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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

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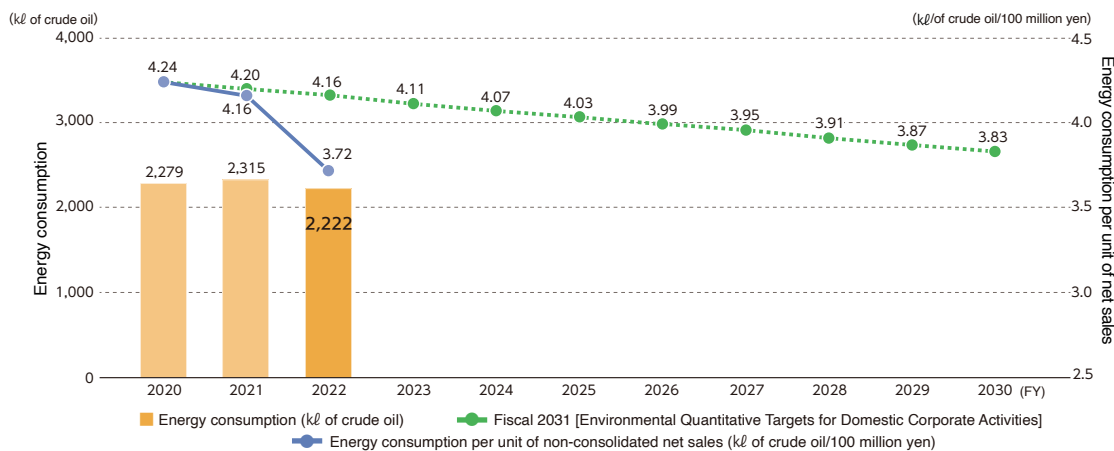
Progress on Fiscal 2031 Environmental Quantitative Targets

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



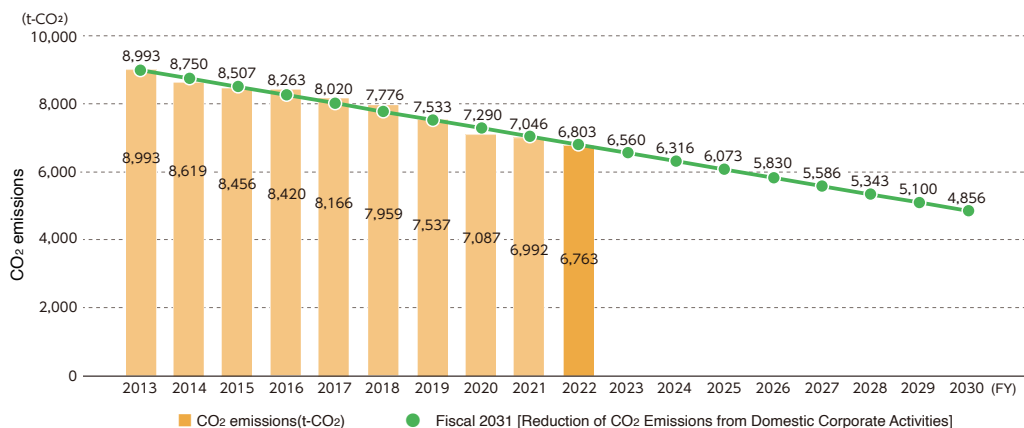
Scope of calculation: Energy consumption at all of RISO KAGAKU CORPORATION'S non-consolidated domestic sites (excluding fuel used for outsourced logistics and company-owned vehicles). Net sales refer to non-consolidated net sales. We reviewed the scope of calculation for setting the environmental quantitative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

Taking on “the Challenge for Reducing CO₂” through domestic corporate activities (non-binding targets)

Throughout Japan:

- 1) Reduction of energy-originated CO₂ emissions at domestic sites; and
- 2) Challenging to reduce them by around 46% compared to the base year (fiscal 2014)

Figure 2 Changes in CO₂ 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 CO₂ emissions in conjunction with those. Net sales refer to non-consolidated net sales. We reviewed the scope of calculation for setting the environmental quantitative targets for fiscal 2031.

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Figure 3 Fiscal 2023 Environmental Quantitative Targets and Achievements; Fiscal 2024 Environmental Quantitative Targets

Category	Reduction of CO ₂ emissions		
Scope of application	All domestic operations and overseas production subsidiaries	All domestic operations	Total for all domestic production sites
Fiscal 2023 Environmental Quantitative Targets	Reduce to 7,995 tons-CO ₂ or less.	Reduce to 7,027 tons-CO ₂ or less.	Reduce to 2,593 tons-CO ₂ or less.
Fiscal 2023 Activity Results	7,704 tons-CO ₂	6,763 tons-CO ₂ Note 1	2,594 tons-CO ₂
Rating	○	○	△
Fiscal 2024 Environmental Quantitative Targets	Reduce to 7,558 tons-CO ₂ or less.	Reduce to 6,632 tons-CO ₂ or less.	Reduce to 2,551 tons-CO ₂ or less.

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

Note 1 The difference from the CO₂ emissions in fiscal 2023 (7,219 tons-CO₂/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 2023, 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 CO₂ emissions.

There was not an increase in CO₂ emissions compared to fiscal year 2022.

We are examining using reusable energy or introducing non-conventional approaches to reduce CO₂ emissions.

