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### Regarding the Explanatory Notes:

Note: Explaining the increase and decrease of individual passages

† : Comments on the entire chart

\*: Definition of words

## Environmental Data

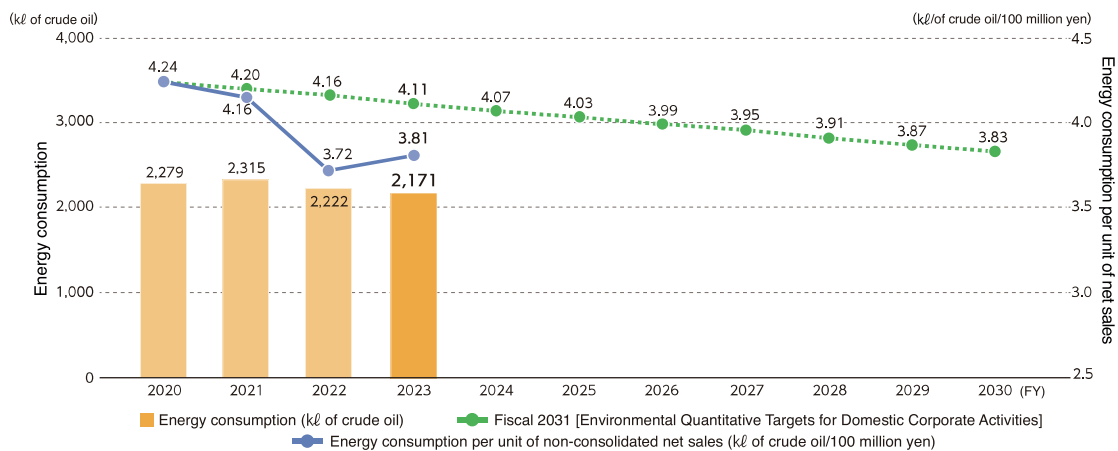
### Progress on Fiscal 2031 Environmental Quantitative Targets

Based on “The Electrical and Electronics Industries ‘Carbon Neutrality Action Plan’” proposed by the industrial community with the aim of reconciling corporate growth and global warming policies, we have set quantitative targets for each fiscal year and are managing the progress of measures to curtail environmental impacts in order to achieve the fiscal 2031 environmental quantitative targets.

#### “Promotion for Energy Saving” through domestic corporate activities

Throughout Japan, reduce the energy consumption per unit by 9.56% in fiscal 2031 compared to the base year (Fiscal 2021). (Reduce the energy consumption per unit of non-consolidated net sales to 3.83 kℓ of crude oil/100 million yen or less in fiscal 2031.) The yearly average improvement in the energy consumption per unit of net sales is set at 1%.

**Figure 1** Changes in Energy Consumption and Energy Consumption Per Unit of Net Sales by Domestic Corporate Activities



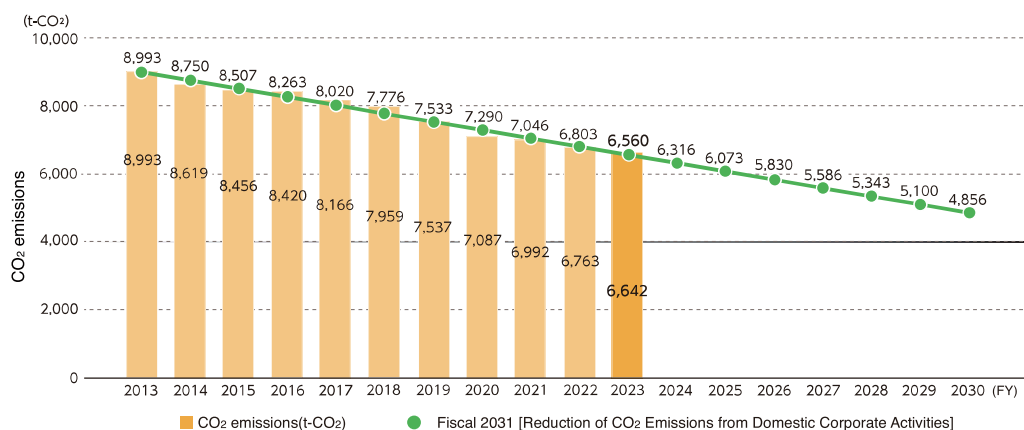
Scope of calculation: Energy consumption at all of RISO KAGAKU CORPORATION'S non-consolidated domestic sites (excluding fuel used for outsourced logistics and company-owned vehicles). Net sales refer to non-consolidated net sales.  
We reviewed the scope of calculation for setting the environmental quantitative targets for fiscal 2031.

#### Taking on “the Challenge for Reducing CO<sub>2</sub>” through domestic corporate activities (non-binding targets)

Throughout Japan:

- 1) Reduction of energy-originated CO<sub>2</sub> emissions at domestic sites; and
- 2) Challenging to reduce them by around 46% compared to the base year (fiscal 2014)

**Figure 2** Changes in CO<sub>2</sub> Emissions from Domestic Corporate Activities



Scope of calculation: Energy consumption of all domestic sites, fuel consumption of company-owned vehicles, outsourced logistics for products and services under the jurisdiction of the logistics department, and CO<sub>2</sub> emissions in conjunction with those.  
We reviewed the scope of calculation for setting the environmental quantitative targets for fiscal 2031.

## Environmental Data

Figure 3 Fiscal 2024 Environmental Quantitative Targets and Achievements; Fiscal 2025 Environmental Quantitative Targets

Category	Reduction of CO <sub>2</sub> emissions		
Scope of application	All domestic operations and overseas production subsidiaries	All domestic operations	Total for all domestic production sites
Fiscal 2024 Environmental Quantitative Targets	Reduce to 7,558 tons-CO <sub>2</sub> or less.	Reduce to 6,632 tons-CO <sub>2</sub> or less.	Reduce to 2,551 tons-CO <sub>2</sub> or less.
Fiscal 2024 Activity Results	7,580 tons-CO <sub>2</sub>	6,642 tons-CO <sub>2</sub> <span>Note 1</span>	2,491 tons-CO <sub>2</sub>
Rating	△	△	○
Fiscal 2025 Environmental Quantitative Targets	Reduce to 7,594 tons-CO <sub>2</sub> or less.	Reduce to 6,645 tons-CO <sub>2</sub> or less.	Reduce to 2,531 tons-CO <sub>2</sub> or less.

Rating symbols: ○: Achieved; △: Improved; ×: Not Achieved

Note 1 The difference from the CO<sub>2</sub> emissions in fiscal 2024 (7,083 tons- CO<sub>2</sub>/year) in Figure 4 occurred because this amount includes contracted transport whose scope of calculation in Figure 4 is not under the jurisdiction of the logistics department.

## KEY POINT

In fiscal 2024, we continued to update energy-efficient equipment such as air conditioners or lighting; however, we didn't make proactive investment with equipment that would make great reduction of CO<sub>2</sub> emissions.

There was not an increase in CO<sub>2</sub> emissions compared to fiscal year 2023.

We are examining using reusable energy or introducing non-conventional approaches to reduce CO<sub>2</sub> emissions.

