



2023 Sustainability Report

We are invisible. But we are everywhere!

Table of contents

Letter to Stakeholders	3
The process of preparing the Sustainability Report	5
Our stakeholders	5
Material topics.....	6
The Sustainability Manifesto	9
1. A history spanning over 100 years	12
1.1 <i>Made in Italy</i> since 1918.....	12
1.2 Our organisation.....	13
1.2.1 Governance and sustainability	14
1.2.2 Economic performance	16
1.2.3 Associations	17
2. Our invisible strength	19
2.1 A high-quality production process.....	19
2.2 Careful selection of materials.....	24
2.3 Our team.....	28
3. Attention to the environment and safety	34
3.1 Environmental Protection	34
3.1.1 Water withdrawal and discharge	36
3.1.2 Waste.....	37
3.1.3 Emissions of pollutants.....	40
3.1.4 Energy consumption and greenhouse gas emissions.....	40
3.2 The health and safety of workers and customers	43
Methodological note	47
GRI Content Index.....	51

Letter to Stakeholders

Dear readers,

I am proud to present to you again this year our Sustainability Report, which, in line with previous years, is not intended to respond to a legal obligation, but rather to tell you about us and to share with you our activities during the year and our future commitments.

Demonstrating far-sightedness and a strong focus on emerging social and environmental topics, in 1998 we decided to join the "Responsible Care" Programme, which promotes the Sustainable Development of the chemical industry internationally, according to values and behaviour geared towards health, safety and the environment. This voluntary programme, launched globally in the eighties, represents excellence on the industrial scene: a unique, ethical and sustainable way of working while, at the same time, creating a corporate culture, improving company performance in terms of occupational health and safety and environmental protection.

With this in mind, we appointed a Director of Sustainability in 2023 to coordinate sustainability-related projects and strategies, improve our business performance and continue our sustainable growth through the acquisition of new certifications. In this regard, during the year we drafted our Sustainability Manifesto, a document aimed at communicating ICF's vision with respect to ESG issues and describing our mission to pursue responsible business practices and contribute to the reduction of greenhouse gas emissions.

Our focus on these issues has led us to offer our customers products with an increasingly reduced environmental impact, without compromising functionality and performance. In this direction, we have indeed been working for years on the replacement of hazardous substances present in the formulation of our products and on the development of eco-friendly and low VOC adhesives, challenging working methods and technologies consolidated over time. Our commitment is reflected in the continuous expansion of our range of products certified according to the GRS (Global Recycle Standard), FSC (Forest Stewardship Council), OK biobased and EU Ecolabel standards.

In the first months of the year, we also decided to expand our commercial offer with complementary and highly synergic products, by acquiring the business unit of Tessitura Langé, a historical *Made in Italy* company for the finishing of high-end packaging and industrial fabrics, characterised by a strong focus on innovation and sustainability. Langé fabrics are also GRS-certified and characterised by GOTS and BCI certifications.

In addition, thanks to our LCAs and our contribution in the drafting of a specific 'Fabrics' Product Category Rules (PCR), we achieved EPD (Environmental Product Declaration) certification for our extruded and impregnated fabrics in 2023, establishing a world record within the footwear industry. This gave us not only a competitive advantage, but also ecodesign support for the final product.

In addition to product sustainability, we focus on Industry 4.0 investments, aimed at innovating and digitising our production processes, and on energy efficiency, which has become a key pillar of our sustainability strategy in recent years. For example, in 2022 we installed a new ventilation and cooling system in the company's premises and an innovative refrigeration system for the adhesive production machinery; in 2023, a photovoltaic system went into operation, which enabled us to reduce energy consumption and avoid the emission of around 101 tonnes of CO₂.

Social sustainability is also reflected within Industrie Chimiche Forestali, where we strongly believe in the value of our people. We give them the opportunity to learn a skilled job and invest in them to develop their talents.

In this vein, we guarantee compliance with measures to ensure the safety not only of our employees but also of our customers and the surrounding communities. We have always thought that properly qualified personnel and the development of processes and plants with high standards of quality and safety are the prerequisites that we put before any other technical-economic consideration.

For all these reasons, at Industrie Chimiche Forestali, we believe we are in the right direction to continue the process of integration of economic, environmental and social sustainability, demonstrating a greater ability to be competitive, as well as dynamic and flexible on the market, and a constant “business rationale” aimed at creating value.

The Chairman

Guido Cami

The process of preparing the Sustainability Report

Again this year, Industrie Chimiche Forestali S.p.A. (hereinafter referred to as ICF or Industrie Chimiche Forestali) decided to draft a Sustainability Report (hereinafter also referred to as "Report"), thus continuing with its aim of strengthening and making its communication increasingly transparent towards its stakeholders and sharing the key information and initiatives relating to environmental, social and economic aspects that have been an art of ICF for over 100 years.

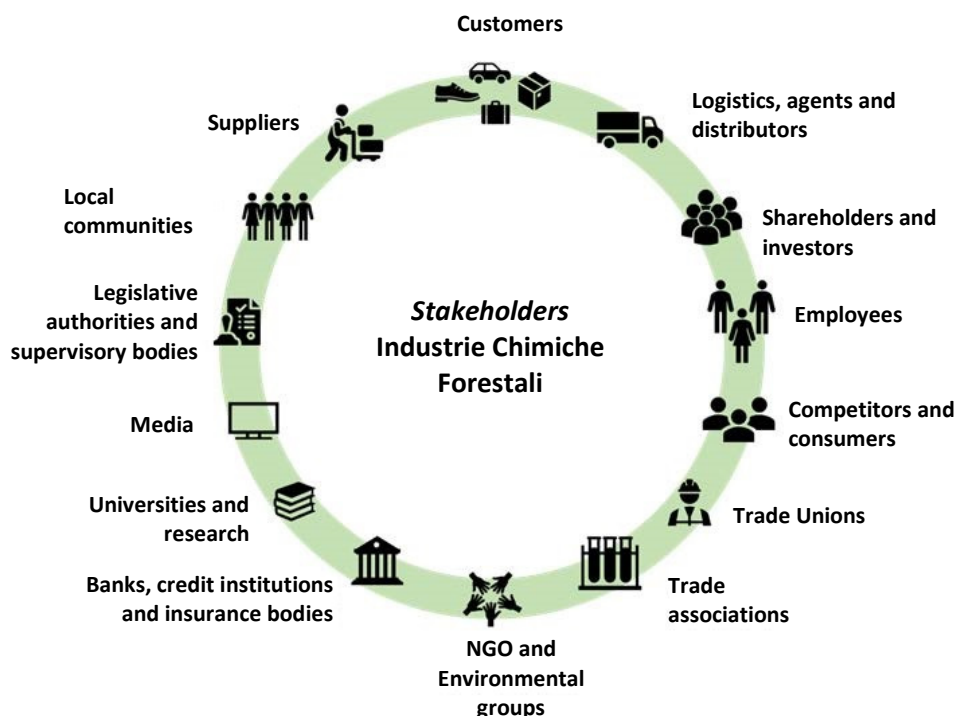
The process undertaken by Industrie Chimiche Forestali to update the Report involved senior management and the various corporate functions in preparing the document and collecting data and information useful for drafting the Report.

ICF's Sustainability Report was prepared in accordance with the *Global Reporting Initiative Sustainability Reporting Standards* ("GRI Standards"), whose principles and benchmark indicators are the most widely used and applied around the world.

Our stakeholders

For the first year of drafting the Sustainability Report, the various stakeholders of ICF were mapped on the basis of an analysis of the company structure, business activities, value chain and network of existing relationships involving Industrie Chimiche Forestali.

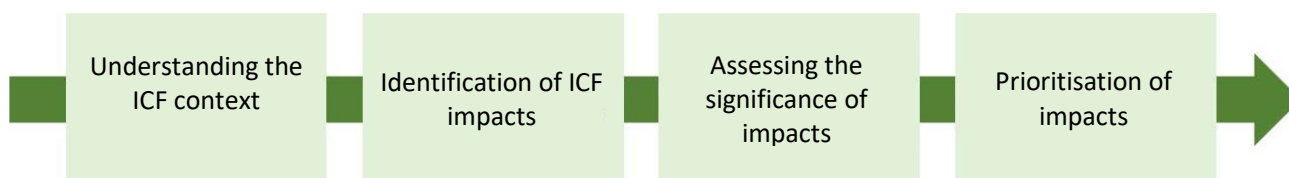
For the 2023 Sustainability Report, the previously identified stakeholder categories have been confirmed.



The company's communication with its stakeholders, aimed at transparency and willingness to collaborate, is maintained via numerous press releases and ongoing updates on the website, as well as at the usual meetings relating to the performance of business activities. These activities make it possible to establish a bilateral dialogue and consolidate a relationship of trust and continuous exchange, which are necessary to identify Industrie Chimiche Forestali's strengths and possible points of improvement and are essential for safeguarding stakeholders' interests.

