



INDIANA ENVIRONMENTAL STEWARDSHIP PROGRAM ANNUAL PERFORMANCE REPORT

State Form 53475 (R7 / 2-21)

INDIANA DEPARTMENT OF ENVIRONMENTAL MANAGEMENT
ENVIRONMENTAL STEWARDSHIP PROGRAM

Indiana Department of Environmental Management
Office of Program Support
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Indianapolis, IN 46204-2251
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Please use this form if you are a member of the Indiana Environmental Stewardship Program (ESP) to report on progress toward objectives and targets AND certify ESP requirements continue to be achieved. Indiana ESP facilities must submit an Annual Performance Report (APR) by April 1st of every year, for each calendar year in which the entity has been a member for at least three (3) full months. Membership terms are renewed every four (4) years through submitting your APR. Your APR should be reviewed and signed by a senior manager at your facility prior to submittal. Once signed, e-mail the APR to IDEM at esp@idem.IN.gov. Please do not include any confidential business information in your annual performance report. Public access laws require IDEM to make the APR publicly available, which may include posting all portions of your report on the Indiana ESP Web site. If you have any questions, please contact IDEM at esp@idem.IN.gov or (800) 988-7901.

This form will also be used for ESP members who are also members of the Indiana Partners for Pollution Prevention Program to recertify their membership and reaffirm their commitment to the Partners Pledge.

SECTION A

FACILITY INFORMATION

Name of facility

Toyota Boshoku Indiana

Name of parent company (if applicable)

Toyota Boshoku America

Street address (number and street)

1698 S 100 W

City / State / ZIP code

Princeton IN 47670

County

Gibson

Website of facility / company

www.tbprinceton.com

How many employees (full time equivalents) currently work at your facility?

1215

CONTACT INFORMATION

Name of Primary Contact (Mr. / Mrs. / Ms. / Dr.)

Philip Alvey

Title

EHS Manager

Telephone number

(812) 632-8868

FAX number

(812) 491-9101

E-mail address

philip.alvey@toyota-boshoku.com

Mailing address (if different from facility address)

City / State / ZIP Code

Name of Secondary Contact (Mr. / Mrs. / Ms. / Dr.)

Mary Carner

Title

EHS Specialist

Telephone number

(812) 632-1653

FAX number

(812) 491-9101

E-mail address

mary.carner@toyota-boshoku.com

Mailing address (if different from facility address)

City / State / ZIP Code

REPORTING PERIOD

Reporting period dates from prior calendar year (mm/dd/yyyy – mm/dd/yyyy)

04/01/2020-3/31/2021

1a. Is this the fourth ESP Annual Performance Report of your membership term?

☐ Yes—If yes, answer question 1b.

☒ No—If no, skip to the "Change in Information" section of this report.

1b. Do you wish to renew your Indiana Environmental Stewardship Program membership?

☒ Yes—If yes, please complete all sections of this annual report.

☐ No—If no, please complete all sections of this annual report except for Section F.

2a. Are you a member of the Indiana Partners for Pollution Prevention (Partners) Program?

☒ Yes—If yes, answer question 2b.

☐ No—If no, skip to the "Change in Information" section of this report.

REPORTING PERIOD (CONTINUED)

2b. Do you wish to recertify your Partners for Pollution Prevention (Partners) Pledge?

☒ Yes—If yes, please complete all sections of this annual report.

☐ No—If no, please complete all sections of this annual report except for Section F.

CHANGE IN INFORMATION

In your ESP application and, perhaps, in previous annual performance reports, you described what your facility does or makes. Have there been any changes or additions to your facility's list of products or activities?

☐ Yes—If yes, please describe them: _____

☒ No

SECTION B

PUBLIC OUTREACH AND PERFORMANCE REPORTING

Why do we need this information?

IDEM needs to know how environmental information was shared with the public.

What do you need to do?

Describe how the facility has shared and plans to share environmental information.

Please briefly describe the activities that your facility conducted during this reporting period to interact with the community on environmental issues and to report publicly on its environmental performance. Welding, Stamping, Pipe and wire bending and urethane cushion manufacturing, seat and door assembly, Injection Molding

Please indicate which of the following methods your facility plans to use to make its ESP Annual Performance Report available to the public. Please check as many as appropriate.

☐ Web site (<http://www.>) ☐ Open house ☐ Meetings ☐ Press releases ☒ Other Provided upon request, and through the IDEM programs

SECTION C

ENVIRONMENTAL MANAGEMENT SYSTEM ASSESSMENT

Why do we need this information?

Facilities need to have implemented an EMS that meets certain criteria and use an ISO 14001 EMS Lead Auditor at least every thirty-six (36) months to assess the EMS.

What do you need to do?

Answer the following questions about your EMS.

1. What is the most recent date that an ISO 14001 EMS Lead Auditor performed an EMS assessment at your facility? July 29th, 2020

2. Name, title, and organization of ISO 14001 EMS Lead Auditor who conducted the most recent EMS assessment: George Herald, NSF lead auditor, NSF

3. Is the date of the most recent EMS assessment performed by an ISO 14001 EMS Lead Auditor within the past thirty-six (36) months?

☒ Yes—If yes, skip to Question 4.