Figure 4 Environmental Burden throughout Japan (Fiscal 2024)

INPUT					OUTPUT							
		FY2023	FY2024	Compared to FY2023			FY2023	FY2024	Compared to FY2023			
Energy consumption and CO <sub>2</sub> emissions, resource input amount, waste generation, etc. in all business activities within Japan												
Energy consumption	GJ/yr	120,962	Note 1	118,728	98	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	7,217	Note 1	7,083	98	
Electricity	MWh	7,849	Note 1	7,659	98	Electricity	t-CO <sub>2</sub> /yr	4,356	Note 1	4,251	98	
Bunker A	kℓ	34		30	89	Bunker A	t-CO <sub>2</sub> /yr	92		82	89	
LPG	t	104		98	94	LPG	t-CO <sub>2</sub> /yr	313		295	94	
Kerosene	kℓ	0		0	—	Kerosene	t-CO <sub>2</sub> /yr	0		0	—	
City gas	1,000 m3	50		55	110	City gas	t-CO <sub>2</sub> /yr	111		123	110	
Gasoline	kℓ	398		407	102	Gasoline	t-CO <sub>2</sub> /yr	940		959	102	
Diesel	kℓ	1		0	43	Diesel	t-CO <sub>2</sub> /yr	2		1	43	
Volume of contracted transport*6	10,000 t-km	750		686	91	Volume of contracted transport*6	t-CO <sub>2</sub> /yr	1,402		1,374	98	
Water consumption	m3	24,046		23,224	97	Water drainage	m3	21,901		21,462	98	
						Steam, water, and related emissions	m3	0		0	—	
Product parts and materials	t	4,895		4,238	87	Products*5	t	7,140		6,096	85	
Collection of used products	t	2,062		2,009	97	Used product/waste disposal volume*1	t	2,842		2,720	96	
						Volume transferred to recycling processes*7	t	239		213	89	
						Volume recycled*2	t	2,578		2,456	95	
						Other*3	t	4		10	229	
						Final disposal (landfill)*4	t	21		40	187	Note 2

Scope of calculation: INPUT and OUTPUT in the Figure 5 "Environmental Burden in Japan by Operational Process (Fiscal 2024)" (p4) are calculated.

Calculation target: At the head office, sales, development/designs and production sites, energy consumption and associated CO<sub>2</sub> emissions, water consumption and water drainage, and waste generation; at production sites, material input in production; at domestic logistics and transportation sites, fuel consumption by company-owned vehicle operations, and contracted transport volume (from not only the logistics department but also others), and associated CO<sub>2</sub> emissions; at sites of collection, reuse and recycling, volumes of used products collected and waste generation.

Note 1 There was an error in the figure for fiscal 2023 and accordingly, it has been corrected.

Note 2 This was due to the disposal of equipment.

\*1 Waste generation: RISO classifies all unwanted substances generated from its operational processes, including valuable resources and resources to be recycled or reused, as waste.

\*2 Volume recycled: Total volume of materials for recycling and thermal recycling, including valuable resources. The volume to be reused in operational processes is excluded.

\*3 Other (waste generation): The volume of gas emissions from recycling processing and incineration.

\*4 Final disposal (landfill): The volume to be disposed of in landfill sites, which includes residues and incinerated ash from intermediate processing such as recycling.

\*5 Major products: ComColor high-speed color printers, RISOGRAH digital duplicators, and inks, masters, and other supply products for ComColor and RISOGRAH.

\*6 Volume of contracted transport using external carriers: Volume of contracted transport (for delivery, procurement, collection, etc.) of products, parts, used products, and waste.

\*7 Volume transferred to recycling processes: The amount of recycled materials to be reused as raw materials in operational processes.

● CO<sub>2</sub> Emissions Calculations

Electricity: For Japan, a conversion value of 0.555kg-CO<sub>2</sub>/kWh was used throughout the year, and for overseas, conversion values in IEA statistical data for each country were applied.

Bunker A: 2.71 kg CO<sub>2</sub>/L LPG: 3.00 kg CO<sub>2</sub>/kg Gasoline: 2.32 kg CO<sub>2</sub>/L Volume of contracted transport: According to the calculation standards of Act on the Rational Use of Energy.

## Environmental Data

Figure 5 Environmental Burden in Japan by Operational Process (Fiscal 2024)

Operational process	INPUT				OUTPUT					
		FY2023	FY2024	Compared to FY23		FY2023	FY2024	Compared to FY23		
Head Office and Sales  Scope of calculation: The head office and domestic sales bases of RISO KAGAKU CORPORATION and RISO OKI-NAWA CORPORATION (Data on wastes are available only for the head office.)	Energy consumption and CO <sub>2</sub> emissions from the head office and sales department service activities									
	Energy consumption	GJ/yr	18,231	18,111	99	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	1,003	996	99
	Daytime electricity	MWh	1,615	1,572	97	Daytime electricity	t-CO <sub>2</sub> /yr	896	873	97
	LPG	t	3	5	159	LPG	t-CO <sub>2</sub> /yr	9	15	159
	Kerosene	kℓ	0	0	—	Kerosene	t-CO <sub>2</sub> /yr	0	0	—
	City gas	1,000 m <sup>3</sup>	44	49	111	City gas	t-CO <sub>2</sub> /yr	98	109	111
	Water consumption	m <sup>3</sup>	3,260	2,662	82	Water drainage	m <sup>3</sup>	3,260	2,662	82
					Waste generation*1	t	9	8	91	
					Volume recycled*2	t	9	8	91	
					Other*3	t	0	0	—	
				Final disposal (landfill)*4	t	0	0	137		
Design and Development  Scope of calculation: RISO R&D Center RISO R&D CenterII	Energy consumption and CO <sub>2</sub> emissions at the product development stage									
	Energy consumption	GJ/yr	22,598 <a href="#">Note 1</a>	22,413	99	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	1,282 <a href="#">Note 1</a>	1,271	99
	Daytime electricity	MWh	1,610 <a href="#">Note 1</a>	1,618	100	Daytime electricity	t-CO <sub>2</sub> /yr	893 <a href="#">Note 1</a>	898	100
	Nighttime electricity	MWh	676 <a href="#">Note 1</a>	646	96	Nighttime electricity	t-CO <sub>2</sub> /yr	375 <a href="#">Note 1</a>	359	96
	LPG	t	0	0	—	LPG	t-CO <sub>2</sub> /yr	0	0	—
	City gas	1,000 m <sup>3</sup>	6	6	106	City gas	t-CO <sub>2</sub> /yr	13	14	106
	Water consumption	m <sup>3</sup>	6,640	6,817	103	Water drainage	m <sup>3</sup>	6,640	6,817	103
					Waste generation*1	t	103	86	83	
					Volume recycled*2	t	98	77	78	
					Other*3	t	3	8	—	
				Final disposal (landfill)*4	t	0.9	0.8	93		
Production  Scope of calculation: Tsukuba Works Ube Works Kasumigaura Works	Volume of raw materials used, energy consumption, CO <sub>2</sub> emissions, and waste generation in the process of major product**5 manufacturing									
	Energy consumption	GJ/yr	45,581	43,795	96	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	2,587	2,483	96
	Daytime electricity	MWh	3,583	3,475	97	Daytime electricity	t-CO <sub>2</sub> /yr	1,989	1,929	97
	Nighttime electricity	MWh	365	348	95	Nighttime electricity	t-CO <sub>2</sub> /yr	202	193	95
	Bunker A	kℓ	34	30	89	Bunker A	t-CO <sub>2</sub> /yr	92	82	89
	LPG	t	101	93	92	LPG	t-CO <sub>2</sub> /yr	304	280	92
	Kerosene	kℓ	0	0	—	Kerosene	t-CO <sub>2</sub> /yr	0	0	—
	Water consumption	m <sup>3</sup>	14,146	13,745	97	Water drainage	m <sup>3</sup>	12,001	11,983	100
	Product parts and materials	t	4,895	4,238	87	Steam, water, and related emissions	m <sup>3</sup>	0	0	—
	Metals	t	790	758	96	Products*5	t	7,140	6,096	85
	Plastic	t	849	731	86					
	Glass	t	0	0	96					
	Paper	t	1,440	1,174	82					
	Other	t	1,815	1,575	87					
	PRTR-regulated substances	t	1.9	2.3	121	Total PRTR substance emissions/transfers	kg	56.2	277.0	493
					Emissions into the air	kg	0	0	—	
					Emissions into the waters	kg	0	0	—	
					Emissions into the soil	kg	0	0	—	
					Volume transferred to waste	kg	56.2	277.0	493	
				Waste generation*1	t	668	617	92		
				Volume recycled*2	t	666	594	89		
				Other*3	t	1	3	278		
				Final disposal (landfill)*4	t	2	21	1,171 <a href="#">Note 2</a>		
Sales, Logistics, and Transportation  Scope of calculation: Logistics and transportation in Japan, operation of company-owned vehicles	Fuel consumption and CO <sub>2</sub> emissions from company-owned vehicles used in sales activities and maintenance services for customers, and energy consumption and CO <sub>2</sub> emissions from contracted transport such as product delivery and used product collection and transportation are calculated.									
	Energy consumption	GJ/yr	34,552	34,408	100	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	2,344	2,333	100
	Gasoline	kℓ	398	407	102	Gasoline	t-CO <sub>2</sub> /yr	940	959	102
	Diesel	kℓ	1	0	43	Diesel	t-CO <sub>2</sub> /yr	2	1	43
	Volume of contracted transport*6	10,000 t-km	750	686	91	Volume of contracted transport*6	t-CO <sub>2</sub> /yr	1,402	1,374	98
Collecting, Reusing, and Recycling  Scope of calculation: Used products in Japan	Volumes of used products collected, reused, and recycled. Although RISO promotes the effective use of collected products, some collected components that cannot be recycled are processed for landfill disposal.									
	Collection of used products	t	2,062 <a href="#">Note 1</a>	2,009	97	Used product disposal volume	t	2,062	2,009	97
	Digital duplicators and other printers	t	1,827 <a href="#">Note 1</a>	1,781	97	Volume transferred to recycling processes*7	t	239	213	89
	Ink bottles	t	208	200	96	Volume recycled*2	t	1,805	1,778	99
	Ink cartridges	t	27	28	104	Other*3	t	0	0	—
					Final disposal (landfill)*4	t	18	18	98	