Material topics

Materiality analysis plays a key role in defining the information to be reported in the Sustainability Report. The aim is to achieve an accurate and complete representation of the impacts, actual or potential, positive or negative, generated by Industrie Chimiche Forestali's activities, providing a clear and transparent view. For this reason, ICF conducted the materiality analysis during 2023, in line with the process defined by the *GRI Universal Standards 2021*.



The materiality analysis process consisted of four different steps:

1. **Understanding the context** in which ICF operates: **an analysis of the sector** in which ICF operates (automotive, flexible packaging, footwear and leather goods) was carried out, taking into consideration different categories of public sources, including the main international sustainability reporting standards, sector regulations and legislation, and reports published by comparable companies and clients, in order to create a long list of impacts. Subsequently, an analysis of the **relevance** of sustainability issues **with respect to the media and public opinion** was carried out, through the recognition of the main issues that affected ICF in the year in question, by sifting through the main articles in local and international newspapers.
2. **Identification of ICF impacts**: **an analysis of internal documentation** was carried out in order to identify the impacts applicable to the ICF business model, leading to the definition of a short list of impacts. These impacts have been categorised through the following definitions:
 - **Actual or potential**: an impact is considered actual when its effects have occurred or are currently occurring. Conversely, it is defined as potential when its effects could occur, but have not yet occurred at the time of analysis;
 - **Positive or negative**: impacts are considered positive when they contribute to sustainable development. On the contrary, they become negative when they do not contribute to sustainable development.
3. **Evaluation of the significance of impacts**: A level of significance was defined for all impacts according to their degree of *severity* and *likelihood*. In particular, the severity of an impact was assessed by taking into account three aspects:
 - *Scale*: how severe the impact is and the external context in which the impact occurs;
 - *Scope*: how widespread the impact is, which can be measured in terms of its impact on the geographical scope, the number of people involved and the value chain;
 - *Irremediable character*: how difficult it is to repair the damage generated by the negative impact.































Specifically, the significance of actual impacts was determined by assessing only their severity, while for potential impacts the likelihood of occurrence was also considered. In the latter case, it was calculated by analysing all the policies, procedures and actions ICF has taken to prevent and mitigate the identified impact. In addition, for positive impacts, severity was calculated taking into

consideration the scale of intensity and scope; while for negative impacts, irreparability was also considered.





4. **Prioritisation of impacts:** in the last step, a materiality threshold was defined to highlight the most significant impacts, which were grouped into the material topics that guided ICF in drafting the 2023 Sustainability Report.

The relevance of each impact and its material issues were finally validated in a meeting involving the COO and Director of Sustainability and the EHS&QA Manager of ICF.

The following page lists the 2023 material topics and their impacts. Descriptions of impacts and related GRI Disclosures are provided in the Methodological Note.

Material Topics	Impacts	Type of impact ¹
Diversity and equal opportunities	Failure to protect equal opportunities of employees	 
Emissions of pollutants	Effects on human health and ecosystems caused by air pollutant emissions	 
Energy and climate change	Reducing energy availability due to inefficient production processes	 
	Climate change due to greenhouse gas emissions	 
Training and education	Development of employees' professional and personal skills	 
Waste Management	Environmental pollution due to limited sending of waste for recycling/reuse	 
Raw materials and supply chain	Depletion of primary resources due to consumption of virgin raw materials	 
Water Withdrawals and Discharges	Pollution of water resources	 
	Depletion of water resources due to consumption of water in production processes	 
Industrial relations	Enhancing employee well-being	 
Occupational health and safety	Damage to the health and safety of workers	 
Customer health and safety	Negative health effects on users	 
Product sustainability	Promotion of eco-design and product sustainability through continuous research and development	 
Territorial and community development	Increased employment rate, valorisation of local suppliers and community development	 
Violation of human rights	Violation of human rights	 

1

Key:  Effective  Potential  Positive  Negative

The Sustainability Manifesto

Industrie Chimiche Forestali is aware of the importance of sustainable development for future generations and firmly believes that companies have a crucial role to play in the transition to more sustainable production practices, regardless of their size or sector. ICF is therefore not only committed to reducing the environmental impact of its activities, but also strives to support its stakeholders, partners and collaborators.

In 2023, ICF drafted its **Sustainability Manifesto**², a document aimed at communicating the company's vision with respect to ESG issues and describing ICF's ethical commitment and mission to pursue responsible business practices and contribute to the reduction of greenhouse gas emissions. Short- and long-term goals in line with the ambitions of the Paris Agreement were stated in the Sustainability Manifesto.

The main **areas of action** identified by the company to improve its performance are:



The **objectives** identified, the first five of which are short-term and the others long-term, aim to:

- Increase the share of impregnated and co-extruded fabrics containing bio-based and biodegradable recycled materials by 20% by 2025;
- Reduce the amount of process solvent-related waste through an internal recovery system by 20% by 2023³, by 50% by 2024 and by 75% by 2025;
- Modernise the wastewater treatment plant for sludge reduction by 2025;
- Achieve EPD certification for all fabrics by the end of 2023⁴ and carry out LCA studies on all water-based adhesives by 2025;

² For more details on the actions envisaged by the Manifesto, please refer to the full document, available on the ICF website, in the section *Forests for Sustainability*.

³ ICF expects to reach the target during 2024.




⁴ Target already achieved in July 2023.

- Develop a line of water-based adhesives with a low volatile organic compound (VOC) content specifically for the automotive sector (laminating and flocking) by 2025;
- Ensure that at least 50% of European footwear companies working with ICF use water-based adhesives by 2030;
- Ensure that 60 per cent of ICF adhesive production has a low environmental impact, with features such as solvent-free or water-based, by 2030;
- Ensure that all company textiles produced in Europe contain at least 50% recycled, organic or biodegradable materials by 2030;
- Evaluate and identify possible biological raw materials to be introduced in automotive adhesive formulations and flexible packaging by 2030.

The continuous search for new sustainable products and materials, coupled with the attainment of product and process certifications, has led ICF to achieve milestones in line with the United Nations Sustainable Development Guidelines. The **2030 Sustainable Development Agenda**, approved in 2015, is an action programme aimed at finding common solutions to the planet's major challenges, including extreme poverty, climate change, environmental degradation and health crises. The 2030 Agenda consists of 17 **Sustainable Development Goals (SDGs)**, framed within a broader action agenda of 169 environmental, economic, social and institutional targets to be achieved by 2030.



ICF has identified three benchmark SDGs for its activities, having contributed to the achievement of some of the related goals.

SDG	GOAL
	<p>Objective 8: Promote sustained, inclusive and sustainable economic growth, full and productive employment and decent work for all</p> <ul style="list-style-type: none"> - ICF has made several investments in Industry 4.0 and management that have improved productivity standards through technological progress and innovation; - ICF has reduced its energy consumption through the installation of the photovoltaic system and introduced energy efficiency plans, improving efficiency in the consumption and production of resources; - ICF supports activities and initiatives related to education and training, reducing the proportion of young people unemployed and out of education or training; - ICF pays close attention to workers' rights through its Code of Ethics and Model 231, promoting a healthy and safe working environment for all.
	<p>Objective 12: Ensuring sustainable production and consumption patterns</p> <ul style="list-style-type: none"> - ICF's production process is characterised by the use of natural resources and materials, as attested by the various certifications obtained, with a view to their sustainable management; - ICF has implemented several solutions to reduce its waste production, such as creating packaging from recycled materials, recovering solvents and reusing process water; - ICF continues to invest in R&D to find new green solvents/adhesives such as water-based adhesives and, by including these in its Sustainability Report, wants to incentivise other players to do the same, making the entire industry more sustainable; - ICF continues on its path of reporting its sustainability achievements, providing relevant information to its stakeholders and promoting awareness of sustainable development.
	<p>Objective 15: Protect, restore and promote sustainable use of terrestrial ecosystems</p> <ul style="list-style-type: none"> - ICF's entire value chain is sustainable as all products and processes are verified by specific industry certifications, such as GRS, GOTS, BCI or FSC, ensuring the conservation and sustainable use of ecosystems and promoting sustainable forest management.

1. A history spanning over 100 years



5 brands



81.1 million euro of economic value generated

1.1 *Made in Italy* since 1918

Industrie Chimiche Forestali's story began in **1918**, the year in which the company Forestali s.r.l. (hereinafter referred to as Forestali) was established to extract the pyroligneous acid from the wood of the Maccagno forests in the province of Varese. In the **1920s**, the production of formaldehyde as a derivative of pyroligneous acid began, first in Maccagno and then in the plant in Sesto San Giovanni (MI). The activity of Forestali was then strengthened in the **1930s** with the establishment of the Società Italiana Resine (SIR) for the production of phenolic resins in Sesto San Giovanni.

In **1941**, the production of special impregnated fabrics for the footwear industry began and in the **fifties** the production of adhesives. After the sale of SIR, formaldehyde production continued in Maccagno and Sesto San Giovanni until **1983**, when the company stopped production in basic chemicals and focused definitively on the upstream segment of the footwear industry.

