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Regarding the Explanatory Notes:

Note: Explaining the increase and decrease of individual passages

※: Comments on the entire chart

*: Definition of words

Environmental Data

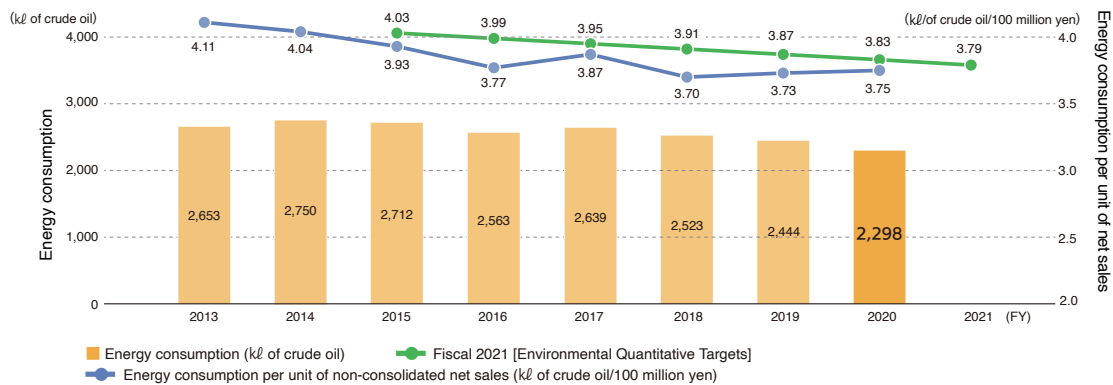
Progress on Fiscal 2021 Environmental Quantitative Targets

Based on the Action Plan of the Industries of Electrical and Electronics on a Low Carbon Society initiative 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 2021 environmental quantitative targets.

Reduction of energy consumption (crude oil-equivalent)

Throughout Japan, reduce the energy consumption per unit of non-consolidated net sales to 3.79 k ℓ of crude oil/100 million yen or less in fiscal 2021. (From fiscal 2015 to fiscal 2021, the yearly average improvement in energy consumption per unit of net sales is set at 1%. A determination that the target has been achieved will be based on improvement of at least 7.73% in fiscal 2021 compared to the base year (fiscal 2013)).

Figure 1 Changes in Companywide (Domestic) Energy Consumption and Energy Consumption Per Unit of Net Sales



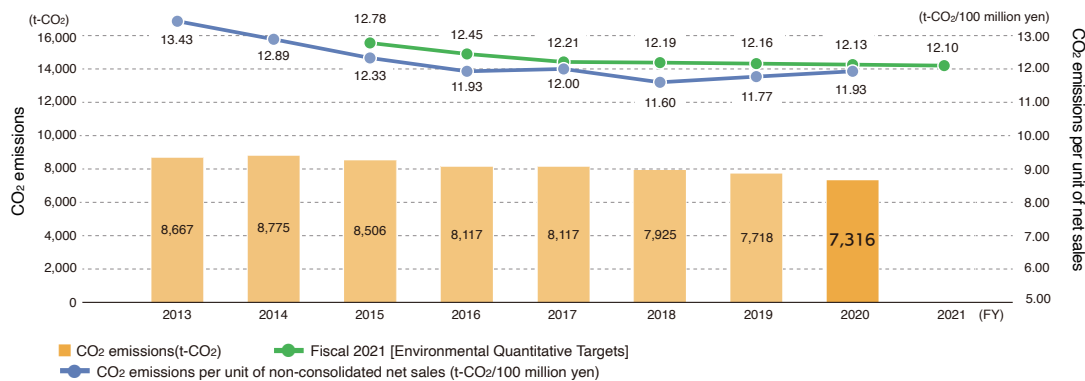
Scope of calculation: Energy consumption at all of RISO KAGAKU CORPORATION'S non-consolidated domestic sites (excluding fuel used for outsourced logistics and company-owned vehicles). Net sales refer to non-consolidated net sales.

Reduction of CO₂ emissions

Throughout Japan, reduce CO₂ emissions per unit of non-consolidated net sales to 12.10 tons-CO₂/100 million yen or less in fiscal 2021. (The value for energy consumption of 3.79k ℓ of crude oil/100 million yen per unit of non-consolidated net sales converted to CO₂ emissions per unit of non-consolidated net sales, including CO₂ emissions from logistics and company-owned vehicles)

Throughout all domestic production sites, reduce CO₂ emissions per unit cost of production to 11.50 tons-CO₂/100 million yen or less in fiscal 2021. (The value for energy consumption of 3.79k ℓ of crude oil/100 million yen per unit of non-consolidated net sales converted to CO₂ emissions per unit cost of production)

Figure 2 Changes in Companywide (Domestic) CO₂ Emission and CO₂ Emission Per Unit of Net Sales



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.