\*1 Waste generation: RISO classifies all unwanted substances generated from its operational processes, including valuable resources and resources to be recycled or reused, as waste.

\*2 Volume recycled: Total volume of materials for recycling and thermal recycling, including valuable resources. The volume to be reused in operational processes is excluded.

\*3 Other (waste generation): The volume of gas emissions from recycling processing and incineration.

\*4 Final disposal (landfill): The volume to be disposed of in landfill sites, which includes residues and incinerated ash from intermediate processing such as recycling.

\*5 Major products: ComColor high-speed color printers, RISOGRAPH digital duplicators, and inks, masters, and other supply products for ComColor and RISOGRAPH digital duplicators.

\*6 Volume of contracted transport using external carriers: Volume of contracted transport (for delivery, procurement, collection, etc.) of products, parts, used products, and waste.

\*7 Volume transferred to recycling processes: The amount of recycled materials to be reused as raw materials in operational processes.

**Note 1** There was an error in the figure for fiscal 2023 and accordingly, it has been corrected.

**Note 2** This was due to the disposal of equipment.



## Environmental Data

Figure 6 Environmental Burden of Overseas Production Bases (Fiscal 2024)

Target	INPUT				OUTPUT					
		FY2023	FY2024	Compared to FY23		FY2023	FY2024	Compared to FY23		
Overseas production subsidiaries	Volume of raw materials used, energy consumption, CO <sub>2</sub> emissions, and waste generation in overseas production subsidiaries									
	Energy consumption	GJ/yr	13,334	13,533	101	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	940	939	100
	Electricity	MWh	1,248	1,275	102	Electricity	t-CO <sub>2</sub> /yr	881	885	100
	LPG	kℓ	3	3	102	LPG	t-CO <sub>2</sub> /yr	9	9	102
	Gasoline	kℓ	16	14	86	Gasoline	t-CO <sub>2</sub> /yr	38	33	89
	Diesel	kℓ	5	5	93	Diesel	t-CO <sub>2</sub> /yr	13	12	93
	Water consumption	m <sup>3</sup>	13,265	15,024	113	Water drainage	m <sup>3</sup>	9,968	11,368	114
	Product parts and materials	t	3,430	2,995	87	Steam, water, and related emissions	m <sup>3</sup>	2,690	3,028	113
	Metals	t	1,849	1,550	84	Products*5	t	4,038	3,678	91
	Plastic	t	503	446	89					
	Glass	t	0	0	80					
	Paper	t	442	412	93					
	Other	t	637	587	92					
						Waste generation*1	t	192	175	91
						Volume transferred to recycling processes*7	t	0	0	—
						Volume recycled*2	t	163	149	91
						Other*3	t	11.5	10	87
						Final disposal (landfill)*4	t	17.5	16.3	93

Figure 7 Environmental Burden of Overseas Sales Subsidiaries (Fiscal 2024)

Target	INPUT				OUTPUT					
		FY2023	FY2024	Compared to FY23		FY2023	FY2024	Compared to FY23		
All overseas sales subsidiaries	Energy consumption and CO <sub>2</sub> emissions at the head office and sales bases of overseas subsidiaries									
	Energy consumption per unit	GJ/person* <sup>9</sup>	56.7	52.8	93	CO <sub>2</sub> emissions per unit	t-CO <sub>2</sub> /person* <sup>9</sup>	3.68	3.43	93
	Energy consumption	GJ/yr	38,641	35,425	92	CO <sub>2</sub> emissions	t-CO <sub>2</sub> /yr	2,513	2,304	92
	Electricity	MWh	1,206	1,161	96	Electricity	t-CO <sub>2</sub> /yr	728	708	97
	Natural gas	kℓ	8,733	11,771	135	Natural gas	t-CO <sub>2</sub> /yr	18	24	133
	Gasoline	kℓ	600	530	88	Gasoline	t-CO <sub>2</sub> /yr	1,392	1,229	88
	Diesel	kℓ	145	133	92	Diesel	t-CO <sub>2</sub> /yr	375	343	91
	Water consumption	m <sup>3</sup>	513	731	142	Water drainage	m <sup>3</sup>	513	731	142

Scope of calculation:  
16 overseas subsidiaries<sup>†</sup>  
and sales bases\*<sup>8</sup>

† RISO, INC., RISO FRANCE S.A., RISO (Deutschland) GmbH, RISO (U.K.) LTD., RISO IBERICA, S.A., RISOGRAPH ITALIA S.R.L., RISO AFRICA (PTY) LTD., RISO KOREA LTD., RISO HONG KONG LTD., RISO (Thailand) CO., LTD., RISO INDIA PRIVATE LTD., RISO TECHNOLOGY CHINA CO., LTD., RISO LATIN AMERICA, INC., RISO EURASIA LLC, RISO TURKEY BASKI COZUMLERI A.S, RISO (SG) PTE. LTD.

\*1 Waste generation: RISO classifies all unwanted substances generated from its operational processes, including valuable resources and resources to be recycled or reused, as waste.

\*2 Volume recycled: Total volume of materials for recycling and thermal recycling, including valuable resources. The volume to be reused in operational processes is excluded.

\*3 Other (waste generation): The volume of gas emissions from recycling processing and incineration.