In **1984**, Forestali produced a complete series of adhesives and auxiliary products for industries other than footwear: Durabond was created, a complete line of technical adhesives for furniture and, at the same time, high-quality and easy to use adhesives were formulated specifically for export to developing countries. Today, Durabond is present in Italy, Europe and over 30 non-European countries.

In **1987**, Forestali relocated production from the plant in Sesto San Giovanni to the new plant in Marcallo con Casone in the province of Milan and on **31 December 1999** ceased production of fabrics for toe caps and counters at the plant in Maccagno. In **October 2006**, the Company changed its name to Industrie Chimiche Forestali S.p.A.

In **2016**, the company Adhesive Based Chemicals S.r.l. (hereinafter ABC) was merged and became a division within ICF. ABC started its activity in **2005** in Marcallo with Casone, as a company fully dedicated to the polyurethane adhesive industry, focusing its activity in research, development, formulation and production of polyurethane adhesives for industrial applications for different sectors, mainly automotive, flexible packaging, graphic arts and industrial applications.

On **14 May 2018**, the entire share capital of Industrie Chimiche Forestali S.p.A. was acquired by EPS Equita PEP SPAC S.p.A., a company listed on the AIM Italia market regulated by Borsa Italiana. Following the acquisition, EPS Equita PEP SPAC S.p.A. changed its name to ICF Group S.p.A. and began to carry out management and coordination activities as a holding company for its subsidiary Industrie Chimiche Forestali S.p.A.

On **1 August 2020** Industrie Chimiche Forestali S.p.A. finalised the reverse merger with the then parent company ICF Group S.p.A. and the simultaneous admission to listing on the Alternative Capital Market, AIM Italia, organised and managed by Borsa Italiana S.p.A., of the ordinary shares and warrants that have been

issued as at the effective date of the merger. The merger became effective for civil law purposes on 1 August 2020 with accounting and tax backdating to 1 January 2020.

On **1 July 2021** ICF acquired the business branch of Industria Chimica Morel & C. S.p.A. (hereinafter referred to as Morel), dedicated to the design, manufacture and sale of textile components, toe caps, counters and stiffeners for the luxury footwear and leather goods market, thus supporting the existing brands (Forestali, Durabond and ABC). The brand was owned by a family business, established in 1926 in the heart of Milan based on an idea of Maurice Morel: to manufacture a cotton gauze impregnated with glue for the toe cap stiffeners, which was highly performing but at the same time easy for shoemakers to handle.

2022, just like 2021, was a challenging year for Industrie Chimiche Forestali because of high energy and raw material costs. In this context, ICF reacted positively, however, increasing the value of its annual turnover by 17% compared to 2021 and improving its performance in all areas, thanks in part to the Morel product line, whose sales resulted in revenues of around EUR 8 million in 2022.

Lastly, it should be noted that on 8 February **2023**, ICF signed the preliminary purchase and sale agreement, finalised on **3 April 2023**, of the business unit of **Tessitura Langé S.r.l.** dedicated to the business of finishing and ennobling fabrics and trading in yarns, fabrics and textile products in general, with the aim of consolidating its competitive position in the market and expanding its commercial offer with complementary and highly synergic products.

1.2 Our organisation

Industrie Chimiche Forestali designs, manufactures and markets high-tech adhesives and fabrics in the following main markets: automotive, footwear, leather goods, upholstered furniture, flexible and industrial packaging.

ICF, while operating under a single company name, produces and markets its products through **five separate brands: Industrie Chimiche Forestali, ABC - Adhesive Based Chemicals, Durabond, Morel and Langé**, integrated in April 2023.

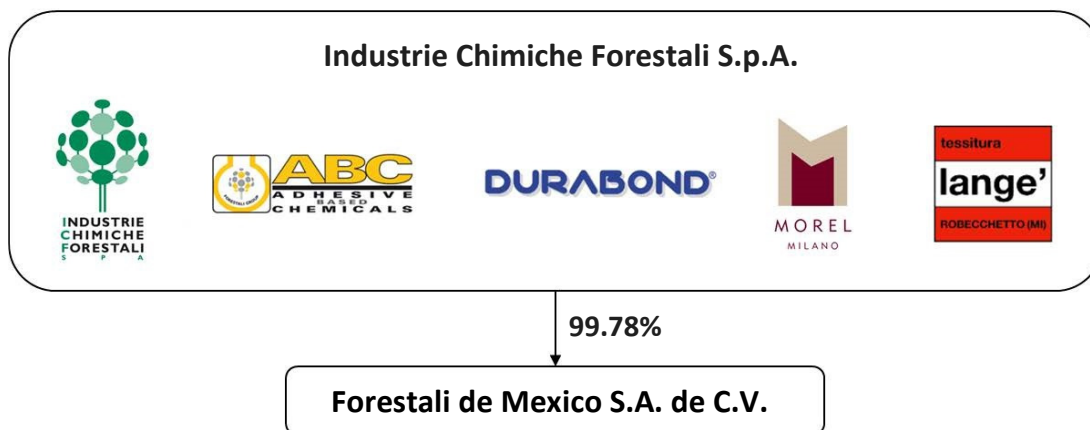


The production activity of ICF is carried out through two separate **divisions**:

- **ICF Division**, specialised in the production of adhesives and fabrics such as toe caps, linings and counters for the footwear industry, as well as solvent and water-based adhesives for the leather goods and upholstered furniture industries;
- **ABC Division**, which produces adhesives for the automotive, flexible packaging and industrial segments.

Both divisions operate at the production site in Marcallo con Casone (MI), while Tessitura Langè's production is in Robecchetto con Induno (MI). Industrie Chimiche Forestali, however, also has an international presence through its subsidiary Forestali de Mexico S.A., which markets its products in the Mexican market.

Group Structure



With 158 employees and a turnover of EUR 80 million⁵ in 2023, ICF exports to 80 countries around the world with around 53% of its turnover being exported. Sales and logistics management represents a strategic point for the competitiveness of Industrie Chimiche Forestali, which has an extensive sales network of 34 agents (19 Italian and 15 foreign) and three logistics bases in Mexico, the United States and Hong Kong. Some of the countries interested in marketing ICF's products within the EU are Germany, France, Spain, Portugal, Poland, Hungary and Slovenia, while worldwide they include Mexico, the United States, Colombia, Japan, China, Taiwan, Vietnam, India, Pakistan, Bangladesh, Turkey, Africa and Middle East. Globally, ICF has a portfolio of around 1,032 customers, the largest and least numerous of which are related to the automotive industry, while the remainder are small customers in the footwear and leather goods industry.

1.2.1 Governance and sustainability

The governance of Industrie Chimiche Forestali consists of an administrative body (Board of Directors), a decision-taking body (Shareholders' Meeting) and a control body (Board of Statutory Auditors).

The members of the **Board of Directors (BoD)** are selected in accordance with the principles of integrity, transparency, honesty and fairness, on the basis of lists of candidates submitted by the shareholders. All directors must meet the legal requirements of eligibility, professionalism and integrity, and at least two must also meet the minimum requirements of independence. Overall, the members of the Board of Directors remain in office for a maximum period of three financial years and may be re-elected.

In particular, the Board of Directors was renewed in 2023 and is currently composed of 7 members:

- Guido Cami: Chairman and CEO, with more than 30 years of experience in industry, currently also Vice President of the Adhesives and Sealants Group (AVISA - Federchimica) and Chairman of FEICA (Association of the European Adhesive & Sealant Industry);

⁵ The reported value refers only to the turnover of Industrie Chimiche Forestali S.p.A., equal to € 79.9 million.

- Giovanni Campolo: Board Member, Non-Executive Director;
- Vincenzo Polidoro: Board Member, Non-Executive Director;
- Marco Di Lorenzo: Board Member, Non-Executive Director;
- Steve Kenny: Board Member, Independent Director;
- Roberto Rettani: Board Member, Independent Director;
- Marina Balzano: Board Member, Independent Director.

Currently, 71% of the board is over 50 years of age, while the remaining 29% belong to the 30-50 age group; there is one woman on the board (14%) and there are no underrepresented social groups. In addition to Chairman Guido Cami, the other Board members also hold other posts, which, however, do not compromise their ability to perform their duties within the organisation or to express independent judgements, free from external influence or conflicts of interest. The authority of the board members is ensured by their specific managerial skills and their background in the diverse sustainability-related topics.

The **Shareholders' Meeting** deliberates on matters reserved to it by law, regulations and the articles of association, being constituted and passing resolutions with the majorities prescribed by law. ICF's Shareholders' Meeting has, among its main tasks, the appointment of the Board of Directors, determining its duration, members and total remuneration for all its members. Furthermore, it has the task of appointing the Board of Auditors and its members, as well as determining their remuneration. In addition, the shareholders' meeting appoints the independent auditors for the financial years and approves both the Financial Report and the Sustainability Report.

ICF's corporate management is, on the other hand, supervised by a **Board of Statutory Auditors**, consisting of three statutory auditors and two alternate auditors, appointed by the Shareholders' Meeting on the basis of lists of candidates submitted by the shareholders and operating in accordance with the law.