Figure 4 Environmental Burden throughout Japan (Fiscal 2023)

	INPUT				OUTPUT				
	FY2022	FY2023	Compared to FY2022	FY2022	FY2023	Compared to FY2022			
Energy consumption and CO₂ emissions, resource input amount, waste generation, etc. in all business activities within Japan									
Energy consumption	GJ/yr	125,129	121,038	97	CO ₂ emissions	t-CO ₂ /yr	7,453	7,219	97
Electricity	MWh	8,266	7,853	95	Electricity	t-CO ₂ /yr	4,588	4,359	95
Bunker A	kl	36	34	95	Bunker A	t-CO ₂ /yr	97	92	95
LPG	t	91	104	114	LPG	t-CO ₂ /yr	274	313	114
Kerosene	kl	0	0	—	Kerosene	t-CO ₂ /yr	0	0	—
City gas	1,000 m ³	53	50	94	City gas	t-CO ₂ /yr	115	111	97
Gasoline	kl	415	398	96	Gasoline	t-CO ₂ /yr	982	940	96
Diesel	kl	1	1	119	Diesel	t-CO ₂ /yr	1	2	119
Volume of contracted transport*6	10,000 t-km	733	750	102	Volume of contracted transport*6	t-CO ₂ /yr	1,396	1,402	100
Water consumption	m ³	22,507 Note 1	24,046	107	Water drainage	m ³	20,188	21,901	108
Product parts and materials	t	5,079	4,895	96	Steam, water, and related emissions	m ³	0	0	—
Collection of used products	t	2,286	2,051	90	Products*5	t	7,489	7,140	95
					Used product/waste disposal volume*1	t	3,071	2,842	93
					Volume transferred to recycling processes*7	t	191	239	125
					Volume recycled*2	t	2,856	2,578	90
					Other*3	t	1	4	522
					Final disposal (landfill)*4	t	24	21	88

Scope of calculation: INPUT and OUTPUT in the Figure 5 "Environmental Burden in Japan by Operational Process (Fiscal 2023)" (p4) are calculated.

Calculation target: At the head office, sales, development/designs and production sites, energy consumption and associated CO₂ 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 CO₂ 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 2022 and accordingly, it has been corrected.

- *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.

●CO₂ Emissions Calculations

Electricity: For Japan, a conversion value of 0.555kg-CO₂/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 CO₂/L LPG: 3.00 kg CO₂/kg Gasoline: 2.32 kg CO₂/L Volume of contracted transport: According to the calculation standards of Act on the Rational Use of Energy.

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Figure 5 Environmental Burden in Japan by Operational Process (Fiscal 2023)

Operational process	INPUT				OUTPUT					
		FY2022	FY2023	Compared to FY22		FY2022	FY2023	Compared to FY22		
Head Office and Sales Scope of calculation: The head office and domestic sales bases of RISO KAGAKU CORPORATION and RISO OKINAWA CORPORATION (Data on wastes are available only for the head office.)	Energy consumption and CO₂ emissions from the head office and sales department service activities									
	Energy consumption	GJ/yr	20,594	18,231	89	CO ₂ emissions	t-CO ₂ /yr	1,134	1,003	88
	Daytime electricity	MWh	1,843	1,615	88	Daytime electricity	t-CO ₂ /yr	1,023	896	88
	LPG	t	3	3	104	LPG	t-CO ₂ /yr	9	9	104
	Kerosene	kℓ	0	0	—	Kerosene	t-CO ₂ /yr	0	0	—
	City gas	1,000 m ³	48	44	92	City gas	t-CO ₂ /yr	103	98	95
	Water consumption	m ³	2,966	3,260	110	Water drainage	m ³	2,966	3,260	110
						Waste generation*1	t	10	9	89
						Volume recycled*2	t	10	9	88
						Other*3	t	0	0	0
					Final disposal (landfill)*4	t	0	0	151	
Design and Development Scope of calculation: RISO R&D Center RISO R&D CenterII	Energy consumption and CO₂ emissions at the product development stage									
	Energy consumption	GJ/yr	23,382	22,674	97	CO ₂ emissions	t-CO ₂ /yr	1,326	1,285	97
	Daytime electricity	MWh	1,698	1,665	98	Daytime electricity	t-CO ₂ /yr	942	924	98
	Nighttime electricity	MWh	669	625	93	Nighttime electricity	t-CO ₂ /yr	372	347	93
	LPG	t	0	0	—	LPG	t-CO ₂ /yr	0	0	—
	City gas	1,000 m ³	5	6	111	City gas	t-CO ₂ /yr	12	13	111
	Water consumption	m ³	6,438	6,640	103	Water drainage	m ³	6,438	6,640	103
						Waste generation*1	t	120	103	86
						Volume recycled*2	t	118	98	83
						Other*3	t	0	3	—
					Final disposal (landfill)*4	t	0.8	0.9	117	
Production Scope of calculation: Tsukuba Works Ube Works Kasumigaura Works	Volume of raw materials used, energy consumption, CO₂ emissions, and waste generation in the process of major product**5 manufacturing									
	Energy consumption	GJ/yr	46,061	45,581	99	CO ₂ emissions	t-CO ₂ /yr	2,613	2,587	99
	Daytime electricity	MWh	3,674	3,583	98	Daytime electricity	t-CO ₂ /yr	2,039	1,989	98
	Nighttime electricity	MWh	381	365	96	Nighttime electricity	t-CO ₂ /yr	212	202	96
	Bunker A	kℓ	36	34	95	Bunker A	t-CO ₂ /yr	97	92	95
	LPG	t	88	101	115	LPG	t-CO ₂ /yr	265	304	115
	Kerosene	kℓ	0	0	—	Kerosene	t-CO ₂ /yr	0	0	—
	Water consumption	m ³	13,102	14,146	108	Water drainage	m ³	10,784	12,001	111
	Product parts and materials	t	5,079	4,895	96	Steam, water, and related emissions	m ³	0	0	—
	Metals	t	728	790	109	Products*5	t	7,489	7,140	95
	Plastic	t	893	849	95					
	Glass	t	0	0	110					
	Paper	t	1,518	1,440	95					
	Other	t	1,940	1,815	94					
	PRTR-regulated substances	t	2.2	1.9	86	Total PRTR substance emissions/transfers	kg	93.3	56.2	60
			Note 1			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	93.3	56.2	60	
					Waste generation*1	t	656	668	102	
					Volume recycled*2	t	653	666	102	
					Other*3	t	1	1	100	
					Final disposal (landfill)*4	t	2	2	88	
Sales, Logistics, and Transportation Scope of calculation: Logistics and transportation in Japan, operation of company-owned vehicles	Fuel consumption and CO₂ emissions from company-owned vehicles used in sales activities and maintenance services for customers, and energy consumption and CO₂ emissions from contracted transport such as product delivery and used product collection and transportation are calculated.									
	Energy consumption	GJ/yr	35,091	34,552	98	CO ₂ emissions	t-CO ₂ /yr	2,380	2,344	99
	Gasoline	kℓ	415	398	96	Gasoline	t-CO ₂ /yr	982	940	96
	Diesel	kℓ	1	1	119	Diesel	t-CO ₂ /yr	1	2	119
	Volume of contracted transport*6	10,000 t-km	733	750	102	Volume of contracted transport*6	t-CO ₂ /yr	1,396	1,402	100
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	2,286	2,051	90	Used product disposal volume	t	2,286	2,062	90
	Digital duplicators and other printers	t	2,029	1,816	90	Volume transferred to recycling processes*7	t	191	239	125
	Ink bottles	t	231	208	90	Volume recycled*2	t	2,074	1,805	87
	Ink cartridges	t	26	27	104	Other*3	t	0	0	—
						Final disposal (landfill)*4	t	21	18	87

