required	2026	Facility management		
	Reduction of the amount of natural gas needed at air scrubbing system TNV 2	Establishment of solvent injection at TNV 2	2026	Supply technology	In progress	
	Reduction of the amount of energy needed for central cooling system tower 2	Conversion of central cooling system tower 2 by fitting a heat pump	2026	Supply technology	In progress	
	Reduction of the amount of natural gas needed by converting the central supply system	Heating line between P3 and the Lotz hall	2026	Supply technology		
	Increase in the percentage of regenerative energy to > 100%	Use of electricity from renewable energies	2026	Purchasing		
Recycles	Increase in the internal use of PIR by 400t/a	Reggranulation of self-adhesive film; use of PIR in hygiene products	2026	Production		



Ecological objectives

Bischof+Klein Konzell

Aspect	Objective	Measures	Date	Responsible	Status	Remark
Energy	Reduction of dependence on fossil fuels	Optimization of heat recovery and the use of centralized/ decentralized heat supply, etc.	2026	Supply technology	In progress	
	Purchasing regionally generated electricity	Power purchase agreement (PPA), ideally with the neighborhood, to stabilize prices and support decarbonization	2026	Technology		
	Reduction of primary energy requirements and CO ₂	Establishment of the heat pump strategy	2026	Supply technology	In progress	
	Use of waste wood to generate energy	Feasibility study on the use of up to 350t waste wood per year to generate energy	2026	Supply technology	In progress	
	Increase in the percentage of regenerative energy to > 100%	Use of electricity from renewable energies	2026	Purchasing		
Product	Switch of an additional 5 hygiene market customers to 60% PCR	Development of a film for all applications with a PCR content of 60%	2026	Sales/innovation	In progress	
Recyclates	Recycling of scrap through regranulation	Establishment of a new regranulation line, whereby twice the volume of production scrap is to be regranulated	2026	Production	In progress	



Glossary

Regulations and standards

AwSV

German Regulation on Facilities for Handling Substances that are Hazardous to Water.

BImSchG

Federal Immission Control Act: act protecting against harmful environmental impacts caused by air pollution, noise, shocks, and similar processes.

BRC/IoP

The BRC/IoP hygiene standard for assuring the quality of packaging materials is the result of cooperation between the British Retail Consortium (BRC) and the Institute of Packaging (IoP). It is aimed at manufacturers of foodstuff packaging and is certified by accredited institutions.

ChemKlimaSchutzV

German Chemicals Climate Protection Ordinance: ordinance for the protection of the climate from changes due to the entrainment of certain fluorinated greenhouse gases.

CLP Regulation

Regulation (EC) No. 1272/2008 of the European Parliament and of the Council of December 16, 2008 on the classification, labeling, and packaging of substances and mixtures.

EMAS III

Eco-Management and Audit Scheme: general designation of Regulation (EC) No. 1221/2009 of the European Parliament and of the Council dated November 25, 2009 pertaining to the voluntary participation of organizations in a community environmental management and corporate environmental auditing system in combination with Regulation (EU) No. 2017/1505 and Regulation (EU) No. 2018/2016.

German Commercial Waste Ordinance

Ordinance on the management of commercial urban waste and certain types of construction and demolition waste.

KrWG

German Circular Economy Act: Act to Promote Circular Economy and Safeguard the Environmentally-compatible Management of Waste.

LFGB

The German Food and Feed Code (LFGB) is the umbrella law of German food law. Its purpose is to ensure the protection of consumers by preventing or averting a danger to human health. It encompasses all production and processing stages along the food value chain and also applies to animal feed and cosmetics in addition to food and consumer goods.

PPWR

Packaging and Packaging Waste Regulation: EU regulation that defines requirements for the design, recyclability, and reuse of packaging in order to reduce packaging waste.

REACH Regulation

Regulation (EC) No. 1907/2006 of the European Parliament and of the Council of December 18, 2006 concerning the Registration, Evaluation, Authorization, and Restriction of Chemicals (REACH), establishing a European Chemicals Agency.

