

Environmental Stewardship Initiative Annual Report

published December 2016



Table of Contents

Executive Summary.....	3
2015 Progress Report	5
Achievements.....	5
Membership Growth.....	5
Member Goals.....	7
Member Reductions.....	8
Greenhouse Gas Reductions.....	10
Cost Savings.....	12
Community Involvement.....	13
Program Updates	14
Membership.....	18
Criteria.....	18
Benefits.....	20
Conclusions.....	21
Member List.....	22

N.C. Department of Environmental Quality
Division of Environmental Assistance and Customer Service
1639 Mail Service Center, Raleigh, NC 27699-1639
877-623-6748 (toll-free)

Cover photo: DEQ Secretary Donald van der Vaart presents Steward recognition plaque to Stanley, Black & Decker – Kannapolis Distribution Center employees.

Executive Summary

The N.C. Department of Environmental Quality's Environmental Stewardship Initiative is a voluntary program that assists and encourages facilities to use pollution prevention and innovation to meet and go beyond regulatory requirements. The ESI takes a unique approach to supplement regulation by providing a voluntary, systematic and holistic approach to environmental management.

Reductions and cost savings reported by members demonstrate real results and improvements to the environment and economy in North Carolina. The ESI model addresses environmental challenges through partnerships and a voluntary, comprehensive and innovative approach that benefits the environment and continued economic growth.

This approach combines recognition with assistance, training, mentoring and networking opportunities. A three-tiered membership structure of Partners, Rising Stewards and Stewards allows participation from a wide range of organizations. The Partner level is the entry level of the program and helps organizations set environmental goals and develop an Environmental Management System while higher tiers require organizations to be models of stewardship, as well as provide mentoring and educational resources to others in the program. In 2015, ESI had 134 member sites as shown in Figure 1 below.

2015 ESI Participants

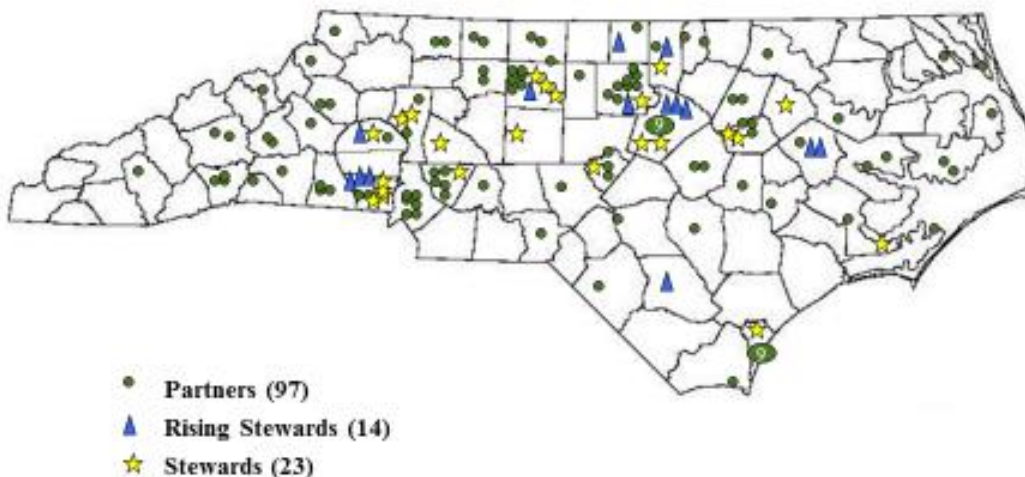


Figure 1: Map of 2015 ESI Participants

The ESI Program is open to any entity in North Carolina that commits to improving its environmental impact. (See the Membership section of this report for more information on eligibility and the three levels of the program). ESI members commit to developing environmental management systems and/or measurable goals that lead to continual improvement and stewardship. In 2015, ESI members set 251 goals covering multi-media regulated and non-regulated impacts including energy and water conservation. Seventy-six members reported progress toward these specific goals. Partners may apply to the program as a multi-site that allows a collection of sites to submit a single annual report. New members must be in the program for at least one year prior to having their results included in the totals. Therefore the total reporting may be less than the total membership numbers. In 2015, ESI members reported the following reductions in environmental impact, shown in Table 1.

2015 ESI Members Reported Reductions			
	Area	2015	Unit
Reductions	Air Emissions	76.28	Tons
	Greenhouse Gas Emissions*	818	Metric Tons CO2e
	Hazardous Waste	284	Tons
	Landfilled Waste	42,737	Tons
	Energy	22,289,629	mmBtu
	Water Use	2,439,754,313	Gallons
	Material Consumption	589	Tons
	Wastewater Pollutants	3,530	Tons
	Wastewater Volume	1,690,643	Gallons
Totals	Biomass Recovery**	54,359.91	Tons
	Total Recycled Volume	42,150	Tons
	Total Cost Savings	\$ 2,626,306.91	
	*Indirect not reported in energy reductions		
	**Category created for compost/mulch related goals		

Table 1: 2015 ESI Members Reported Reductions

2015 Progress Report

By supporting and encouraging superior environmental performance from North Carolina's business and industrial community, the ESI seeks to assist organizations in implementing environmental management systems and making progress on environmental goals. The ESI strives to help communities that share ideas and develop an atmosphere of collaboration while fostering a culture of continuous improvement.

The current command and control regulatory approach to environmental management is necessary in the real world and has led to significant improvements. However, it is not practical or fiscally possible for North Carolina to regulate all pollution and consumption of natural resources. The ESI seeks to reduce an organization's impacts beyond measures required by any permit or rule in a way that will improve the environment, conserve natural resources and provide long-term economic benefits.

Each organization has committed to report annually on its progress toward meeting its goals. This annual report summarizes all of the self-reported annual data collected by the ESI members in calendar year 2015. Starting in 2005, members included cost savings from implementing environmental improvements. Reporting on greenhouse gas emissions reductions was first included in 2008. A new category was created in 2010 for biomass recovery. It was created to capture activities related to composting and mulching as a means of diverting waste from landfills for a beneficial use. In 2012, the ESI was opened to organizations not regulated by DEQ permits in order to increase the program's reach and build a larger network of organizations working together to make North Carolina a model of environmental stewardship.