☐ No—If no, please have your ISO 14001 EMS Lead Auditor complete and sign the following checklist, indicating whether or not your EMS meets the listed criteria for ESP membership:

- | | |
|--|---|
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Evidence of senior management support, commitment, and approval. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | A written environmental policy directed toward compliance, pollution prevention, and continuous improvement. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Identification of the environmental aspects at the entity. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Prioritization of the environmental aspects and a determination of those aspects deemed significant considering, at the minimum, environmental impacts and applicable laws and regulations. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Established priorities, and environmental objectives and targets for continuous improvement in environmental performance and for ensuring compliance with applicable environmental laws, regulations, and permit conditions. Objectives and targets must go beyond current legal requirements and specify the environmental media, types of pollution to be prevented or reduced, implementation activities, and projected time frames. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | An established community outreach mechanism that includes identifying and responding to community concerns; informing the community of important matters that affect the community; and reporting on the EMS, including reporting to the public on the environmental policy and significant aspects. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Incorporation of environmental and pollution prevention planning in the development of new products, processes, and services and modifications of existing processes. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Evidence of clear responsibility for implementation, training, monitoring, EMS maintenance, taking corrective action, and ensuring compliance with applicable environmental laws, regulations, and permit conditions. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Documentation of the implementation procedures and the results of implementation. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | Appropriate written EMS procedures. |
| <input type="checkbox"/> Yes <input type="checkbox"/> No | An annual evaluation of the EMS with written results provided to senior management and affected employees. |

Most current NSF audit attached

Signature of ISO 14001 EMS Lead Auditor

Date (month, day, year)

SECTION C

ENVIRONMENTAL MANAGEMENT SYSTEM ASSESSMENT
CONTINUED

4. Were any deficiencies found during the most recent EMS assessment?

☐ Yes—If yes, describe any deficiencies found and the corrective action taken to address each deficiency: _____

☒ No

5. What type of protocol was used to perform the independent EMS assessment?

☒ ISO 14001:2015 Certified audit

☐ ESP Independent Assessment Protocol

☐ Other (please specify): _____

6. Is the EMS certified to a recognized standard?

☒ Yes—If yes, what standard does the EMS follow (please provide a copy of the most recent certificate)?

☒ ISO 14001:2015

☐ Responsible Care EMS

☐ Responsible Care 14001

☐ No

7. When was the last Senior Management review of your EMS completed?

Month / Year: 04/2020

Who headed the review (name and title)? Philip Alvey EHS Manager

8. When did your facility last conduct an internal or corporate environmental compliance audit? Do not include inspections or site visits by regulatory organizations.

Scope of the compliance audit: TNACompliance Audit

Month(s) / Year(s): Feb-2021

Who conducted the audit(s) (e.g., facility staff, corporate, third party)? TBA Scott Smith

9. Explain the emergencies experienced within the facility during the past year. Were the applicable emergency and contingency plans detailed in the EMS effective? What changes, if any, have been made to your facility's emergency or contingency plans?

No emergencies took place at TBIN in 2020.

10. Has your facility corrected all instances of potential environmental non-compliance and EMS non-conformance identified during your audits and other assessments?

☐ Yes—If yes, briefly summarize corrective actions taken and other improvements made as a result of your EMS assessment(s) or compliance audit(s).

☐ No—If no, please explain your plans to correct these instances.

☒ No such instances identified.

NSF ISO14001-2015 External audit had zero non conformances. TBA corporate audit also had zero compliance non conformances.

SECTION D

ADDITIONAL INFORMATION

Why do we need this information?

This information will help IDEM to effectively manage the Environmental Stewardship Program.

What do you need to do?

Answer the questions as completely as possible.

1. In addition to ESP, please list environmental awards received or voluntary programs participated in during the past twelve (12) months.

N/A

2. Has your facility taken advantage of any ESP incentives? If so, please describe the implementation process and list additional benefits IDEM should consider.

Not as of this time

3. If your facility was not registered to the ISO 14001 standard prior to becoming an ESP member, has ESP helped you to pursue registration? If so, how has ESP been instrumental in achieving registration?

IDEM ESP program was instrumental in getting our Environmental Program in compliance and our ISO14001:2015 program when we joined the program.

4. Are the ESP and/or Partners group meeting your expectations? Please provide feedback or suggestions.

Yes. 2020 has been a tough year for all of us with the COVID restrictions , But the ESP / Partners program is a great resource and program for Indiana businesses.

SECTION D

ADDITIONAL INFORMATION (CONTINUED)

5. If you are a member of Partners, please reaffirm your facility's or organization's pledge to the Partners and provide additional information regarding commitment to pollution prevention (P2).

Yes	No	
<input checked="" type="checkbox"/>	<input type="checkbox"/>	1. Ensure employees are aware of the facility's commitment to P2 and understand their role in implementing P2 objectives and goals in the facility.
<input checked="" type="checkbox"/>	<input type="checkbox"/>	2. Your facility has incorporated P2 planning in the development of new products, processes, and/or services.
<input checked="" type="checkbox"/>	<input type="checkbox"/>	3. Your facility established a mechanism to monitor waste generation and identify realistic P2 goals.
<input checked="" type="checkbox"/>	<input type="checkbox"/>	4. Your facility has established a process to listen and respond to stakeholder concerns.
<input checked="" type="checkbox"/>	<input type="checkbox"/>	5. Your facility makes available your general waste reduction and P2 information to members of our community, IDEM, and the Partners, if requested?
<input type="checkbox"/>	<input checked="" type="checkbox"/>	6. Your facility has participated in or conducted outreach activities that include details of your P2 efforts; please specify: _____
<input checked="" type="checkbox"/>	<input type="checkbox"/>	7. Your facility has participated in two or more Partners meetings in the last year.
<input type="checkbox"/>	<input checked="" type="checkbox"/>	8. Your facility supported the annual Pollution Prevention Conference and Trade Show. Please check all that apply: <input type="checkbox"/> Financial sponsorship <input type="checkbox"/> One or more attendees from your facility <input type="checkbox"/> Other (specify) _____

SECTION E

ENVIRONMENTAL IMPROVEMENT INITIATIVE RESULTS

Why do we need this information?