\*4 Final disposal (landfill): The volume to be disposed of in landfill sites, which includes residues and incinerated ash from intermediate processing such as recycling.

\*5 Major products: ComColor high-speed color printers, RISOGRAPH digital duplicators, and inks, masters, and other supply products for ComColor and RISOGRAPH digital duplicators.

\*6 Volume of contracted transport using external carriers: Volume of contracted transport (for delivery, procurement, collection, etc.) of products, parts, used products, and waste.

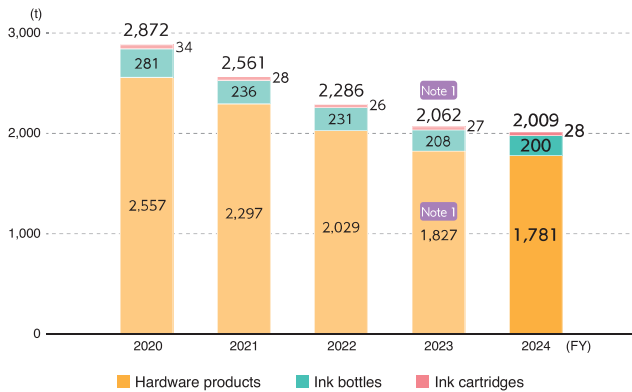
\*7 Volume transferred to recycling processes: The amount of recycled materials to be reused as raw materials in operational processes.

\*8 The head office has primary responsibility for ascertaining the environmental burden of overseas sales subsidiaries, but data collection for sales bases such as branch offices is incomplete. The data supplement rate based on the ratio of employees registered at offices/bases in fiscal 2021 was 53.5%.

\*9 Concerning overseas sales subsidiaries, because there are large fluctuations in topics such as office movement, the increase and decrease of personnel, and the propriety of surveys, the output level is calculated using the total number of employees belonging to the site where the survey was conducted as the denominator, and represents the change in efficiency.

## Environmental Data

Figure 8 Quantity of Used Products and Consumables Collected



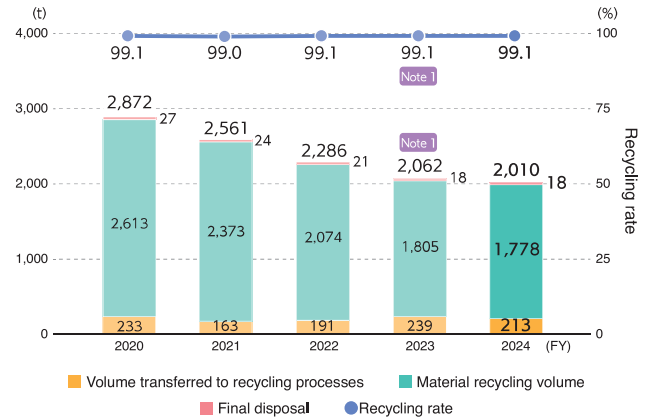
Scope of calculation: The amount of used RISO products in Japan (excluding second-hand digital duplicators that are returned or collected and then used as rental equipment)

**Note 1** There was an error in the figure for fiscal 2023 and accordingly, it has been corrected.

## KEY POINT

We are actively carrying out the collection and recycling of used hardware products and consumables based on the idea that used products are not wastes but precious resources. Even overseas, we are promoting the collection and recycling of used products based on local laws and social demands.

Figure 9 Recycling of Used Products and Recycling Rate



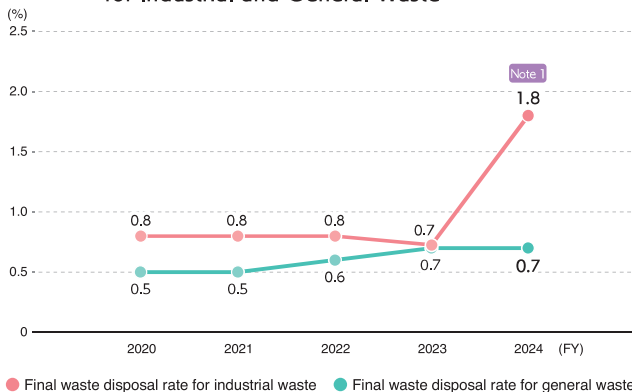
Scope of calculation: The amount of used RISO products in Japan (excluding second-hand digital duplicators that are returned or collected and then used as rental equipment)

**Note 1** There was an error in the figure for fiscal 2023 and accordingly, it has been corrected.

## KEY POINT

We continue to use products recycled from used products and to recycle parts and components which can't be reused.

Figure 10 Specific Final Waste Disposal Rates\* for Industrial and General Waste



Scope of calculation: Industrial and general waste (including valuable resources and recyclable materials) generated at the Tsukuba Works, Ube Works, Kasumigaura Works, and R&D Division; volume of all used RISO products collected in Japan, materials recycled, and materials for other treatment processes (excluding rental equipment returned or reused by different users without refurbishment)

\*Specific final waste disposal rate: RISO calculates the amount of specific final waste disposal as the total of the amount of waste incinerated, the residue and ashes resulting from recycling processes and used for landfill, and other waste used directly for landfill. Then, RISO calculates the specific final waste disposal rate as the ratio of the specific final waste disposal amount to the total waste it generates, including valuable and recyclable substances. RISO recognizes the incineration of waste as an inefficient treatment of resources. Therefore, the amount of waste incinerated is included in the amount of other waste directly used for landfill.

**Note 1** This was due to the disposal of equipment.

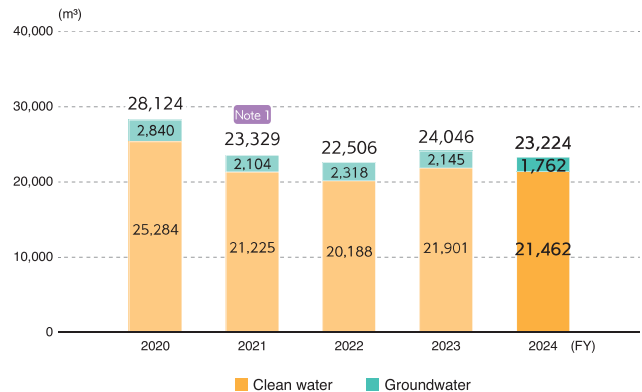
Target for fiscal 2025 for reducing waste:

The final waste disposal rate for industrial waste and general waste will not exceed 1.0%.

## KEY POINT

Maintenance and management are being performed so that specific final waste disposal rates for industrial and general waste do not exceed current levels.

Figure 11 Water Consumption



Scope of calculation: Data is collected for water consumption volume in Japan.

**Note 1** The scope of calculation was changed.

Target for fiscal 2025:

The water consumption will reduce by 3% or higher from the previous fiscal year.

## KEY POINT

Approximately 10% of the water used at production sites are for raw materials and raw water for boiler steam, and the remaining 90% of water are for daily use such as toilets and dining halls. This water is discharged into the public waters and the sewage systems.

The amount used in fiscal 2024 decreased by approximately 822m³ (approximately 3%) from the previous fiscal year.

