



GS-1

FINAL REVISED GREEN SEAL™ STANDARD FOR
SANITARY PAPER PRODUCTS

Note: Modifications made to the Final Revised Standard are noted in red font in this version of the standard.

TBD, 2010

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THE MARK OF ENVIRONMENTAL RESPONSIBILITY

GREEN SEAL™

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FINAL REVISED GREEN SEAL™ STANDARD FOR SANITARY PAPER PRODUCTS, GS-1

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FOREWORD

General. The final issued standard was developed in an open and transparent process with stakeholder input that included producers, users, and general interests.

The requirements in the standard are based on an assessment of the environmental, health, or social impacts associated with the products, services, or organizations covered in the scope of the standard. The requirements included in the standard are subject to revision. Provisions for safety have not been included in this standard. This standard neither modifies nor supersedes laws and regulations. Compliance with this Standard is not a substitute for, and does not assure, compliance with any applicable law or regulations. This standard (and any corresponding conformity assessment) presumes compliance with all applicable laws and regulations.

Products, services, or organizations that are substantially similar to those covered by this standard in terms of function and life cycle considerations may be evaluated against the intent of the requirements of this standard, accounting for relevant differences between the intended scope of the standard and the actual product, service, or organization to be evaluated.

This standard may not anticipate features of sanitary paper products that may significantly, and undesirably, increase its impact on the environment, health, or society. In such a situation, Green Seal will ordinarily amend its standards to account for the unanticipated environmental, health, and societal impacts.

Normative references (e.g., other standards) in this standard intend to refer to the most recent edition of the normative reference.

Edition. This version represents the development of the Third Edition and will replace the Second Edition from February 12, 1992, including substantive revisions once completed.

Disclaimer of Liability. Green Seal[™], as the developer of this standard, shall not incur any obligations or liability for any loss or damages, including, without limitation, indirect, consequential, special, or incidental damages arising out of or in connection with the interpretation or adoption of, reliance upon, or any other use of this standard by any party. Green Seal makes no express or implied warranty of merchantability or fitness for a particular purpose, nor any other express or implied warranty with respect to this standard.

Tests may be required by the standards that involve safety considerations. Adequate safeguards for personnel and property should be employed in conducting such tests.

LIST OF ACRONYMS AND ABBREVIATIONS

BOD. Biochemical Oxygen Demand.
BTU. British Thermal Unit.
CD. Cross direction.
CFC. Chlorofluorocarbon.
CFR. Code of Federal Regulations.
CO₂. Carbon dioxide.
DOC. Dissolved Organic Carbon.
EPA. United States Environmental Protection Agency.
gf. Gram force.
GHS. Globally Harmonized System for Classification and Labeling of Chemicals.
GJ. Gigajoules.
in. inch.
IARC. International Agency for Research on Cancer.
ISO. International Organization for Standardization.
IRIS. Integrated Risk Information System.
Kg. Kilogram.
Kwh. Kilowatt-hour.
lb. pound.
m² or m³. Square meters or cubic meters.
MCL. Maximum Contaminant Level.
MD. Machine direction.
MDIP. Market De-Inked Pulp.
MRDL. Maximum Residual Disinfectant Level.
MT. Metric ton.
N. Newton.
NTP. National Toxicology Program.
OECD. Organization for Economic Co-operation and Development.
OSHA. Occupational Safety and Health Administration.
PCF. Processed Chlorine Free.
PMRA. Pest Management Regulatory Agency.
QSAR. Quantitative Structure-Activity Relationship.
SIC. Standard Industrial Classification.
TAPPI. Technical Association of the Pulp and Paper Industry.
ThOD. Theoretical Oxygen Demand.
Yield_{PC}. Post-Consumer Material Yield.
Yield_R. Recovered Material or Agricultural Residue Yield.

FINAL REVISED GREEN SEAL™ STANDARD FOR SANITARY PAPER PRODUCTS, GS-1

1.0 SCOPE

This standard establishes environmental, health, and social requirements for sanitary paper products including paper towels, general-purpose wipes, paper napkins, bathroom tissue, facial tissue, toilet seat covers, placemats, tray liners, table coverings, and other sanitary paper products. The standard covers products for institutional as well as retail markets. This standard does not include nonwoven sanitary products, general-purpose disposable and flushable wipes containing cleaning agents or fragrances, disposable diapers, or sanitary napkins and tampons. See Appendix A for an example list of products included in the standard.

This standard neither modifies nor supersedes laws and regulations. Compliance is required for all applicable laws and regulations for the manufacturing and marketing of the products. Generally, the requirements included in this standard cover aspects above and beyond compliance issues.

2.0 DEFINITIONS

2.1 Agricultural Residue. Process waste material remaining from a **non-timber species** agricultural plant after it was used to produce food or fiber, which would otherwise be incinerated or disposed of *in situ* or in a landfill. Material that would normally be used as compost/fertilizer *in situ* is excluded.

2.2 Bathroom Tissue. A class of soft paper products used to maintain personal hygiene, designed to disperse in septic tanks. Products typically come in rolls.