Environmental Data

Figure 3 Fiscal 2020 Environmental Targets and Achievements; Fiscal 2021 Environmental Quantitative Targets

Category	Reduction of energy consumption (crude oil-equivalent)	Reduction of CO ₂ emissions	
Scope of application	All domestic operations (non-consolidated)	All domestic operations	Total for all domestic production sites
Fiscal 2020 Environmental Quantitative Targets	(1) Reduce the energy consumption to less than 2,419 kl of crude oil or less. (2) Reduce the energy consumption per unit of non-consolidated net sales to 3.65 kl of crude oil/100 million yen or less.	(1) Reduce the CO ₂ emissions to 7,640 tons-CO ₂ or less. (2) Reduce the CO ₂ emissions per unit of non-consolidated net sales to 11.54 tons-CO ₂ /100 million yen or less.	(1) Reduce the CO ₂ emissions to 2,772 tons-CO ₂ or less. (2) Reduce the CO ₂ emissions per unit cost of production to 9.58 tons-CO ₂ /100 million yen or less.
Fiscal 2020 activity results	(1) Cumulative energy consumption: 2,298 kl of crude oil (2) Energy consumption per non-consolidated net sales: 3.75 kl of crude oil/100 million yen	(1) Cumulative CO ₂ emissions: 7,316 tons ^{Note 1} (2) CO ₂ emissions per unit of non-consolidated net sales: 11.93 tons-CO ₂ /100 million yen	(1) Cumulative CO ₂ emissions: 2,561 tons ^{Note 2} (2) CO ₂ emissions per unit cost of production: 9.65 tons-CO ₂ /100 million yen
Rating (1) / (2)	O / X	O / X	O / △
Fiscal 2021 Environmental Quantitative Targets	^{Note 3}	(1) Reduce the CO ₂ emissions to 7,192 tons-CO ₂ or less. ^{Note 3}	(1) Reduce the CO ₂ emissions to 2,716 tons-CO ₂ or less. ^{Note 3}

Rating symbols: O: Achieved; △: Improved; X: Not Achieved

Note 1 The difference from the CO₂ emissions in fiscal 2020 (8,072 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.

Note 2 The difference from the CO₂ emissions in fiscal 2020 (2,756 tons-CO₂/year) in Figure 5 occurred because Kasumigaura Works is not included in the scope of calculation in Figure 3.

Note 3 Due to effects of the novel coronavirus (COVID-19) pandemic, there are various uncertain elements and it is difficult to make a reasonable calculation at this time. Therefore, the "environmental quantitative targets" for fiscal 2021 cover only CO₂ emissions volumes. Figure 1 reports the status of achievement of the environmental quantitative targets for fiscal 2021 based on the Action Plan of the Industries of Electrical and Electronics on a Low Carbon Society initiative proposed by the industrial community with the aim of reconciling corporate growth and global warming policies.

KEY POINT

In fiscal 2020, we continued to focus on the conservation of electric power. We made proactive investment with energy-efficient updates to equipment such as air conditioners and lighting.

Compared to fiscal 2019, energy consumption per unit of non-consolidated net sales was -0.4% and CO₂ emissions per unit of non-consolidated net sales was -1.3%. In addition, energy consumption (crude oil-equivalent) was improved by 6.0 and total CO₂ emissions were improved by 5.2%.

In fiscal 2020, we achieved the quantitative targets for both the energy consumption and CO₂ emissions.

Moving forward, we will take appropriate PDCA measures as part of efforts towards reducing our impact on the environment.

Figure 4 Environmental Burden throughout Japan (Fiscal 2020)

	INPUT			OUTPUT					
	FY2019	FY2020	Compared to FY2019	FY2019	FY2020	Compared to FY2019			
Energy consumption and CO₂ emissions, resource input amount, waste generation, etc. in all business activities within Japan									
Energy consumption	GJ/yr	141,186	133,267	94	CO ₂ emissions	t-CO ₂ /yr	8,500	8,072	95
Electricity	MWh	8,933	8,404	94	Electricity	t-CO ₂ /yr	4,958	4,664	94
Bunker A	kℓ	35	37	108	Bunker A	t-CO ₂ /yr	94	101	108
LPG	t	96	85	88	LPG	t-CO ₂ /yr	289	255	88
Kerosene	kℓ	0	0	—	Kerosene	t-CO ₂ /yr	0	0	—
City gas	1,000 m ³	10	9	94	City gas	t-CO ₂ /yr	22	21	94
Gasoline	kℓ	487	483	99	Gasoline	t-CO ₂ /yr	1,161	1,154	99
Diesel	kℓ	2	1	38	Diesel	t-CO ₂ /yr	4	1	26
Volume of contracted transport*6	10,000 t-km	953	885	93	Volume of contracted transport*6	t-CO ₂ /yr	1,972	1,875	95
Water consumption	m ³	31,358	28,124	90	Water drainage	m ³	28,311	25,284	89
Product parts and materials	t	6,449	6,188	96	Steam, water, and related emissions	m ³	0	0	—
Collection of used products	t	2,976	2,872	97	Products*5	t	9,615	9,152	95
					Used product/waste disposal volume*1	t	4,105	3,954	96
					Volume transferred to recycling processes*7	t	257	233	91
					Volume recycled*2	t	3,812	3,689	97
					Other*3	t	1	2	195
					Final disposal (landfill)*4	t	35	30	86

Scope of calculation: INPUT and OUTPUT in the Figure 5 "Environmental Burden in Japan by Operational Process (Fiscal 2020)" (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

*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, RISOGRAF digital duplicators, and inks, masters, and other supply products for ComColor and RISOGRAF

*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.

