



## Ceramica Alhambra Manufacturing Process Green Aspects

Ceramica Alhambra, in terms of Green product has the following aspects on it is manufacturing process.

1. Ceramica Antique recuperates rain Water in a Cistern for all clay and glaze formulations.
2. We recuperate the bisque products to be recycled into new Ceramica Alhambra Products. (Red Body)
3. All Glazes are Lead Free.
4. All water used to prepare the Red Clay is recycled and reused 100%.
5. All product from green phase up to bisque fired is reutilized 100%.
6. New packaging for all Ceramica Antique products will be 100% recycled within 2007.

# WALKER ZANGER

SASSUOLO, MARCH 9<sup>th</sup> 2007

## **SICHENIA ENVIRONMENTLY FRIENDLY MANUFACTURING PROCEDURES (for Pietra di Fiandra and Broadway Collections)**

Inside, the raw clays and different materials used in the ceramic tile manufacturing process are recycled:

- 100% of the factory service water used during the clay grinding process ,
- 100% of the factory sludge due to the industrial waters cleaning process,
- 100% of the manufactured soft waste, prior to the firing process,
- 100% of all manufactured hard waste and manufactured rejections after the firing and selection process.

The plants are equipped with a dust control system used during the whole manufacturing process, to avoid any health hazards in the work areas and to reduce emissions into the open air. These are well below the limits set by the law.

The kilns are equipped with a special dust control system with lime filters, which can capture fluorine, sulphur and other components, normally included in their exhausts. This lime is then recycled in the raw materials.

The spray driers are equipped with a dust control system working through a wet washing process.

The glazes are free of any toxic elements such as lead, cadmium, and selenium.

The hot air coming from the kilns is recycled, to heat the work areas and the vertical fast drier stocking units.

All the water used in the manufacturing process is 100% recycled and none is discharged into the sewerage system.

The overall percentage of recycled materials in each piece of ceramic tile manufactured by Sichenia varies on average between 5% and 10%.

All other kinds of waste and garbage are then selected by an outside contractor and recycled according to type: paper, cardboard, wood, plastic, metal.

### **SICHENIA GRUPPO CERAMICHE S.P.A.**

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## Mantra - Recycled Glass Content Percentages

PRODUCT (by Glass Color)  
All products in the Mantra collection

Percentage of Post-consumer  
Recycled Material  
70



## Mizu Umi - Recycled Content Percentages

<u>PRODUCT NAME</u>	<u>Percentage of Post-consumer Recycled Material</u>
All products in the Mizu Umi collection	30

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## Weave Recycled Glass Content

<b>BASE COLOR</b>	<b>POST CONSUMER %</b>	<b>POST INDUSTRIAL %</b>	<b>TOTAL %</b>
Amber	0	20	20
Aqua	0	20	20
Black	64	20	84
Bohemian	51	20	71
Cane	0	20	20
Clear	0	20	20
Cobalt	66	20	86
Equator	0	20	20
Fleet Blue	0	20	20
Harvest	0	20	20
Kashmir	0	20	20
Midori	51	20	71
Moonstone	18	20	38
Morado	52	20	72
Olive	0	20	20
Oxygen	0	20	20
Palladium	0	0	0
Red	0	50	50
Spruce	52	20	72
Tahoe	0	20	20
White	0	20	20

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**Vintage Glass - Recycled Content Percentages**

<b>PRODUCT (by Glass Color)</b>	<b>Percentage of Post-consumer Recycled Material</b>
<b>Vintage Oyster</b>	<b>20</b>
<b>Vintage Lemon Drop</b>	<b>20</b>
<b>Vintage Pearl</b>	<b>70</b>
	<b>70</b>
	<b>70</b>
<b>Vintage Onyx</b>	<b>70</b>
<b>Vintage Zinc</b>	<b>70</b>
	<b>55</b>
<b>Vintage Denim</b>	<b>70</b>
<b>Vintage Tiffany</b>	<b>25</b>