2.3 Biocide. A chemical used to kill biological organisms.

2.4 By-Product. A secondary or incidental product deriving from a manufacturing process.

2.5 Carcinogen. Chemicals listed as a known, probable, reasonably anticipated, or possible human carcinogen by the International Agency for Research on Cancer (IARC Groups 1, 2A, and 2B), National Toxicology Program (NTP Groups 1 and 2), United States Environmental Protection Agency Integrated Risk Information System (EPA IRIS weight-of-evidence classifications A, B1, B2, C, carcinogenic, known/likely human carcinogen, likely to be carcinogenic to humans, and suggestive evidence of carcinogenicity or carcinogen potential), or by the Occupational Safety and Health Administration (OSHA as carcinogens under 29 Code of Federal Regulations (CFR) 1910.1003(a)(1)); and

those chemicals that fall into Carcinogenicity Hazard Category 1A and 1B under the Globally Harmonized System for Classification and Labeling of Chemicals (GHS).

2.6 Colorant. Inks, dyes, or pigments which are capable of imparting color when added in the paper-making process.

2.7 Contaminant. A substance that was not intentionally added, but is known to be present above 0.01% (100 parts per million) by weight in the papermaking additives as purchased.

2.8 Converted Product. Manufactured paper that has been further processed and converted into a finished product that is saleable.

2.9 Energy Use. The total energy used to manufacture sanitary paper products, including the net energy consumption during re-pulping of recovered material or agricultural residue pulping, throughout the paper making process, during waste treatment, and during converting and/or packaging. Net energy consumption is considered energy purchased and generated less sales. It does not include transportation.

2.10 Facial Tissue. A class of soft, absorbent, disposable paper products suitable for use on the face. Products may come in flat, cube, or dispenser type boxes. Flat and dispenser boxes are typically rectangular in shape and wider than they are tall. Cube boxes are typically an upright package with a square base and an elongated height.

2.11 Finishing Broke. Discarded paper resulting from any finishing (converting) operation, including, but not limited to winding, slitting, cutting, sorting, counting, cartoning, palletizing, and wrapping.

2.12 Forest Residue. Fibrous **timber** by-products of harvesting, manufacturing, extractive or woodcutting processes such as, but not limited to, chips, stumps, branches and sawdust.

2.13 Fragrance. A constituent, often (but not limited to) a multi-component constituent, used in a product for the purpose of imparting a scent to the product.

2.14 Fresh Water Use. The total amount of steam, process, and cooling water used in the manufacture of sanitary paper products, including water used during recovered material re-pulping or agricultural residue pulping, throughout the paper making process, and during converting (if applicable).

2.15 Furnish. The mixture of recovered material fiber or agricultural residue fiber and other chemicals that is blended in a water suspension, or slurry, from which paper products are made. Also referred to as stock.

- 2.16 General-Purpose Wipes.** A class of absorbent disposable paper products suitable for use as industrial wipers and containing no cleaning agents (e.g., surfactants) or fragrances.
- 2.17 Institutional.** A category of products manufactured for use at institutional facilities, such as schools, hospitals, hotels, or offices, sold to professional purchasing staff and not to consumers.
- 2.18 Integrated Mill.** A facility with either a pulp mill or the capability to repulp virgin or recovered fiber and a paper mill on the same site.
- 2.19 Intentional Introduction.** The act of deliberately utilizing a material in the formation of a package or packaging component where its continued presence is desired in the final package or packaging component to provide a specific characteristic, appearance, or quality.
- 2.20 Mill Broke.** Paper discarded from any point in the manufacturing process, which is subsequently re-pulped and reprocessed. “Wet broke” is typically generated from the wire or presses, while “dry broke” emanates from the dryers, reel, and winder.
- 2.21 Mutagen.** Substances designated as known to induce heritable mutations, regarded as if they induce, or which cause concern for humans owing to the possibility that they may induce heritable mutations in the germ cells of humans, and thus meets the criteria for categories 1 and 2 (H340 and H341) under the GHS.
- 2.22 Non-Timber Species.** Plant species used in the manufacture of sanitary paper products such as but not limited to bamboo, hemp, cotton, kenaf, or sugar cane, that are not typical fiber sources for pulp or paper products and are botanically not considered trees.
- 2.23 Nonwoven Sanitary Products.** A product category that incorporates nonwoven fabrics in the manufacturing process. A product is considered nonwoven when the fibers (synthetic or wood pulp) used in fabrication are bonded together instead of woven, using either an adhesive or a chemical reaction. Nonwoven products include, but are not limited to, disposable diapers, feminine hygiene products, or premoistened tissues.
- 2.24 Optical Brightener.** Additives designed to enhance the appearance of colors and whiteness in materials by absorbing ultraviolet radiation and emitting blue radiation. These compounds are also known as fluorescent whitening agents.
- 2.25 Ozone-Depleting Compound.** Any compound with an ozone-depletion potential greater than 0.01 (chlorofluorocarbon [CFC]11=1) according to the EPA

list of Class I and Class II Ozone-Depleting Substances; or any substances or mixtures falling into category 1 (H420), hazardous to the ozone layer, under the GHS.