*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 2022 and accordingly, it has been corrected.

Environmental Data

Figure 6 Environmental Burden of Overseas Production Bases (Fiscal 2023)

Target	INPUT				OUTPUT					
		FY2022	FY2023	Compared to FY22		FY2022	FY2023	Compared to FY22		
Overseas production subsidiaries Scope of calculation: All overseas production bases of the Riso Kagaku Group: RISO TECHNOLOGY CHINA CO., LTD., ZHUHAI FACTORY, RISO TECHNOLOGY CHINA CO., LTD., RISO INDUSTRIES (SHENZHEN) LTD., RISO INDUSTRY SHANGHAI CO., LTD., RISO INDUSTRY (THAILAND) CO., LTD.	Volume of raw materials used, energy consumption, CO₂ emissions, and waste generation in overseas production subsidiaries									
	Energy consumption	GJ/yr	14,202	13,334	94	CO ₂ emissions	t-CO ₂ /yr	981	940	96
	Electricity	MWh	1,331	1,248	94	Electricity	t-CO ₂ /yr	919	881	96
	LPG Note 1	kℓ	3	3	102	LPG Note 1	t-CO ₂ /yr	9	9	102
	Gasoline	kℓ	19	16	84	Gasoline	t-CO ₂ /yr	44	38	85
	Diesel	kℓ	3	5	140	Diesel	t-CO ₂ /yr	9	13	140
	Water consumption	m ³	15,340	13,265	86	Water drainage	m ³	11,732	9,968	85
	Product parts and materials	t	3,530 Note 2	3,430	97	Steam, water, and related emissions	m ³	2,954	2,690	91
	Metals	t	1,878 Note 2	1,849	98	Products*5	t	4,185 Note 2	4,038	96
	Plastic	t	513 Note 2	503	98					
	Glass	t	0	0	100					
	Paper	t	468 Note 2	442	95					
	Other	t	672 Note 2	637	95					
						Waste generation*1	t	201	192	95
						Volume transferred to recycling processes*7	t	0	0	—
						Volume recycled*2	t	168	163	97
						Other*3	t	11.3	11.5	102
					Final disposal (landfill)*4	t	21.6	17.5	81	

Figure 7 Environmental Burden of Overseas Sales Subsidiaries (Fiscal 2023)