Achievements

Membership Growth

ESI membership has grown by almost six times its original membership, from 24 member sites in 2002 to 134 member sites in 2015. In 2004, a middle tier, the Rising Steward level, of membership was added (Figure 2). Beginning in 2005, Partner applicants were allowed to submit one application for multiple facilities. Facilities of all sizes participate with the smallest having only one employee and the largest employing more than 18,000 (Figure 3). Sixty-seven members are registered to ISO 14001 by third-party auditors and three have been deemed functionally equivalent by ESI staff. In 2015, four member facilities closed and eight chose to drop out of the program rather than submit the required ESI annual report. In 2015, 11 sites joined the ESI (Figure 4).

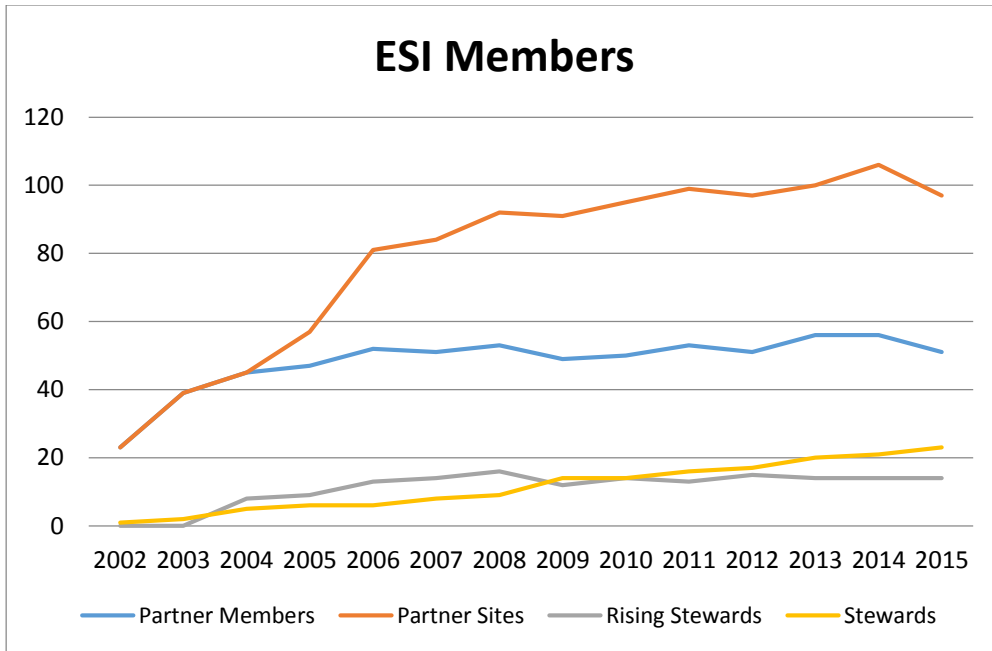


Figure 2: ESI Membership Growth, 2002-2015

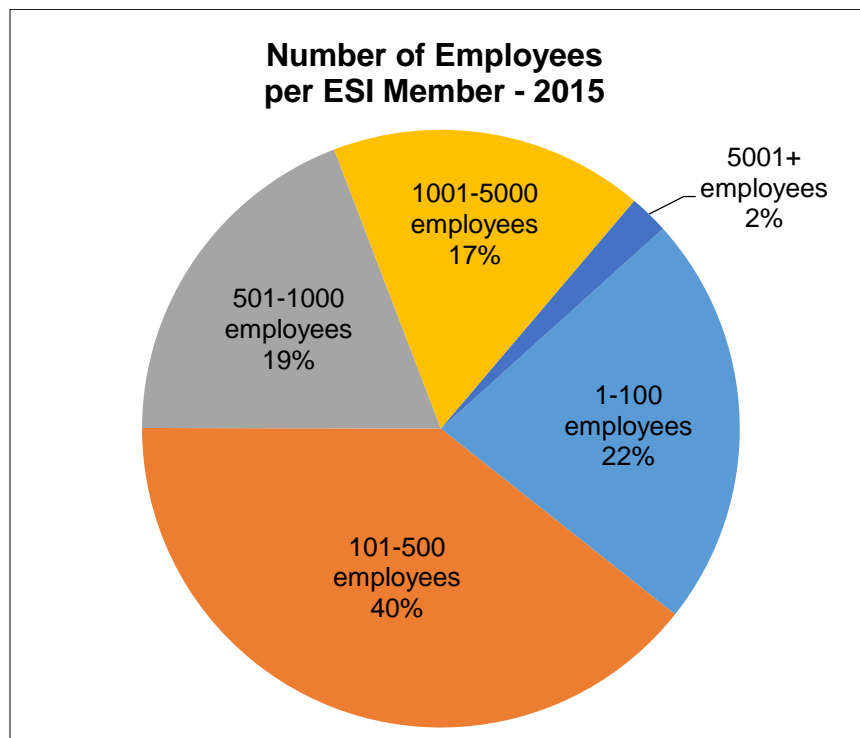


Figure 3: 2015 Graph of ESI Members by Number of Employees

2015 ESI New Members

Facility Name	ESI Level	Year Entering Program	City	County
Ajinomoto North America, Inc. - Raleigh, NC Plant	P	2015	Raleigh	Wake
American Emergency Vehicles	P	2015	Jefferson	Ashe
American Snuff Company / Taylor Brothers	P	2015	Winston-Salem	Forsyth
Caterpillar-Clayton, NC	P	2015	Clayton	Johnston
General Electric Aviation - Durham Engine Facility	P	2015	Durham	Durham
HAECO Airframe Services	P	2015	Greensboro	Guilford
Iredell Fiber, Div. of Leggett & Platt	P	2015	Statesville	Iredell
PRC Industries	P	2015	Spruce Pine	Mitchell
TE Connectivity - Burgess Rd	S*	2015	Greensboro	Guilford
Liberty Tire Recycling, LLC - Central Carolina Holdings	P	2015	Cameron	Moore
Liberty Tire Recycling, LLC - U.S. Tire Recycling	P	2015	Concord	Cabarrus

* Entered as Partner in Spring and moved to Steward in the Fall

Figure 4: 2015 New ESI Members

Member Goals

In 2015, ESI members reported on 251 goals that covered multi-media regulated and non-regulated impacts. As shown in Figure 5, the greatest number of goals set in 2015 were related to energy use reductions.



Figure 5: Graph of 2015 ESI Member Goals

Member Reductions

ESI members are required to report on performance toward environmental goals and reductions in environmental impacts. While there are 134 sites in the program, there are eight multi-site members reporting. Therefore, 76 members reported progress toward these goals, resulting in the following environmental impact reductions (See Tables 2 through 5). Members' reductions are included in the final compilation after being in the program for one full year. All reduction data are self-reported by member facilities and are not verified by the N.C. Department of Environmental Quality. While reductions are only counted in the first year of their occurrence, most are permanent reductions.