Environmental Data

Figure 5 Environmental Burden in Japan by Operational Process (Fiscal 2020)

Operational process	INPUT				OUTPUT					
		FY2019	FY2020	Compared to FY19		FY2018	FY2019	Compared to FY19		
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	18,570	18,181	98	CO ₂ emissions	t-CO ₂ /yr	1,034	1,013	98
	Daytime electricity	MWh	1,845	1,809	98	Daytime electricity	t-CO ₂ /yr	1,024	1,004	98
	LPG	t	3	3	80	LPG	t-CO ₂ /yr	10	8	80
	Kerosene	kℓ	0	0	—	Kerosene	t-CO ₂ /yr	0	0	—
	City gas	1,000 m ³	0	0	—	City gas	t-CO ₂ /yr	0	0	—
	Water consumption	m ³	4,218	3,879	92	Water drainage	m ³	4,218	3,879	92
						Waste generation*1	t	19	17	92
						Volume recycled*2	t	18	17	92
						Other*3	t	0	0	870
					Final disposal (landfill)*4	t	0	0	100	
Design and Development Scope of calculation: RISO R&D Center	Energy consumption and CO₂ emissions at the product development stage									
	Energy consumption	GJ/yr	23,225	22,474	97	CO ₂ emissions	t-CO ₂ /yr	1,294	1,253	97
	Daytime electricity	MWh	1,664	1,614	97	Daytime electricity	t-CO ₂ /yr	924	896	97
	Nighttime electricity	MWh	667	643	96	Nighttime electricity	t-CO ₂ /yr	370	357	96
	LPG	t	0	0	—	LPG	t-CO ₂ /yr	0	0	—
	City gas	1,000 m ³	10	9	94	City gas	t-CO ₂ /yr	22	21	94
	Water consumption	m ³	9,788	8,356	85	Water drainage	m ³	9,788	8,356	85
						Waste generation*1	t	Note 1 204	256	125
						Volume recycled*2	t	Note 2 203	254	126
						Other*3	t	0	0	—
					Final disposal (landfill)*4	t	1.7	1.4	83	
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	53,168	48,616	91	CO ₂ emissions	t-CO ₂ /yr	3,013	2,756	91
	Daytime electricity	MWh	4,278	3,945	92	Daytime electricity	t-CO ₂ /yr	2,374	2,189	92
	Nighttime electricity	MWh	479	393	82	Nighttime electricity	t-CO ₂ /yr	266	218	82
	Bunker A	kℓ	35	37	108	Bunker A	t-CO ₂ /yr	94	101	108
	LPG	t	93	82	89	LPG	t-CO ₂ /yr	278	247	89
	Kerosene	kℓ	0	0	—	Kerosene	t-CO ₂ /yr	0	0	—
	Water consumption	m ³	17,352	17,352	99	Water drainage	m ³	14,305	13,049	91
	Product parts and materials	t	6,449	6,188	96	Steam, water, and related emissions	m ³	0	0	—
	Metals	t	930	968	104	Products*5	t	9,615	9,152	95
	Plastic	t	1,124	1,057	94					
	Glass	t	0	0	104					
	Paper	t	1,947	1,875	96					
	Other	t	2,447	2,288	93					
	PRTR-regulated substances	t	Note 2 10.7	4.0	Note 2 38	Total PRTR substance emissions/transfers	kg	35.4	29.5	83
						Emissions into the air	kg	2.6	1.9	73
						Emissions into the waters	kg	0	0	—
					Emissions into the soil	kg	0	0	—	
					Volume transferred to waste	kg	32.8	27.6	84	
					Waste generation*1	t	906	809	89	
					Volume recycled*2	t	899	805	89	
					Other*3	t	1	2	188	
					Final disposal (landfill)*4	t	6	2	35	
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	46,223	43,996	95	CO ₂ emissions	t-CO ₂ /yr	3,137	3,030	97
	Gasoline	kℓ	487	483	99	Gasoline	t-CO ₂ /yr	1,161	1,154	99
	Diesel	kℓ	2	1	38	Diesel	t-CO ₂ /yr	4	1	26
	Volume of contracted transport*6	10,000 t-km	953	885	93	Volume of contracted transport*6	t-CO ₂ /yr	1,972	1,875	95
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	2,976	2,872	97	Used product disposal volume	t	2,976	2,872	97
	Digital duplicators and other printers	t	2,647	2,557	97	Volume transferred to recycling processes*7	t	257	233	91
	Ink bottles	t	297	281	95	Volume recycled*2	t	2,692	2,613	97
	Ink cartridges	t	32	342	106	Other*3	t	0	0	—
						Final disposal (landfill)*4	t	27	27	98

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

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

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

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

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

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

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

Note 1 There were errors in the figures for fiscal 2019, and accordingly, they has been corrected.

Note 2 This is result of the existence of substances that are no longer handled.

Environmental Data

Figure 6 Environmental Burden of Overseas Production Bases (Fiscal 2020)

Target	INPUT				OUTPUT					
		FY2019	FY2020	Compared to FY19		FY2019	FY2020	Compared to FY19		
Overseas production bases 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 bases									
	Energy consumption	GJ/yr	17,216	15,427	90	CO ₂ emissions	t-CO ₂ /yr	1,213	1,213	87
	Electricity	MWh	1,598	1,454	91	Electricity	t-CO ₂ /yr	1,127	999	89
	Bunker A	kℓ	0	0	—	Bunker A	t-CO ₂ /yr	0	0	—
	Gasoline	kℓ	37	27	73	Gasoline	t-CO ₂ /yr	86	62	72
	Diesel	kℓ	0	0	—	Diesel	t-CO ₂ /yr	0	0	—
	Water consumption	m ³	15,453	16,919	109	Water drainage	m ³	12,605	13,242	105
	Product parts and materials	t	2,623	1,986	76	Steam, water, and related emissions	m ³	2,221	3,154	142
	Metals	t	1,134	863	76	Products*5	t	3,249	2,509	77
	Plastic	t	430	328	76	Waste generation*1	t	565	419	74
	Glass	t	1	1	91	Volume transferred to recycling processes*7	t	0	0	—
	Paper	t	589	476	81	Volume recycled*2	t	528	384	73
	Other	t	470	318	68	Other*3	t	11.1	13.4	121
						Final disposal (landfill)*4	t	26.7	22.2	83