As from 2014, Industrie Chimiche Forestali adopted an **Organisational, Management and Control Model** pursuant to Legislative Decree No. 231 of 8 June of 2001 (hereinafter also referred to as "Model 231") and a **Code of Ethics** (hereinafter also referred to as the "Code") with the aim of raising awareness and communicating in a transparent manner the ethical and social values that inspire ICF, as well as defining the fundamental principles, rules of behaviour and responsibilities within ICF itself.

In order to safeguard the interests of stakeholders and ensure an efficient and reliable working method, the Code identifies the prerequisites to ensure that the business activity is inspired by the principles of fairness, transparency, diligence, honesty, mutual respect, loyalty and good faith.

Moreover, the Code of Ethics specifies the topics of fundamental importance for ICF's growth strategy:

- Responsibility of internal personnel and external collaborators;
- Conflict of interests, protection of company assets and image;
- Rules of behaviour in the management and recruitment of human resources;
- Rules of behaviour in relations with public bodies (public administration, parties, trade unions and associations);
- Rules of behaviour for the management of contributions and sponsorships;
- Rules of behaviour for the management of relations with the media;

- Rules of behaviour for the prevention of corporate crimes, crimes with the purpose of terrorism, computer crimes and unlawful data processing;
- Protection of Intellectual Property and Privacy;
- Principles on which the behaviour of ICF is based and with which strict compliance is required by the Recipients with regard to occupational health and safety;
- Principles on which the behaviour of ICF is based and with which strict compliance is required by the Recipients with regard to the Environment;
- Relations and rules of behaviour with stakeholders, shareholders, suppliers and external collaborators.

With the adoption of Model 231, ICF established a **Supervisory Body** with the task of periodically checking the system of proxies and powers of attorney in force and their consistency with the entire system of organisational communications.

The new Director of Sustainability role

In 2023, Marcello Taglietti was appointed Director of Sustainability in order to coordinate sustainability-related projects and strategies. The introduction of this role is intended not only to formalise responsibilities within these issues, but also to continue ICF's sustainable growth by gaining new certifications and improving corporate performance.

Among the activities carried out during the year was the publication of the Sustainability Manifesto through which ICF declared its commitments related to this issue, defining precise objectives and an action plan to achieve them.

1.2.2 Economic performance

The **economic value generated** by Industrie Chimiche Forestali S.p.A. in 2023 was EUR 81.1 million⁶ of which approximately 91% was distributed to ICF's main stakeholders while the remainder was retained by the Company. Specifically:

- Operating costs amounted to approximately € 61.2 million, 82% of which related to raw materials;
- staff remuneration amounted to approximately € 10.8 million, up from 2022;
- a value of approximately € 1.3 million was distributed to capital suppliers, while a value of approximately € 744 thousand was distributed to the Public Administration;
- donations, membership fees and sponsorships to the community amounted to € 19 thousand, up from € 15 thousand in 2022.

Economic performance (k€)	2021	2022	2023
Generated economic value	76,941	90,585	81,112
Distributed economic value	70,633	83,088	74,054
Operating costs	62,242	71,842	61,226

⁶ The economic value generated includes both turnover and other income of Industrie Chimiche Forestali S.p.A.

Value distributed to employees	9,065	9,580	10,788
Value distributed to capital providers	1,248	639	1,277
Value distributed to the P.A.	1,939	1,012	744
Value distributed to the community	17	15	19
Retained economic value	6,308	7,498	7,058

ICF ended 2023 with a declining economic value generated compared to 2022: the slowdown in the global economy, caused by inflation and increasingly tight financing conditions, was reflected in all of the company's focus areas. Despite the drop in turnover, ICF worked on reducing its operating costs, leading to an improvement in overall sales profitability, and completed its investment plan for the modernisation of industrial operations, research and development and workplace safety. Finally, during the year, ICF reviewed Tessitura Langè's internal operations, installed a new computer system to bring it in line with the rest of the company, and established good business relations with customers and suppliers as a basis for future growth. The acquisition of the business unit of Tessitura Langè contributed more than € 5 million to the 2023 turnover.

Community Initiatives

Since 2012, driven by its strong sense of social responsibility and solidarity, Industrie Chimiche Forestali has been supporting the non-profit **"I Bambini delle Fate"** Foundation, to which it donated € 6,000 in 2023. The foundation provides financial support to social inclusion projects and programmes managed by local partners for families with autism and other disabilities.

ICF also supported other associations, including:

- **"L'ORO Onlus"**, an association in Marcallo con Casone that works in the defence of the rights of people with disabilities, to which ICF donated a minibus in 2023;
- **"A.la.t.Ha Onlus"**, a social cooperative present since 1995 in the Lombardy region that offers services and projects for the social inclusion of elderly people, people with disabilities or people with reduced mobility;
- **"U.S. Marcallese A.S.D."**, the football association of Marcallo con Casone.

In addition, ICF has collaborated with schools and universities on projects such as:

- **"Progetto educazione scuola" (School Education Project)**, created to distribute an educational booklet in primary and middle schools dedicated to raising children's awareness of topics of great social impact, including the environment, first aid, road safety and food education;
- Preparation of the exhibition **"Scales of Transformation - Between Architecture and Chemical Engineering"**, organised by the Milan Polytechnic for educational and cultural purposes, aimed at both university and high school students. Also in collaboration with the Milan Polytechnic, ICF is also sponsoring the **'Leather Goods and Footwear'** course for the award of 4 scholarships.

1.2.3 Associations

Industrie Chimiche Forestali is a member of **Associazione nazionale Vernici, Inchiostri, Sigillanti e Adesivi (AVISA)** (National Association of Paints, Inks, Sealants and Adhesives) of Federchimica, part of Confindustria and member of CEFIC (European Chemical Industry Council). AVISA represents the companies producing adhesives and sealants that carry on industrial activities in Italy in various sectors including: stationery, packaging, footwear, construction, wood and furniture, means of transport. The Association also liaises with European associations by joining **CEPE** (*Conseil Européen de l'Industrie des Peintures, des Encres*

d'Imprimerie et des Couleurs d'Art) and **FEICA** (*Fédération Européenne des Industries de Colles et Adhésifs*), the European association of adhesive and sealant manufacturers.

The Chief Executive Officer of Industrie Chimiche Forestali S.p.A. is currently the Chairman of FEICA, as well as Vice Chairman of Federchimica's **Adhesives and Sealants Group**. Through a network of institutional relations with the main national and European industry stakeholders, the Adhesives and Sealants Group ensures that the requirements of the Italian Adhesives and Sealants Industry are taken into consideration during the law formation processes.

Among the services that AVISA offers its member companies, the Technical Service plays a central role by overseeing the technical and legislative issues of interest, following and analysing the development of the legislative and regulatory framework and activating working groups to investigate specific issues and draw up guidelines and technical monographs.

ICF's employees actively participate and collaborate in the various initiatives promoted by **Federchimica**, of which AVISA is a member, including Responsible Care (for further information, see paragraph 0 03.1 *Environmental Protection*) and the Technical Committee established by the association. The latter has the function of overseeing and documenting technical and legislative issues, monitoring and analysing the development of EU and national legislation with repercussions on the activities of the represented industries, and activating working groups for the in-depth study of critical issues.

ICF is associated with **Unione Nazionale Accessori e Componenti (UNAC)** (National Union of Accessories and Components, which represents the Italian industry of manufacturers of accessories and alternative materials for footwear and leather goods, and **SATRA (Shoe and Allied Trades Research Association)**, a research and certification association for the footwear and leather goods industry. Moreover, the Group supports the **Politecnico Calzaturiero**, a training, technology transfer and business services structure in the Riviera del Brenta Footwear District, where shoes are produced mainly for women, for the major luxury brands.

In the packaging sector, ICF is a member of **GIFLEX**, which brings together manufacturers of flexible packaging in intaglio and flexographic printing, intended for the packaging of food, pharmaceutical, chemical products and other industrial applications, and the **Italian Packaging Institute**, an association of packaging companies in Italy.

The Group is also a member of the local employers' association **ASSOLOMBARDA** and participates in refresher courses on the various issues scheduled during the year with various company functions.

ICF is also a member of **AssoNEXT** (*Associazione Italiana delle PMI Quotate*, Italian Association of Listed SMEs), which was created at the end of 2019 as AssoAIM (Associazione Emittenti AIM Italia, the Association of companies listed on the AIM market of the Italian Stock Exchange) and renamed in 2021 when the AIM Italia market was renamed Euronext Growth Milan. The Association's aim is to represent small and medium-sized companies (SMEs) listed on the AIM Italia segment, now called Euronext Growth Milan.

During 2021, ICF became a member of **UNICHIM** (*Associazione per l'unificazione nel Settore dell'Industria Chimica*, (Association for Unification in the Chemical Industry Sector), which is involved in the development of new analysis methodologies, many of which are still used in national laboratories for legal provisions or UNI standards. It is also a member of **AmCham Italy** (American Chamber of Commerce in Italy), a private non-profit organisation whose aim is to develop and promote financial and cultural relationships between the United States and Italy.