Target	INPUT				OUTPUT					
		FY2022	FY2023	Compared to FY22		FY2022	FY2023	Compared to FY22		
All overseas sales subsidiaries Scope of calculation: 17 overseas subsidiaries† and sales bases*8	Energy consumption and CO₂ emissions at the head office and sales bases of overseas subsidiaries									
	Energy consumption per unit	GJ/person*9	55.6 Note 2	56.7	102	CO ₂ emissions per unit	t-CO ₂ /person*9	3.61 Note 2	3.68	102
	Energy consumption	GJ/yr	38,624 Note 2	38,641	100	CO ₂ emissions	t-CO ₂ /yr	2,505 Note 2	2,513	100
	Electricity	MWh	1,167 Note 2	1,206	103	Electricity	t-CO ₂ /yr	696 Note 2	728	105
	Natural gas	kℓ	10,323	8,733	85	Natural gas	t-CO ₂ /yr	21	18	86
	Gasoline	kℓ	591	600	102	Gasoline	t-CO ₂ /yr	1,371	1,392	102
	Diesel	kℓ	162	145	90	Diesel	t-CO ₂ /yr	417	375	90
	Water consumption	m ³	592	513	87	Water drainage	m ³	592	513	87

† 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., RISO EURASIA KAZAKHSTAN LLC.

*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%.

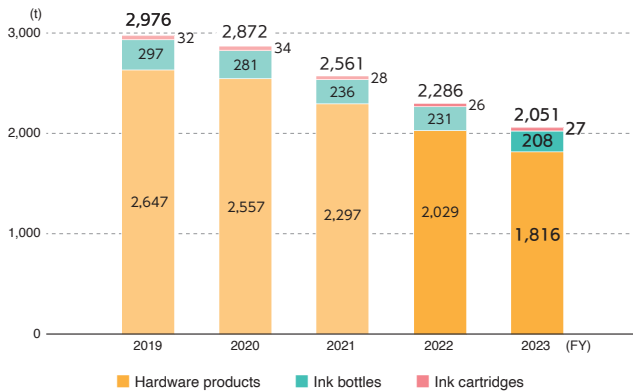
*9 Concerning overseas sales subsidiaries, because there are large fluctuations in topics such as office movement, the increase and decrease of personnel, and the propriety of surveys, the output level is calculated using the total number of employees belonging to the site where the survey was conducted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

[Note 1](#) Bunker A was changed to LPG.

[Note 2](#) There were errors in the figures for fiscal 2022 and accordingly, they have been corrected.

Environmental Data

Figure 8 Quantity of Used Products and Consumables Collected

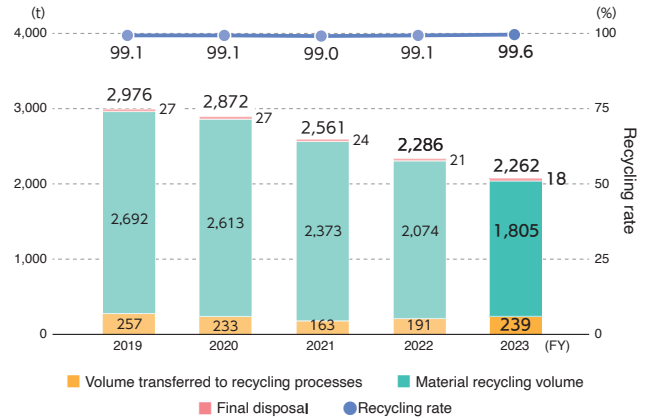


Scope of calculation: The amount of used RISO products in Japan (excluding second-hand digital duplicators that are returned or collected and then used as rental equipment)

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

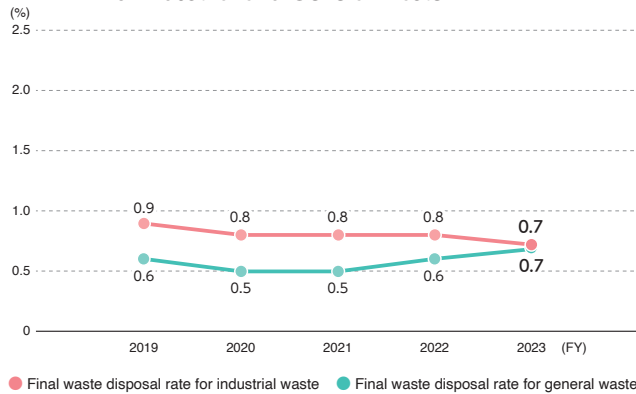


Scope of calculation: The amount of used RISO products in Japan (excluding second-hand digital duplicators that are returned or collected and then used as rental equipment)

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)

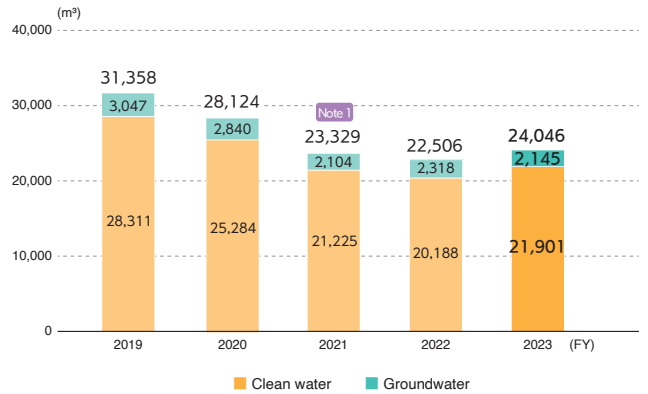
*Specific final waste disposal rate: RISO calculates the amount of specific final waste disposal as the total of the amount of waste incinerated, the residue and ashes resulting from recycling processes and used for landfill, and other waste used directly for landfill. Then, RISO calculates the specific 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.