Figure 7 Environmental Burden of Overseas Non-Production Bases (Fiscal 2020)

Target	INPUT				OUTPUT					
		FY2019	FY2020	Compared to FY19		FY2019	FY2020	Compared to FY19		
All non-production sites overseas Scope of calculation: 16 overseas subsidiaries* and sales bases*8	Energy consumption and CO₂ emissions at the head office and sales bases of overseas subsidiaries (non-production departments)									
	Energy consumption per unit	GJ/person	68.8	64.1	93	CO ₂ emissions per unit	t-CO ₂ /person*9	Note 1 4.27	4.32	101
	Energy consumption	GJ/yr	54,318	53,543	99	CO ₂ emissions	t-CO ₂ /yr	3,651	3,604	99
	Electricity	MWh	1,219	1,227	101	Electricity	t-CO ₂ /yr	829	838	101
	Natural gas	kℓ	24,583	23,846	97	Natural gas	t-CO ₂ /yr	51	50	98
	Gasoline	kℓ	852	841	99	Gasoline	t-CO ₂ /yr	1,976	1,951	99
	Diesel	kℓ	308	297	96	Diesel	t-CO ₂ /yr	795	765	96
	Water consumption	m ³	1,309	1,738	133	Water drainage	m ³	1,309	1,738	133

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

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

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

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

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

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

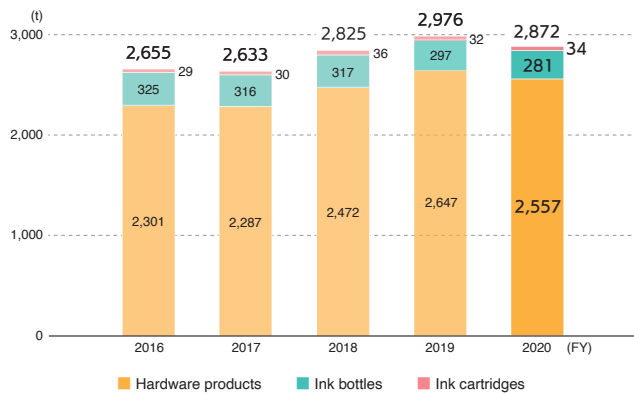
*8 The head office has primary responsibility for ascertaining the environmental burden of overseas non-production sites, but data collection for sales bases such as branch offices is incomplete. The data supplement rate based on the ratio of employees registered at offices/bases in fiscal 2020 was 64.1%.

*9 Concerning overseas non-production sites, 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 There was an error in the figures for fiscal 2019, and accordingly, it has been corrected.

Environmental Data

Figure 8 Quantity of Used Products and Consumables Collected

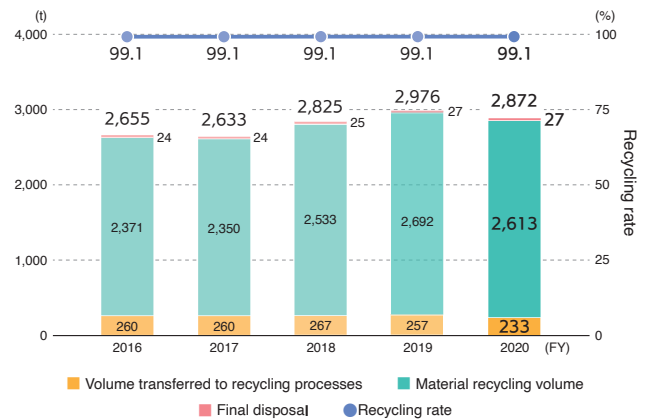


Scope of calculation: The amount of used RISO products in Japan (excluding second-hand digital duplicators that are returned or collected and then used as rental equipment)

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

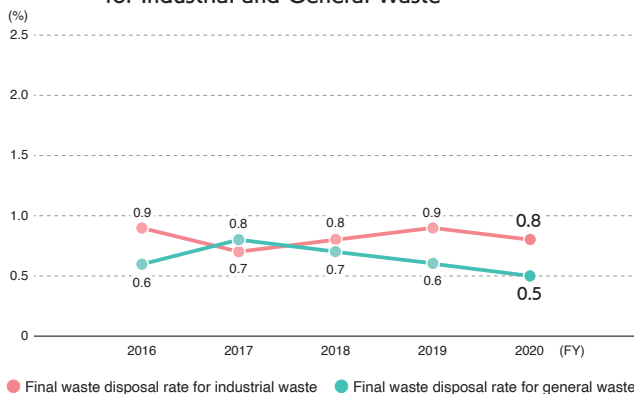


Scope of calculation: The amount of used RISO products in Japan (excluding second-hand digital duplicators that are returned or collected and then used as rental equipment)

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)