Year	Total Cost Savings
2004	NA
2005	\$ 12,721,772
2006	\$ 10,393,930
2007	\$ 2,961,039
2008	\$ 4,523,391
2009	\$ 3,070,439
2010	\$ 3,270,504
2011	\$ 13,292,968
2012	\$ 5,262,972
2013	\$ 836,537
2014	\$ 2,188,478
2015	\$ 2,626,307
Totals	\$ 61,148,337

Table 2: Total cost savings from environmental projects reported 2004-2015

ESI members saved enough money on environmental projects in one year to pay the salary of almost 88 people earning \$30,000 per year.

ESI members saved enough energy in one year to power almost 293,000 average North Carolina homes for a year.

Year	Energy Reductions	GHG Emission Reductions *	Air Emission Reductions**
2004	11,736.51	NA	296.84
2005	48,451.00	NA	208.14
2006	123,821.27	NA	231.63
2007	28,527,501.45	9,370.00	243.08
2008	9,196,666.00	5,466.00	29.46
2009	1,549,174.68	64,223.74	155.41
2010	598,590.94	1,444.00	46.11
2011	1,626,533.99	18,677.40	4.27
2012	547,877.71	1,276.53	12.89
2013	8,643,348.46	2,041.13	72.75
2014	79,174.69	11,136.33	112.03
2015	22,289,628.84	818.13	76.28
Total	73,242,505.54	114,453.26	1,488.88
Units	mmBtu	Metric Tons CO2e	Tons
*Indirect not reported in energy reductions			
**Not including GHG emission reductions			

Table 3: Energy and air emission reductions 2004-2015

Year	Water Use Reductions	Wastewater Volume Reductions	Wastewater Pollutant Reductions
2004	369,529,216	NA	379.40
2005	54,201,286	85,566,162	527.00
2006	591,356,273	106,092,200	399.95
2007	83,929,264	881,690	0.02
2008	183,587,248	202,701	104.61
2009	1,444,617,822	18,304,480	137.93
2010	41,895,325	20,449,660	3.60
2011	347,399,898	5,904,175	7,209.60
2012	455,656,908	10,862,255	229.88
2013	547,725,143	16,252	3,616.37
2014	2,105,928,788	7,381,860	11,139.25
2015	2,439,754,313	1,690,643	3,530.32
Totals	8,665,581,485	257,352,078	27,278
Units	Gallons	Gallons	Tons

ESI members saved enough water in one year to fill more than 110,000 average-sized swimming pools

Table 4: Water and wastewater reductions

Year	Hazardous Waste Reductions	Landfilled Waste Reductions	Material Consumption Reductions	Total Biosolids Volume	Total Biomass Recovered*	Total Recycled Volume
2004	12.31	996.93	508.73	NA	NA	10,015.11
2005	119.00	82,453.10	37,728.00	7,208,691	NA	8,047.48
2006	405.16	59,441.11	973.20	2,720,350	NA	12,594.15
2007	12.52	205,168.79	59.60	18,410,000	NA	23,986.29
2008	200.32	737.28	2,135.70	Not Reported	2,783.00	4,777.12
2009	10.10	4,072.40	639.46	Not Reported	258,635.00	34,233.11
2010	5.77	10,245.22	1,792.20	Not Reported	333,374.90	36,666.68
2011	14.90	3,754.55	115.37	Not Reported	346,436.60	29,901.00
2012	4.27	3,071.32	665.55	Not Reported	2,958.60	33,836.74
2013	37.32	1,604.67	24.32	Not Reported	3,122.40	46,349.80
2014	1,538.20	11,505.19	23,073.14	Not Reported	17.40	32,158.18
2015	283.53	42,737.20	589.07	Not Reported	54,359.91	42,150.28
Totals	2,643.39	425,787.76	68,304.34	28,339,041	1,001,687.81	314,715.95
Units	Tons	Tons	Tons	Gallons	Tons	Tons

*Category created for compost/mulch related goals

Table 5: Solid and hazardous waste reductions, material consumption reductions and beneficial use totals 2004-2015

Reducing energy usage, water usage and solid waste generation as well as recycling were the most common reduction goals of ESI members in 2015.

- Forty-eight goals related to reducing consumption of energy (natural gas, propane and electricity) as well as fuel used in fleets (gasoline and diesel) were reported with a reduction of more than 22 million mmBtus (million British Thermal Units, or BTUs). Improving process efficiencies and re-lamping projects were the main contributors to these reductions.
- Twenty-seven goals related to water reduction were reported with reductions of more than 2 billion gallons of water used, due to improvements in efficiency.
- Forty goals related to solid waste and 31 related to recycling were reported with a reduction of almost than 43,000 tons of waste going to the landfill and more than 42,000 tons of material being recycled. Also, seven sites reported having a zero-waste-to-landfill goal. Reductions in material consumption also reduce solid waste impacts. Twelve goals were established related to reducing material consumption. This reduced material consumption by 589 tons and saved members \$944,530.

Facilities also reported reductions in hazardous waste, wastewater volume, wastewater pollutants and greenhouse gas emissions in 2015. Increasing biomass recovery was also reported.

- Five goals were reported on hazardous waste reduction that resulted in reducing hazardous waste by more than 283 tons. A more beneficial disposal method for medical waste was the largest contributor to this savings.
- Two goals related to biosolids recovery from a wastewater treatment plant were reported, and additional data was provided on composting and other organic material recovery such that more than 54,000 tons of organic material was diverted from landfills into beneficial uses.
- Eleven goals were reported on air pollutant reduction. This resulted in 73 tons of air pollutant reductions related to volatile organic compounds.
- Four facilities reported wastewater volume reductions of more than 1.6 million gallons.
- Ten goals were related to wastewater effluent pollutant reductions.
- Ten facilities reported on reduction activities in indirect greenhouse gas emissions that were not included in the energy reductions.

Greenhouse Gas Reductions

Energy reductions can be converted to greenhouse gas reductions. Table 6 and Figure 6 show the breakdown of reductions in energy use and the subsequent metric tons of carbon dioxide prevented from entering the atmosphere. They also include the greenhouse gas reductions that were reported separate from energy reductions. The Simplified Greenhouse Gas Calculator tool provided by the EPA Climate Leaders program was used to convert the heating values to metric tons of carbon

dioxide equivalent. This tool can be found under Pollution Prevention Tools and Calculators under the calculators tab here: <http://www2.epa.gov/p2/pollution-prevention-tools-and-calculators>.