Facilities need to share the results of the environmental improvement initiative that was pursued during the reporting period. IDEM needs to report cumulative program reduction results.

What do you need to do?

Reference Section F for "Category" and "Indicator" options to complete this section. Summarize your facility's progress on achieving the initiative you identified in the application or last year's APR. For assistance, please call (800) 988-7901 or email esp@idem.IN.gov.

Initiative #1

Category 1: Air Emissions Indicator 1:	Baseline (indicate measurement unit)	Current (indicate measurement unit)	Cost Savings
Calendar year	2020	2020	
Actual quantity (per year)	12137	11857	\$36,820
Production unit (select one)	Earned Labor Hours Other -- specify (e.g. Gallons, length, etc.)	Production units Production lbs.	
Production Quantity	184291	145453	NA
Normalization factor (Current year production ÷ Baseline year production) .79			
Normalized quantity (Actual current year quantity - Actual baseline quantity) x Normalization factor -34,566			
Briefly describe how you achieved improvements for environmental initiative #1 or, if relevant, any circumstances that delayed progress. COVID caused plant closure for 6 weeks. Plant installed LED lighting in the parking and shipping areas outside of the plant, new equipment more energy efficient. Removal and replacement of water based chiller for more energy efficient air to air chiller.			

Initiative #2

Category 2: Waste Indicator 2:	Baseline (indicate measurement unit)	Current (indicate measurement unit)	Cost Savings
Calendar year	2020	2020	
Actual quantity (per year)	619	481	\$46,223
Production unit (select one)	Earned Labor Hours Other -- specify (e.g. Gallons, length, etc.)	Production units Production lbs.	
Production Quantity	184291	145453	NA
Normalization factor (Current year production ÷ Baseline year production) .79			
Normalized quantity (Actual current year quantity - Actual baseline quantity) x Normalization factor -34,566			
Briefly describe how you achieved improvements for environmental initiative #2 or, if relevant, any circumstances that delayed progress. COVID caused plant closure for 6 weeks. We were able to find a recycler for our door skin scrap once we removed the PVC from the formula, we also increased our reusable shipping packaging.			

SECTION E

ENVIRONMENTAL IMPROVEMENT INITIATIVE RESULTS
CONTINUED

Initiative #3

Category 3: Water	Baseline	Current	Cost Savings
Indicator 3:	(indicate measurement unit)	(indicate measurement unit)	
Calendar year	2020	2020	
Actual quantity (per year)	14226	13024	\$4002
Production unit (select one)	Earned Labor Hours Production units Production lbs. Other -- specify (e.g. Gallons, length, etc.) Headcount		
Production Quantity	1169	1194	NA

Normalization factor (Current year production ÷ Baseline year production) 1.02

Normalized quantity (Actual current year quantity ÷ Actual baseline quantity) x Normalization factor 25.5

Briefly describe *how* you achieved improvements for environmental initiative #3 or, if relevant, any circumstances that delayed progress.
 COVID caused plant closure for 6 weeks. Water Mistlers on bathroom sinks, Waterless urinals installed in new restroom. Removal and replacement of water based chiller for more energy efficient air to air chiller. Frequent examinations for water leaks.

1. Briefly describe the *impacts or wastes* eliminated resulting from the environmental initiative(s). If multiple initiatives, please indicate which specifically.
 Removing PVC from our Door skin formula allowed us to recycle our scrap from that process.

2. Are there other best management practices (BMPs) you can share correlating to your initiative(s)?

3. If the objectives and targets associated with the environmental improvement initiative(s) were not attained, please verify continued progress toward the environmental initiative(s). If multiple initiatives, please indicate which specifically.

4. Please provide a narrative summary of progress made toward *qualitative, significant* EMS objectives and targets, if any.

5. Please list any state, U.S. EPA, or other partnership programs to which you are reporting this data (e.g., Energy Star, Project XL).

6. Is your entity willing to share the environmental improvement initiative(s) and its best management practices (BMPs) at the ESP Annual Meeting and/or a Partners for Pollution Prevention quarterly meeting or conference? ☒ Yes ☐ No

SECTION F

ENVIRONMENTAL IMPROVEMENT INITIATIVE

Why do we need this information?

Facilities need to show they are committed to improving their environmental performance.

What do you need to do?

Refer to the Environmental Performance Table and answer the following questions.

1. Select the appropriate boxes in the following table to indicate the **category** and **indicator(s)** that represents the next environmental improvement initiative selected by your facility. For the category and indicator selected, list the **baseline year** (e.g., 2015) and the **future year** (e.g., 2016). Next, list the **baseline annual quantity** (e.g., 5 tons) and **future annual quantity** (e.g., 2 tons) you are committing to achieve by the end of the future year.