## Environmental Data

Figure 12 Breakdown of Released and Transferred Volume of PRTR-Designated Chemical Substances

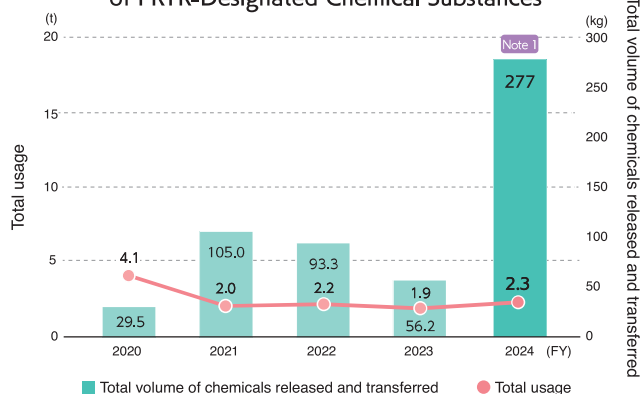
(kg)

	Total usage		Total volume of chemicals released and transferred									
	FY2023	FY2024			Emissions into the air		Emissions into the waters		Emissions into the soil		Waste generated	
			FY2023	FY2024	FY2023	FY2024	FY2023	FY2024	FY2023	FY2024	FY2023	FY2024
Polyoxyethylene alkyl ether	114.7	61.5	—	—	—	—	—	—	—	—	—	—
BHT	10.0	290.0	7.0	254.0	—	—	—	—	—	—	7.0	254.0
Molybdenum and its compounds	107.9	102.9	—	—	—	—	—	—	—	—	—	—
2,3-Epoxypropyl methacrylate	1,610.9	1,584.3	19.6	—	—	—	—	—	—	—	19.6	—
2-Ethylhexanoic acid	3.0	29.7	0.2	—	—	—	—	—	—	—	0.2	—
Methacrylic acid	4.4	0.8	4.4	1.0	—	—	—	—	—	—	4.4	1.0
Methyl methacrylate	9.9	0.9	9.9	1.0	—	—	—	—	—	—	9.9	1.0
Hexamethylene diacrylate	1.0	—	1.0	—	—	—	—	—	—	—	1.0	—
Organotin compounds	1.0	—	1.0	—	—	—	—	—	—	—	1.0	—
Normal Hexane	12.1	—	12.1	—	—	—	—	—	—	—	12.1	—
2-Hydroxyethyl Acrylate	1.0	0.6	1.0	1.0	—	—	—	—	—	—	1.0	1.0
Diethylene glycol monobutyl ether	—	10.3	—	—	—	—	—	—	—	—	—	—
Diethanolamine	—	136.9	—	—	—	—	—	—	—	—	—	—
Cyclohexane	—	30.1	—	—	—	—	—	—	—	—	—	—
Glyphosate isopropylamine salt	—	4.1	—	—	—	—	—	—	—	—	—	—
Alkylphenol	—	20.0	—	20.0	—	—	—	—	—	—	—	20.0
Total	1,875.8	2,272.1	56.2	277.0	—	—	—	—	—	—	56.2	277.0

Scope of calculation: Tsukuba Works, Ube Works, Kasumigaura Works, and RISO R&amp;D Center

† Data based on the results of environmental inspections with regard to the release and transfer of substances that RISO handled 1 kg or more in weight on an annual basis.

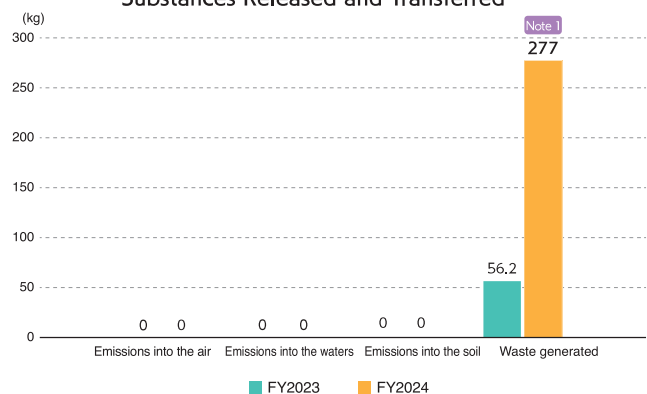
Figure 13 Consumption, Release and Transfer of PRTR-Designated Chemical Substances



Scope of calculation: Tsukuba Works, Ube Works, Kasumigaura Works, and RISO R&amp;D Center

† Data based on the results of environmental inspections with regard to the release and transfer of substances that RISO handled 1 kg or more in weight on an annual basis.

Figure 14 Volume of PRTR-Designated Chemical Substances Released and Transferred



Scope of calculation: Tsukuba Works, Ube Works, Kasumigaura Works, and RISO R&amp;D Center

† Data based on the results of environmental inspections with regard to the release and transfer of substances that RISO handled 1 kg or more in weight on an annual basis.

**Note 1** This was because we stopped handling and disposed of PRTR-designated chemical substances.

## KEY POINT

We are investigating the environmental release and transfer of toxic chemicals listed in PRTR\*. Based on this investigation, we examine the possibility of reducing toxic releases, or switching to alternatives, so that total releases and transfers during the manufacturing process are minimized.

The total usage of PRTR-designated chemical substances in fiscal 2024 was 2.3 tons, an increase of 0.4 tons compared with the previous fiscal year. The total volume of release and transfer increased by 0.22 tons.

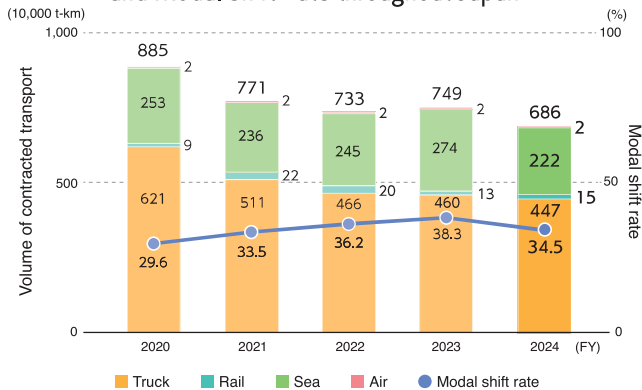
By constantly considering the use of alternative substances, we continue to strive to reduce the use of PRTR-listed substances.

Target for fiscal 2025 for reducing PRTR-designated chemical substances:

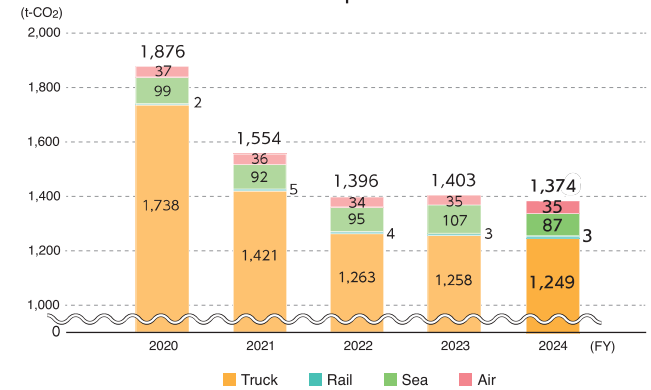
The total of PRTR-designated chemical substances released and transferred will reduce by 5% or higher from the previous fiscal year.

\*PRTR (Pollutant Release and Transfer Register): A system whereby business operators ascertain the volumes of chemical substances that may pollute the environment (atmosphere, water, soil) as well as the volumes transferred as waste, report the results to an administrative body, and disclose the results to promote the voluntary management by business operators and prevent impediments to environmental preservation.