2015 Reported Greenhouse Gas Reductions

	mmBtu	metric tons CO ₂ e
Electricity	22106225.51	5483331.30
Natural Gas	139424.9086	33365.15
Diesel	16139.28691	1318.44
Gasoline	14710.674	1140.98
GHG (not reported in energy reductions)	6227.158201	818.13
Propane	6901.304146	19.68
Residual Oil	0	0.00
Distillate Oil	0	0.00
Coal	0	0
E-85	0	0
Total Energy	22289628.84	5519993.67

Table 6: Greenhouse Gas Reductions Reported for 2015

In one year ESI members reduced greenhouse gas emissions equivalent to over 1,166,000 passenger vehicles driven for one year!

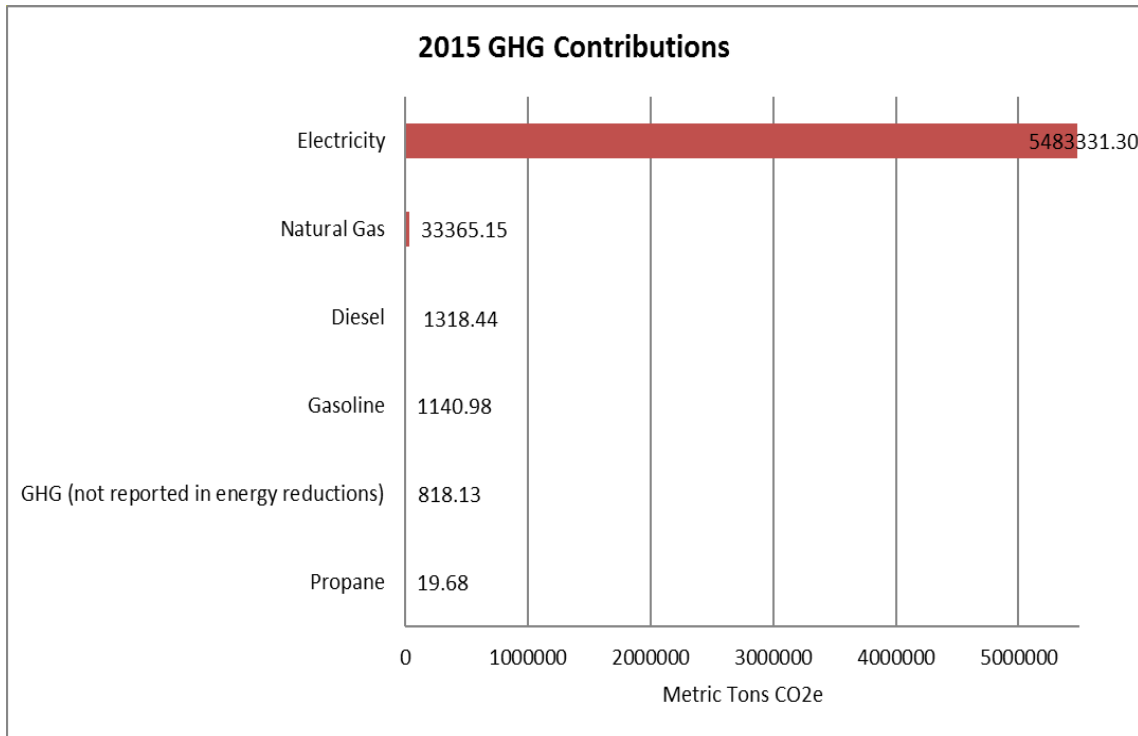


Figure 6: 2015 Greenhouse Gas Emission Reductions by Energy Source in Metric Tons CO2e

Cost Savings

More than \$2 million in cost savings were reported by the ESI members for projects conducted in 2015. Savings were reported on 12 facility goals with most dollars saved through energy reduction projects. Savings were also reported from material consumption, water and wastewater reductions as well as recycling and biomass (landfill avoidance). Figure 7 shows the breakdown of cost savings by goal type.