Category	Indicator	Baseline Year 20 20	Future Year 20 21	Unit
<input type="checkbox"/> Material Procurement	<input type="checkbox"/> Recycled content			Pounds, tons
	<input type="checkbox"/> Hazardous/toxic components			Pounds, tons
<input type="checkbox"/> Suppliers' Environmental Performance	<input type="checkbox"/> Specify indicator: _____			As specified for the particular indicator
	<input type="checkbox"/> Materials used			Pounds, tons
<input type="checkbox"/> Material Use	<input type="checkbox"/> Hazardous materials used			Pounds, tons
	<input type="checkbox"/> Ozone depleting substances used			CFC-11 equivalent pounds
	<input type="checkbox"/> Total packaging materials used			Pounds, tons
<input checked="" type="checkbox"/> Water Use	<input checked="" type="checkbox"/> Total water used	13024 m3	13559 m3	Gallons
	<input type="checkbox"/> Electricity			kWh / MWh, Btu / MMBtu
	<input type="checkbox"/> Steam			kWh / MWh, gallons, ft ³
	<input type="checkbox"/> Natural gas			Btu / MMBtu
	<input type="checkbox"/> Diesel			Gallons
	<input type="checkbox"/> Propane / LPG			Btu / MMBtu, gallons
	<input type="checkbox"/> Gasoline			Gallons
	<input type="checkbox"/> Solar			kWh / MWh
	<input type="checkbox"/> Wind			kWh / MWh
	<input type="checkbox"/> Landfill gas			Btu / MMBtu
	<input type="checkbox"/> Combined heat and power			kWh / MWh, Btu / MMBtu
	<input type="checkbox"/> Other: _____			_____
<input type="checkbox"/> Land and Habitat	<input type="checkbox"/> Land and habitat conservation			Square feet, acres
	<input type="checkbox"/> Community land revitalization			Square feet, acres
	<input checked="" type="checkbox"/> Total GHGs	11857	15672	MTCO2E
<input checked="" type="checkbox"/> Air Emissions	<input type="checkbox"/> VOCs			Pounds, tons
	<input type="checkbox"/> NOx, SOx, PM _{2.5} , PM ₁₀ , or CO			Pounds, tons
	<input type="checkbox"/> Air toxics			Pounds, tons
	<input type="checkbox"/> Odor			European Odour Units
	<input type="checkbox"/> Radiation			Curies, Becquerels
	<input type="checkbox"/> Dust			Pounds, tons
	<input type="checkbox"/> COD or BOD			Pounds, tons
	<input type="checkbox"/> Toxics			Pounds, tons
<input type="checkbox"/> Discharges to Water	<input type="checkbox"/> Total suspended solids			Pounds, tons
	<input type="checkbox"/> Nutrients			Pounds, tons of N or P
	<input type="checkbox"/> Sediment from runoff			Pounds, tons
	<input type="checkbox"/> Pathogens			MPN/ml, CFU/ml
<input checked="" type="checkbox"/> Non-hazardous Waste	<input checked="" type="checkbox"/> Landfill	481 Tons	535 Tons	Pounds, tons
<input type="checkbox"/> Hazardous Waste	<input type="checkbox"/> Incineration			Pounds, tons
	<input type="checkbox"/> Reused/recycled off-site			Pounds, tons, gallons
	<input type="checkbox"/> Other: _____			Pounds, tons, gallons
<input type="checkbox"/> Noise	<input type="checkbox"/> Noise			dBA
<input type="checkbox"/> Vibration	<input type="checkbox"/> Vibration			Inches per second
	<input type="checkbox"/> Expected lifetime energy use			kWh / MWh, Btu / MMBtu
	<input type="checkbox"/> Expected lifetime water use			Gallons
<input type="checkbox"/> Products	<input type="checkbox"/> Expected lifetime waste to air, water, or land from product use			Pounds, tons
	<input type="checkbox"/> Waste to air, water, or land from disposal or recovery			Pounds, tons

If you need assistance filling out the form, please contact the ESP program manager at either esp@idem.in.gov or 1-(800) 988-7901.

SECTION F

FUTURE YEAR ENVIRONMENTAL IMPROVEMENT INITIATIVE

CONTINUED

2. If the environmental improvement initiative(s) will be *qualitative* in nature, please describe. _____
3. What activities or process changes do you plan to undertake at your facility to accomplish your initiative (e.g., technology changes in a particular process line, employee training)? _____
Additional LED lighting with motion sensors, As HVAC units are replaced will utilize more energy efficient units, Adjustment of inside temperatures in winter months, gradual increase in reusable packaging, employee awareness continued information on recyclable products.
4. Does this initiative address a significant aspect in your EMS?
☒ Yes
☐ No—If no, please explain why you believe this indicator should be included as an environmental improvement initiative: _____

CERTIFICATION AND PLEDGE

On behalf of (name of facility) Toyota Boshoku Indiana

I certify that the information contained in this Annual Performance Report and attachments is accurate to the best of my knowledge and that this facility is, to the best of my knowledge and based on reasonable inquiry, currently in compliance with all applicable federal, state, and local environmental requirements, or has a corrective action program in place to attain compliance.

We, Toyota Boshoku Indiana, commit to maintaining the principles and goals outlined in our Environmental Management System for our facility's Indiana Environmental Stewardship Program status. We agree to strive for full compliance with all regulations promulgated by the U.S. EPA, state, or local jurisdictions. We agree to promote the Indiana Environmental Stewardship Program and to share our success stories with other facilities. We understand that we must meet the requirement of implementing one (1) new, independent environmental improvement initiative each year of membership (for a total of four (4) initiatives), that the Annual Performance Report must be submitted to IDEM by April 1st of each year, and that we must reapply to the Indiana Environmental Stewardship Program every four (4) years.