## Environmental Data

**Figure 15** Breakdown of Contracted Transport Volume and Modal Shift Rate throughout Japan

Scope of calculation: Volume of contracted transport (of products, components, raw materials, waste and used products) in Japan by the logistics department, sales department, plants, and the Center for Recycling

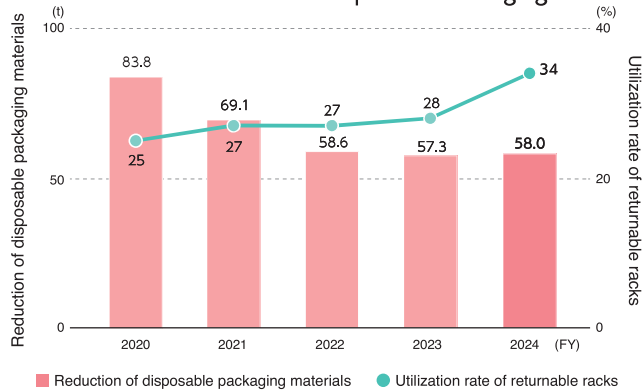
**Figure 16** Breakdown of CO<sub>2</sub> Emissions from Contracted Transport

Scope of calculation: CO<sub>2</sub> emissions attributable to contracted transport (of products, components, raw materials, waste and used products) in Japan by the logistics department, sales department, plants, and the Center for Recycling

## KEY POINT

Although our company is not included as a designated shipper under the Energy Conservation Act, in order to reduce environmental burden during product transportation, we are working to accurately understand the volume of contracted transport and reduce CO<sub>2</sub> emissions.

In fiscal 2024, we continued to implement a modal shift from trucks to ships for the transportation of consumables. Compared to fiscal 2023, the modal shift rate went from 38.3% to 34.5% and CO<sub>2</sub> emissions decreased by 29 tons-CO<sub>2</sub> or 2.1%.

**Figure 17** Utilization Rate of Returnable Racks and Reduction in Use of Disposable Packaging

Scope of calculation: Digital duplicators and high-speed color printers shipped from the Tsukuba Distribution Center to RISO's Japanese sales bases, sales representatives, and customers nationwide

## KEY POINT

The use of returnable racks for product shipments reduces the volume of disposable packaging materials such as cardboard and polystyrene foam.

The returnable rack usage rate was 34% in fiscal 2024, which is equivalent to a 58.0-ton reduction in packaging materials.

**Figure 18** Environmental Education Programs and Number of Participants (Fiscal 2024)

Type of education	Events (times)	Participants (employees)	Hours (aggregate)
Basic environmental education program (e-Learning)	1	1,681	420
Basic environmental education program	12	127	81
Environmental policy and EMP confirmation training	1	301	151
Internal auditor training	8	53	412
Special environmental education program	11	90	33
Accident/emergency drill	8	149	110
Disaster drill	3	514	498
Advanced EMS skill program	2	18	18
Outside seminars (including regulatory trends)	3	9	36
Workplace health and safety program	1	53	53
<b>Total</b>	<b>50</b>	<b>2,995</b>	<b>1,812</b>

Scope of calculation: Educational and training programs provided at RISO's domestic sites in Japan

† Table includes data for programs with an environmental focus.

## KEY POINT

In order to raise the environmental awareness of each employee and carry out environmental conservation activities, a wide variety of programs are provided from general education to specialized trainings regarding internal quality environmental auditors, EMS external qualification, ISO, and so on.

# Environmental Accounting

## ● Calculation method and idea

- Our calculations of the environmental protection costs and the economic effects are basically made in keeping with the "Environmental Account Guidebook (2005)" of the Ministry of the Environment. However, the classification of costs is modified to our own standard. Also, expenses related to environmental protection costs do not include depreciation. The economic effects are based on revenue and cost saving, both of which are considered to be actual effects (as they are calculated using actual figures), and not on presumed or estimated effects.
- Ideally, the environmental protection costs relating to environment-friendly design should be listed in the chart. However, due to the difficulty in accurately distinguishing which costs are directly related to environmental protection, the trend data presented on the securities report is based on total R&D expenditures.

● **Term:** Fiscal 2024 (April 1, 2023 to March 31, 2024)

● **Scope of calculation:** All of RISO KAGAKU CORPORATION'S domestic sites in Japan (Tsukuba Works, Kasumigaura Works, Ube Works, RISO R&D Center, the head office, and domestic sales bases).  
For RISO's sales network, "resource conservation and recycling" as well as "EMS establishment and maintenance activities" are included in the scope of calculation.

**Figure 19** Environmental Accounting Results for Fiscal 2024

(Thousands of Yen)

Activities	Classification	Environmental protection costs			Environmental protection effect	
		Environmental protection activities	Investment	Cost	Economic effect	Actions
Global warming prevention measures	<ul style="list-style-type: none"> <li>Reduction of fuel consumption</li> <li>Reduction of electricity consumption</li> </ul>	<ul style="list-style-type: none"> <li>Replacement of boilers with high efficiency models, pursuit of a modal shift strategy</li> <li>Introduction of energy-saving equipment</li> </ul>	5,470	3,500	146	<ul style="list-style-type: none"> <li>Reduction of CO<sub>2</sub> emissions during manufacture and product transport</li> <li>Reduction of electricity consumption</li> </ul>
Promotion of resource conservation and recycling	<ul style="list-style-type: none"> <li>Effective utilization of used products</li> <li>Effective utilization of wastes</li> <li>Safe disposal of wastes</li> </ul>	<ul style="list-style-type: none"> <li>Collection and recycling of used products</li> <li>Separation and recycling of waste</li> </ul>		267,548	369,445	<ul style="list-style-type: none"> <li>Reduction of costs through reuse</li> <li>Improvement of resource recovery rates</li> </ul>
Environmental communication	<ul style="list-style-type: none"> <li>Publication of product environmental data</li> <li>Publication of information about environmental initiatives</li> </ul>	<ul style="list-style-type: none"> <li>Acquisition of environmental label certification</li> <li>Publication of the Environmental Data Book</li> <li>Participation in events and exhibitions</li> </ul>		17,454		<ul style="list-style-type: none"> <li>Acquisition of certification under the Eco Mark Program</li> <li>Publication of the Environmental Data Book, website revisions, etc.</li> </ul>
Green areas	<ul style="list-style-type: none"> <li>Clean-up and maintenance of green areas</li> </ul>	<ul style="list-style-type: none"> <li>Clean-up and maintenance of green areas</li> </ul>		3,520		<ul style="list-style-type: none"> <li>Clean-up and maintenance of green areas</li> </ul>
Legal compliance (pollution control measures, environmental pollution control)	<ul style="list-style-type: none"> <li>Compliance activities (water, air, etc.)</li> <li>Understanding of legal and regulatory trends</li> </ul>	<ul style="list-style-type: none"> <li>Water drainage management</li> <li>Gas emissions management</li> <li>Inspection and maintenance of facilities</li> <li>Monitoring of laws and regulations</li> </ul>		25,411		<ul style="list-style-type: none"> <li>Environmental protection activities</li> <li>Research for and understanding of legal and regulatory trends in Japan and overseas</li> </ul>
Green procurement	<ul style="list-style-type: none"> <li>Collection and registration of environmental data relating to raw materials and parts</li> </ul>	<ul style="list-style-type: none"> <li>Implementation of an environmental information system covering REACH and other regulations</li> </ul>		6,667		<ul style="list-style-type: none"> <li>Environmental information updates, operation and maintenance</li> </ul>
EMS establishment and maintenance activities	<ul style="list-style-type: none"> <li>ISO</li> </ul>	<ul style="list-style-type: none"> <li>Acquisition and maintenance of ISO 14001 certification</li> </ul>		9,531		<ul style="list-style-type: none"> <li>Updates and maintenance of ISO 14001 certification</li> </ul>
<b>Total</b>			5,470	333,631	369,591	

**Figure 20** Breakdown of Costs (Investment + Actual Costs)

(Thousands of Yen)

	FY2020	FY2021	FY2022	FY2023	FY2024
Global warming prevention measures	18,163	1,073	1,370	570	8,970
Promotion of resource conservation and recycling	383,016	333,979	291,048	260,595	267,548
Environmental communication	15,153	8,749	11,971	14,139	17,454
Green areas	3,000	2,686	2,350	3,616	3,520
Legal compliance	15,604	18,282	20,887	17,829	25,411
Green procurement	7,484	6,970	7,524	6,633	6,667
EMS establishment and maintenance activities	5,071	9,321	4,230	4,431	9,531

**Figure 21** Breakdown of Economic Effects (Revenue + Cost Saving)

(Thousands of Yen)

	FY2020	FY2021	FY2022	FY2023	FY2024
Global warming prevention measures	676	148	150	154	146
Promotion of resource conservation and recycling	358,227	219,061	279,058	394,723	369,445

† Five categorized activities, including environmental communication, had no economic effects.