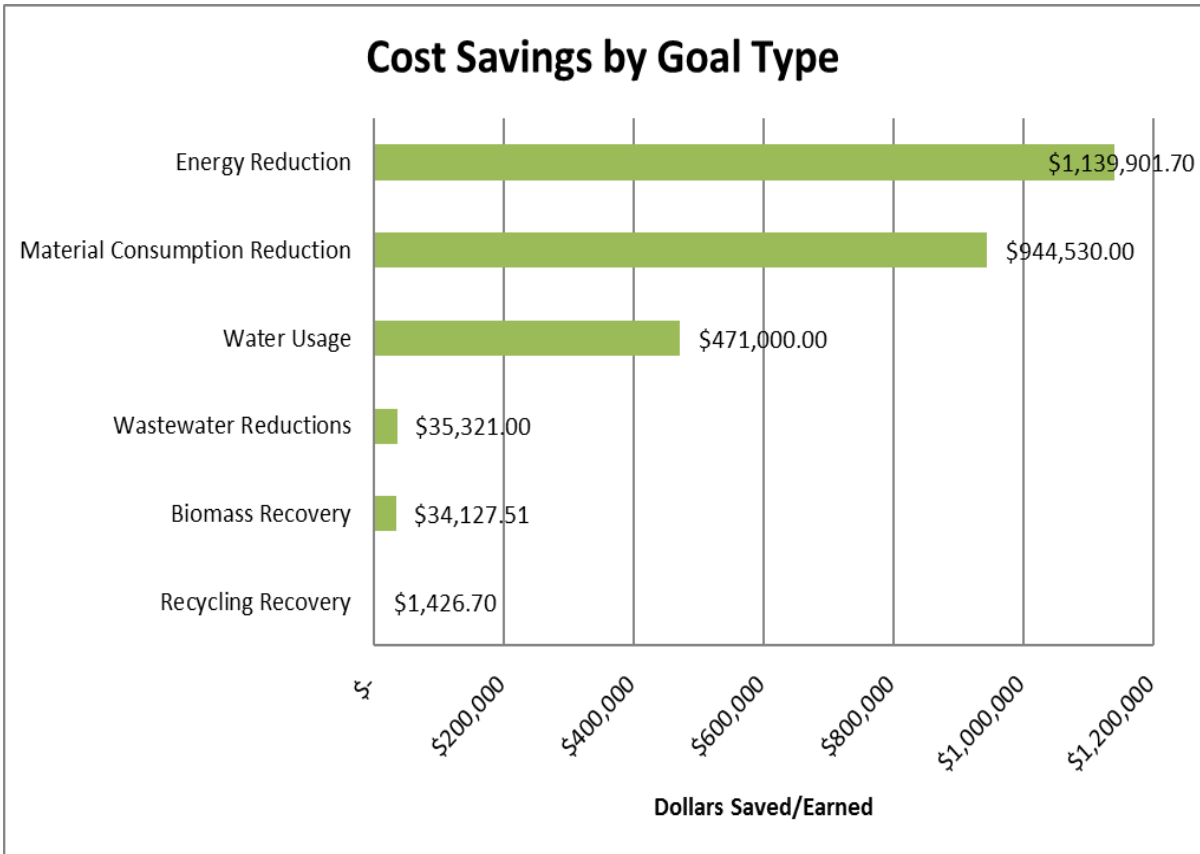


Figure 7: 2015 ESI Member Cost Savings by Goal Type

Community Involvement

In addition to reporting on goals, the participants also submit information on their environmental involvement in the community. ESI Stewards are required to communicate with their communities about their environmental performance. Although only the Stewards are required to report these activities, other participants may choose to report their activities as well. For 2015, 269 activities were reported by 40 members. The following graph in Figure 8 shows the breakdown of activities.

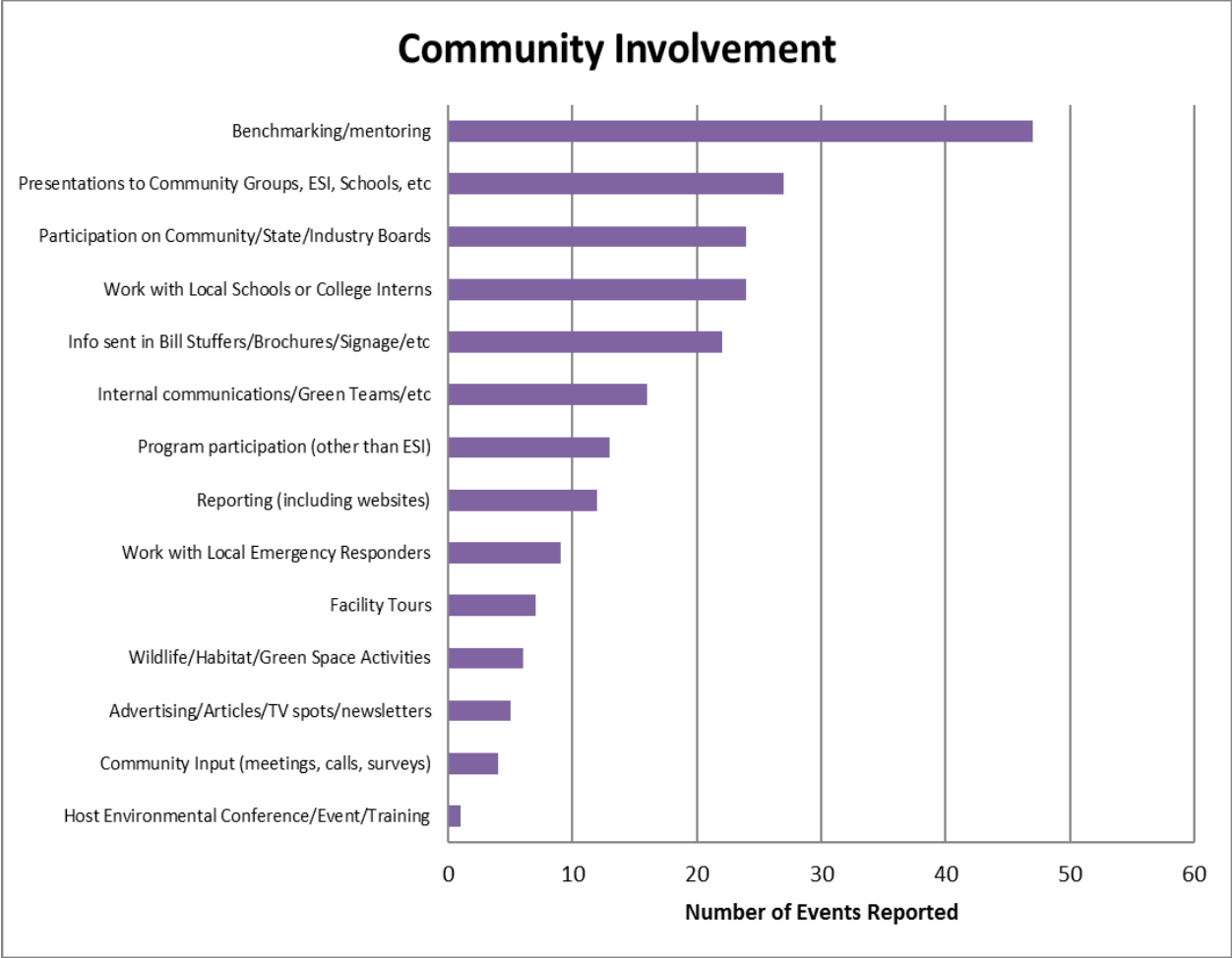


Figure 8: 2015 ESI Member Community Involvement

Program Updates

The ESI operates on a limited budget that is funded by a federal grant and appropriations from the N.C. General Assembly. From 2002 through 2005, 560 actions were recorded by employees with the N.C. Department of Environmental Quality related to EMS development and assistance. These activities included site visits, presentations, meetings and other technical assistance. See Figure 9 below for a breakdown of 2006 through 2015 actions. Outreach includes training classes provided by ESI staff, speaking engagements, booths at various events and other program marketing activities. Site visits are made specifically to ESI or potential ESI member sites. Assistance provided includes all other information provided through email and phone calls, including the electronic newsletter to our ESI members.