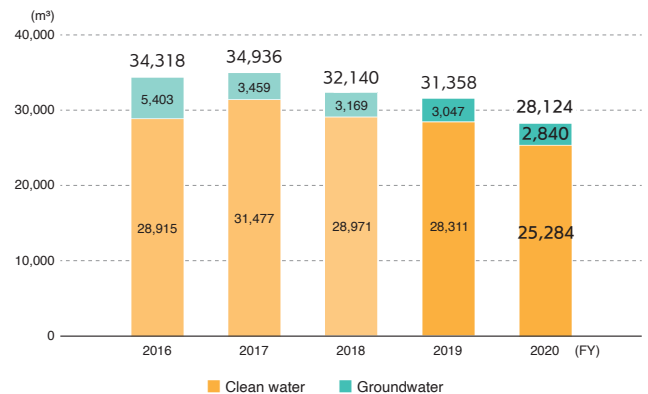
*Specific final waste disposal rate: RISO calculates the amount of specific final waste disposal as the total of the amount of waste incinerated, the residue and ashes resulting from recycling processes and used for landfill, and other waste used directly for landfill. Then, RISO calculates the specific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

The target for reducing waste for the FY2021: The final waste disposal rates 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.

The target for the FY2021:

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 2020 decreased by approximately 3,234 m³ (approximately 10%) from the previous fiscal year.

Environmental Data

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

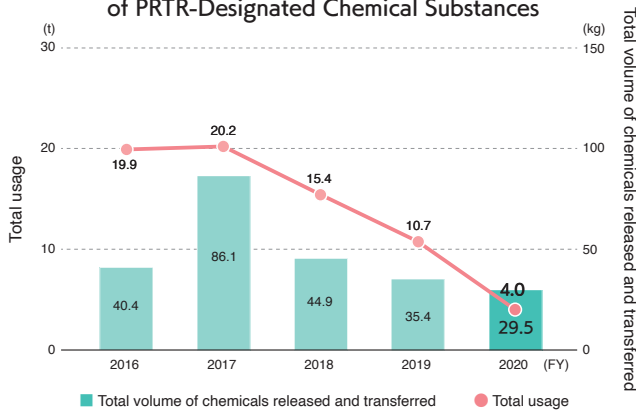
(kg)

	Total usage		Total volume of chemicals released and transferred									
	FY2019	FY2020	Emissions into the air		Emissions into the waters		Emissions into the soil		Waste generated			
			FY2019	FY2020	FY2019	FY2020	FY2019	FY2020	FY2019	FY2020		
Polyoxyethylene alkyl ether	136.8	129.9	—	—	—	—	—	—	—	—	—	—
BHT	7,440.0	2,120.0	25.2	25.2	—	—	—	—	—	—	25.2	25.2
Boron and its compounds	1,373.0	83.5	7.6	2.4	—	—	—	—	—	—	7.6	2.4
2-Aminoethanol	2.6	1.9	2.6	1.9	2.6	1.9	—	—	—	—	—	—
Molybdenum and its compounds	12.6	91.0	—	—	—	—	—	—	—	—	—	—
Sodium poly (oxyethylene) dodecyl ether sulfonate	—	—	—	—	—	—	—	—	—	—	—	—
Dibutyltin dilaurate	—	—	—	—	—	—	—	—	—	—	—	—
2,3-Epoxypropyl methacrylate	1,673.3	1,619.9	—	—	—	—	—	—	—	—	—	—
2-Ethylhexanoic acid	4.4	3.8	—	—	—	—	—	—	—	—	—	—
Methylenebis (4,1-phenylene) diisocyanate	12.6	—	—	—	—	—	—	—	—	—	—	—
Total	10,655.3	4,050.0	35.4	29.5	2.6	1.9	—	—	—	—	32.8	27.6

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.

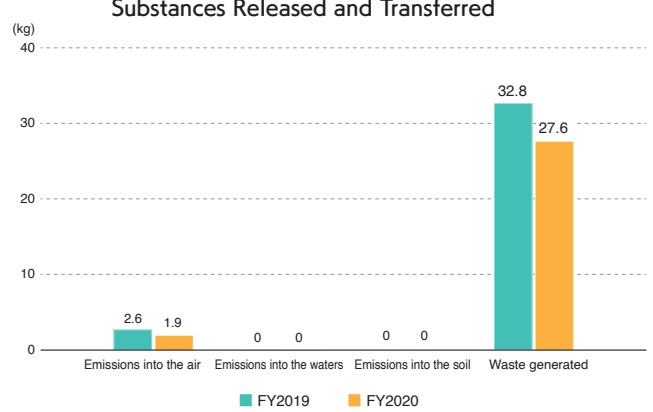
Figure 13 Consumption, Release and Transfer of PRTR-Designated Chemical Substances



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.
 The target to reduce PRTR-designated chemical substances for the FY2021: The total of PRTR-designated chemical substances released and transferred will reduce by 5% or higher from the previous fiscal year.

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.