Target for fiscal 2024 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 2024:
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 2023 increased by approximately 1,540m³ (approximately 7%) from the previous fiscal year.

Environmental Data

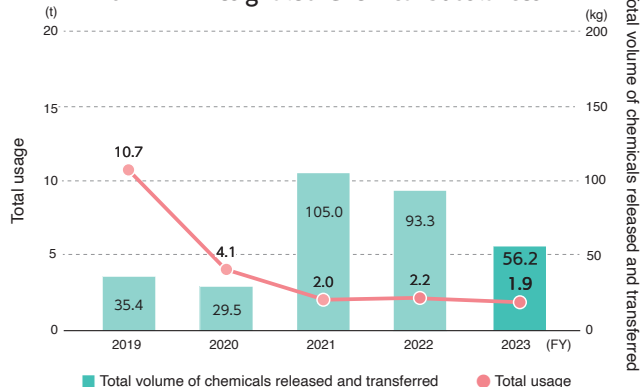
Figure 12 Breakdown of Released and Transferred Volume of PRTR-Designated Chemical Substances (kg)

	Total usage		Total volume of chemicals released and transferred									
	FY2022	FY2023	Emissions into the air		Emissions into the waters		Emissions into the soil		Waste generated			
			FY2022	FY2023	FY2022	FY2023	FY2022	FY2023	FY2022	FY2023		
Polyoxyethylene alkyl ether	124.3	114.7	—	—	—	—	—	—	—	—	—	—
BHT	160.0	10.0	16.0	7.0	—	—	—	—	—	—	16.0	7.0
Molybdenum and its compounds	115.2	107.9	—	—	—	—	—	—	—	—	—	—
2,3-Epoxypropyl methacrylate	1,724.5	1,610.9	36.0	19.6	—	—	—	—	—	—	36.0	19.6
2-Ethylhexanoic acid	20.4	3.0	17.0	0.2	—	—	—	—	—	—	17.0	0.2
Cobalt and its compounds	0.0	0.0	0.0	0.0	—	—	—	—	—	—	0.0	0.0
Methacrylic acid	1.5	4.4	1.5	4.4	—	—	—	—	—	—	1.5	4.4
Acetonitrile	17.3	0.0	17.3	—	—	—	—	—	—	—	17.3	0.0
Methyl methacrylate	1.5	9.9	1.5	9.9	—	—	—	—	—	—	1.5	9.9
Xylene	1.5	0.0	1.5	0.0	—	—	—	—	—	—	1.5	0.0
Ethylbenzene	1.5	0.0	1.5	0.0	—	—	—	—	—	—	1.5	0.0
Hexamethylene diacrylate	1.0	1.0	1.0	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	—	1.0	—	—	—	—	—	—	—	1.0
Total	2,168.8	1,875.9	93.3	56.2	—	—	—	—	—	—	93.3	56.2

Scope of calculation: Tsukuba Works, Ube Works, Kasumigaura Works, and RISO R&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.

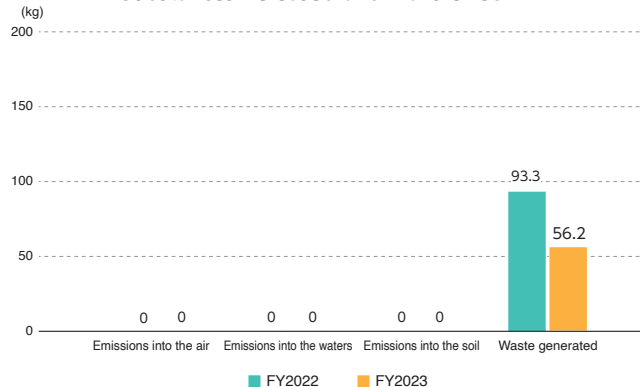
Figure 13 Consumption, Release and Transfer of PRTR-Designated Chemical Substances



Scope of calculation: Tsukuba Works, Ube Works, Kasumigaura Works, and RISO R&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&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.

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 2023 was 1.9 tons, a decrease of 0.3 tons compared with the previous fiscal year. The total volume of release and transfer decreased by 0.04 tons.

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

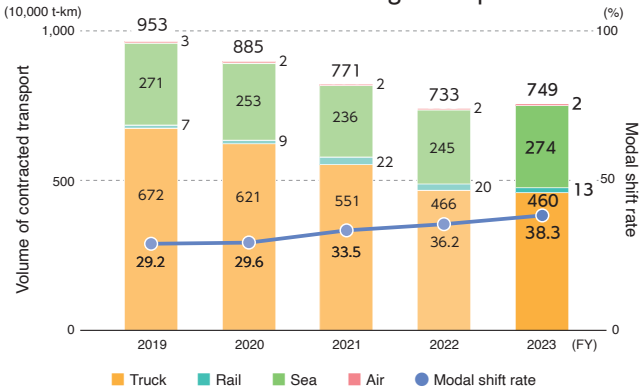
Target for fiscal 2024 for reducing PRTR-designated chemical substances:

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.