I understand that the information provided in this Annual Performance Report will be public record. I am the senior facility manager or authorized facility signatory, and fully authorized to execute this statement on behalf of the corporation or other legal entity whose facility is submitting this Annual Performance Report.

Signature

Date (month, day, year)
03/25/2021

Printed signature
Philip Alvey

Title
EHS Manager



NSF International Strategic Registrations Audit Report

Toyota Boshoku Indiana (TBIN)

1698 S 100W

Princeton, 47670

C0143146

Audit Type

Surveillance Audit

Auditor

George Herold

Standard

ISO 14001:2015

(Exp Date: 13-AUG-2021)

Audit Date(s):

07/27/2020 - 07/29/2020

Recommendation

ISO 14001:2015 : Continue Certification, NO CARs



Executive Summary

ISO 14001:2015

TBIN has come back in operation after a shutdown due to COVID. There were no nonconformances identified and evidence was presented of continuous improvement to the Environment with improved weld fume filtration being expanded. New model will also allow for recycling of material that previously could not be recycled -only landfilled. Recognized was the maximum capacity for flammables cabinets in use-evidence of going above and beyond in EHS compliance. This is just one example of how the Environmental program is meeting all 14001 requirements with no nonconformance found. Team members should both be congratulated and monitored for continuing to follow recycling of materials and following instructions to help meet environmental targets.

Despite COVID all required 14001 requirements were found being maintained up to date without any excuses and no evidence of any compliance violations -hats off to management and the EHS team. The 2020 surveillance audit for TBIN verified that the scope of registration is accurate overall but the East plant shown as remote on the certificate has activities beyond just shipping and receiving. These include wire and pipe bending, weld, and urethane foam. This surveillance audit verified through sampling of processes identified on the matrix and related documented information that the Environmental Management System is effective and conforms with the requirements of 14001. The objective of maintaining the EMS to continued 14001 certification was achieved.

Opportunities

ISO 14001:2015

Currently given the first audit of the facility remotely - there were no areas for opportunities identified. .

Corrective Action Requests

There is NO Corrective Action Request in this audit.

Site Information

The audit was based on a sampling of the company's management system.

Industry Codes

NACE:DH 25.2, NACE:DJ 28.4, NACE:DJ 28.7, NACE:DM 34.3

Scope of Registration

ISO 14001:2015 : The environmental management system is applicable to the management of the environmental aspects related to:

The assembly of automotive seats and door panels, and automotive interior components.



Opportunities for Improvements

Processes

ISO 14001:2015

Process Name	Observations / Auditor Notes
8: Auto interior components	<p>Describe whether the process is effective or not (effectiveness should be supported with specific data/results). Include strengths & weaknesses of system:</p> <p>Auto interior components process was found effective by interview with managers, supervisors, and team members that provided details in interviews conducted using V/C technologies regarding the environmental programs, policy, and targets. Emergency preparedness information was also provided covering evidence of training and drills related to actions in an emergency.</p> <p>Tour of the area found no evidence of environmental rules not being followed for example - recycled materials not being sorted properly or chemicals and wastes not being stored properly. Procedures and work instructions were reviewed to verify what was written aligns with what was witnessed and being performed at TBIN.; Gold Shift audited Kris the Gold shift manager in depth. Witnessed the plant president in the floor with the Gold shift at 2000 when normal start time in early morning and going strong.</p> <p>Kris pointed out internal communications as being key to meeting environmental targets as well as monitoring of protocols. Spills, waste generation and general trash are all areas that need to be monitored. Discussed segregation of waste streams to support recycling such as cardboard. Saving energy by turning off equipment. Conveyors were the largest draw on electric. New hire 2 week orientation with HR is followed by 10 days in production under close supervision, reinforcing environmental practices such as sorting of scrap for recycling, and after which there is a knowledge and suitability for the job check. The last thermal event drill went well. Audited Tristain the weld manager also covering tool & die. Big items related to the environment were the recycling almost all items from weld go to recycling almost zero trash. Exhaust fumes are filtered cleaned and returned as indoor air.</p> <p>Cutting of welds and testing is done by QC- these are recycled and many seat frames can be repaired rather than be scrapped. Thermal event training and drill has taken place this year and all went well. Turning off equipment when not in use is a regular occurrence.</p> <p>Recycling is also supported with laundering of towels and gloves rather than simply throwing them away. There are also robot carts that have batteries that charge on recharging points.</p> <p>Reviewed the small weld area added to the plan along with sound booths for seats, the majority of parts coming in in reuseable totes, plastic pallets, wood pallets and cardboard. Parts from China come in cardboard boxes. Multiple balers separate for plastic and cardboard.</p> <p>Repair seat covers with steam - taking out wrinkles.</p> <p>Blue shift -Stacy manager for weld and seat rails. Steel scrap goes to recycling and leftover grease goes to seat tracks. Empty 5 gallon bucket and put into waste room. Weld exhaust fumes are wet collectors - allows removal of all particulates - very clean process. Dry collectors serve 1/3 of welders 3 month filter change and then get put outside. All filters will be wet collectors target date September 17, 2020 - next shutdown.</p> <p>No spills and last thermal event back at least 2 1/2 years ago.</p> <p>Rick injection molding impacting the environment - regrind trim and shots, recycle plastic bottles and cans, hydraulic fluids haven't leaked yet. Energy use key around injection machine high use. No paint touch up at this mold machine..</p> <p>Joe wire for highlander seat frames installed fans recently to keep workers comfortable and these get turned off when not needed or no workers at that area.</p>