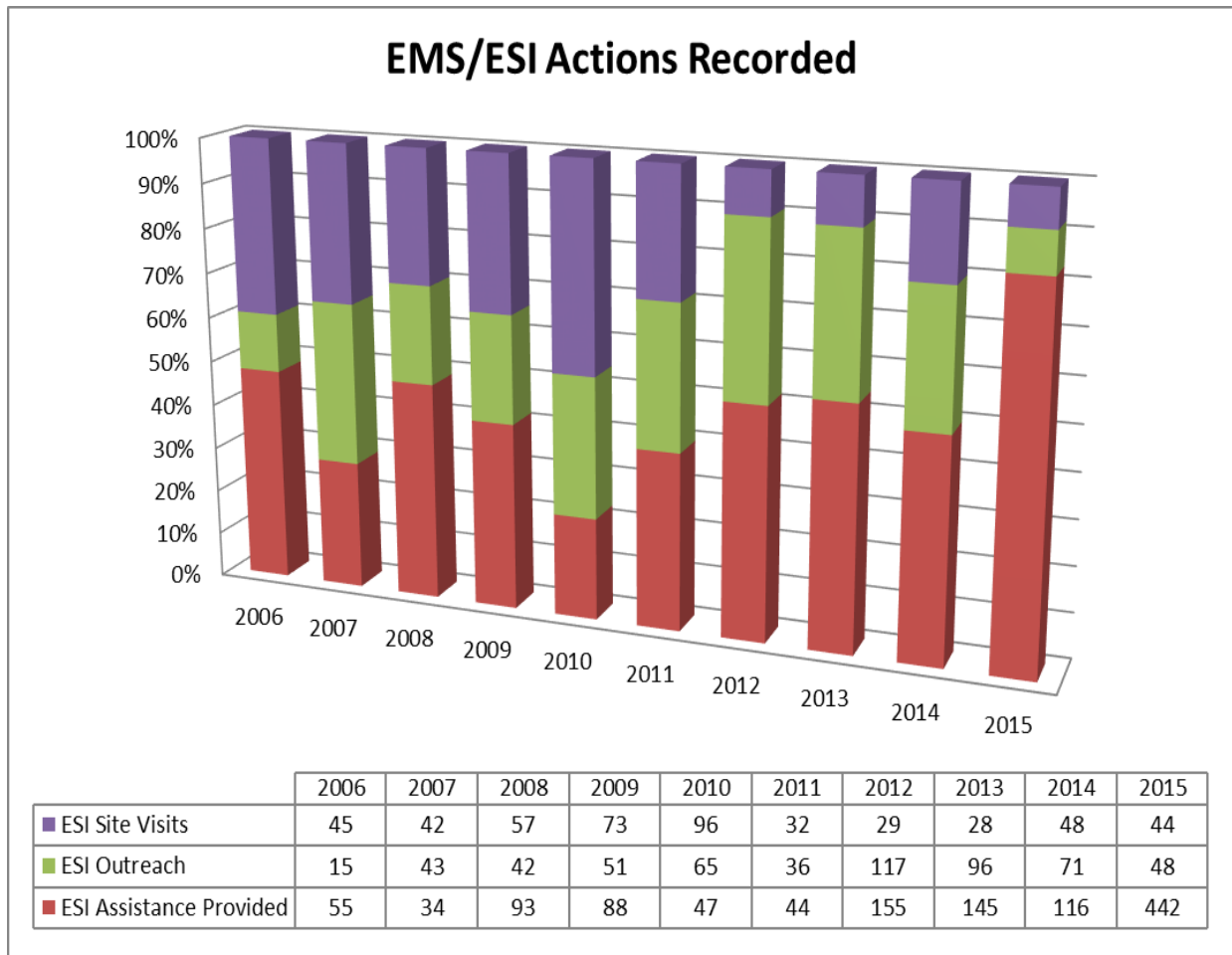


Figure 9: ESI Actions 2006-2014

Partner applications are accepted year-round and reviewed quarterly by the DEQ Internal Workgroup. In 2012, ESI began accepting Steward and Rising Steward applications year-round as well. The advisory board meets to review applications and site visit reports twice per year. While applications at the higher levels are in process, the applicants are processed as Partners in order to begin receiving benefits such as newsletters and training notifications.

Following receipt of an application, an environmental compliance check is completed to determine if the facility has been under environmental criminal indictment or convicted within the last two years, as well as identify any compliance issues (Figure 10).

