



THE ORIGINAL GREEN  
SEAL OF APPROVAL  
SINCE 1989

# GS-1 Green Seal™ Standard for Sanitary Paper Products, 3rd Edition

## ***Why the standard was created***

The third edition of GS-1 combines Green Seal's two tissue and towel product standards (GS-1 & GS-9) into one comprehensive standard that evaluates the critical issues in the sanitary paper products lifecycle. Since the standards were last issued, technological and scientific advancements have been made to identify and improve the environmental life cycle of the products. GS-1 provides a comprehensive, user-friendly standard that addresses issues relevant to the paper and pulp industry.

## ***Scope of Standard***

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 for both institutional and retail markets.

## ***Product-Specific Performance Requirements***

The standard addresses basis weight, tensile strength, stretch, water absorbency, and minimum product per roll/package requirements for each product category.

## ***Fiber Requirements***

The fiber source must either be made from 100% recovered material; made from up to 85% agricultural residue, with the balance made from post-consumer material; or be made from any combination of recovered material and agricultural residue, with the balance of the product made from post-consumer material. Products made from recovered material shall meet the following post-consumer material requirements :

<b>Product Category</b>	<b>Post-Consumer Material Requirements</b>
Paper Towels, General-Purpose Wipes, and Napkins	50%
Bathroom Tissue	25%
Facial Tissue	15%

## ***Product-Specific Sustainability Requirements***

The papermaking processes must be *Processed Chlorine Free* and may not contain any additives or contaminants that are, or are known to produce or release, carcinogens, mutagens, or reproductive toxins. Chlorophenolic biocides; fragrances; heavy metals, including but not limited to lead, chromium, or selenium both in the elemental form or compounds and

ENVIRONMENTAL  
LEADERSHIP STANDARDS



CERTIFICATION FOR  
PRODUCTS, SERVICES,  
PROPERTIES & COMPANIES



PARTNERSHIPS IN  
GREEN PURCHASING &  
FACILITIES MANAGEMENT



SUSTAINABILITY  
RESEARCH & LIFE CYCLE  
ANALYSIS



ozone-depleting compounds are also prohibited. Optical brighteners used as an additive may not exceed 200 ppm. Any additives used in the papermaking process, except for inorganic compounds, polymers, optical brighteners, and biocides, shall be readily biodegradable.

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### **Social Responsibility**

Documentation must be provided that the production of the product meets: Freedom of Association, Collective Bargaining, Freedom of Labor, Freedom from Discrimination, Occupational Health and Safety Conditions of Employment.

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### **Manufacturing Sustainability Requirements**

Air and wastewater monitoring as well as solid waste data must be reported for processes including re-pulping, deinking, papermaking, product converting, and waste treatment. If a manufacturer only converts, then the supplier of the parent rolls will be required to provide the additional relevant data. The manufacturing process must also meet fresh water and energy use levels set in the standard.

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### **Packaging Requirements**

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).

Criteria include limits on inks, dyes, pigments, stabilizers, lead, cadmium, and hexavalent chromium with respect to packaging. 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.

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### **Labeling Requirements**

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

If used, the Green Seal Certification Mark must appear visibly on the product with a clear written description of the basis for its certification, provided by Green Seal. Any language used that varies from the description provided, may be used with written approval from Green Seal. All labeling of the product must comply with government labeling requirements, in addition to Green Seal requirements.

***This is only a summary of the standard. The full standard is available at:  
[www.greenseal.org](http://www.greenseal.org)***

For more information call 202.872.6400, email [greenseal@greenseal.org](mailto:greenseal@greenseal.org) or visit: [www.greenseal.org](http://www.greenseal.org)