2.26 Papermaking Additives. Materials intentionally added to paper or to the papermaking furnish to modify or improve certain paper properties or to facilitate the papermaking process. This definition encompasses all materials that enter the system except fiber and water, including, but not limited to: surfactants, detergents, defoamers, dispersants, foaming agents, collectors, wet strength resins, and biocides.

2.27 Papermaking Process. The process of using fiber, water and additives to make paper, including, but not limited to re-pulping, cleaning, screening, deinking, washing, bleaching, and papermaking.

2.28 Paper Napkins. A class of absorbent, disposable paper products that is typically folded and is suitable for wiping hands and mouth, including, but not limited to: retail beverage, luncheon, dinner, and guest towel napkins; institutional folded towels used with or without a dispenser; and institutional beverage, luncheon, dinner, and guest towel napkins.

2.29 Paper Towels. A class of absorbent, disposable paper products suitable for use in drying hands, wiping windows, cleaning equipment, or cleaning up spills, including, but not limited to: retail, perforated roll towels; retail, folded towels; institutional, hardwound roll towels; institutional, folded towels, and institutional, perforated roll towels.

2.30 Parent Roll. The full-width roll produced from a paper machine, prior to any further finishing or converting.

2.31 Placemats. A protective layer made from paper for a portion of a table or other surface. Tray liners are considered the same as placemats for the purposes of this standard.

2.32 Post-Consumer Material. Material that would otherwise be disposed of as solid waste, having completed its intended end-use by the consumer. Post-consumer material does not include materials, agricultural residue, or by-products generated from, and commonly reused within, an original manufacturing and fabrication process.

2.33 Pre-Consumer Material. Material diverted from a waste stream during the manufacturing process, excluding material such as rework, regrind, or scrap generated in a process and capable of being reused within the same process that generated it.

2.34 Primary Packaging. Material physically containing and coming into physical contact with the product, including, but not limited to: paper and paperboard material such as roll cores, brown papers, wrappers, bands, and folding cartons; and plastic materials such as film wrappers and roll core inserts.

2.35 Processed Chlorine Free (PCF). Recycled- or recovered-content papers in which chlorine or chlorine-containing compounds are not used in any of the unit processes used to manufacture the product, including, but not limited to, the re-pulping, screening, deinking, washing, and bleaching stages.

2.36 Recovered Material. Either material recovered from or otherwise diverted from the solid waste stream, that is generated after the completion of the paper manufacturing process; or fiber and broke recovery that contains 100% recovered material and is integral to the manufacturing process from which it was generated.

Recovered material may include:

- Finishing waste generated after completion of the papermaking process (i.e., during converting), such as envelope cuttings; bindery trimmings; printing waste; cuttings and other converting waste (finishing broke); butt rolls and mill wrappers; obsolete inventories; and rejected unused stock.
- Post-consumer materials such as paper, paperboard, and fibrous materials from retail stores, office buildings, homes, etc., after they have completed their intended end-use.
- Fibers recovered from whitewater or wastewater, or mill broke (wet or dry) generated from the manufacturing process used only to make the certified product (i.e., mill broke containing 100% recovered material).

Recovered material does not include:

- Fibers recovered from whitewater or wastewater, or mill broke (wet or dry) generated from the manufacturing process used to make non-certified products containing virgin material (i.e., mill broke containing any virgin material), regardless of whether such materials are used by the same or another company.
- Forest residue such as fibrous by-products of harvesting, extractive or woodcutting processes.

2.37 Recyclable. The package or product can be collected in a substantial majority of communities, separated or recovered from the solid waste stream and used again, or reused in the manufacture or assembly of another product package through an established recycling program.

2.38 Reproductive Toxin. A chemical listed as a reproductive toxin (including developmental, female, and male reproductive toxins) by the State of California under the Safe Drinking Water and Toxic Enforcement Act of 1986 (California Code of Regulations, Title 22, Division 2, Subdivision 1, Chapter 3,

Sections 1200, et. Seq., also known as Proposition 65), substances designated as category 1 (H360), known or presumed reproductive toxicant, or category 2 (H361), suspected human reproductive toxicant, under the GHS, or a substance designated as having adverse effects on or via lactation (H362), under the GHS.

2.39 Retail. A category of products typically manufactured for use in residential homes and sold to consumers.

2.40 Sanitary Paper Products. Products covered by the Standard Industrial Code (SIC) 2676. Products including facial and bathroom tissues, toilet seat covers, paper towels and general-purpose wipes, paper napkins, paper placemats and table coverings. Products that are technically in this category by SIC code, but not covered by this standard, include nonwoven sanitary products, general-purpose disposable and flushable wipes containing cleaning agents or fragrances, disposable diapers, or sanitary napkins and tampons.

2.41 Secondary Packaging. Packaging used to contain primary package/s and typically used for merchandizing. This does not include case or shipping packaging or the primary package.

2.42 Solid Waste. Waste materials from the manufacturing of the product not included in the finished product, which are not salable and are discarded. Sanitary waste (e.g., restrooms, etc.) and materials that are recycled are excluded.