**Figure 22** Status of Environmental Accounting

(Comparison of Figures Excluding Development Costs such as Environmental-Friendly Design for Products)

	FY2020	FY2021	FY2022	FY2023	FY2024
Costs (investment + actual costs) (Thousands of Yen)	447,491	381,059	339,379	308,179	339,101
Economic effect (Revenue + Cost saving) (Thousands of Yen)	358,903	219,209	279,208	394,878	369,591
Economic effect ratio (%)	80%	58%	82%	128%	109%

## KEY POINT

In fiscal 2024, the cost of global warming prevention measures (investment + actual cost) increased by 8,400,000 yen. We continued to replace lighting and air conditioning equipment with units that have high energy-saving effects and implement other measures. The positive economic effect decreased by 8,000 yen.

The number of used products collected and production using reused parts decreased. The cost of resource saving and recycling promotion increased by 6,953,000 yen. The positive economic effect decreased by 25,278,000 yen.

The ratio of cost (investment + actual costs) and economic effects (revenue + cost saving) was 109%.

# Environmental Data for Major Plants and Offices

Figure 23

## Tsukuba Works

Scope of calculation: Tsukuba Works

### Overview

**Address** 127-7 Fukuda(Fukuda-Kougyou-danchi),  
Ami-machi, Inashiki-gun, Ibaraki-ken,  
Japan

**Commencement of Operations** October 1981

### Site Area

97,000m<sup>2</sup>

### Total Floor Space

29,326m<sup>2</sup>

### Number of Employees

273 (As of March 31, 2024)

### Major Products

RISOGRAPH digital duplicators and peripherals  
ComColor high-speed color printers, inks, and peripherals

### Registration of Specified Facilities

- Facilities that generate smoke (boilers), as specified under the Air Pollution Control Act
- Facilities specified in the ordinance regarding the prevention of eutrophication in Kasumigaura: Purification tank
- Facilities specified in the Vibration Regulation Law: Hydraulic and mechanical presses, air compressors, shear cutters, circular saw machines

### Major Environmental Protection Activities

- ISO 14001: Certification
- Designing environmentally friendly products to respond to the RoHS Directive and other environmental regulations
- Reduction of CO<sub>2</sub> emissions through energy conservation
- Implementation of green procurement
- Promotion of green purchasing
- Reduction of waste generation and promotion of recycling
- Recycling of used ink bottles

### Environmental Data

	Unit	FY2020	FY2021	FY2022	FY2023	FY2024	YoY (%)
Electricity consumption	MWh	1,855	1,805	1,816	1,791	1,748	98
Water consumption	m <sup>3</sup>	9,737	7,963	7,543	8,893	8,459	95
Clean water	m <sup>3</sup>	9,737	7,963	7,543	8,893	8,459	95
Groundwater	m <sup>3</sup>	0	0	0	0	0	—
Water drainage	m <sup>3</sup>	9,737	7,963	7,543	8,893	8,459	95
Annual biochemical oxygen demand (BOD) emissions	kg	9.7	8.0	8.1	8.9	9.1	103
Annual nitrogen emissions	kg	78	72	72	74	85	115 <a href="#">Note 1</a>
Annual phosphorus emissions	kg	13.2	4.1	3.8	7.5	6.9	93
Total waste generation	t	460	397	345	362	350	97
Final disposal (landfill)	t	1.5	1.9	1.6	1.6	1.7	105
Waste recycling rate	%	99.7	99.5	99.5	99.6	99.5	100

† Wastewater from Tsukuba Works is drained into the public waters.

[Note 1](#) The range of variation within the standard value

Figure 24

## Kasumigaura Works

Scope of calculation: Kasumigaura Works, including the Center for Recycling

### Overview

**Address** 282-2 Ami, Ami-machi,  
Inashiki-gun, Ibaraki-ken, Japan

**Commencement of Operations** August 1965

### Site Area

28,265m<sup>2</sup>

### Total Floor Space

16,821m<sup>2</sup>

### Number of Employees

45 (As of March 31, 2024)

### Major Products

Digital duplicators

### Registration of Specified Facilities

Facilities as specified under the Noise Regulation Law and the Vibration Regulation Law: machine tools, including compressors and shearing machines

### Major Environmental Protection Activities

- ISO 14001: Certification
- Recycling of used printers
- Reduction of waste generation and promotion of recycling
- Reduction of CO<sub>2</sub> emissions through energy conservation

### Environmental Data

	Unit	FY2020	FY2021	FY2022	FY2023	FY2024	YoY (%)
Electricity consumption	MWh	464	449	443	434	415	96
Water consumption	m <sup>3</sup>	843	843	900	820	791	96
Clean water	m <sup>3</sup>	843	843	900	820	791	96
Groundwater	m <sup>3</sup>	0	0	0	0	0	—
Water drainage	m <sup>3</sup>	843	843	900	820	791	96
Annual biochemical oxygen demand (BOD) emissions	kg	5	11	5	4	3	72 <a href="#">Note 1</a>
Annual nitrogen emissions	kg	30	41	40	36	34	92
Annual phosphorus emissions	kg	4.3	4.8	4.3	3.5	3.2	92
Total waste generation	t	160	153	139	125	103	82
Final disposal (landfill)	t	0.3	1.1	0.3	0.1	0.1	95
Waste recycling rate	%	99.8	99.2	99.8	99.9	98.3	98

† Wastewater from Kasumigaura Works is drained into the public sewage systems.

[Note 1](#) The range of variation within the standard value



# Environmental Data for Major Plants and Offices

Figure 25

## Ube Works

Scope of calculation: Ube Works

Overview	Address	Setobara-Kougyou-danchi, Ube-shi, Yamaguchi-ken, Japan	Site Area	75,871m <sup>2</sup>
			Total Floor Space	15,598m <sup>2</sup>
	Commencement of Operations	June 1986	Number of Employees	65 (As of March 31, 2024)

**Major Products** Inks and masters for digital duplicators

**Registration of Specified Facilities** There is no applicable facility.

**Major Environmental Protection Activities**

- ISO 14001: Certification updated in September 2023
- Designing environmentally friendly products to respond to the RoHS Directive and other environmental regulations
- Reduction of CO<sub>2</sub> emissions through energy conservation
- Promotion of green purchasing
- Reduction of waste generation and promotion of recycling
- Recycling of used ink bottles

### Environmental Data

	Unit	FY2020	FY2021	FY2022	FY2023	FY2024	YoY (%)
Electricity consumption	MWh	2,109	1,693	1,797	1,723	1,660	96
Water consumption	m <sup>3</sup>	5,309	4,324	4,659	4,433	4,495	101
Clean water	m <sup>3</sup>	2,469	2,220	2,341	2,288	2,733	119
Groundwater	m <sup>3</sup>	2,840	2,104	2,318	2,145	1,762	82
Water drainage	m <sup>3</sup>	2,469	2,220	2,341	2,288	2,733	119
Annual biochemical oxygen demand (BOD) emissions	kg	5	9	33	13	11	78 <span>Note 1</span>
Total waste generation	t	188	148	172	182	164	90
Final disposal (landfill)	t	0.3	0.1	0.1	0.1	19.0	19,000 <span>Note 2</span>
Waste recycling rate	%	98.7	99.4	99.4	99.5	87.8	88.3

† Wastewater from Ube Works is drained into the public waters.