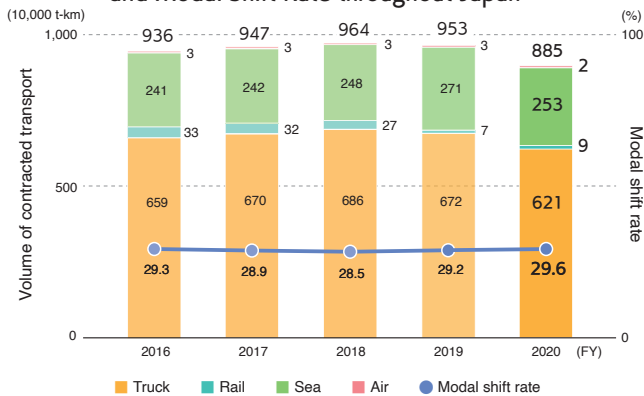
Total usage of PRTR-designated chemical substance in fiscal 2020 was 4.0 tons, a decrease of 6.6 tons compared with the previous fiscal year. Total volume of release and transfer decreased by 0.01 tons.

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

*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

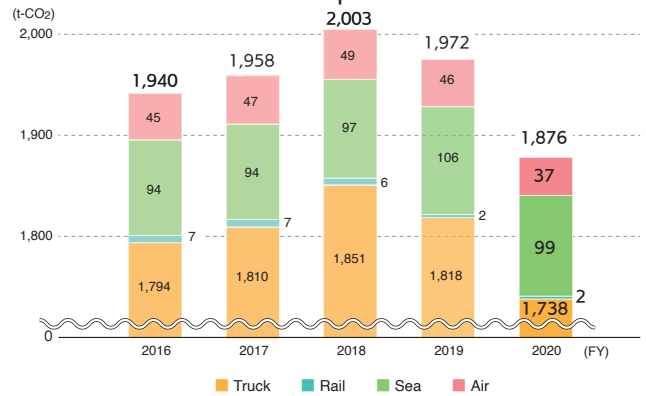
Environmental Data

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

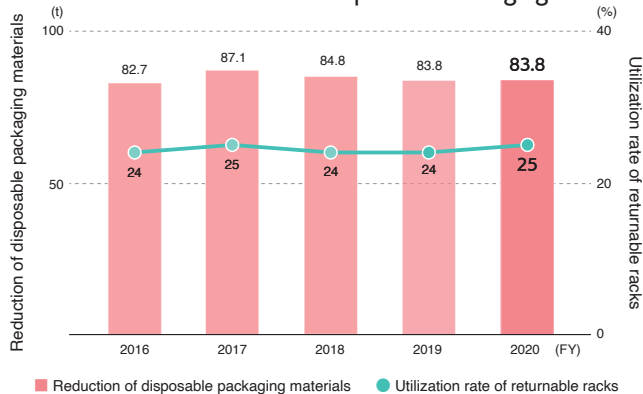


Scope of calculation: CO₂ emissions attributable to contracted transport (of products, components, raw materials, waste and used products) in Japan by the logistics department, sales department, plants, and the Center for Recycling

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 2020, we worked hard on a modal shift from trucks to ships for the transportation of consumables. Compared to fiscal 2019, the modal shift rate went from 29.2% to 29.6%, and CO₂ emissions decreased by 96 tons-CO₂, or 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 25% in fiscal 2020, which is equivalent to an 83.8-ton reduction in packaging materials.

Figure 18 Environmental Education Programs and Number of Participants (Fiscal 2020)

Type of education	Events (times)	Participants (employees)	Hours (aggregate)
Basic environmental education program	11	135	92
Internal auditor training	7	96	741
EMS activity program (waste sorting, etc.)	3	73	98
Special environmental education program	7	93	47
Accident/emergency drill	9	108	69
Disaster drill	3	579	579
Advanced business skill program	4	100	100
Advanced EMS skill program	2	409	245
Workplace health and safety program	1	44	44
Total	47	1,637	2,015

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 2020 (April 1, 2019 to March 31, 2020)

● **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 2020

(Thousands of Yen)

Activities	Classification	Environmental protection costs			Environmental protection effect	
		Environmental protection activities	Investment	Cost	Economic effect	Actions
Global warming prevention measures	•Reduction of fuel consumption •Reduction of electricity consumption	•Replacement of boilers with high efficiency models, pursuit of a modal shift strategy •Introduction of energy-saving equipment	17,535	628	676	•Reduction of CO ₂ emissions during manufacture and product transport •Reduction of electricity consumption
Promotion of resource conservation and recycling	•Effective utilization of used products •Effective utilization of wastes •Safe disposal of wastes	•Collection and recycling of used products •Separation and recycling of waste		383,016	358,227	•Reduction of costs through reuse •Improvement of resource recovery rates
Environmental communication	•Publication of product environmental data •Publication of information about environmental initiatives	•Acquisition of environmental label certification •Publication of the Environmental Data Book •Participation in events and exhibitions		15,153		•Acquisition of certification under the Eco Mark Program •Publication of the Environmental Data Book, website revisions, etc.
Green areas	•Clean-up and maintenance of green areas	•Clean-up and maintenance of green areas		3,000		•Clean-up and maintenance of green areas
Legal compliance (pollution control measures, environmental pollution control)	•Compliance activities (water, air, etc.) •Understanding of legal and regulatory trends	•Water drainage management •Gas emissions management •Inspection and maintenance of facilities •Monitoring of laws and regulations		15,604		•Environmental protection activities •Research for and understanding of legal and regulatory trends in Japan and overseas
Green procurement	•Collection and registration of environmental data relating to raw materials and parts	•Implementation of an environmental information system covering REACH and other regulations		7,484		•Environmental information updates, operation and maintenance
EMS establishment and maintenance activities	•ISO	•Acquisition and maintenance of ISO 14001 certification		5,071		•Updates and maintenance of ISO 14001 certification
Total			17,535	429,956	358,903	