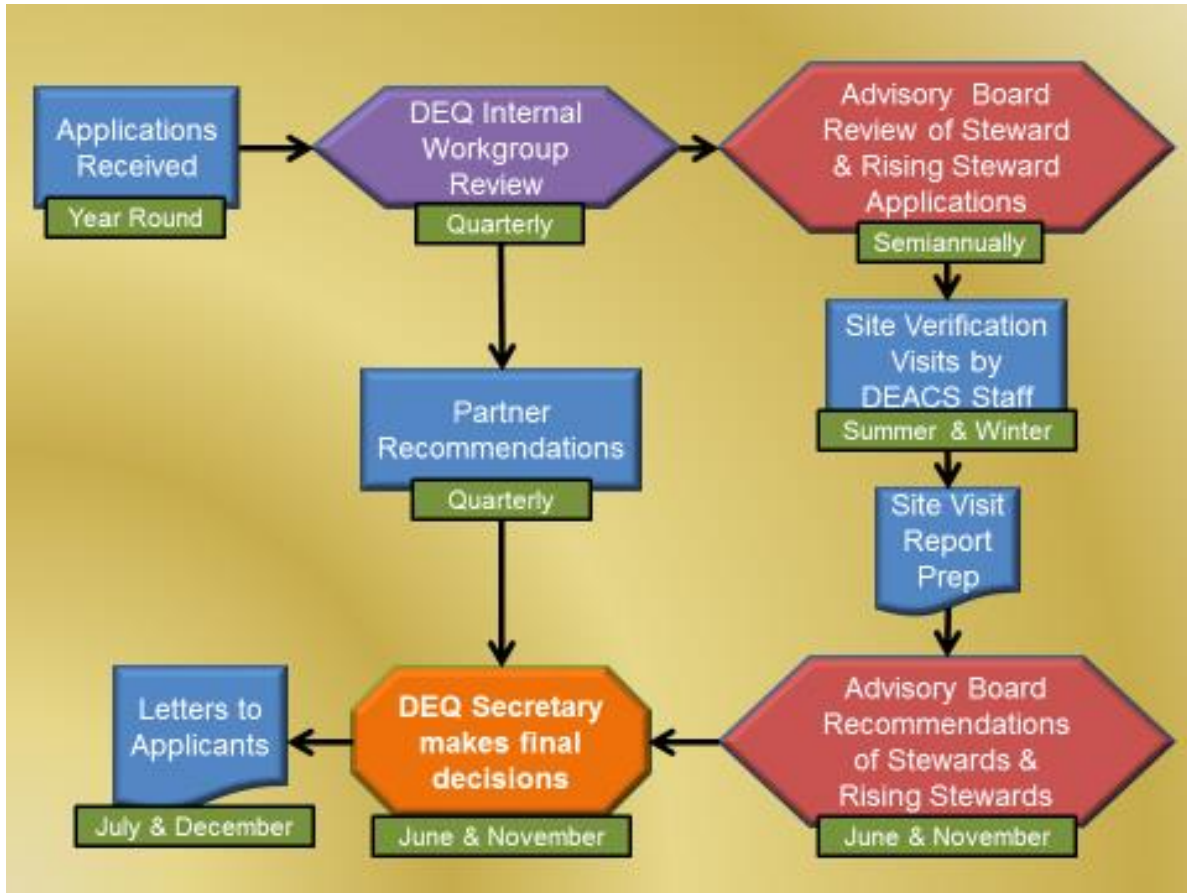


Figure 10: Application Process Diagram

The DEQ Internal Workgroup reviews all Partner applications and makes a recommendation to the DEQ secretary regarding acceptance into the program. The internal workgroup reviews Rising Steward and Steward applications to provide regulatory and compliance information to the ESI Advisory Board. The internal workgroup is comprised of the following representatives (Table 7) from regulatory divisions within DEQ:

2015 DEQ Internal Workgroup Members

Name	Division
Bernard McKee	DAQ
Vanessa Manuel	DWR
David Lee	DEACS
John Evans	Chief Deputy Secretary
Paula Hemmer	DAQ
Shawn Mckee	DWM
Sushma Masemore	DAQ
Toby Vinson	DEMLR

Table 7: 2015 DEQ Internal Workgroup Members

Following the compliance review by the Internal Workgroup, the Rising Steward and Steward applications are presented to the ESI Advisory Board.

The Department of Environmental Quality’s secretary established a volunteer advisory board to oversee program development and implementation. Membership consists of manufacturers, industries, industry trade groups, environmental and citizen nongovernmental organizations, small businesses, representatives of city and county governments, DEQ representatives and others as deemed appropriate. A DEQ employee appointed by the secretary serves as the board’s chairperson. Whenever possible, Environmental Stewards are given priority for membership for the business, government and at-large seats. Membership on the advisory board rotates every four years and is capped at 15 members. The 2015 board is listed in Table 8 below.

2015 Advisory Board Members

Name	Organization	Representation
Daniel Bagnell	The Scrap Exchange	Small Business
Jan Comer	Engineered Sintered Components	Steward - Large Business
John Evans	N.C. DEQ	N.C. DEQ - Chair
Tausha Fanslau	Bridgestone Americas Tire Operations	Steward – Large Business
Tim Fasolt	EMC Corporation	Steward - Large Business
Kimberly Killian	GKN Sanford Precision Forming	Steward – At Large
Mary Joan Pugh	N.C. Zoological Park	Steward – State/Federal Facility
David Shellenbarger	City of Gastonia	Steward - Local Government
Steve Street	Hickory Manufacturing Technology Center – Corning Cable Systems	Steward – At Large

Table 8: 2015 Advisory Board Members

Rising Steward and Steward applicants receive an on-site verification visit by DEQ staff to ensure the Environmental Management System is functioning and gather observations supporting the organization’s application. All information obtained through the application and the on-site verification visit is documented and collated into a report that is presented to the advisory board for review. The advisory board then makes recommendations to the DEQ secretary regarding acceptance of the Rising Steward and Steward applicants.

The DEQ secretary reviews recommendations made by the advisory board and makes the final decisions. Organizations accepted into the program are usually announced in December and June.

Membership

Using pollution prevention and other innovative approaches, this voluntary effort offers benefits to members for developing and implementing programs to meet and go beyond regulatory requirements.

Any company or organization that operates one or more facilities in North Carolina and whose activities impact the environment is eligible to participate in the ESI. This includes manufacturers, businesses, agribusiness, service providers, government agencies, schools and nonprofit organizations. Members can enter the program at any of the three tiers: Environmental Partner, Rising Environmental Steward or Environmental Steward. Membership criteria in the ESI varies depending on the tier. In 2012, changes were made to open the Partner level to a wider range of interested organizations while still maintaining the integrity of the program at the Steward and Rising Steward levels.

Criteria

The Environmental Partner level is designed for adoption by a broad range of organizations that are interested in beginning the process of developing a systematic approach to improving their environmental performance. In 2012, Partners were given the option to implement measurable goals in lieu of developing an environmental management system. Additionally, Partners are no longer required to be regulated by DEQ to apply. Partner applications may include multiple sites. By year end of 2015, the program had 97 Environmental Partner sites.

To be considered at the Partner level, the following criteria must be met:

- Demonstrate commitment to compliance.
- Set environmental performance goals that include pollution prevention and are appropriate to the nature, scale and environmental impact of the organization and/or commit to developing, implementing and maintaining an environmental management system based on ISO 14001 or a functionally equivalent model.
- Not be under any environmental criminal indictment or conviction.
- Agree to report annually on progress toward the organization's environmental performance goals, reductions in environmental emissions and/or discharges of releases, solid and hazardous waste disposal, use of energy and water and any reportable non-compliance events.



Kim Killian of GKN Driveline - Sanford accepts a plaque from Ted Bush, director of the N.C. Division of Environmental Assistance and Customer Service. The plaque recognized the GKN Driveline facility for its 10-year renewal at the Steward level.

The Rising Environmental Steward level is designed for those organizations that have a mature environmental management program. Rising Steward applications must be for a single site. The program had 14 Rising Environmental Stewards by Dec. 31, 2015.

Rising Environmental Steward applicants must meet all Partner criteria and the following:

- Set measurable environmental performance goals that are adopted into the framework of the EMS, and must demonstrate annual improvements to performance.
- Demonstrate a mature EMS based on ISO 14001 or a functionally equivalent model. The EMS for the site must be ISO 14001 third-party certified or be reviewed on-site and deemed functionally equivalent by DEQ staff.
- Have current or past regulatory oversight or demonstrate exemplary business and environmental practices normally expected of Rising Stewards.
- Demonstrate commitment to meet and go beyond compliance.

The Environmental Steward level is for those organizations that display a commitment to exemplary environmental performance beyond what is required by law. Steward applications must be for a single site. By year end of 2015, the program had 23 Environmental Stewards.

Environmental Steward applicants must meet all Partner and Rising Steward criteria and the following:

- Set aggressive environmental performance goals.
- Have a process for communication with the local community on program activities and progress toward performance goals.
- Demonstrate how the Environmental Management System is integrated into core business functions.
- Agree to be a mentor to Environmental Partner and Rising Environmental Steward participants.