Process Name	Observations / Auditor Notes
	<p>Thiero in Urethane was able to discuss recycle small pieces, target for reduce waste and emergency fire procedures were explained clearly..</p> <p>Mark in weld knew targets and objectives for the environment, knew recycling of metal, and correctly identified the steps to take in case of a thermal event.</p>
8: Door Panels	<p>Describe whether the process is effective or not (effectiveness should be supported with specific data/results). Include strengths & weaknesses of system:</p> <p>Overall effective based on interviews with team members and managers on both shifts. Workers were able to communicate knowledge of environmental aspects, environmental objectives for the plant, and what they do to support the policy and how the plant is performing in relation to the objectives. Tour of the area found no evidence of procedures and work instructions not being followed.; Gold Shift audited Bob the assistant manager who belongs to Blue shift at door injection molding. Bob focused on group meetings and internal communication as the main effort in his areas to support environmental targets. Minimizing pollution and reducing emissions of CO2 along with lowering electric and filtering the spraying of parts and changing of filters to prevent air ducts from showing any paint residues. Empty spray cans are sent to be punctured and drained before being disposed of in a barrel and sent for disposal. Emergency preparedness was touched on to include spills, fire, and severe weather.</p> <p>Blue shift -Christie inspector on Highlander doors. Energy usage is the biggest impact to environment in her area. Emergency preparedness well prepared with exit door close and clear direct path to storm shelter. Meeting environmental objectives for the plant by reducing energy consumption. Lowering water use with new faucets.</p>
8: EMS Management	<p>Describe whether the process is effective or not (effectiveness should be supported with specific data/results). Include strengths & weaknesses of system:</p> <p>Emission report checked - including emergency generator running, electric and natural gas use, propane use in forklifts, etc. YTD totals are well below limits assigned by INDEM. Outdoor flammable storage building that is climate controlled for new materials and waste cans to dry is just outside separate building not climate controlled.</p> <p>No neighbor or interested party complaints.</p> <p>EMS Objective Water is being met target 1258 actual 500; Waste target 146 actual is 95 , CO2 target 3459 actual 1988 - all 3 being met. Zero incidents- met. Targets are based on planned number of units produced against the actual. The shutdown helped to lower overall numbers. Propane use for forklifts individually and this does track in with CO2 use. Wastewater is tracked in gallons as based on city water supplied water, and wastewater goes to Public wastewater treatment plant. As a Japanese company all things are tracked.</p> <p>Legal compliance list shows clean air act as covering IN regulation code 426 IN EN ENV 501 SD E rev 2. Import 1 chemical for door panel from Japan. No shipments out of the country of any chemicals.</p> <p>Aspects and impacts list form# IN EN ENV 605 SP E significant rev 3 CO2 27 , TDI 27, Toluene 24. 24 or above and they are considered hazardous. No changes since 2017 - no changes.</p> <p>Emergency Preparedness and Response IN EN ENV 527 PR E rev 2 8/21/17 updated form and control. IN EN ENV 551 WI E rev 19 Emergency plan of Action 8/23/17 update form and control.</p> <p>Drills in 2020 - fire scheduled for September 2020. Oct 4, 2019 was fire. No confirmed date due to COVID for severe weather. Spill drill with training 7/24/20 Gold and Blue 7/14 & 17/ 20.</p> <p>Hazcom training covers all staff annually.</p> <p>Maintenance and Engineering get s special environmental related training-2020 training completed and the attendance for training also covers competency with a statement of</p>