2.43 Source-Reduced Package. A package or packaging item that has at least 20% less material by weight for a given product unit (e.g., paper towel roll, box of tissue) compared to the packaging for a given product unit (of the same size), commonly used for that product.

2.44 Source Reduction. Altering the design, manufacture, or use of sanitary paper products to reduce the amount that would be disposed of in a landfill.

2.45 Table Coverings. A lightweight, protective layer made from paper intended to cover an entire table or other surface.

2.46 Take-Back Program. A program sponsored by the original product manufacturer that has been demonstrated to receive at least 50% of sold containers for recycling, composting, or reuse.

2.47 Third-Party Certification Program. A program without any financial interest or stake in the sales of the product or service being certified or other conflict of interest. There must be a standard to base the certification from and the standard must be appropriate and meaningful for its intended purpose. The standard must be publically available and developed with stakeholder input. Certification to the standard must be completed by an independent party (i.e., not

the product company), include site inspections, where applicable, and have a monitoring program to verify ongoing compliance.

2.48 Toilet Seat Covers. A class of soft, thin paper product used to cover toilet seats for personal hygiene protection, designed to disperse in septic tanks.

2.49 Virgin Fiber/Material. Fiber/material that is not of recovered or post-consumer origin.

2.50 Wastewater. Wastewater effluent from the manufacturing of the product, that is not salable and is treated and disposed at an onsite or offsite wastewater treatment facility.

2.51 Whitewater. Whitewater is a general term for any furnish (stock) filtrate or process water that contains fiber fines. On a paper machine, whitewater is produced during the forming and dewatering of the paper sheet.

2.52 Wood Pulp. Pulp originally generated from softwood or hardwood trees, such as but not limited to aspen, birch, eucalyptus, fir or pine.

3.0 PRODUCT-SPECIFIC PERFORMANCE REQUIREMENTS

3.1 Product Performance. Product performance requirements shall be consistently measured on either the unconverted (parent roll) or converted product depending on facility procedures. Testing shall be conducted under controlled and reproducible laboratory conditions. In addition to the measured performance requirements, the product shall be made in accordance with reasonable industry practice.

3.1.1 Basis Weight (grammage). Basis weight (grammage) shall be measured according to Technical Association of the Pulp and Paper Industry (TAPPI) T 410, or International Organization for Standardization (ISO) 536 and shall meet the following requirements when measured as grams per square meter (g/m^2 , SI Units) or pounds/ream (lbs/ream, English units):

Product	Basis Weight	Grammage ^(a)
	(lbs/ream ^(b))	(g/m^2)
Institutional paper towels –hard wound or center pull	15 – 35	24.4 – 56.9
Institutional paper towels –folded	15 - 35	24.4 – 56.9
Institutional paper towels –kitchen roll	11 - 30	17.9 – 48.8
Retail paper towels – folded	15 - 35	24.4 – 56.9

Product	Basis Weight	Grammage ^(a)
Retail paper towels – kitchen roll	11 - 30	17.9 – 48.8
Paper napkins	9 – 28.5	14.6 – 46.4
Bathroom tissue	8 – 22	13.0 – 35.8
Facial tissue	8 – 19	13.0 – 30.9
Toilet seat covers	8 – 10.5	13.0 – 17.1
Placemats/Tray Liners	26 – 40	38.5 – 59.2
Table coverings	15 - 22	22.2 – 32.6

(a) See TAPPI T 1210 Table 1, Section 1.1 for conversion factors (Basis weight [pounds/ream]*1.6275 = Grammage [grams per square meter]).

(b) Based on a 24 inch x 36 inch -500 sheet ream, or 3000 sq. ft.

3.1.2 Tensile Strength (Dry and Wet). Product characteristics shall be measured for tensile strength in the machine direction (MD) and cross direction (CD) using the methods described in either section 3.1.2.1 or section 3.1.2.2.

3.1.2.1 Tensile strength using TAPPI T 494/456. Product characteristics shall meet the following requirements when tested according to TAPPI T 494 or ISO 1924/3 (dry tensile strength) and TAPPI T 456 (wet tensile strength), as measured in gram force/inch (gf/in, English units):

Product	Dry Tensile Strength ^(a)		Wet Tensile Strength	
	MD	CD	MD	CD
	(gf/in)	(gf/in)	(gf/in)	(gf/in)
Institutional paper towels – hard wound or center pull	1700 - 3100	600 - 2000	250 - 850	100 - 700
Institutional paper towels – folded	800 - 2700	200 - 1300	230 - 600	90 - 400
Institutional paper towels – kitchen roll	400 - 1300	100 - 650	100 - 350	50 - 200
Retail paper towels – folded	800 - 2700	200 - 1300	230 - 600	90 - 400
Retail paper towels – kitchen roll	400 - 1200	100 - 640	100 - 300	50 - 170
Paper napkins	400 - 1100	230 - 570	--	--
Bathroom tissue	140 - 900	50 – 450	--	--
Facial tissue	250 - 750	80 - 250	15 - 80	8 - 40
Toilet seat covers	2 - 10	0.5 - 2	--	--
Placemats/Tray liners	--	--	--	--

Product	Dry Tensile Strength ^(a)		Wet Tensile Strength	
	MD	CD	MD	CD
Table coverings	--	--	--	--