Note 1 The range of variation within the standard value

Note 2 This was due to the disposal of equipment.



Figure 26

## RISO R&D Center

Scope of calculation: RISO R&amp;D Center

Overview	Address	2 Chome 8-1, Gakuenminami, Tsukuba-shi, Ibaraki-ken, Japan	Site Area	17,521m <sup>2</sup>
			Total Floor Space	15,197m <sup>2</sup>
	Commencement of Operations	June 2013		

**Registration of Specified Facilities**

Specified facilities related to the Water Pollution Prevention Act and Sewerage Act: 1 draft chamber, 5 sinks, 1 washing machine

Specified facilities related to the Noise Regulation Law: 4 ventilators, 3 hydraulic presses, 2 shearing machines

Specific facilities related to the Vibration Regulation Law: 3 hydraulic presses, 2 shearing machines

Facilities that generate smoke: 1 emergency generator

**Major Environmental Protection Activities**

- ISO 14001: Certification updated in November 24, 2023
- Designing environmentally friendly products
- Reduction of CO<sub>2</sub> emissions through energy conservation
- Reduction of waste generation and promotion of recycling
- Greening activities

### Environmental Data

	Unit	FY2020	FY2021	FY2022	FY2023	FY2024	YoY (%)
Electricity consumption	MWh	2,257	2,037	2,130	2,061	2,046	99
Water consumption	m <sup>3</sup>	8,356	6,258	5,967	6,355	6,547	103
Clean water	m <sup>3</sup>	8,356	6,258	5,967	6,355	6,547	103
Groundwater	m <sup>3</sup>	0	0	0	0	0	—
Water drainage	m <sup>3</sup>	8,356	6,258	5,967	6,355	6,547	103
Annual biochemical oxygen demand (BOD) emissions	kg	275	356	269	107	244	229 <span>Note 1</span>
Total waste generation	t	256	116	120	99	78	79
Final disposal (landfill)	t	1.4	0.8	0.8	0.8	0.8	95
Waste recycling rate	%	99.2	99.0	98.8	98.8	98.1	99

† Wastewater from RISO R&D Center is drained into the public sewage systems.

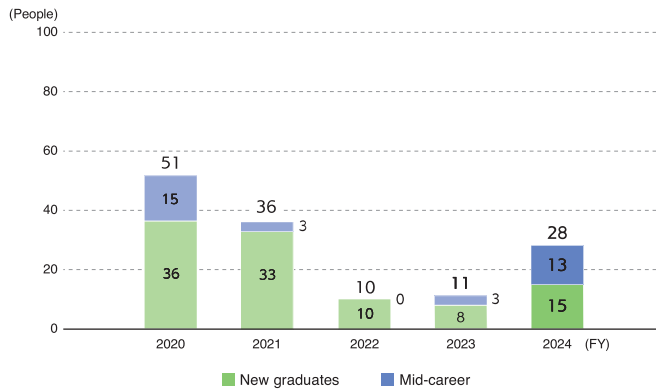
† Opened in June 2013. We continue to consider the environment.

Note 1 The range of variation within the standard value



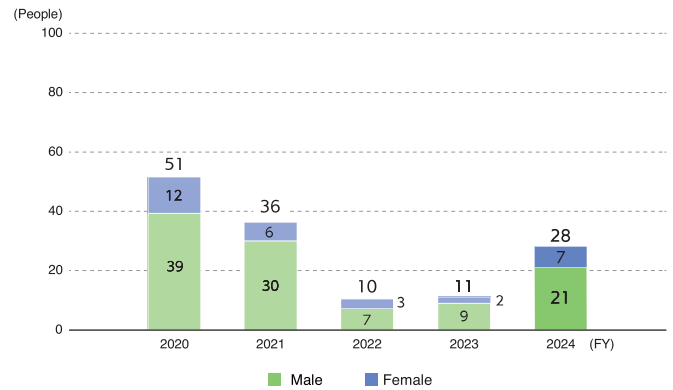
## Social Data

**Figure 27** Employment (Japan)  
(New Graduates/Mid-career)



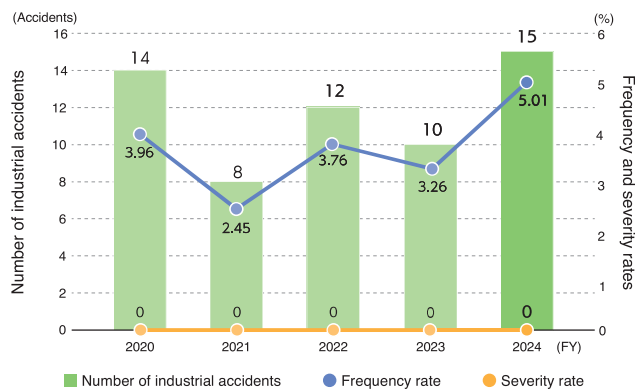
Scope of calculation: Non-consolidated basis (Japan)

**Figure 28** Employment (Japan)  
(Male/Female)



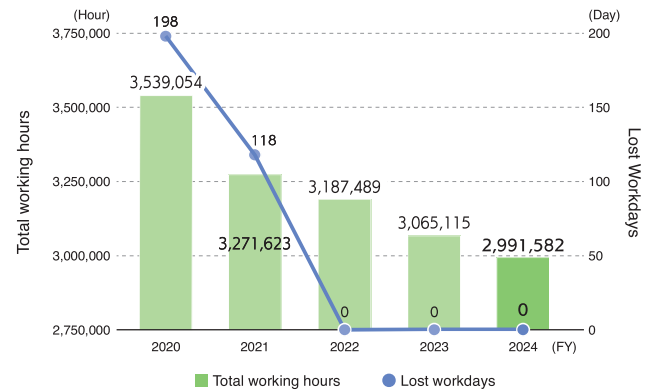
Scope of calculation: Non-consolidated basis (Japan)

**Figure 29** Industrial Accidents:  
Frequency and Severity Rate



Scope of calculation: Non-consolidated basis (Japan)

**Figure 30** Total Working Hours and Lost Workdays



Scope of calculation: Non-consolidated basis (Japan)

## KEY POINT

#### Occupational health and safety

Each production site has established an Occupational Health and Safety Committee to improve the work environment, identify and correct unsafe areas, and undertake voluntary safety activities in an effort to prevent accidents and disasters.

In addition, we have an Occupational Health and Safety page on the company intranet to raise awareness and educate employees about safety.

The number of industrial accidents in Japan in fiscal 2024 was 15, an increase of 5 from fiscal 2023. There have been no lost workdays due to industrial accidents since fiscal 2023.

#### Promoting employee health

We are attentive toward the health of employees through the implementation of health checkups and concern toward mental health.

We conduct general health checkups, lifestyle-related disease checkups, and comprehensive medical exams in order to verify the health status of employees and provide guidance on lifestyle and health as seen needed.

In addition, to maintain not only physical health but also mental health, we have established a mental health inquiry and assistance service.

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