Figure 20 Breakdown of Costs (Investment + Actual Costs)

(Thousands of Yen)

	FY2016	FY2017	FY2018	FY2019	FY2020
Global warming prevention measures	15,997	63,469	50,347	63,672	18,163
Promotion of resource conservation and recycling	287,683	312,210	344,356	391,304	383,016
Environmental communication	22,055	18,279	18,140	21,320	15,153
Green areas	4,640	3,293	3,000	3,000	3,000
Legal compliance	30,190	18,899	29,440	28,657	15,604
Green procurement	7,528	7,692	7,684	7,489	7,484
EMS establishment and maintenance activities	4,487	3,995	9,732	4,765	5,071

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

(Thousands of Yen)

	FY2016	FY2017	FY2018	FY2019	FY2020
Global warming prevention measures	781	840	1,948	1,142	676
Promotion of resource conservation and recycling	421,579	398,467	410,695	414,798	358,227

*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)

	FY2016	FY2017	FY2018	FY2019	FY2020
Costs (investment + actual costs) (Thousands of Yen)	372,580	427,838	462,699	520,208	447,491
Economic effect (Revenue + Cost saving) (Thousands of Yen)	422,360	399,307	412,643	415,941	358,903
Economic effect ratio (%)	113%	93%	89%	80%	80%

KEY POINT

In fiscal 2020, the cost of global warming prevention measures (investment + actual cost) decreased by 45,509,000 yen in comparison with fiscal 2019. Despite making proactive investments such as switching to high energy-saving lighting and air conditioning, the positive economic effect decreased by 466,000 yen. The number of used products collected and production using reused parts decreased. Production of reused parts was flat, but the cost of resource saving and recycling promotion decreased by 8,289,000 yen. The positive economic effect decreased by 56,572,000 yen. The ratio of cost (investment + actual costs) and economic effects (revenue + cost saving) was 80%, the same as in fiscal 2019.

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 286 (As of March 31, 2020)

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 Control 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	FY2016	FY2017	FY2018	FY2019	FY2020	YoY (%)
Electricity consumption	MWh	1,845	2,133	2,021	2,066	1,855	90
Water consumption	m ³	9,795	13,019	10,044	10,669	9,737	91
Clean water	m ³	9,795	13,019	10,044	10,669	9,737	91
Groundwater	m ³	0	0	0	0	0	—
Water drainage	m ³	9,795	13,019	10,044	10,669	9,737	91
Annual biochemical oxygen demand (BOD) emissions	kg	1.8	7.2	3.3	0.9	9.7	Note 1 1,141
Annual nitrogen emissions	kg	91	106	95	92	78	85
Annual phosphorus emissions	kg	3.9	10.0	9.8	8.2	13.2	Note 1 161
Total waste generation	t	507	594	555	439	460	105
Final disposal (landfill)	t	3.6	4.4	3.5	3.3	1.5	Note 2 45
Waste recycling rate	%	99.3	99.3	99.4	99.2	99.7	100

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

Note 1 The range of variation within the standard value

Note 2 This was because we changed to a new waste disposal contractor with a lower final disposal rate and a higher recycling rate.

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 59 (As of March 31, 2020)

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	FY2016	FY2017	FY2018	FY2019	FY2020	YoY (%)
Electricity consumption	MWh	595	477	480	511	464	91
Water consumption	m ³	4,438	1,609	1,573	1,155	843	Note 1 73
Clean water	m ³	2,414	1,609	1,573	1,155	843	Note 1 73
Groundwater	m ³	2,024	0	0	0	0	—
Water drainage	m ³	3,796	1,609	1,573	1,155	843	Note 1 73
Annual biochemical oxygen demand (BOD) emissions	kg	34	10	29	8	5	Note 2 58
Annual nitrogen emissions	kg	75	6	90	49	30	Note 2 60
Annual phosphorus emissions	kg	7.2	6.3	9.9	6.2	4.3	Note 2 69
Total waste generation	t	399	387	293	256	160	Note 3 63
Final disposal (landfill)	t	0.7	0.3	0.6	2.5	0.3	Note 3 11
Waste recycling rate	%	99.8	99.9	99.8	99.0	99.8	101

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

Note 1 Water leakage was discovered when replacing aging water distribution pumps, and the piping was also updated, resulting in the improvement.

Note 2 The range of variation within the standard value

Note 3 This was the result of a decline in production activities.

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	82 (As of March 31, 2020)

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	FY2016	FY2017	FY2018	FY2019	FY2020	YoY (%)
Electricity consumption	MWh	2,294	2,504	2,303	2,182	2,109	93
Water consumption	m ³	6,966	6,069	5,854	5,528	5,309	96
Clean water	m ³	3,587	2,610	2,685	2,481	2,469	100
Groundwater	m ³	3,379	3,459	3,169	3,047	2,840	93
Water drainage	m ³	3,587	2,610	2,685	2,481	2,469	100
Annual biochemical oxygen demand (BOD) emissions	kg	35	8	17	15	5	Note 1 36
Total waste generation	t	186	220	226	211	188	89
Final disposal (landfill)	t	0.3	0.2	0.6	0.2	0.3	Note 2 150
Waste recycling rate	%	99.1	99.5	99.2	99.5	98.7	99