TA Luft (German Clean Air Act)

Technical Instructions on Air Quality Control: First General Administrative Regulation Pertaining to the Federal Immission Control Act. The Technical Instructions serve to protect the general public and the neighborhood against the harmful effects of air pollution. Among other items, they contain calculation regulations for significant air pollutants and establish uniform Federal requirements for systems which require approval according to the Ordinance on Installations Requiring a Permit.

VOC Ordinance

Ordinance on the Limitation of Emissions of Volatile Organic Compounds Due to the Use of Organic Solvents in Certain Installations – 31st BImSchV.

WHG

Federal Water Act: Water Resources Management Act.

Miscellaneous

Binding obligations

The term binding obligations includes legal obligations and other requirements that may arise, for instance, from the requirements of the company's stakeholders.

Carbon footprint

The carbon footprint is a measure of the greenhouse gas emissions of products and services, etc.

Context of the organization

The context of the organization within the meaning of the EMAS or ISO 14001:2015 includes relevant internal and external topics (e.g., environmental conditions or events, political, economic, or social factors) that influence the continuous improvement of the environmental management system. These influencing factors have to be systematically recorded and evaluated.

Convenience

Consumer friendliness.

Demographics

Development of populations and their structures.

Emissions

Solid, liquid, or gaseous substances as well as noise, heat, and radiation that are emitted into the environment.

Environmental aspects (direct/indirect)

Environmental aspects are all activities, services, and products which emanate from a company and which have a significant impact on the environment. Direct aspects can be directly influenced by the company; indirect aspects can only be controlled to a limited extent.

Environmental impacts

Environmental changes which are the result of a company's activity, product, and/or service.

Environmental performance

The measurable results of the management of an organization's environmental aspects by this organization.

FDA

The U.S. Food and Drug Administration (FDA) is the United States food monitoring and drug authority.

GEMIS

The Global Emission Model for Integrated Systems (GEMIS) is a computer model with integrated database for analyzing energy and material flows. The model performs a life cycle analysis for various processes and scenarios and provides key data for pollutant and greenhouse gas emissions, among others.

Stakeholder

Groups or individual persons who are extensively affected by the activities, products, and/or services of the company or who are themselves able to extensively influence the management of the company.

Validation

Declaration of validity by a registered environmental expert.

VOC

Volatile Organic Compounds: volatile organic carbon compounds (e.g., organic solvents).

Environmental expert's declaration

regarding the appraisal and validation activities

On behalf of the KPMG Cert GmbH environmental expert organization, registration number DE-V-0328, the undersigned, Georg Hartmann, EMAS environmental expert with registration number DE-V-0245, in cooperation with Dr. Ulrich Wilcke, EMAS environmental expert with registration number DE-V-0297, accredited or registered for the area of NACE code 22.22 (manufacture of plastic packing goods), confirms that he has appraised whether the plants or the entire organizations, as specified in the environmental statement of the organizations Bischof+Klein SE & Co. KG and Bischof+Klein Holding SE & Co. KG, registration number DE-156-00009, meet all of the requirements of Regulation (EC) No. 1221/2009 of the European Parliament and of the Council dated November 25, 2009 pertaining to the voluntary participation of organizations in a community environmental management and corporate environmental auditing system (EMAS) in combination with Regulation (EU) No. 2017/1505 and Regulation (EU) No. 2018/2016.

On signing this declaration, it is confirmed that:

- + the appraisal and validation have been carried out in full compliance with the requirements of Regulation (EC) No. 1221/2009 in combination with Regulation (EU) No. 2017/1505 and Regulation (EU) No. 2018/2016.
- + there is no evidence of nonadherence to the applicable environmental regulations.
- + the data and information contained in the environmental statement for the organizations provide a reliable, credible, and truthful portrayal of all of the organizations' activities within the scope specified in the environmental statement.

This statement cannot be equated to EMAS registration. EMAS registration can only be carried out by a competent body pursuant to Regulation (EC) No. 1221/2009 in combination with Regulation (EU) No. 2017/1505 and Regulation (EU) No. 2018/2016. This statement may not be used as an independent basis for public information.

Lengerich, May 2026

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