(a) See TAPPI T 1210, Table 1, Section 2.1 for conversion factors
(1 gf/in = 0.3886 newton/meter (N/m); 1 ozf/in = 10.945 N/m) -- = no requirement

3.1.2.2 Tensile strength using TAPPI T 576. Product characteristics shall meet the following requirements when tested according to TAPPI T 576 (dry and wet tensile strength), as measured in gf/3 in (English units):

Product	Dry Tensile Strength ^(a)		Wet Tensile Strength	
	MD	CD	MD	CD
	(gf/3 in)	(gf/3 in)	(gf/3 in)	(gf/3 in)
Institutional paper towels – hard wound or center pull	5100 - 9300	1800 - 6000	750 - 2550	300 - 2100
Institutional paper towels – folded	2400 - 8100	600 - 3900	690 - 1800	270 - 1200
Institutional paper towels – kitchen roll	1200 - 3900	300 - 1950	300 - 1050	150 - 600
Retail paper towels – folded	2400 - 8100	600 - 3900	690 - 1800	270 - 1200
Retail paper towels – kitchen roll	1200 - 3600	300 - 1920	300 - 900	150 - 510
Paper napkins	1200 - 3300	690 - 1710	--	--
Bathroom tissue	420 - 2700	150 - 1350	--	--
Facial tissue	750 - 2250	240 - 750	45 - 240	24 - 120
Toilet seat covers	6 - 30	1.5 - 6	--	--
Placemats/Tray liners	--	--	--	--
Table Coverings	--	--	--	--

(a) See TAPPI T 1210, Table 1, Section 2.1 for conversion factors
(1 gf/3in = 0.3886 newton/meter (N/m); 1 ozf/in = 10.945 N/m) -- = no requirement

3.1.3 Stretch and Water Absorbency. Product characteristics shall be measured for or water absorbency when tested according to TAPPI T 494 or ISO 1924/3 or TAPPI T 576 for stretch; and TAPPI T 432 for water absorbency; and shall meet the following requirements, as measured in % stretch or seconds of water absorbency:

Product	Stretch	Water Absorbency
	(%)	(seconds)
Paper towels-institutional	2 - 22	0 - 160
Paper towels - retail	2 - 22	0 - 160
Paper napkins	2 - 22	0 - 180
Bathroom tissue	2 - 24	--
Facial tissue	2 - 24	--
Toilet seat covers	1 - 10	--
Placemats/Tray liners	1 - 10	--
Table Coverings	--	--

-- = no requirement

3.2 Alternative Product Performance. Alternative test methods may be allowed for sanitary paper products or categories not specified in this standard. A manufacturer must provide documented rationale for use of the method. The method must be an objective, scientifically-validated method, conducted under controlled and reproducible laboratory conditions. The results of the testing must meet performance ranges that are considered reasonable industry practice.

3.3 Product Specifications. Products must contain the following minimum material specifications, (i.e., minimum product per roll/package). Note that the conversion basis, consisting of the number of sheets and the sheet size, is provided so that a manufacturer can convert between the product in square feet and sheets per roll^(a). Any combination of sheet size and number of sheets is acceptable, as long as the minimum product per roll/package is met:

Product	Single Ply Specification		Multi Ply Specification	
	Minimum product per roll/package	Conversion Basis	Minimum product per roll/package	Conversion Basis
INSTITUTIONAL PRODUCTS				
Bathroom Tissue	83 ft ² /roll	800–3.75" x 4" sheets	41 ft ² /roll	400–3.75" x 4" sheets
Facial Tissue –Flat Box	--	--	44 ft ² /box	100–8" x 8" sheets
Facial Tissue – Cube/ Dispenser Boxes	--	--	37 ft ² /box	85–8" x 8" sheets
Paper Towels –Hard wound or Center Pull	133 ft ² /roll	200 sheets–8 inch wide roll	67 ft ² /roll	100 sheets–8 inch wide roll
Paper Towels –Folded	84 ft ² /package	150–9" x 9" sheets	42 ft ² /package	75–9" x 9" sheets

