

# CSR Report of Ibaraki Plant

**Business activities:** Production of high-pressure hoses, sealants  
**Total site area:** 152,000m<sup>2</sup>  
**Number of employees:** 304 (as of December 2013)  
**Location:** 1 Hatori-Nishi, Omitama City, Ibaraki 319-0198, JAPAN

**Contact for consultation and complaints:**

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## Message from the General Manager



Takashi Hisanaga

The Ibaraki Plant started its operations in 1973 as an exclusive plant of high pressure hoses one of the largest in Japan and in 1997 it started plant operations for building sealing materials and has continued production today.

While working on measures in accordance with Yokohama Rubber's GD100 Basic Policy so we become "a company having world-class strengths in technologies for protecting the environment", in that we also aim to achieve harmony, fusion and coexistence with the abundant and beautiful nature of Ibaraki, the plant is promoting numerous regional and social

contribution activities in addition to its environmental policies. With respect to reducing industrial waste, we have achieved results by strengthening team-improvement activities under the themes of reducing process nonconformities, and improving materials and equipment management.

For energy saving activities, all employees actively promote renewal of machinery and equipment of power saving types, increased energy saving awareness and paperless processes. The plant has been maintaining the highest AAA rank of the eco office registration system established by the prefecture.

Furthermore, although we have completed the plantings plan within the plant, we continue to grow seedlings. We donate these seedlings to both locally-held planting events and planting activities held within the disaster-impacted areas.

Last year we also commenced biodiversity activities and we conducted a survey of aquatic life from the Sonobe River down to Kasumigaura. Through such activities, we are striving to improve our communication with local communities. We will further strengthen our environmental management systems at the Ibaraki Plant. We will also push forward with the total-employee participation model, both with regard to those activities that make an environmental contribution, and with regard to the prevention of environmental trouble.



## Organizational Governance

### Decision-making processes and structures

The following three items have been established with respect to the structuring of the plant's safety culture:

- 1) The taking of initiative when conducting the 3S's (seiri-organizing, seiton - arranging, seiso - cleaning)
- 2) The delivery of safety "greetings" in a loud voice
- 3) Punctuality (being seated at meetings three minutes prior to starting times)

With respect to the plant's safety, environment and quality policies, such are established in accordance with corporate policy. Concerning their orientation, such is decided through the meetings system.



## Human Rights

### Consideration of human rights by suppliers

In December 2013, the second CSR study meeting was conducted, and 14 people from 13 suppliers participated. This time, explanations were given on the following topics:

"Harassment (Power Harassment, Sexual Harassment), Don't Do It! Don't Allow It!"

"Information Management, Don't Leak Information"



### Promoting employment of people with disabilities

One new disabled graduate was hired for the purpose of promoting the employment of such people. We currently have three disabled employees working actively in the plant.

### Combining work and life

Two days a week, Wednesdays and Fridays, have been established as days with specified hours for leaving work. In FY2013, we had six people working reduced hours and reduced days, seven people on childcare leave and three people on refreshment leave.

### Complaint resolution

The Compliance Promotion Office received no reports or consultations regarding complaints.

### Creating a safe and healthy workplace environment

Concerning work injuries, there was an incident involving an incision wound caused by a blade tip. In responding to this, improvements were made to the workplace, a work procedure manual was created and the tools that were used were improved.

Furthermore, two study meetings were conducted. One was on the topic of responding to employees requiring mental healthcare, the other was on return-to-work programs for such employees.

### Labor-management relations, human resources development and training

Labor and management held a life seminar in June on the theme of life after retirement.

### Maintenance

The 27 M/C (machinery devices) located within the plant are allocated to 26 individual work circles and work teams, and since December 2013, we have been carrying out the second step of a program called "TPM" (total productive maintenance).

TPM pre-checks are done by the leaders and supervisors of each work team. By following such a policy, we are aiming to improve the skill levels of other team leaders and supervisors. The Plant General Manager, various managers, Technical Masters, the Production Technology Assistant Manager and the Production Assistant Manager conduct actual audits by confirming the different workplaces using check sheets. Furthermore, in that we are working to improve the self-maintenance levels of machinery and equipment operators, there are regular technical classes held by Maintenance Masters so that it becomes possible for class participants to carry out improvements and repairs, etc., by themselves. (37 participants took the classes)

### Human resources development and training

Work training is undertaken by our assignment of more senior workers to both new hires and fixed-term employees for periods of three years. This one-on-one training increases individual skill levels because training results can be reviewed and revisited.

### Preventing pollution

So as to prevent risks to the environment, once a year we conduct drills and tests in response to predicted emergency scenarios (such scenarios include oil leaks occurring from heavy oil storage tanks and solvent cans being upset during transportation, etc.).

### Steps to reduce industrial waste

On the issue of reducing industrial waste, through our waste-reduction (MD) activities, we are revising the methods used to segregate waste within the plant and also promoting a paperless culture. Concerning auxiliary materials that are incidental to our products, we have obtained the EU ELV and RoHS Statement of Non-Inclusion Directives. Furthermore, goods that we purchase do not contain those substances that are subject to these provisions.