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	<p>understanding. This was also completed and marked on the planned schedule for training.</p> <p>2/27/20 is the last pick up of electronics by C&I in Evansville, IN.</p> <p>Procedures and work instructions - no exposure IN EN ENV541-WI E rev 2 8/21/17 formatting completed. Plastic baling IN EN ENV 617-SP-E rev 3 9/15/17 - data is in a monthly report for all recycled by pounds and dollars received. Currently there are no items that are a negative revenue stream to get recycled.</p> <p>There was a review of the activities and items witnessed on the plant tour to include the cleaning of the urethane molds with dry ice (CO2) and how it relates to the target of reducing CO2 emissions and the reduction in energy use. Witnessed in the tour were the outside grounds and separate storage buildings. Secondary containment was found under all liquid chemicals. Discussion regarding cleanliness of the secondary containers.</p> <p>Discussed where West plant is the west plant but the East plant is also referred to as downstairs by some old timers.</p> <p>Jeremy from Safety Clean on site discussed items taken to include adhesive, grease, aerosol, light bulbs universal waste, used oil, empty drums. Waste to energy is TDI, isocyanate waste, and adhesive in El Dorado AR.</p> <p>Superior takes the filter and liquid weld filter water for disposal.</p> <p>Sid is in EH&S - permits updates, pollution prevention, and conduct regular checks. TBA standards require more than permits. Recycling issues -trying to reduce landfill door trim PVC being discontinued in September. Reduce pollutants reducing weld cells, less machines. SPCC training for all. Special employee get training for urethane due to TDI. with SCBA to be worn by spill clean up staff. Weekly RCRA checks review spill kits for minimums.</p> <p>Storage of UW work instruction - IN EN ENV 556 WI E rev 2 no CARs open against this procedure.</p> <p>Michelle gold team safety and a little bit of environmental. Sid is the environmental but trained in Hazwoper. Minimize pollution Kaizen to continuous improve. No spills. ; Currently 2 trained internal auditors and a 3rd going for training in August. Currently up to date as per the calendar for 2020 of scheduled audits. Last ncr was from July 20 2019 related to foaming for seats. Root cause found 3 errors in the process that were corrected. No other issues. Spill was less than 3 gallons and corrective action shows effective with no other occurrences.</p> <p>Management review latest was 7/22/20 with daily and monthly meetings supporting this annual meeting. Posting is updated as info comes in. Max occupancy has been reduced 50% across the board. Social distancing established. No severe weather drill conducted due to COVID. In plant 100% mask except eating or only person in a room.</p> <p>Reviewed TDI nonconformances and closed them out-the only action item from 2019 for follow-up in 2020. Documents were reviewed - no changes. Two permits -1 each for each plant. West plant adding welding cells. Indiana Dept. of environment wants 2 permits to continue.</p> <p>No changes to risks and opportunities - door trim will be recycleable with new model change in October. Currently there is landfill of door material currently and completed product assembled makes them nonrecycleable with all combined materials.</p> <p>Communications external nothing since last NSF audit - 2 INDEM has 2 voluntary programs that TBIN participates in. Metal and cardboard to recycle - Green metals , Urethane - Green metals , Injection mold is regrind and recycled - HOEHN plastics, Strap and plastic is recycled - HOEHN. Safety Klean takes used oil, mixed waste, TDI, wash water, used lubricants. Parts washer is not hazardous - taken by Crystal Clean. Air bags that are defective are exploded in a sealed box on premises. Advanced disposal takes regular trash. June payment was \$40/ton(.02 cents per pound) for cardboard. Recycling containers for employees aluminum, paper, and plastic. Advance will sort since they accept single stream and are required to sort. TDI is the most hazardous and a flammable glue and solvent mix both disposed of thru Safety Klean. There is monthly tracking of what is shipped out - Clean Harbors web site has copies available to look up and download. 2576 lbs shipped so far this year YTD. Sum for 2019 was 5675 lbs of flammable liquids. Records of disposal by manifest is retained in a book east and west plants separate and then by month shipping copy and final disposal copy. List of wastes maintained in Excel tracking sheet. Plants are at about 95% in conversion to LED lights from other bulbs. Motion sensors on interior lighting. No solar panels with outside LEDs.</p>



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	<p>Philip toured all disposal facilities for all wastes.</p> <p>Permits - DOT east plant # 042920550012CE expires June 30, 2023; west # 042920550014CE expires June 30, 2023; Annual notifications East plant M051-34509-00050 minor source operating permit; West M051-41551-00045. IN code reference 326. East plant RCRA id# INR000125906; West # INR000106906; Stormwater East no exposure June 16, 2020 #INRX00027 expires July 1, 2025; West permit # INRX 00720 renewable June 15, 2021.</p> <p>EPA ECHO checked FRS # East 110041350640 & FRS # west 110035869771 no visit in 3 1/2 years. Compliance calendar - Air emissions report completed in January as planned along with this NSF audit planned and shown as being done in July, X for completed. TRI reporting: in June 2019 last completed 4767WTYBS733S1. Tier II complete in February 2020 id#111934.</p> <p>Completed manifests audited: West 007244578 adhesives 6/12/20 and East 16686 grease 6/15/20 sorting last completed final disposal facility signature. Monitoring and measuring includes weekly checks environmental inspections, spray booths Jan-Jun 2020; Weekly compliance 6/26/20 on IN EN ENV488 FM E. East & West weekly RCRA checks IN EN ENV 488 FM E 6/26/20. Spray booths BT EN FM 44..</p>
8: Maintenance & Engineering	<p>Describe whether the process is effective or not (effectiveness should be supported with specific data/results). Include strengths & weaknesses of system:</p> <p>Overall the maintenance process was found effective with team members working to keep equipment operating safely. Maintenance was found on the floor in both plants on both shifts fixing, doing PM, or checking to ensure equipment was operating correctly. Prep for new launch was also noted. The evidence of effectiveness was planned improvements completed or at least on track with no lines or equipment shut down during the audit.</p> <p>Vince Meleski is the head of this department for East and West plant. Touch up of injection molded parts with spray paint and spray adhesive are the biggest release to air. Maintenance does PM and checks, Weld fumes are filtered and returned to the indoor air. Nothing big happening this week, water use reducing by small chillers and taking out large water cooling towers. Smaller welders use less cooling water. Spill kits maintained throughout the plant. Roof leaks controlled to prevent spills from causing slip hazards. Energy consumption largest are injection mold presses. Reduce cooling tower fans, pumps will all lower energy use. Getting rid of older press would also save. All capital expenses pending. RTU a/c units might need to be replaced.</p> <p>Jim engineering manager model change and 2 new launches. Machine KanBan system pink is safety and environmental nothing new no door program so reduction in adhesive use. Launch and model changes - reduce amount of glue used. Changes involve both plants new jigs. Nothing really big with changes.</p> <p>Scott Blue Seats Manager - eliminated air and equipment costs in seats area. Energy savings reduced. Lines up and efficient for the moving of the seats on newer more efficient conveyors. Team members reduced by 2 on 1 line. Eliminate team members handling injection molding. Ratio change more efficient by blending of product together as it is being produced.</p> <p>New employee orientation covers emergency preparedness. Covid has interrupted the normal plant drills such as the severe weather.</p> <p>; Environmental management does checks of eye wash, fire extinguisher, and emergency lights. Map shows locations of items needing to be checked. SDS Kiosks identified. Map of the facility shows stormwater flow and storm drains and sources of noise, spray booths. Weekly RCRA inspections with a place to note any issues or findings identified during an inspection. Front shows inspector and date 1/3/20 by Philip Alvey then map with space to show issues.</p> <p>Audited Gold shift Mike Group leader with the plant for 21 years. Current big issue is repairing an E stop properly. Urethane and TDI spills are the biggest negative aspect potential. Hydraulic oil and spill drills an important part of environmental impact via maintenance.</p> <p>Audited Randy the Assistant Manager with Gold who targets PM on injection mold machine and hydraulic leaks - spill drills and reporting but 5 gallon or less is considered</p>