Product	Single Ply Specification		Multi Ply Specification	
	Minimum product per roll/package	Conversion Basis	Minimum product per roll/package	Conversion Basis
Paper Towels – Kitchen Rolls	110 ft ² /roll	160–11” x 9” sheets	58 ft ² /roll	85–11” x 9” sheets
Paper Towels –General Purpose Wipes	125 ft ² /box	200–9” x 10” sheets	62 ft ² /box	100–9” x 10” sheets
Paper Napkins – Folded (used with or without a dispenser)	330 ft ² /package	200–14” x 17” sheets	165 ft ² /package	100–14” x 17” sheets
Paper Napkins –Beverage	69 ft ² /package	100–10” x 10” sheets	34 ft ² /package	50–10” x 10” sheets
Paper Napkins–Luncheon	117 ft ² /package	100–13” x 13” sheets	58 ft ² /package	50–13” x 13” sheets
Paper Napkins – Dinner/Guest Towel	97 ft ² /package	50–16.75” x 16.75” sheets	48 ft ² /package	25–16.75” x 16.75” sheets
RETAIL PRODUCTS				
Bathroom Tissue	36 ft ² /roll	350–3.75” x 4” sheets	18 ft ² /roll	175–3.75” x 4” sheets
Facial Tissue –Flat Box	--	--	41 ft ² /box	100–7.5” x 8” sheets
Facial Tissue – Cube/Dispenser Boxes	--	--	35 ft ² /box	80–8” x 8” sheets
Paper Towels – Folded	35 ft ² /roll	60–9.1” x 9.25” sheets	17.5 ft ² /roll	30–9.1” x 9.25” sheets
Paper Towels – Kitchen Rolls	80 ft ² /roll	130–11” x 8” sheets	40 ft ² /roll	65–11” x 8” sheets
Paper Napkins –Beverage	62 ft ² /package	100–9.5” x 9.5” sheets	31 ft ² /package	50–9.5” x 9.5” sheets
Paper Napkins–Luncheon	91 ft ² /package	100–11” x 12” sheets	45 ft ² /package	50–11” x 12” sheets
Paper Napkins – Dinner/Guest Towel	88 ft ² /package	50–15” x 17” sheets	44 ft ² /package	25–15” x 17” sheets
MISCELLANEOUS PRODUCTS				
Toilet Seat Covers	250 sheets per package	--	--	--
Placemats, tray liners, and Other Table Coverings	--	--	--	--

(a) For example, bathroom tissue: number of sheets per roll = square feet per roll divided by sheet size (in²) multiplied by 144 (in²/ft²).

-- = no requirement

Alternatively, different sizes that generate better package or shipping efficiency may be permitted provided that the manufacturer submits specifications to demonstrate that they have improved the packaging and shipping efficiency.

4.0 PRODUCT-SPECIFIC SUSTAINABILITY REQUIREMENTS

4.1 Fiber Requirements. The fiber source shall meet one of the following:

- a) The product shall be made from 100% recovered material;
- b) The product shall be made from up to 85% agricultural residue, with the balance made from post-consumer material as required in section 4.2 herein¹;
- c) The product shall be made from any combination of recovered material and agricultural residue, and the balance of the product shall meet the post-consumer material requirement in section 4.2 herein.

For integrated mills where whitewater and/or wastewater recovery may cause contamination of the incoming recovered material furnish (stock), reclaimed mixed fibers containing virgin material may be acceptable as long as it can be shown, through mass balance calculations, that the amount of virgin fiber in the reclaimed mixed fibers is less than 0.5% of the incoming recovered material furnish (stock).

For agricultural residue, the manufacturer shall document the original source of the material and the agricultural residue shall originate from a crop certified to the Rainforest Alliance Sustainable Agriculture Standard, or other approved third-party certification program.

4.2 Post-Consumer Material Requirements. Products made from recovered material shall meet the following requirements:

Product Type	Post-Consumer Material Requirement (%)
Paper Towels, General-Purpose Wipes, and Napkins	50%
Bathroom Tissue	25%
Facial Tissue	15%
Toilet Seat Covers	25%
Placemats/Tray liners	40%
Table Coverings	40%

4.3 Post-Consumer Material Calculations. The percentage of post-consumer material shall be calculated and certified based on the fiber weight of the paper. The calculation of recycled content based on fiber weight shall be performed using the following formula for post-consumer material:

¹ For agricultural residue products, this requirement may be satisfied by using post-consumer material that originated from wood pulp, because post-consumer materials originally made from agricultural residue may not be available.

$$\frac{\text{Post-consumer Material x Yield}_{\text{PC}}}{\text{Recovered Material or Agricultural Residue x Yield}_{\text{R}}}$$

Yield will depend on the product manufactured, the raw material, the level of contaminants and the cleaning and deinking technology employed. The percentage yield shall be calculated by dividing the total material output by the total material input². The percentage of recovered material or agricultural residue and post-consumer material shall be calculated based on a weighted average of the materials used for a period of time not to exceed the previous three months.

4.4 Source Reduction. Reserved.

4.5 Material Processing.

4.5.1 Processed Chlorine Free (PCF). The papermaking process used to produce the products shall be PCF.

4.5.2 Water Disinfection. Chlorine derivatives and biocides may be used to disinfect the incoming fresh water supply and recycled process water. Product testing is not required, as long as the residual concentration of the chlorine derivatives and biocides used for disinfection is below the applicable maximum residual disinfectant levels (MRDLs) in the National Primary Drinking Water Regulations found in 40 CFR, Part 141 at any location where chlorine derivatives and biocides are added to the papermaking process. Biocides must be registered with the EPA or the Pest Management Regulatory Agency (PMRA).

4.5.3 Carcinogens, Mutagens, and Reproductive Toxins. The papermaking process shall not contain any papermaking additives or contaminants that are carcinogens, mutagens or reproductive toxins or that are known to produce or release carcinogens, mutagens, or reproductive toxins. An exception shall be made for titanium dioxide and carbon black used in colorants.