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

Note 1 The range of variation within the standard value

Note 2 The range of variation



Figure 26

RISO R&D Center

Scope of calculation: RISO R&D Center

Overview	Address	2 Chome 8-1, Gakuenminami, 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 December 2017
- Reduction of CO₂ emissions through energy conservation
- Designing environmentally friendly products
- Reduction of waste generation and promotion of recycling

Environmental Data

	Unit	FY2016	FY2017	FY2018	FY2019	FY2020	YoY (%)
Electricity consumption	MWh	2,444	2,353	2,289	2,331	2,257	97
Water consumption	m ³	9,117	9,883	9,958	9,788	8,356	Note 2 85
Clean water	m ³	9,117	9,883	9,958	9,788	8,356	Note 2 85
Groundwater	m ³	0	0	0	0	0	—
Water drainage	m ³	9,117	9,883	9,958	9,788	8,356	Note 2 85
Annual biochemical oxygen demand (BOD) emissions	kg	205	195	153	Note 1 275	275	100
Total waste generation	t	210	193	185	Note 1 204	256	125
Final disposal (landfill)	t	2.0	1.6	1.9	1.7	1.4	Note 3 81
Waste recycling rate	%	97.2	99.0	98.9	99.2	99.2	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 There were errors in the figures for fiscal 2019, and accordingly, they have been corrected.

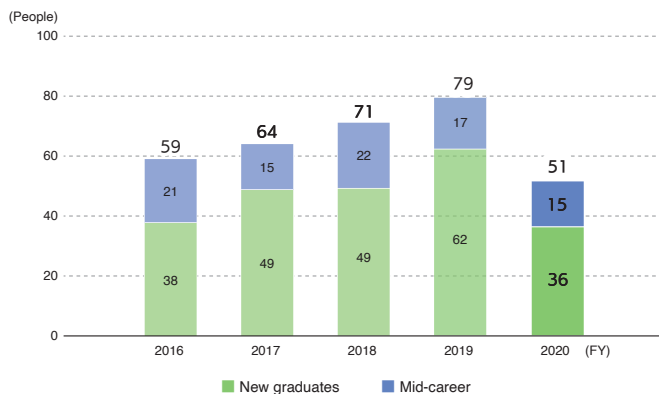
Note 2 Due to an improvement in operating efficiency.

Note 3 This was because we changed to a new waste disposal contractor with a lower final disposal rate and a higher recycling rate.



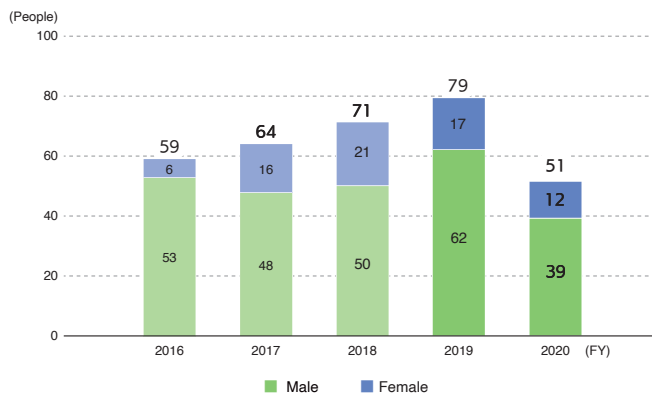
Social Data

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



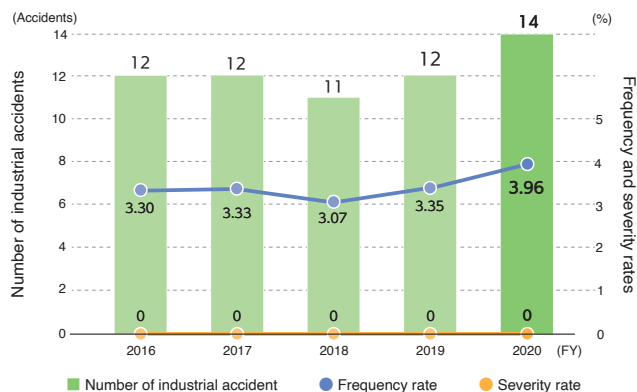
Scope of calculation: Non-consolidated basis (Japan)

Figure 28 Employment (Japan)
(Male/Female)



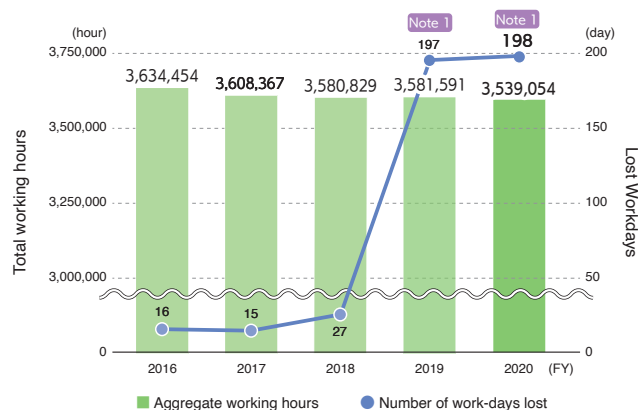
Scope of calculation: Non-consolidated basis (Japan)

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)

Note 1 The increases in fiscal 2019 and fiscal 2020 were due to an employee who missed work due to occupational injuries or illness.

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 2020 was 14, an increase of 2 from fiscal 2019. The lost workdays due to industrial accidents increased by 1 day.

Promoting employee health

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

We also hold sports competitions with the goal of deepening friendships among employees and creating a fun outlet.

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