Finally, we report that in 2023 ICF joined **Assomac** (the National Association of Manufacturers of Footwear, Leather Goods and Tannery Technology), part of the Confindustria System, and is a member of Federmacchine. Assomac brings together and represents Italian manufacturers of machinery for all stages

of industrial production in the leather sector (footwear, leather goods, furs, automotive, furniture and clothing) and aims to support the interests of its member companies and promote their business globally.

2. Our invisible strength



5 management system certifications

5 product certifications



93% of raw material procurement expenditure goes to European suppliers



158 Employees

18% of the workforce are women

2.1 A high-quality production process

"We are invisible. But we are everywhere!" This is Industrie Chimiche Forestali's slogan.

ICF produces and exports all over the world technical products for glueing and reinforcing footwear, leather goods of all kinds and industrial products. Products that are "invisible" but present everywhere. Glueing has now become an indispensable technique for bonding two or more substrates, not only in the industrial field but also in everyday life. Adhesives are now present in many sectors, from automotive to footwear, fabrics, leather goods, furniture; from flexible packaging to paper lamination and in many other industrial applications. Adhesives represent the hidden strength that gives shape to the world, without which there would be almost none of the products that each of us today is used to taking for granted. Not only that: many innovative products could not even be manufactured without using glueing techniques. Bonding by means of adhesives is increasingly becoming a technology adopted as a replacement for traditional mechanical assembly systems. Today, adhesives are seen and perceived as a new solution to reduce the weight of materials and improve energy efficiency in construction.

ICF produces two types of products:

- **adhesives**, which harden by physical process or chemical reaction for the footwear and leather goods industry as well as for the automotive and flexible packaging industry;
- **fabrics**, also for the footwear and leather goods sector, as well as high-end packaging.

In particular, the **Forestali Division** (or simply "**Forestali**") produces: adhesives and fabrics for toe caps, counters, linings, stiffeners and insoles for the footwear market, in which it has always been a leader in Italy and for which it collaborates with the most prestigious brands; solvent-based and water-based adhesives for the leather goods and upholstered furniture market. The production of Forestali's adhesives includes: dissolving adhesives (polychloroprene, natural rubber-based and synthetic rubber-based), water-based adhesives, synthetic adhesives (polyurethane), primers and activators. The adhesives produced by the Forestali Division for the upholstered furniture industry are marketed under the **Durabond brand**, while the remaining products of this division are sold under the **Industrie Chimiche Forestali brand**. As of the second half of 2021, Morel-branded toe and counter fabrics will also fall within the Forestry Division, and as of April 2023, Langè-branded fabrics will also fall within it.

Tessitura Langè acquisition

As of 3 April 2023, Tessitura Langè, a historic Made in Italy company for the finishing of high-end packaging fabrics and industrial textiles, equipped with state-of-the-art plants and first-class certifications, also became part of ICF. Langè is characterised by a strong focus on innovation and sustainability, demonstrated by the use of BCI ethically sourced cottons made with organic raw material guaranteed by GOTS certification and/or recycled with GRS certification, as well as by the use of chemical substances in the production processes that comply with the REACH protocol and the SVHC (Substances of Very High Concern) list.

The acquisition involved the entire industrial business, including the brand, industrial assets and customer portfolio; Langè's production and employees remained in the production plant in Robecchetto con Induno, in the province of Milan, which remained under the previous owners.

This operation has enabled ICF to integrate one of its main suppliers in the textile division, adding value to its products in terms of sustainability by being able to clearly and comprehensively trace the production chain. This acquisition also increased the Group's exposure in the high-end footwear, leather goods, clothing and packaging sectors.

The range of adhesives and fabrics of the Forestali Division includes a series of "continuous" articles, which are produced up to a minimum quantity (*made to stock*), and numerous tailor-made products, i.e. customised solutions able to meet specific customer requirements (*made to order*).

The **Adhesive Based Chemicals Division** (or simply "ABC") deals with the production of adhesives for the automotive, packaging and industrial sectors. The products of this division are sold under the **ABC brand** and include: synthetic polyurethane adhesives with and without solvent, polyurethane adhesives in water dispersion, nitrocellulose-based adhesives, nitrile and nitro-butyl rubber and cleaners. The production of the ABC Division, in line with the type of sectors served, is planned on a monthly basis.



The production of **adhesives** is the most chemical aspect of the plant in Marcallo con Casone and provides different methods of transformation according to the type of resin used. Adhesives can be produced by dissolution in solvent or water in special tanks under agitation, or by synthesis inside temperature controlled reactors.

In line with the production process, which is constantly supervised by the plant operators, **quality controls** are carried out in the plant's internal laboratories and consist of analyses aimed at checking the composition of the adhesive upstream, during and downstream of processing. Some of the parameters

analysed are dryness, viscosity, initial heat resistance and gas-chromatographic composition of solvents. The finished product is then filtered and packaged in tanks, drums or buckets of various sizes.

Fabrics consist of special articles used for covering or reinforcing footwear or leather goods. They are made in the fabric department through a series of processes that are not necessarily sequential but can follow a different order from time to time according to the required formulations. The fabric can be impregnated in an impregnation bath, "inseminated" in case of application of powdered or coextruded products. Some impregnated or coextruded fabrics can pass through a dedicated hot-melt application line. The impregnated fabric passes through a heated and ventilated area for drying and water removal; in other cases, the fabric passes through an oven to obtain the melting of the applied adhesive and then inside the calenders for cooling.

Morel products can really be distinguished from ICF fabrics in the drying phase which, instead of using the heat produced by the combustion of methane, uses the flow of steam inside the plant. This technology enhances the properties of the natural fibres with zero production waste, and gives the fabric a particular plasticity and malleability, features which are much appreciated by customers. Moreover, the powders are spread via a "4.0 custom" powder coating machine that allows a range of raw materials to be used that are generally impossible to mix with any other production system. Generally, the product obtained is in the form of coils. For the production of toe caps and counters, the fabrics obtained are then unwound and cut into 1 m by about 1.4 m sheets in order to be easily placed on the pallets used for shipping.

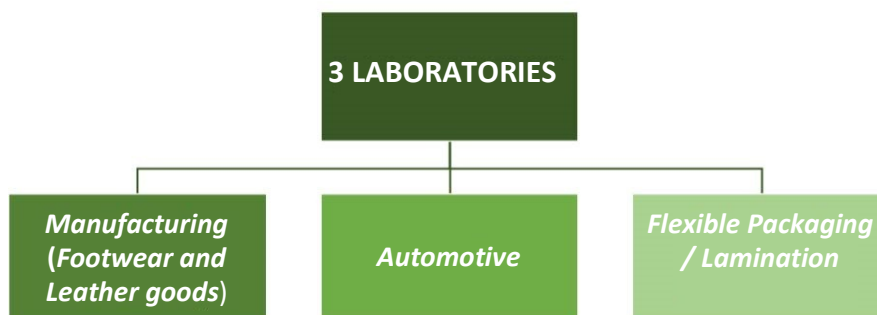
Langè products, on the other hand, are mainly destined for the footwear, leather goods and clothing sectors. Specifically, fabrics are produced both for the production of tips and counters, as well as linings and packaging for luxury products. The fabrics, in cotton or blends, are refined through a vertical production cycle that enables them to offer customers top-quality products made specifically according to their needs and requirements.

ICF is known for the high quality standards of its products thanks to the meticulous checks carried out on incoming raw materials, the strict controls of the production process and the analyses carried out on the finished products. Industrie Chimiche Forestali has always pursued a quality-conscious policy, obtaining **Quality Management System certification** according to **UNI EN ISO 9001** in 1997, which is periodically renewed. This certification will be extended to the Robecchetto con Induno site in 2024. As a confirmation of the constant commitment to safeguarding quality, in 2021 ICF also integrated the **VGM (Verified Gross Mass) certification according to the SOLAS International Convention**, concerning the shipment of containers by sea, and adopted (as early as December 2020) the *Container Weighing Management Operating Procedure*, which defines the criteria and operating methods for the proper management of container weighing of ICF's products.

Moreover, in 2019, ICF obtained **IATF 16949 certification** for the automotive products of the ABC Division, relating to the quality management system specific to the automotive industry. This standard is designed to be used in conjunction with ISO 9001 and contains additional requirements specific to the automotive industry with a view to continuous improvement, prevention of defects, reduction of variation and waste in the supply chain.

Constant attention is paid by the ICF to the numerous EU and international regulations that mandate a thorough examination of the changes introduced. The use of the software application for the drafting of Safety Data Sheets and labelling of chemical products is now well-established, as is the tool that allows, after entering databases, to provide by querying the regulatory compliance status of chemical products with customer compliance lists (for more details see section 3.2 *Health and Safety of Workers and Customers*) and in particular with the new requirements included in Annex VIII.

Industrie Chimiche Forestali's ability to check and guarantee the quality and performance of its products is also ensured by the three **laboratories** dedicated to **Research and Development (R&D)** and **Quality Control that ICF has set up**. In particular, the **Manufacturing laboratory (Footwear and Leather Goods)** is dedicated to the Forestali Division, while the ABC Division makes use of the **Automotive** and **Flexible Packaging/Lamination** laboratories.