4.5.4 Optical Brighteners. Optical brighteners may be used as a papermaking additive at a dosage not to exceed 200 parts per million (0.02%) by weight as added to the papermaking process. This level does not include any optical brighteners that may be present in the furnish through the use of recovered materials.

² If a particular manufacturer's operating procedures do not provide for accurate yield measurements, the following shall be used as default values:

Default Recovered Material or Agricultural Residue yield (Yield_R): 75%

Default Post-Consumer Material yield (Yield_{PC}): 75%

4.5.5 Colorants. The product shall not contain any colorants as papermaking additives; an exception shall be made for products that would not contain colorants but from the addition of recovered materials.

Further, paper towels and general-purpose wipes, paper napkins, and placemats and other table coverings may be printed with colorants provided that these colorants contain a sum concentration of less than 100 parts per million, by weight (0.01%), of heavy metals including lead, mercury, cadmium, and hexavalent chromium.

4.5.6 Biodegradability. Any papermaking additives used in the papermaking process, except for inorganic compounds, polymers, optical brighteners, and biocides, shall exhibit ready biodegradability in accordance with the Organization for Economic Co-operation and Development (OECD) definition, as follows. Biodegradability shall be measured according to any of the following methods: ISO 7827, 9439, 10707, 10708, 9408, 14593; OECD Methods 301A – F; or OECD 310. Specifically, within a 28-day test, the ingredient shall meet one of the following criteria:

- Removal of Dissolved Organic Carbon (DOC) > 70%
- Biochemical Oxygen Demand (BOD) >60%
- % of BOD of Theoretical Oxygen Demand (ThOD) > 60%
- % Carbon Dioxide (CO₂) evolution of theoretical > 60%

For papermaking additives that do not exhibit ready biodegradability in these tests the manufacturer may demonstrate biodegradability in sewage treatment plants using the Coupled Units Test found in OECD 303A by demonstrating DOC removal > 90%.

An exception shall be made for papermaking additives that do not exhibit ready biodegradability, if the additive has low aquatic toxicity (acute LC₅₀ ≥ 100 mg/L for algae, daphnia, or fish) and exhibits inherent biodegradability per ISO test methods 9887 or 9888 or OECD 302A-C.

Testing is not required for any papermaking additives for which sufficient information exists concerning its biodegradability, either in peer-reviewed literature or databases. In the absence of experimental data, quantitative structure-activity relationship (QSAR) data from EPA's BioWin (EPISuite) models may be considered.

4.5.7 Additional Prohibited Substances. The papermaking process shall not contain the following substances as papermaking additives or contaminants:

- Chlorophenolic Biocides
- Fragrances

- Heavy metals, including but not limited to lead, chromium, or selenium both in the elemental form or compounds
- Ozone-depleting compounds

5.0 MANUFACTURING SUSTAINABILITY REQUIREMENTS

5.1 Social Responsibility. Documentation must be provided that the production of the product meets the following social responsibility requirements:

5.1.1 Freedom of Association and Collective Bargaining. Workers shall have the right to join or form trade unions of their own choosing and their right to bargain collectively shall be recognized and respected.

5.1.2 Freedom of Labor. There shall not be forced or bonded labor or use of child labor.

5.1.3 Freedom from Discrimination. There shall not be discrimination in terms of race, color, sex, religion, age, disability, gender, marital status, sexual orientation, union membership, political opinion, national extraction or social origin such that it affects the opportunity or treatment in employment and there shall be no support or tolerance of corporal punishment, physical or verbal coercion, sexual or other harassment, intimidation or exploitation.

5.1.4 Occupational Health and Safety. A safe and hygienic workplace environment shall be provided with access to potable water. Adequate steps shall be taken to minimize the hazards of the workplace and workers shall receive health and safety training to prevent accidents and injury.

5.1.5 Conditions of Employment. Workers shall work under fair conditions of employment. Wages, working hours and overtime shall meet at a minimum the national legal or industry benchmark standard and regular employment shall be provided.

5.2 Manufacturing and Converting Reporting Requirements. The following information shall be reported for processes including re-pulping, deinking, papermaking, product converting, and waste treatment (on-site or off-site facilities), on an annual basis or when any changes are made to the processes. If a manufacturer only does converting, then the supplier of the parent rolls will be required to provide additional relevant data. The facility shall also provide their total annual production of paper³ data as tons⁴.

³ Total production represents the gross production of paper from the machines, and not sales of paper.

⁴ 1 ton = 0.907 metric tonnes

5.1.1 Air Monitoring. Air monitoring data shall be reported as required by the facility's air permit. The data shall be reported at the frequency and units specified in the permit and the associated permit limits for monitored parameters shall be provided.

5.1.2 Wastewater Monitoring. Wastewater monitoring data shall be reported as required by the facility's wastewater permit. The data shall be reported at the frequency and units specified in the permit and the associated permit limits for monitored parameters shall be provided.

5.2.3 Solid Waste. Solid waste shall be reported as the tons of material entering an external solid waste disposal stream as an annual total. Solid waste such as waste packaging materials that cannot be recycled, shall be reported as tons based on the as disposed weight. Solid waste such as wastewater solids shall be reported as dry tons (i.e., wet tons multiplied by the fractional solids content).