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	<p>small. Energy use and reducing energy by 2% is a big part of maintenance and plant activity - good for the company to save money and good for the environment.</p> <p>Blue shift and Percy address emergency generators and PM so they are ready for operations. It was noted that each building gets power from a different utility so electric power supply can be a challenge. Air compressor tanks are checked for integrity per Maintenance manager.</p> <p>Fred group leader on Blue. Improvements to help with environment, urethane lines and spill clean up, every month hazwoper training and iso spill training at least every 6 months. 2500 ton hydraulic press trough under the press. Clean up vacuum at least 2 times per week.</p> <p>Labeling of plastic bottles is a concern since people will take them put something in them without labeling and then when found it will need to be disposed.</p> <p>Percy fac maint 10 years at plant and 21 years before that in maintenance. Doing the right things. Weekly on both generators records - PM sheet completed retained for 1 year. Weekly air compressor maintenance. Air systems is the air compressor company. 1100 gallons of diesel west plant runs 27 hours. East generator no idea of tank size. Tanks double walled. Biggest impact to the environment gaylord boxes get bad electronics including spent LEDs. Air compressor tanks - record of inspection. DHS inspects boiler tanks for hot steam. Discussed cherry picker PM check before use and parking lot LED lights. Nothing stored outside uncovered.</p> <p>RECORDS RETAINED FOR CHECKS LAST BEING 7/24/20. AIR COMPRESSOR 2 & 3. HOURS ARE RECORDED. FIRE PUMPS & GENERATORS ALSO RETAINED. 272421 IN boiler tag seal on tank.</p> <p>Filter wash booth witnessed in the tour for cleaning of weld filters. This waste water also is picked up for disposal by company taking microair wash water - Superior.</p> <p>Pressure tanks covered by service contract. Air Systems 2/27/20.</p> <p>Audited interior and exterior of facility from West bldg yard compactor and recycling bins to East bldg. interior and exterior. Face time touring was completed on Mon, Tue, and Wed to verify consistency with following EHS rules at TBIN.</p> <p>Noted were the maximum capacity on flammables cabinets as completed by EHS compliance.</p> <p>Can puncturing reviewed.</p> <p>TJ was noted as the responsible person for cleaning out the secondary containment units so that if there is a leak they will not overflow. No more than a gallon was found in any 1 of all those audited using video via face time.</p> <p>Recycling of steel has 2 separate containers 1 for seats and 1 for metal seat rail stampings. Also nonferrous contains weld tips, weld guns, and copper.</p>
8: Seat Assembly	<p>Describe whether the process is effective or not (effectiveness should be supported with specific data/results). Include strengths & weaknesses of system:</p> <p>Overall effective with team members and leaders audited on both shifts at TBIN. This is a sub assembly automotive supplier line that can not be shut down so there has to be some effort made to get team members to a V/C to be interviewed. Answers showed evidence of effective communications and training related to activities in their area that impact the environment as well as the environmental policy, objectives and targets, and emergency preparedness training.. ; Gold shift audited Brian in QC who identified aspects of plant</p>



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	<p>operations such as airbags, TDI, recycling, reducing energy consumption and lowering water use as TBIN targets to control and help protect the environment. He demonstrated good knowledge of participating in training and internal communications to get this information. Audited Luis the assistant manager for seats where he identified recycling of scrap materials as the largest effort to support plant environmental efforts. Discussion regarding thermal events and emergency preparedness were covered in depth. Discussed training efforts with new employees to follow all of the rules under an experienced team lead. Audited Tim a team leader in Seat Assembly. Bundling of cardboard was covered along with the environmental objectives. The key aspect was considered to be the urethane. Emergency preparedness was addressed with details of what to do in severe weather the closest to his area being the middle bathroom.</p> <p>Blue shift Jeremy scrap from parts, fabric trim cover, repairables, recycleable, send back to supplier for credit last resort is to throw away. Environmental plant objectives being met. Able to read policy and explain -had card. Thermal event would mean exit, get head count, and wait for all clear- fire drill steps confirmed.</p>
Processes EMS MANAGEMENT add on	<p>Describe whether the process is effective or not (effectiveness should be supported with specific data/results). Include strengths & weaknesses of system:</p> <p>Process was effective given all targets and objectives being met and all EMS annual expectations as possible with COVID impacts.</p> <p>Significant aspects of the EMS with a score of >24 CO2, TDI, and Toluene.; Significant aspects of the EMS with a score of >24 CO2, TDI, and Toluene.</p>

Verification of CARs For ISO 14001:2015

Have you verified the effectiveness of all previous CARs? (List all new CAR's that you initiated in this report because you did not verify effective implementation of a previous CAR)

Yes.

NONE in 2019 previous ncrs below were from 2018.

Discuss your evaluation in detail.

T1981124-1 -minor closed in 2019.

T1981124-2 - Minor closed in 2019