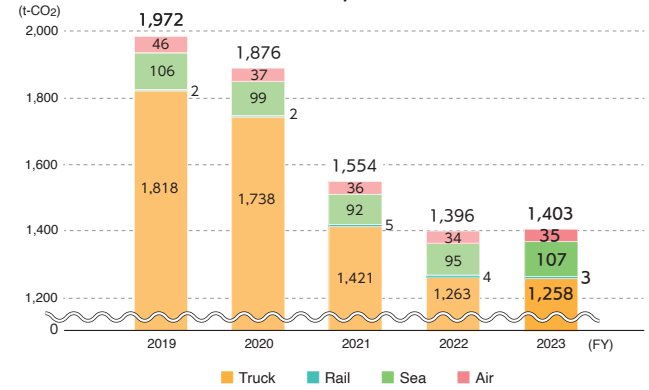
Environmental Data

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 CO₂ Emissions from Contracted Transport



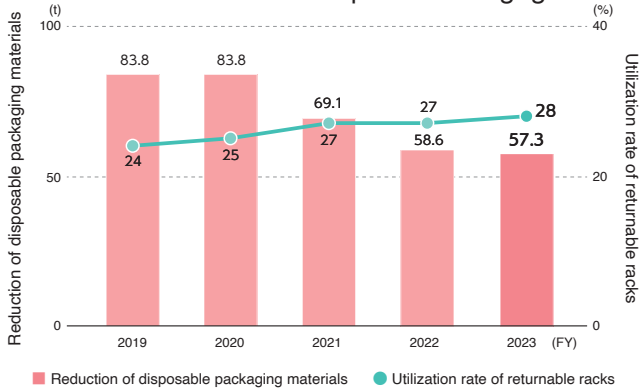
Scope of calculation: CO₂ emissions attributable to contracted transport (of products, components, raw materials, waste and used products) in Japan by the logistics department, sales department, plants, and the Center for Recycling

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 CO₂ emissions.

In fiscal 2023, we continued to implement a modal shift from trucks to ships for the transportation of consumables. Compared to fiscal 2022, the modal shift rate went from 36.2% to 38.3% and CO₂ emissions increased by 7tons-CO₂ or 0.5%.

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 28% in fiscal 2023, which is equivalent to a 57.3-ton reduction in packaging materials.

Figure 18 Environmental Education Programs and Number of Participants (Fiscal 2023)

Type of education	Events (times)	Participants (employees)	Hours (aggregate)
Basic environmental education program (e-Learning)	1	1,681	420
Basic environmental education program	14	151	87
Environmental policy and EMP confirmation training	1	309	155
Internal auditor training	5	42	291
Special environmental education program	12	110	43
Accident/emergency drill	10	105	63
Disaster drill	3	519	490
Advanced EMS skill program	3	18	18
Outside seminars (including regulatory trends)	4	28	84
Workplace health and safety program	1	7	7
Total	54	2,970	1,658

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 2023 (April 1, 2022 to March 31, 2023)

● **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 2023

(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"> Reduction of fuel consumption Reduction of electricity consumption 	<ul style="list-style-type: none"> Replacement of boilers with high efficiency models, pursuit of a modal shift strategy Introduction of energy-saving equipment 	0	570	154	<ul style="list-style-type: none"> Reduction of CO₂ emissions during manufacture and product transport Reduction of electricity consumption
Promotion of resource conservation and recycling	<ul style="list-style-type: none"> Effective utilization of used products Effective utilization of wastes Safe disposal of wastes 	<ul style="list-style-type: none"> Collection and recycling of used products Separation and recycling of waste 		260,595	394,723	<ul style="list-style-type: none"> Reduction of costs through reuse Improvement of resource recovery rates
Environmental communication	<ul style="list-style-type: none"> Publication of product environmental data Publication of information about environmental initiatives 	<ul style="list-style-type: none"> Acquisition of environmental label certification Publication of the Environmental Data Book Participation in events and exhibitions 		14,139		<ul style="list-style-type: none"> Acquisition of certification under the Eco Mark Program Publication of the Environmental Data Book, website revisions, etc.
Green areas	<ul style="list-style-type: none"> Clean-up and maintenance of green areas 	<ul style="list-style-type: none"> Clean-up and maintenance of green areas 		3,616		<ul style="list-style-type: none"> Clean-up and maintenance of green areas
Legal compliance (pollution control measures, environmental pollution control)	<ul style="list-style-type: none"> Compliance activities (water, air, etc.) Understanding of legal and regulatory trends 	<ul style="list-style-type: none"> Water drainage management Gas emissions management Inspection and maintenance of facilities Monitoring of laws and regulations 		17,829		<ul style="list-style-type: none"> Environmental protection activities Research for and understanding of legal and regulatory trends in Japan and overseas
Green procurement	<ul style="list-style-type: none"> Collection and registration of environmental data relating to raw materials and parts 	<ul style="list-style-type: none"> Implementation of an environmental information system covering REACH and other regulations 		6,633		<ul style="list-style-type: none"> Environmental information updates, operation and maintenance
EMS establishment and maintenance activities	<ul style="list-style-type: none"> ISO 	<ul style="list-style-type: none"> Acquisition and maintenance of ISO 14001 certification 		4,431		<ul style="list-style-type: none"> Updates and maintenance of ISO 14001 certification
Total			0	307,812	394,878	

Figure 20 Breakdown of Costs (Investment + Actual Costs)

(Thousands of Yen)