The laboratories constitute a technological centre equipped with all the resources and tools required for research, development and pre- and after-sales technical support. Here, research and technical support merge into a single operational project that allows the company to develop and characterise products by creating **customised solutions for its customers**. ICF, in fact, complying with the requirements of the Industry 4.0 Plan, introduced by the 2017 Italian budget law, constantly invests in its laboratories in order to ensure a continuous renewal of its scientific instrumentation and to have the best technologies present on the market.

The laboratories also represent the point of reference for quality control, which interacts with all departments and ensures an ongoing increase in the quality standards of raw materials, production processes and finished products, leading to a continuous improvement in product quality and process efficiency, in accordance with ISO 9001:2015. All internal controls, from physical and analytical checks on incoming materials and finished products to performance tests during product use, are carried out in ICF's laboratories.

In addition to quality, Industrie Chimiche Forestali also pays great attention to the efficiency of its production processes and the technological innovation of its plants. In this respect, ICF is investing heavily in production optimisation by reducing not only downtime but also the waste of fabrics and solvents generated during production processes.

In order to assess the environmental impacts generated by its products, in 2019 ICF carried out an **LCA (Life Cycle Assessment)** study on the production of four categories of extruded and impregnated fabrics in the leather goods and footwear sector, in collaboration with the *Consiglio Nazionale delle Ricerche* (CNR_STIIMA, Italian Research Council). The study, which complies with ISO 14025 on Labelling and Type III environmental declarations, is supported by the European Community as the main method of calculating environmental effects. Specifically, the LCA analysis made it possible to analyse consumption and emissions over the ICF product's life cycle, from the extraction of raw materials to the production of the fabric and its storage before shipment to the customer. With regard to the transport of raw materials, suppliers were divided into geographical areas to assess the impacts according to the distance from the production site, while data relating to the plant, including incoming raw materials, required energy and waste generated, were used to design the production of fabrics. The impacts analysed (acidification, eutrophication, increased greenhouse effect, photochemical oxidation, stratospheric ozone depletion and water equivalent consumption) were thus compared to one linear metre of product, in order to be able to correctly interpret

them depending on the production capacity of the plant. ICF has planned to carry out a similar LCA study on the production of water-based adhesives in the future.

ICF decided to focus on the LCA of the products and the **EPD (Environmental Product Declaration)**⁷ to obtain not just a competitive advantage, but also support at eco-design level for the final product. The impact assessment actually allows for easy identification of the environmental aspects that can be addressed as early as the design stage to improve a product's carbon footprint. A study ended in March 2020 on toe caps and counters, representative of the manufacture of impregnated and extruded fabrics, revealed that the highest environmental impact is generated at the level of the materials used in the production process: in terms of impact on climate change, for example, the *Global Warming Potential* (GWP)⁸ associated with the raw material accounts for approximately 95%, the production phase for just over 4% and the use and end-of-life of the product for the remainder, while distribution is practically immaterial. This underlines how essential it is to receive an LCA study from all suppliers in order to more accurately weigh the percentages of the various raw materials in the production process for the purposes of assessing whether formulations can be modified in favour of those with a low environmental impact.

With the help of **CNR-STIIMA** (Italian Research Council) and on the basis of its own LCA study, in 2022 ICF introduced within the **Product Category Rule (PCR) "Fabrics"** specific standards for environmental studies on textiles and impregnates, according to ISO 14025 on Type III Environmental Labels and Declarations, in terms of calculation rules, construction scenarios and EPD contents. Specifically, the PCRs, used as a complement to the General Product Instructions (GPI), set out both the requirements for carrying out studies on the environmental performance of products and the standard to be followed to calculate these impacts with respect to a given physical sample, thus ensuring that different LCA analyses can be compared. **PCR 2022:04**, which ICF collaborated in drawing up, is now active and is used as a reference in the fashion industry, enabling companies to make reliable comparisons between different products in order to make decisions on choosing more sustainable materials, processes and products.

Thanks to the definition of a specific PCR, in July 2023 ICF obtained **EPD certification** for its extruded and impregnated fabrics, valid until December 2024, establishing a record within the footwear industry.

ECOVADIS

In 2022, Industrie Chimiche Forestali also participated in the corporate sustainability assessment through the ECOVADIS platform, which involved filling out a questionnaire on various topics in order to calculate performance indicators and determine an overall corporate sustainability score by awarding a badge. The ECOVADIS sustainability scorecard provides detailed information on risks in the areas of environment, labour and human rights, ethics and sustainable procurement.

ICF achieved the "Gold Medal" level of recognition, second only to the "Platinum Medal", and, with an overall score of 71/100, ranks within the top 5% of companies evaluated in the year. The certification obtained was valid until September 2023.

⁷ The **Environmental Product Declaration (EPD)** is a certified declaration that provides environmental data on the life cycle of products in accordance with the international standard ISO 14025.

⁸ The Global Warming Potential (GWP) is an indicator, expressed as the mass of equivalent CO₂, that assesses the emission of all gases contributing to the greenhouse effect together with CO₂ according to the characterisation factors of the IPCC. In the life cycle analysis, the GWP corresponds to the carbon footprint.

2.2 Careful selection of materials

The added value of ICF lies in its highly technical and high-performance products, which allow it to maintain a very high quality reputation on the market. To achieve and maintain this goal, Industrie Chimiche Forestali has always been careful in the choice of raw materials that will be used to make its products. In fact, ICF does not produce the raw materials required to manufacture its products but purchases and uses raw materials that become part of the proprietary formulations of its products.

ICF has had an **Environmental Management System** in place since 1998 in compliance with **UNI EN ISO 14001**, a certification that is periodically renewed and which defines how all phases of work are managed: from the purchase of raw materials, through production, to the delivery of the finished product to the customer.

ICF purchases its raw materials from new and traditional suppliers with high quality standards. Each year, suppliers are evaluated based on quality performance, including the presence of a Quality Management System in accordance with ISO 9000 and its possible certification, the definition of functions, controls and laboratories dedicated to quality control, and the management of anomalies and customer complaints. If any non-conformities are identified, ICF carries out audits at suppliers' premises. To date, the submitted questionnaire does not include specific aspects linked to social or environmental issues or performance.

In its dealing with suppliers of raw materials, ICF gives priority to providers from the European Union.⁹ The problems related to the availability of raw materials and rising energy prices, first as a consequence of the pandemic and then of European geopolitical instability, were somewhat reduced in the course of 2023.

The **raw materials** used by ICF include fabrics and non-woven fabrics (NWF), solvents, resins and polymers. The other **materials** purchased by ICF as **necessary for the production processes** but not part of the final product are additives and lubricants. These materials are stored both within ICF's facility and at an external warehouse leased during 2021 and operated throughout 2023. This warehouse will be vacated as of May 2024, following internal reorganisations.

Although many of the raw materials used are virgin materials, ICF has an ongoing commitment to **using regenerated and recycled materials**, particularly those intended for the footwear and leather goods industry:

- 100% of the cotton fabrics used are regenerated cotton;
- non-woven fabrics used by ICF are composed of 25% regenerated polyesters;
- 60% of extruded fabrics are produced using, among the various types of polymers, about 30% of recycled polymers;
- 15% of the latex used in formulations for the production of impregnated fabrics is 100% natural.

It should also be highlighted that, in 2021, ICF extended **GRS**¹⁰ certification to the entire range of fabrics produced (regenerated cotton fabrics, toe caps and extruded counters containing recycled polymers). Thus products made with over 20% recycled raw materials are certified with the GRS logo, confirming ICF's ongoing commitment to reducing its environmental impact and to an increasingly sustainable economy.

Morel brand cotton fabrics also meet specific sustainability requirements as they are GRS certified; in

⁹ 93.31% of the expenditure for raw materials went on local suppliers, where 'local' suppliers means those based in the European Union.

¹⁰ **GRS (Global Recycle Standard)** is an international certification promoted by Textile Exchange, one of the most important non-profit organisations promoting internationally responsible and sustainable development in the textile industry with the aim of encouraging the use of recycled materials.

addition, **FSC**¹¹ and **OK biobased**¹² were also certified in 2023. Specifically, some versions of the **Lumine line**, characterised by pure cotton fabrics impregnated with latex, have obtained GRS certification, as they are produced with a recycling rate of 21% and 22% respectively, while others have passed the biodegradability test, with percentages of over 90%.

The Langè brand fabrics are also made from a high percentage of recycled raw material and are therefore GRS-certified. They also feature **GOTS**¹³ and **BCI**¹⁴ certifications.