Sam Hayes (seen holding plaque on the right), DEQ's General Counsel, presents employees at TE Connectivity – Burgess Road with a plaque to recognize them as an Environmental Steward.

Rising Stewards and Stewards are reassessed after five years of membership for renewal at their current level. Partner participants are reviewed annually, through their annual report submissions, to assess progress made toward environmental performance and overall program goals.

Benefits

All levels of ESI members are eligible for the following:

- Technical assistance on developing an Environmental Management System (EMS), pollution prevention approaches, environmental management and treatment technologies and maintaining compliance with local, state and federal regulations;
- Specialized training;

- Networking opportunities;
- Recognition of program participation;
- Use of a program logo for the achieved level;
- Coverage by U.S. EPA and DEQ self-reporting policies;
- A single point of contact within DEQ; and
- Other benefits as deemed appropriate by the secretary based on recommendations from the advisory board.

Partners and Rising Stewards have the additional benefit of access to Stewards as mentors where appropriate. Environmental Stewards have the following additional benefits:

- Formal public recognition from the secretary of DEQ that may include an on-site award ceremony, public announcements and press releases.
- Participation in the Steward Forum chaired by the DEQ secretary.
- Priority membership on the ESI Advisory Board when appropriate positions are available.

During the annual members' meeting, facilities accepted into the program at the Environmental Partner level receive a certificate of recognition signed by the DEQ secretary. Rising Environmental Stewards receive a plaque recognizing their achievement. Environmental Stewards accepted into the ESI receive a personal letter signed by the DEQ secretary. The secretary also presents Stewards with a large plaque during an on-site ceremony. DEQ highlights members' participation in press releases, the ESI website, newsletters and/or social media posts.

Conclusions

The results from the ESI annual report show that an approach that exceeds regulatory requirements can lead to positive impacts for regulated pollutants and non-regulated environmental and economic factors. This DEQ program is unique in its ability to collect environmental data across media, including monetary savings associated with the environmental improvements made. These savings to the financial and environmental bottom line help North Carolina organizations to be resilient and promote economic growth. The Environmental Stewardship Initiative encourages North Carolina organizations to share their environmental success stories with each other across sectors in order to provide a better environment for everyone in the state.

2015 ESI Members

Stewards:

- ASMO North Carolina Inc. - Statesville
- Bridgestone Americas Tire Operations LLC - Wilson
- City of Gastonia Crowders Creek Resource Recovery Facility
- City of Gastonia Long Creek Resource Recovery Facility
- City of Gastonia Water Treatment Plant
- Corning Inc. – Wilmington
- Daimler Trucks North America LLC - Cleveland
- EMC Corporation – Apex
- Engineered Sintered Components – Troutman
- Firestone Fibers & Textiles – Kings Mountain
- Fleet Readiness Center East - Cherry Point
- GKN Driveline- Sanford Precision Forming Facility – Sanford
- Hickory Cable Facility, Corning Cable Systems
- John Deere Turf Care – Fuquay-Varina
- Keihin Carolina System Technology, LLC – Tarboro
- N.C. Zoological Park – Asheboro
- Santa Fe Natural Tobacco Knotts Grove Campus - Oxford
- Smithfield Packing Company – Wilson
- Stanley, Black & Decker - Kannapolis
- TE Connectivity - Pegg Rd – Greensboro
- TE Connectivity – Burgess Rd - Greensboro
- Thomas Built Buses, Inc. – High Point
- U.S. Environmental Protection Agency - RTP



Rising Stewards:

- ASMO North America Inc. – Greenville
- AW North Carolina Inc. - Durham
- Bridgestone-Bandag, LLC - Oxford
- City of Gastonia Resource Recovery Farm
- Daimler Trucks North America LLC – Gastonia
- Eaton Corporation, Raleigh Production Operations
- Eaton Corporation, Youngsville Plant Operations
- Firestone Fibers & Textiles Company, Gastonia
- GKN Driveline - Roxboro
- GKN Sinter Metals – Conover
- Grifols Therapeutics - Clayton
- NACCO Materials Handling Group - Greenville
- Smithfield Farmland - Tar Heel Facility
- Qorvo, Inc - Greensboro



Partners:

- Ajinomoto North America, Inc. - Raleigh
- Alliance One International Inc. (5)*
- American Emergency Vehicles
- American Snuff Company / Taylor Brothers
- Baker Furniture –Hildebran
- Baker Furniture - High Point
- Borg Warner Thermal Systems – Fletcher
- BorgWarner Turbo Systems - Arden
- Burt's Bees Inc. – Morrisville
- Cape Fear Public Utility Authority (9)*
- Cascades Tissue Group – North Carolina Inc. – Rockingham
- Caterpillar BCP - Sanford
- Caterpillar - Clayton
- Charlotte-Mecklenburg School System
- City of Gastonia Public Works Division
- City of Hendersonville Water Treatment Plant
- City of Shelby First Broad River Wastewater Treatment Plant
- City of Shelby Water Plant
- Crown Equipment - Kinston
- Daimler Trucks North America LLC - Mt Holly
- Domtar Paper Company, LLC - Plymouth
- Eaton Corporation CPO – Raleigh
- Eno River State Park
- Falls Lake State Recreation Area
- Freudenburg Nonwovens - Durham
- General Electric Company – Aviation – RTP
- General Electric Company – Industrial Solutions – Mebane
- Haeco Airframe Services - Greensboro
- Hanging Rock State Park
- High Point Furniture (2)*
- International Paper - Riegelwood Mill
- Iredell Fiber, Div. of Leggett & Platt - Statesville
- Kao Specialties Americas, LLC – High Point
- Leggett & Platt ON64 - High Point
- Liberty Tire Recycling, LLC (2)*
- Mecklenburg County Solid Waste Operations (4)*
- Medoc Mountain State Park
- Michelin Aircraft Tire Co. - Norwood
- Momentive Specialty Chemicals – Morganton
- MVP Group International - Elkin
- NIEHS - RTP
- N.C. DOT Ferry Division (9)*
- Pfizer – Sanford
- Pilot Mountain State Park
- PRC Industries – Spruce Pine
- PSNC Energy Carolinas Inc. (21)*
- Siemens Medical Solutions, CSG Service Headquarters - Cary
- Smithfield Clinton Plant
- Universal Leaf North America US Inc. (2)*
- Water and Sewer Authority of Cabarrus County (3)*