### Alleviating and responding to climate change

As energy-saving activities, we have employed the use of high-efficiency air conditioners and motors, along with promoting the application of heat-resistant and heat-retaining materials.

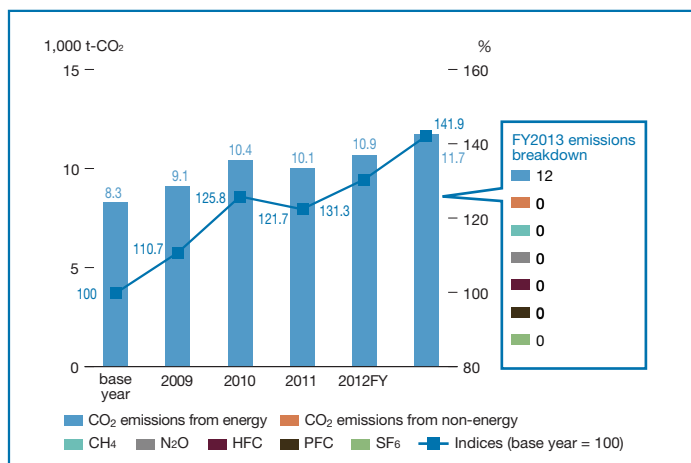
### Environmental protection, recovery of natural habitats

Concerning the Sonobe River into which discharges from this plant flow, we have conducted biodiversity protection surveys with respect to water quality, aquatic life, plants and birdlife, etc. These activities have been conducted at a frequency of three times a year. Through such work we have identified the presence of introduced flora and aquatic life, as well as the existence of certain unstable ecosystems. In the future, we plan to eliminate the introduced species and continue monitoring with a frequency of three times a year.

### Environmental data

#### ■ Reductions in greenhouse gas emissions

##### • Greenhouse gas emissions



\* The base year is defined as 1990 except for HFC, PFC and SF<sub>6</sub>, where the base year is 1995 as per the Kyoto Protocol.  
 \* Greenhouse gases (GHG) calculated in accordance with the Calculation and Reporting Manual for Greenhouse Gas Emissions (Ministry of the Environment, Ministry of the Economy, Trade and Industry). Note that GHG emissions associated with purchased power in FY2009 were calculated using the Table of Emission Coefficients by Power Company (Ministry of the Environment).  
 \* As the closing of accounts period was April to December in FY2011, the calendar year of January to December was calculated by the duplication of data for the period January to March.

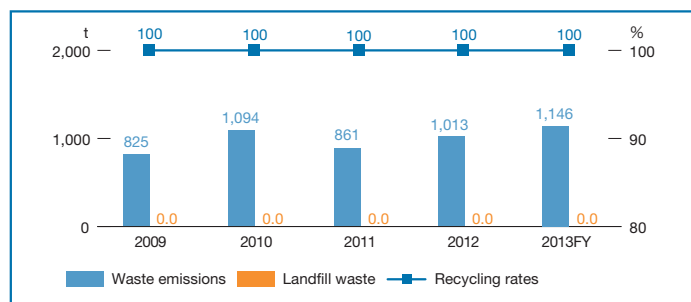
#### ■ Effective use of resources/ Waste reductions

##### • Waste emissions

From FY2006, we have continued complete zero emissions.

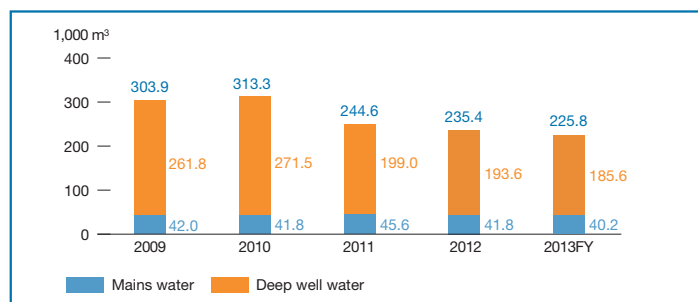
##### • Waste landfill

In FY2007, we achieved a recycling rate of 100% and we have maintained that rate since.



### Water usage

The plant uses 225,000 tons of water a year. Sources consist of underground water of about 82% and city waterworks of 18%.



### Measures for discharges into water, air and soil

#### Data related to water contamination

The plant discharges about 440,000 tons of waste water a year into the Sonobe River.

Item	Regulatory values	Voluntary Standard Values	FY2013 results		
			Average	Maximum	Minimum
PH	5.8~8.6	6.7~8.2	7.6	8.0	7.4
BOD concentration (mg/l)	10	5.5	2.2	4.5	1.0
COD concentration (mg/l)	10	5.5	2.5	4.1	1.1
SS concentration (mg/l)	15	5.0	1.1	4.5	1.0
Oil concentration (mg/l)	3	0.8	0.5	0.5	0.5

\* Ibaraki Prefectural Ordinance and Environmental Protection Agreement with Omitama City.  
\* Discharge point: Sonobe River

#### Soil contamination

We conduct groundwater analysis (shallow well) once a year and confirmed that the standard values were within the laws and the ordinances of Omitama City.