	FY2019	FY2020	FY2021	FY2022	FY2023
Global warming prevention measures	63,672	18,163	1,073	1,370	570
Promotion of resource conservation and recycling	391,304	383,016	333,979	291,048	260,595
Environmental communication	21,320	15,153	8,749	11,971	14,139
Green areas	3,000	3,000	2,686	2,350	3,616
Legal compliance	28,657	15,604	18,282	20,887	17,829
Green procurement	7,489	7,484	6,970	7,524	6,633
EMS establishment and maintenance activities	4,765	5,071	9,321	4,230	4,431

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

(Thousands of Yen)

	FY2019	FY2020	FY2021	FY2022	FY2023
Global warming prevention measures	1,142	676	148	150	154
Promotion of resource conservation and recycling	414,798	358,227	219,061	279,058	394,723

† 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)

	FY2019	FY2020	FY2021	FY2022	FY2023
Costs (investment + actual costs) (Thousands of Yen)	520,208	447,491	381,059	339,379	308,179
Economic effect (Revenue + Cost saving) (Thousands of Yen)	415,941	358,903	219,209	279,208	394,878
Economic effect ratio (%)	80%	80%	58%	82%	128%

KEY POINT

In fiscal 2023, the cost of global warming prevention measures (investment + actual cost) decreased by 800,000 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 increased by 4,000 yen.

The number of used products collected and production using reused parts increased. The cost of resource saving and recycling promotion decreased by 30,453,000 yen. The positive economic effect increased by 115,666,000 yen.

The ratio of cost (investment + actual costs) and economic effects (revenue + cost saving) was 128%.

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

Site Area 97,000m²
Total Floor Space 29,326m²
Number of Employees 285 (As of March 31, 2023)

Commencement of Operations October 1981

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 updated in October 2017
- Designing environmentally friendly products to respond to the RoHS Directive and other environmental regulations
- Reduction of CO₂ 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	FY2019	FY2020	FY2021	FY2022	FY2023	YoY (%)
Electricity consumption	MWh	2,066	1,855	1,805	1,816	1,791	99
Water consumption	m ³	10,669	9,737	7,963	7,543	8,893	118 <small>Note 1</small>
Clean water	m ³	10,669	9,737	7,963	7,543	8,893	118 <small>Note 1</small>
Groundwater	m ³	0	0	0	0	0	—
Water drainage	m ³	10,669	9,737	7,963	7,543	8,893	118 <small>Note 1</small>
Annual biochemical oxygen demand (BOD) emissions	kg	0.9	9.7	8.0	8.1	8.9	109
Annual nitrogen emissions	kg	92	78	72	72	74	103
Annual phosphorus emissions	kg	8.2	13.2	4.1	3.8	7.5	198 <small>Note 2</small>
Total waste generation	t	439	460	397	345	362	105
Final disposal (landfill)	t	3.3	1.5	1.9	1.6	1.6	98
Waste recycling rate	%	99.2	99.7	99.5	99.5	99.6	100

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

Note 1 Due to pre-treatment for thermal insulation coating on roofs and others

Note 2 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

Site Area 28,265m²
Total Floor Space 16,821m²
Number of Employees 53 (As of March 31, 2023)

Commencement of Operations August 1965

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 updated in December 2017
- Recycling of used printers
- Reduction of waste generation and promotion of recycling
- Reduction of CO₂ emissions through energy conservation



Environmental Data

	Unit	FY2019	FY2020	FY2021	FY2022	FY2023	YoY (%)
Electricity consumption	MWh	511	464	449	443	434	98
Water consumption	m ³	1,155	843	843	900	820	91
Clean water	m ³	1,155	843	843	900	820	91
Groundwater	m ³	0	0	0	0	0	—
Water drainage	m ³	1,155	843	843	900	820	91
Annual biochemical oxygen demand (BOD) emissions	kg	8	5	11	5	4	73 <small>Note 1</small>
Annual nitrogen emissions	kg	49	30	41	40	36	92
Annual phosphorus emissions	kg	6.2	4.3	4.8	4.3	3.5	82 <small>Note 1</small>
Total waste generation	t	256	160	153	139	125	89
Final disposal (landfill)	t	2.5	0.3	1.1	0.3	0.1	33 <small>Note 2</small>
Waste recycling rate	%	99.0	99.8	99.2	99.8	99.9	100

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

Note 1 The range of variation within the standard value

Note 2 Due to the promotion of recycling used printers

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 ²
	Commencement of Operations	June 1986	Total Floor Space	15,598m ²
			Number of Employees	69 (As of March 31, 2023)

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 2017
- Designing environmentally friendly products to respond to the RoHS Directive and other environmental regulations
- Reduction of CO₂ emissions through energy conservation
- Reduction of waste generation and promotion of recycling
- Promotion of green purchasing
- Recycling of used ink bottles

Environmental Data

	Unit	FY2019	FY2020	FY2021	FY2022	FY2023	YoY (%)
Electricity consumption	MWh	2,182	2,109	1,693	1,797	1,723	96
Water consumption	m ³	5,528	5,309	4,324	4,659	4,433	95
Clean water	m ³	2,481	2,469	2,220	2,341	2,288	98
Groundwater	m ³	3,047	2,840	2,104	2,318	2,145	93
Water drainage	m ³	2,481	2,469	2,220	2,341	2,288	98
Annual biochemical oxygen demand (BOD) emissions	kg	15	5	9	33	13	40 <small>Note 1</small>
Total waste generation	t	211	188	148	172	182	106
Final disposal (landfill)	t	0.2	0.3	0.1	0.1	0.1	100
Waste recycling rate	%	99.5	98.7	99.4	99.4	99.5	100