In 2022, ICF developed a new line of **environmentally sustainable textile products**, under the registered trademark **Ricicli**TM, which will be used in the production of elastic toe caps, reinforcements and stiffeners for luxury footwear. These products will be made from recycled powders derived from natural sources, thus enabling the reduction of chemical materials use and stimulating the circular economy through the reuse of waste materials. In particular, **Ricicli**TM products are composed by 68% of natural fibres, such as cotton and polyester, both GRS certified, and by 31% of recycled material. In 2023, this line was audited for **ReMade in Italy** certification, which verifies the recycled content and that the production processes are located in Italy. The certificate will be issued in the coming months of 2024.

Although they do not hold the **Standard 100 by OEKO-TEX9** certification, some textile product families for toe-puffs, counters and reinforcements comply with its guidelines to ensure the absence of substances and chemicals potentially harmful to human health.



¹¹ **FSC® (Forest Stewardship Council)** is a certification that guarantees the origin of the product labelled FSC® from a responsible forest and supply chain management. FSC® certification is based on ten rules applicable worldwide that cover the essential aspects of responsible forest management.

In particular, the **FSC Mix** label indicates that the wood or paper in the product comes from FSC® certified material, recycled material and/or controlled wood (not less than 70% certified and/or recycled materials).

¹² The **OK Biobased** label uses a star system to indicate the biobased content of a certified product based on the percentage of renewable raw materials determined.

¹³ **GOTS (Global Organic Textile Standard)** is a certification that ensures the use of natural fibres (such as cotton and linen) grown according to organic farming principles, evaluates the production of textiles on the basis of environmental and social criteria, and guarantees full traceability from the field to the finished product, through all stages of processing.

¹⁴ **BCI (Better Cotton Initiative)** is a certification created by the non-profit organisation of the same name with the aim of promoting a more sustainable and environmentally and socially conscious cultivation of cotton.

Attention to the materials used goes as far as the choice of **packaging for its products**, with the purchase of packaging made of regenerated material such as steel drums and tanks made of plastic, wood and steel parts. Furthermore, in full compliance with CONAI (Consorzio Nazionale Imballaggi) guidelines, ICF has adopted a double packaging system which ensures the complete recovery of the outer drum (equal to 5 kg of iron), which may be used up to 7-8 times, thus guaranteeing a 35-40 kg saving of iron on a single container. The internal element, equal to just 100 grams of polythene, is disposed of. This solution is applied to solvent-based adhesives, subject to the ADR transport standard, which imposes specifically approved packaging standards. As far as water-based adhesives are concerned, by applying the same principle, Industrie Chimiche Forestali uses an external element of recycled cardboard (Bag in Box) instead of iron.

During 2023, investments in **Industry 4.0** for the automation of production plants continued: the old milk canning plant (0.45 kg to 5.2 kg) of solvent-based adhesives was replaced with a new plant equipped with a state-of-the-art level of automation and on-line weight control on 100 per cent of the packaged milk. In addition, a palletising robot was installed, which eliminated the manual handling of products, thus improving the operating and ergonomic conditions of the employees. These installations have also brought advantages in terms of production efficiency and better production planning, as the plant is interconnected with the SAP 4HANA management system that ICF has equipped itself with.

March 2023 saw the completion of the transition to **SAP 4HANA**, a software that allows ICF to continue its **digital innovation** projects, improving and making business processes and their integrations more efficient. This software is based on a new 'in memory' database, which guarantees significantly higher speed and performance than traditional databases, and on SAP FIORI, which allows the development of mobile applications and a *web-oriented* user interface, thus realising fast and advanced statistics on different platforms. From January 2024, the use of this software was also extended to Langè.

Finally, a chamber distiller was also installed in 2023 for the recovery of the ethyl acetate wash used by the ABC division, and the revamping of the treatment plant for aqueous effluents from the washing activities of the ICF and Morel lines was started, with the introduction of control systems directly linked to the management system. The latter project, which will be grounded during 2024, will also include the installation of a sludge concentrator that will optimise production cycles and significantly reduce sludge disposal costs.

The total amount of materials used by ICF (input materials and packaging materials) in 2023 is 18,583 tonnes (slightly down from 19,272 tonnes in 2022), of which about 92% is raw materials. Due to the acquisition of the business unit of Tessitura Langè, which was previously one of the Group's suppliers, the quantities purchased by the ICF Division of woven and regenerated fabrics have decreased, as they are now produced in-house. Considering, however, also the purchases made for the production of Langè, these same items appear to have increased overall compared to previous years. As far as packaging materials are concerned, volumes decreased for all items.

Materials entering the production processes				
	Unit of measurement	2021	2022	2023
Raw materials	t	15,769	17,207	17,040
Fabrics	t	580	851	2,578
Regenerated fabrics	t	855	1,437	1,916
Non-woven fabrics (NWF)	t	2,530	2,988	2,300
Solvents	t	7,022	6,810	5,436
Resins	t	637	616	558
Polymers	t	3,914	4,253	3,993
Regenerated polymers	t	231	252	259
Materials related to processes	t	5	5	5
Additives	t	2	2	2
Lubricants	t	3	3	3
Total	t	15,774	17,212	17,045

Packaging materials				
	Unit of measurement	2021	2022	2023
Steel	t	1,093	1,255	853
Paper and cardboard	t	99	73	55
Wood	t	547	578	489
Plastic	t	178	154	141
Total	t	1,917	2,060	1,538

All ICF products in the footwear industry (adhesives, toe caps, counters, linings and stiffeners) comply with Commission Decision of 9 July 2009 on establishing the criteria for the award of the Community eco-label to footwear by reference to Regulation (EC) 66/2010 on the EU **Ecolabel**¹⁵. As required by European legislation, all ICF products do not contain the following substances: chromium VI, arsenic, cadmium, lead, free formaldehyde, pentachlorophenol and azo dyes. This allows shoe manufacturers to apply for the ecolabel for footwear provided that all other raw materials used comply with the Community standard.

For years ICF has been committed to the production of adhesives with reduced environmental impact, gradually moving from **solvent-based** adhesives to **water-based and solvent-free adhesives**. Industrie Chimiche Forestali identified in the latter the turning point for a real environmental commitment by challenging prejudices and working methods and technologies consolidated over time, developing new formulations of water-based and solvent-free adhesives to replace the traditional solvent-based ones. In addition to a reduced environmental impact and unchanged product performance, these adhesives also ensure the absence of risks in the handling of raw materials as well as in using the adhesive and in the use of the product by the end user.

In 2021, ICF also developed a new line of adhesives free of toluene, a solvent used widely in synthetic products. The development of new products was carried out internally by the R&D department, along with

¹⁵ **EU Ecolabel** is the European Union's ecolabel that distinguishes products and services that, while guaranteeing high performance standards, have a low environmental impact throughout their entire life cycle. Ecolabel is voluntary and subject to certification by an independent body (competent body).

the implementation of strict procedures and technical solutions aimed at promoting the utmost safety of industrial processes. During 2022, new formulations were developed and marketed in both the civil and industrial insulation and footwear sectors.

Another important initiative to reduce the hazardousness of products, carried out over the years by ICF, is the **replacement of toxic and reprotoxic substances** used in the formulations of some polyurethane adhesives, such as triethylamine and N-methyl-2-pyrrolidone.

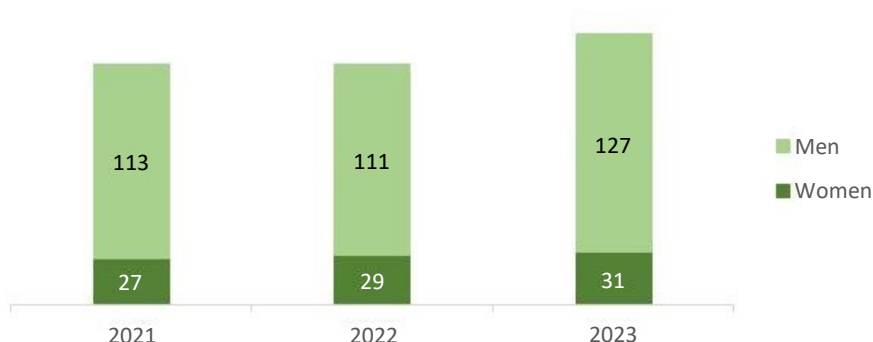
For the flexible packaging sector, in addition to replacing traditional solvent-based adhesives with water-based adhesives, in 2018 ICF began to change product formulations by introducing **raw materials from renewable sources** such as castor oil to replace polyesters of fossil origin. Thanks to the experience of the in-house R&D department, the dual-component adhesives produced by ICF intended for flexible packaging for the food & beverage sector now contain 30% raw materials of vegetable origin.

2.3 Our team

The invisible strength of Industrie Chimiche Forestali is not only represented by its products but is also based on the strong bond between the people, who work together and operate as a single team. Getting to know each other as individuals is what guarantees teamwork within ICF and it is what the employees do every day, pursuing objectives, launching challenges and competing in all markets with passion and determination. The hundred-year-old history of Industrie Chimiche Forestali is made possible by all the people who work and have worked at ICF, putting into practice its fundamental values of **reliability and trust**, which are as important externally as they are internally, among the people who make up ICF and between all of them and ICF itself.