#### Air pollutants (NOx, SOx)

Measurements are conducted twice a year, and we have confirmed that the results are within the standards set out in all laws and in Omitama City Ordinances.

Substance	NOx	SOx
Amount of emission (t/year)	0.54	0.037

Facility	Substance	Regulation	Self-imposed control value	FY2013 results		
				Average	Maximum	Minimum
Ibaraki Plant Boiler	SOx emissions (K-value)	13	10 or less	0.27	0.45	0.19
	NOx (ppm)	260	125	68	95	50
	Soot and dusts (g/m³N)	0.3	0.1	0.002	0.002	0.001

\* The Air Pollution Control Act and Environmental Protection Agreement with Omitama City.

## Fair Operating Practices

### Thorough statutory compliance

We have participated in seminars dealing with the improvement of subcontractors.

### Consideration of supplier labor, safety and workplaces

Business dealings are conducted that are fair, transparent, openly-competitive and suitable.

### Status of management of chemical substances (Response to PRTR Law)

For sub-materials and auxiliary materials, we confirm the existence of 1st Class chemical substances by SDS and we report once a year to the national government (Prefecture) the subject substances of which the handling amount is provided for in the PRTR Law.

(Unit:tons/year)

Designated No.	Specified chemical substance	Amount to treat *1	Emission *2	Transfer *3	Safety Evaluation: VII-5*4			
					Toxicity Rank (effect on people)	Annual Converted Emissions (effect on people)	Toxicity Rank (effect on ecosystem)	Annual Converted Emissions (effect on ecosystem)
239	organic tin compounds	3.452	0	0.165	A	0.000	—	0.000
298	tolylene diisocyanate	27.93	0	0.955	A	0.000	B	0.000
438	methylnaphthalene	16.08	0.08	0	—	0.000	—	0.000
80	xylene	0.32	0.003	0	C	0.030	B	0.300
296	1,2,4-trimethylbenzene	0.169	0.001	0	C	0.010	C	0.010
300	toluene	0.902	0.184	0	B	18.400	C	1.840
355	bis(2-ethylhexyl) phthalate	0.407	0	0.031	A	0.000	B	0.000
392	n-hexane	0.218	0.009	0	C	0.090	—	0.000
	Total	49.478	0.277	1.151	—	18.530	—	2.150

\*1: Whereby annual handled volumes of the chemical substances subject to the Pollutant Release and Transfer Register (PRTR) exceed designated volumes, such shall be subject to reporting

\*2: Emissions Volume = atmosphere + public bodies of water + soil

\*3: Transfer Volume = waste – public sewerage system

\*4: Converted emissions volume is calculated by multiplication of the emissions volume by the toxicity ranking  
For information concerning the standards used in evaluating the degree of impact on safety, please refer to the "Safety Evaluation Table of Domestic Production Bases"  
(<http://www.ryc.co.jp/csr/data/pdf/16kokunaikyoten.pdf>)

### Noise reduction

Noises are measured at fifteen places on the border of the plant premises once a month. We can confirm that the results are within the standards set out in Omitama City Ordinances (below 55db).

## Fair Operating Practices

### Thorough statutory compliance

We have participated in seminars dealing with the improvement of subcontractors.

### Consideration of supplier labor, safety and workplaces

Business dealings are conducted that are fair, transparent, openly-competitive and suitable.

### Thorough compliance

At the 2nd CSR study meeting, an explanation was given to suppliers regarding the topic of information management. As education within the company, we hold "Workplace Compliance Seminars" with a frequency of once a month.



## Consumer Issues

### Response to complaints

If any complaints are raised about products, we quickly collect the actual item and investigate the causes and prepare reports to make a response satisfactory to the customer.

### Promotion of universal design

Concerning the brand mark that is printed on our products, we have commenced activities to consolidate on the new type that is identical to the one used on tires. We are doing this so consumers are not confused.



## Community Involvement and Development

### Coexistence and prosperity with regions

We hold regular meetings for the purpose of promoting exchanges with local governments and local businesses. Furthermore, 30 employees participated in the general meeting.

### Employment creation

A course on traffic manners was held for the benefit of fourth year elementary school students from schools neighboring the plant; during this course safety education was carried out. (June)

### Regional contributions

We established a booth at the Omitama City Fureai Festival and distributed 1,160 seedlings free-of-charge; we also donated 6,250 seedlings to the Social Welfare Corporation, Shinwa Gakuen. Concerning volunteer activities, a total of 26 employees participated in planting activities in disaster-impacted areas in the Tohoku Region, as well as in other activities such as the hydrangea plantings in Takehara close-by the plant. Furthermore, all four new hires were from the local area.

### Biodiversity and environmental educations

We proudly support both the "Omitama City Nature Association" and the "Ibaraki Branch of the Wild Bird Society of Japan". Furthermore, from 2014 we have concluded consulting agreements with both of these organizations and we have continued to receive their instruction.

### Plant Tours

Plant tours were held on a total of four occasions for neighborhood elementary schools and local high schools. Through such activities communication with neighboring areas is being promoted.