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

Note 1 The range of variation within the standard value



Figure 26

RISO R&D Center

Scope of calculation: RISO R&D Center

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

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 9, 2020
- Reduction of CO₂ emissions through energy conservation
- Designing environmentally friendly products
- Reduction of waste generation and promotion of recycling

Environmental Data

	Unit	FY2019	FY2020	FY2021	FY2022	FY2023	YoY (%)
Electricity consumption	MWh	2,331	2,257	2,037	2,130	2,061	97
Water consumption	m ³	9,788	8,356	6,258	5,967	6,355	107
Clean water	m ³	9,788	8,356	6,258	5,967	6,355	107
Groundwater	m ³	0	0	0	0	0	—
Water drainage	m ³	9,788	8,356	6,258	5,967	6,355	107
Annual biochemical oxygen demand (BOD) emissions	kg	275	275	356	269	107	40 <small>Note 1</small>
Total waste generation	t	204	256	116	120	99	83
Final disposal (landfill)	t	1.7	1.4	0.8	0.8	0.8	108
Waste recycling rate	%	99.2	99.2	99.0	98.8	98.8	100

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

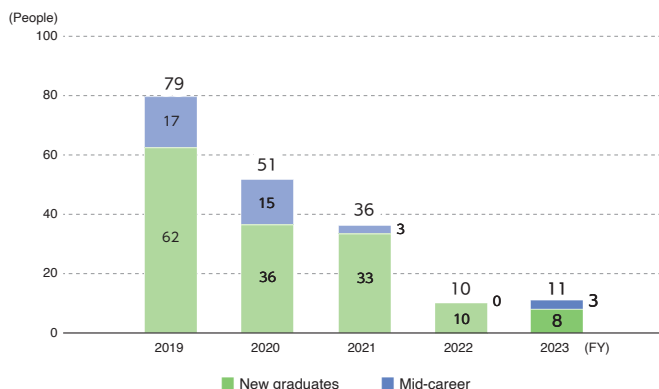
† Opened in June 2013. We continue to consider the environment.

Note 1 The range of variation within the standard value



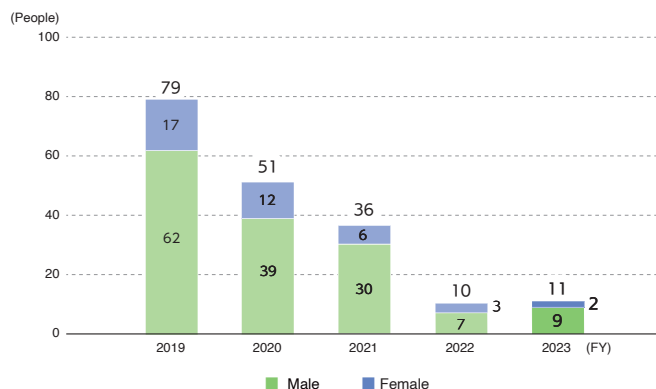
Social Data

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



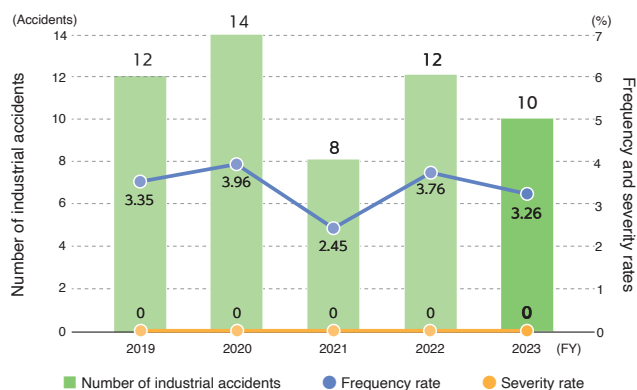
Scope of calculation: Non-consolidated basis (Japan)

Figure 28 Employment (Japan)
(Male/Female)



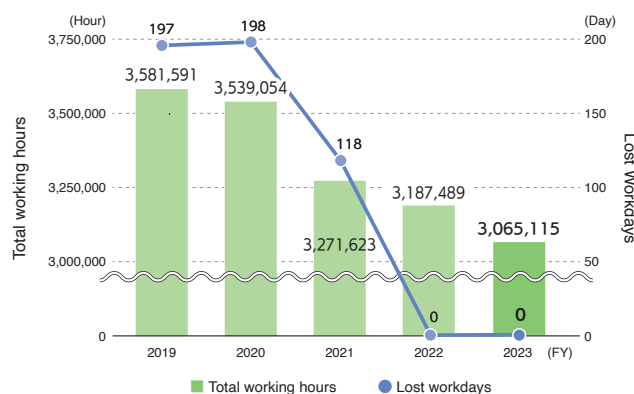
Scope of calculation: Non-consolidated basis (Japan)

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 2023 was 10, a decrease of 2 from fiscal 2022. There have been no lost workdays due to industrial accidents since fiscal 2022.

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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