5.3 Effective as of January 1, 2012, Manufacturing and Converting Requirements – Water and Energy Use. Manufacturers shall meet the following fresh water and energy use criteria, for combined processes including re-pulping, deinking, papermaking, product converting, and waste treatment (on-site or off-site facilities). If a manufacturer only does converting, then the **energy and water use for the other processes (re-pulping, deinking, papermaking, and waste treatment) shall be supplied by the manufacturer of the parent roll.** If a manufacturer purchases market de-inked pulp (MDIP), then the supplier of the MDIP will be required to provide **the energy and water use data associated with production of the MDIP.**

The data shall represent either the total annual resource used divided by the total annual production of paper⁵, or the total annual resource used to produce all grades of certified paper divided by the total annual production of all grades of certified paper⁶. **This implies that estimation and allocation methods are acceptable.**

Fresh Water Use (gallons/ton of final product) ^(a)	Total Energy Use (millions BTUs/ton of final product) ^(b)
19,250	17.0

(a) gallons/T = 0.00417 m³/MT

(b) millions of British Thermal Units (BTUs)/T = 1.16 Gigajoules (GJ)/MT = 323.2 kilowatt-hour (kwh)/MT

5.4 Distribution. Reserved.

⁵ Total production represents the gross production of paper from the machines, and not sales of paper.

⁶ Total production represents the gross production of certified paper from the machines, and not sales of certified paper.

6.0 PACKAGING SUSTAINABILITY REQUIREMENTS

6.1 Primary and Secondary Packaging. Primary and Secondary packaging shall meet the following requirements, based on the packaging material type:

- Packaging made from paper or paperboard shall be recyclable, and made from 100% recovered material.
- Packaging made from containerboard (corrugated cardboard) shall be recyclable and made from at least 30% recovered material.
- Packaging made from plastic shall be recyclable, or source-reduced by 20%, or shall contain 25% recovered material content (pre- or post-consumer). Where a product's packaging is below these levels, the manufacturer must demonstrate that efforts have been made to use the maximum available pre- or post-consumer material in packaging. An exception shall be made for packaging with an effective take-back program.

6.2 Colorants. Packaging may be printed using colorants provided that these colorants contain a sum concentration of less than 100 parts per million, by weight (0.01%), of lead, mercury, cadmium, and hexavalent chromium.

6.3 Heavy Metal Restrictions. Heavy metals, including lead, mercury, cadmium, and hexavalent chromium, shall not be intentionally introduced in packaging. Further, the sum of the concentration levels of these metals present shall not exceed 100 parts per million by weight (0.01%); an exception shall be made for packages that would not exceed this maximum level but for the addition of recovered materials. Further, intentional introduction does not include the use of one of the metals as a processing aid or intermediate to impart certain chemical or physical changes during manufacturing, where the incidental retention of a residual of that metal in the final packaging or packaging component is not desired or deliberate, if the final packaging or packaging component complies with the incidental concentration restrictions of 100 ppm.

6.4 Other Restrictions. Phthalates, bisphenol A, and chlorinated packaging material are prohibited from being intentionally introduced in packaging; an exception shall be made for packages with added phthalates, bisphenol A, or chlorinated packaging material solely from the addition of post-consumer material.

7.0 LABELING REQUIREMENTS

7.1 Disposal. The manufacturer's label shall include a statement encouraging proper disposal of the product and encouraging recycling of appropriate packaging.

If plastic, the packaging must be marked with the appropriate Society of the Plastics Industry symbol to identify the type of plastic for recycling. If the symbol is in a conspicuous location, the appropriate qualification of recyclability is required, as referenced in 6.1, such as “This product may not be recyclable in your area, see if accepted by your local program” or “only a few communities accept this package for recycling, check with your local program.”

7.2 Statement of Basis of Certification. Whenever the product claims to be certified to this standard, it shall be based on a third-party certification program with an on-site auditing program, and shall state, unless otherwise approved in writing by Green Seal:

“This product meets the Green Seal™ Standard for Sanitary Paper Products, GS-1, manufactured using environmentally and socially responsible processes, and made from YY with a minimum of XX% post-consumer material.”

[Where YY is the material used (i.e. 100% recovered material, 85% agricultural residue), and where XX is the verified minimum level of post-consumer material].

Appendix A

Examples of products included and excluded in the scope of GS-1

Products included in GS-1

- Paper towels (hardwound, folded, or kitchen roll)
- Napkins (beverage, luncheon, dinner)
- General-purpose wipes that do not contain any added cleaning agents or fragrances
- Bathroom tissue
- Facial tissue (flat box and cube box)
- Toilet seat covers
- Placemats or tray liners
- Table coverings

Products excluded from GS-1

- Nonwoven sanitary products
- General purpose disposable and flushable wipes that contain added cleaning agents or fragrances
- Facial tissue (travel packs)
- Cotton balls, cosmetic pads
- Disposable diapers
- Sanitary napkins and tampons
- Printing and writing paper (covered in GS-7)
- Newsprint (covered in GS-15)
- Paper products used in the preparation of food (covered in GC-8)
- Coated printing paper (covered in GS-10)