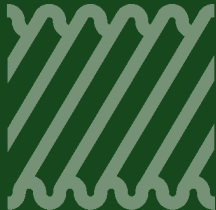
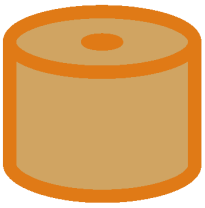


# The Georgia-Pacific Advantage

---

Containerboard Manufacturing  
Toledo, Oregon





# The Georgia-Pacific Advantage Begins Here

The benefits of doing business with Georgia-Pacific begin with the high performance UltraVantage® product line that is produced at our state-of-the-art manufacturing operations. Every step of the way, our operations focus on safety, product quality, customer service and a commitment to environmental excellence. Take a look at our world-class Toledo operations. The Georgia-Pacific Advantage begins here.

## Toledo Key Statistics

### Location:

Toledo, Ore., Lincoln County

### Mill contact:

Communications office (541) 336-8202

**Size of operation:** 311 acres

**Number of employees:** 520

### Union:

Local 13 Association of Western Pulp and Paper Workers (420 employees)

### Payroll:

\$38.7 million in 1999 (includes labor and benefits)

### Products:

Linerboard and corrugating medium

### Principal markets for products:

Domestic and export box plants

### Fiber usage:

Approximately 1.2 million tons per year including:

- 500,000 tons of softwood
- 130,000 tons of hardwood
- 570,000 tons of recycled fiber

### Purchase of local goods and services:

\$198.8 million annually

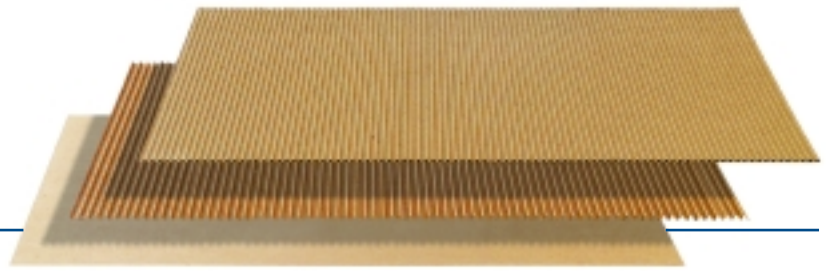
### Significant Mill Improvements:

- 1994-97** Toledo 2000 modernization plan (\$100 million)
- 1995** Completion of recycled fiber plant
- 1997** Construction of boiler and paper machine upgrades

### Key Mill Dates:

- 1956-57** Constructed mill
- 1958** Mill start-up
- 1960** Installed No. 2 paper machine
- 1962** Opened bag plant
- 1973** Purchased No. 3 paper machine
- 1976** Opened No. 1 recycled fiber plant
- 1994** Closed bag plant
- 1994** Began Toledo 2000 modernization project
- 1997** Completed \$100 million Toledo 2000 modernization project including No. 2 recycled fiber plant





## About the Toledo Operations

In 1952, Georgia-Pacific purchased the C.D. Johnson Lumber Company of Toledo, Ore., laying the groundwork for the company's entry into the pulp and paper business. In 1957, we began construction of the new facility at the Toledo site—an integrated pulp and paper mill designed to utilize the residual chip material from the existing on-site sawmill.

To this day, the Toledo mill stands as the only pulp and paper facility ever constructed by G-P and is the hallmark of G-P's entry into the pulp and paper business. The employees at Toledo take great pride in the facility and its heritage. They're proud of its position as the cornerstone of G-P's pulp and paper division.


In 1994, Georgia-Pacific began investing more than \$100 million in "Toledo 2000," a modernization project that propelled the mill into the 21st century. The project reduced the mill's dependence on wood chips for the pulp making process and more than doubled the mill's recycling capacity—which has reached 60 percent recycled material.

The Toledo operations continue the G-P heritage of quality papermaking that began four decades ago in Toledo. And just as it was back then, we are committed to meeting the needs of our customers.

## Toledo Products

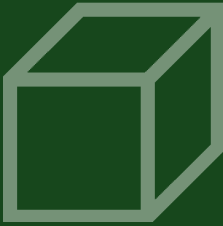
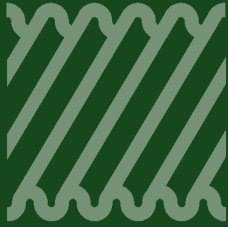
The Toledo mill produces linerboard, including the high performance UltraStak Plus®, as well as a premium corrugating medium. Complete product specifications are provided below:



	Machine 1	Machine 2	Machine 3
<b>Products:</b>			
	90 to 150 min. ring crush 42# to 74#/msf nominal (205 to 361 gsm) linerboard		70 to 80 min. ring crush 35# to 38#/msf nominal (170 to 185 gsm) linerboard
<b>Liner</b>	42# to 76#/msf (205 to 371 gsm) linerboard		26# to 42#/msf (125 to 205 gsm) linerboard
<b>Medium</b>		26# to 40#/msf (125 to 200 gsm) corrugating medium	23# to 33#/msf (112 to 161 gsm) corrugating medium
<b>TPD</b>	1,000 tpd (909 mt)	650 tpd (591 mt)	900 tpd (878 mt)
<b>Max Trim</b>	245" (622 cm)	26#: 159" (404 cm) 33, 36, 40, 54#: 162" (411 cm)	244" (620 cm)
<b>Min/Max Roll Widths</b>	6" (15 cm) to 110" (279 cm)	18" (46 cm) to 120" (305 cm)	7.5" (19 cm) to 120" (305 cm)
<b>Min/Max Roll Diameters</b>	57" (145 cm) min. to 58.5" (147 cm) max. 58.5" (147 cm) standard 50" (127 cm) export	50" (127 cm) min. to 60" (152 cm) max. 58.5" (147 cm) standard	50" (127 cm) min. to 60" (152 cm) max. 58.5" (147 cm) standard
<b>Core Size</b>	4" (10.2 cm)	4" (10.2 cm)	4" (10.2 cm)
<b>Roll Slitter Width Accuracy</b>	± 1/8" (.32 cm)	± 1/8" (.32 cm)	± 1/8" (.32 cm)
<b>Fiber Content</b>	Natural virgin kraft, secondary fiber	40% virgin hardwood/60% secondary recycled fiber	Natural virgin kraft, hardwood, secondary fiber
<b>Process Controls</b>	ABB	ABB	ABB
<b>Other Special Features</b>	Double steel bands; ring crush grades; roll management system	Liner body wrap and up to 3 steel bands; ring crush grades; roll management system	Double steel bands; liner body wrap—corrugating medium; ring crush grades; roll management system



For UltraVantage® sample and product information, contact your Georgia-Pacific representative or call our Customer Service Center at 1-800-944-0001, ext. 4307.



# The Georgia-Pacific Containerboard Advantage

## The Quality Commitment

In the quest for quality and consistency, we have joined technology and skill. Today, G-P containerboard is the product of meticulous monitoring blended with years of papermaking experience. Georgia-Pacific's quality initiatives are formalized in its continuous Mill Improvement Process (MIP) that enhances all areas of mill operations. Toledo's version of MIP is the Toledo Optimization Process (TOP).

To meet our quality commitment, we have invested in new technology and equipment as well as employee training. Our TOP program includes training programs, employee involvement, awareness and communications efforts, and daily monitoring of our processes. Through TOP, employees have gained an appreciation for the importance of consistently delivering quality products to adjoining departments as well as to our customers. A commitment to quality products and service is shared by the people at the Toledo mill and by all of Georgia-Pacific.

## Safety First

Safety comes first at Georgia-Pacific. The company is committed to providing a safe working environment for all employees. G-P has been the safest large company in the forest products industry for several years, according to the American Forest & Paper Association. Many G-P facilities have been accepted into the Occupational Safety and Health Administration's (OSHA) Voluntary Protection Program (VPP) at the Star Level, the VPP's highest recognition for workplace safety.

Toledo achieved VPP Merit site recognition in 1999 and VPP Star status in 2000. Also in 2000, the Toledo mill reached 2.5 million hours worked without a lost-time accident, from January 1998 to June 2000. The Toledo mill has received several safety awards including the G-P Chairman's Award in 1998 for 500,000 hours worked without an OSHA recordable injury and the Oregon Governor's Safety Award for safety excellence in 1995.

## Continuing the Commitment to the Environment

From pollution prevention to recycling and water quality improvement, Georgia-Pacific and the Toledo operations model a total commitment to environmental stewardship. Following company and industry initiatives, we are carefully controlling the use of water, energy and other important resources. The company also is addressing product stewardship issues, such as extended product responsibility and short- and long-term impact through life cycle assessment.

As one of the nation's leading forest products companies, Georgia-Pacific is committed to the practice of sustainable forestry, as represented by its participation in the American Forest & Paper Association's Sustainable Forestry Initiative<sup>SM</sup> program.

The Toledo mill is designed to make the best use of available natural resources. It uses bark and sawdust from area chip mills and sawmills as "waste" fuel in its bark boiler to supply about 25 percent of the mill's energy needs. A companywide pollution prevention program has resulted in the reduction or beneficial use of more than 22 million tons of residual waste. To continuously improve water quality, G-P treats its pulp and paper mill effluent or wastewater. Since 1972, water impurities or pollutants have been reduced by approximately 90 percent.

Georgia-Pacific annually recycles an impressive 1.8 million tons of old corrugated containers (OCC). The Toledo mill contributes to the corporate recycling capabilities with its two recycled fiber plants. Toledo recycles fiber from box plant trim scraps and old corrugated containers, receiving OCC bales from warehouses, stores and collection points throughout the country.

In all its activities, Georgia-Pacific strives to minimize its impact on the environment. The company sets high environmental standards including a commitment to seek 100 percent compliance with all regulations, permits and company goals.