As of 31 December 2023, Industrie Chimiche Forestali employed **158 people**, an increase over the previous year due to the acquisition of Langè and the transfer of its 25 employees to ICF. Of these employees, 150 are employed in Italy, divided between the Marcallo Con Casone site and the new Robecchetto con Induno site, and the remaining eight belong to the sales office in Mexico. Some 82% of the Italian workforce is male, in line with the type of sector in which ICF operates, while in the Mexican office there are four men and four women.

Total employees by gender



ICF is committed to ensuring a stable job for its team, offering mainly **open-ended contracts**, which in 2023 covered 98% of its employees. In particular, 147 of the 150 employees in Italy have open-ended contracts, while at the Mexican headquarters all 8 employees are employed under such a contract.

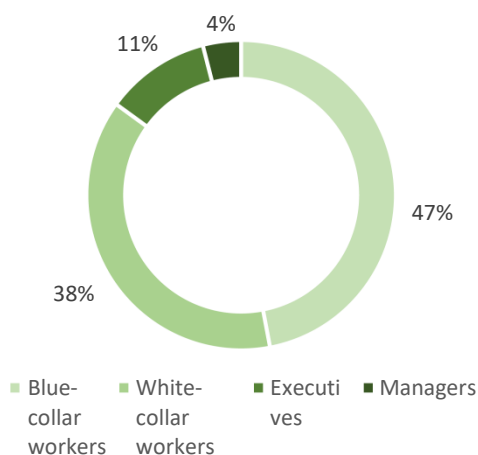
Employees by contract type, gender and geographical area		2021		2022		2023	
	Unit of measurement	Italy	Mexico	Italy	Mexico	Italy	Mexico
Permanent	no.	129	7	128	8	147	8
Women	no.	22	4	23	4	26	4
Men	no.	107	3	105	4	121	4
Fixed-term	no.	4	0	4	0	3	0
Women	no.	1	0	2	0	1	0
Men	no.	3	0	2	0	2	0
Total employees	no.	133	7	132	8	150	8

Moreover, ICF seeks to meet the personal needs of its employees by offering them, where applicable, the opportunity to choose part-time employment. In 2023, 3% of personnel were hired under this type of contract, while the remaining personnel were covered by full-time contracts. In addition, there are no employees who are not guaranteed a minimum or fixed number of working hours.

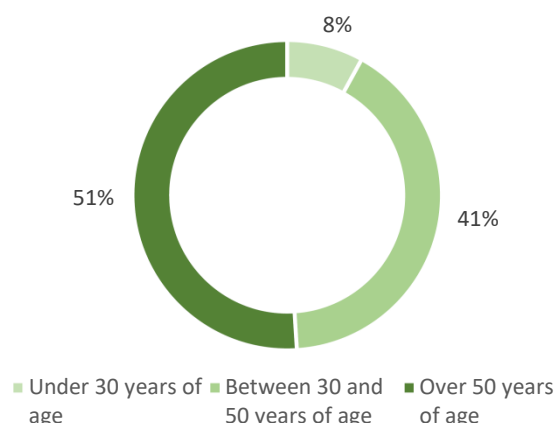
Employees by work type, gender and geographical area		2021		2022		2023	
	Unit of measurement	Italy	Mexico	Italy	Mexico	Italy	Mexico
Full-time	no.	130	7	129	7	146	7
Women	no.	21	4	23	3	25	3
Men	no.	109	3	106	4	121	4
Part-time	no.	3	0	3	1	4	1
Women	no.	2	0	2	1	2	1
Men	no.	1	0	1	0	2	0
Total employees	no.	133	7	132	8	150	8

In 2023, the employees of Industrie Chimiche Forestali consisted mainly of **blue-collar and white-collar** workers, 47 per cent and 38 per cent of the total respectively, while middle managers and executives accounted for a total of 15 per cent of the workforce. The blue-collar category consists almost exclusively of men, while white-collar workers are more evenly distributed between men and women. The majority of employees are in the over-30 age group, with 41% between 30 and 50 years old and 51% over 50.

Employees by professional category in 2023



Employees by age group in 2023



Employees by professional category and gender		2022		2023	
	Unit of measurement	Women	Men	Women	Men
Managers	no.	1	5	1	6
Executives	no.	3	14	3	14
White-collar workers	no.	24	31	26	34
Blue-collar workers	no.	1	61	1	73
Total employees	no.	29	111	31	127

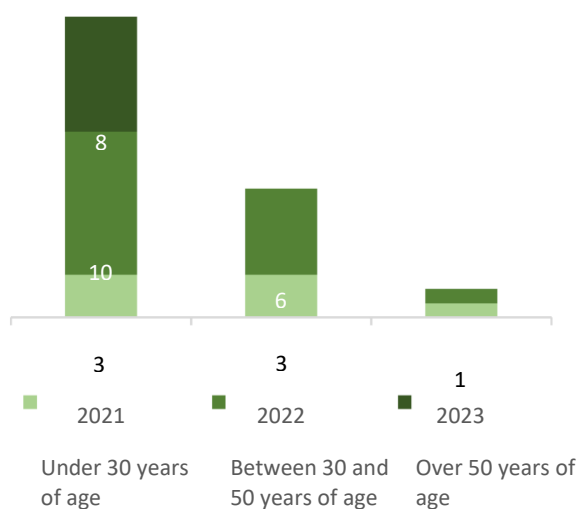
Employees by professional category and age		2022			2023		
	Unit of measurement	<30	30-50	>50	<30	30-50	>50
Managers	no.	0	0	6	0	0	7
Executives	no.	0	0	17	0	1	16
White-collar workers	no.	4	26	25	4	29	27
Blue-collar workers	no.	9	24	29	9	35	30
Total employees	no.	13	50	77	13	65	80

In 2023, there were a total of two recruitments in Italy involving a man and a woman, respectively aged under 30 and between 30 and 50. In 2023, the incoming staff turnover rate thus amounts to about 1%.

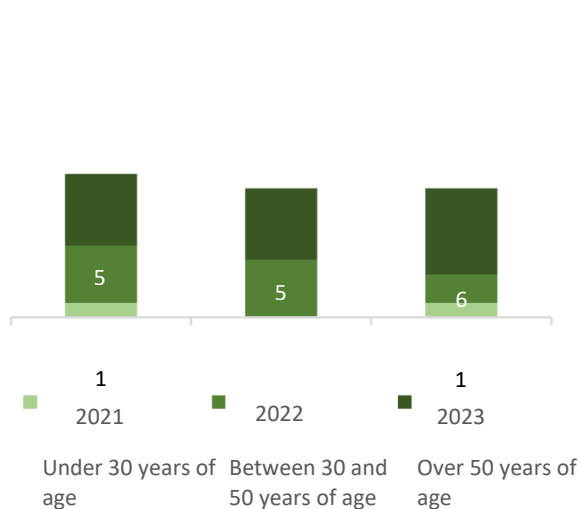
The leaving turnover rate remained at a consistently low level over the three-year period, stabilising at around 6% in 2023. Terminations occurred only in Italy, where the turnover rate is around 5% for men and 1% for women.

Turnover rates				
	Unit of measurement	2021	2022	2023
Joining turnover	%	15	6	1
Leaving turnover	%	7	6	6

New hires by age group



Leavers by age group



New hires by gender



Leavers by gender



Joining turnover		2021		2022		2023	
By age group	Unit of measurement	Italy	Mexico	Italy	Mexico	Italy	Mexico
Under 30 years of age	%	2	0	2	0	1	0
Between 30 and 50 years of age	%	8	0	4	13	1	0
Over 50 years of age	%	6	0	0	0	0	0
By gender							
Women	%	2	0	4	0	1	0
Men	%	14	0	2	13	1	0

Leaving turnover		2021		2022		2023	
By age group	Unit of measurement	Italy	Mexico	Italy	Mexico	Italy	Mexico
Under 30 years of age	%	1	0	0	0	1	0
Between 30 and 50 years of age	%	3	0	3	0	1	0
Over 50 years of age	%	4	0	4	0	4	0

By gender	Unit of measurement	Italy	Mexico	Italy	Mexico	Italy	Mexico
Women	%	1	0	2	0	1	0
Men	%	7	0	5	0	5	0

The search for young talents for the continuous development of products and technologies represents ICF's ongoing commitment to try not only to keep up with the times but, where possible, to be one step ahead. In particular, ICF is in the habit of encouraging young technicians from high schools and chemical universities to join its R&D laboratories through curricular and extra-curricular internships; in 2023, no internships were activated but two students were involved in a **school-to-work alternation** project within the laboratory.

In Italy, all employees are covered by **National Collective Labour Agreements** (CCNL), while in Mexico the employment relationship is regulated by Mexican law. Managers at the Italian headquarters are covered by the National Collective Labour Agreement for managers of industrial companies while the other employees are covered by second-level bargaining in addition to the National Collective Labour Agreement of the chemical industry. The minimum number of weeks of notice, generally communicated to Italian employees and their representatives prior to significant operational changes that could have a major impact on employees, is specified in the CCNLs. Mexican legislation, however, does not have a minimum period of notice.

As stipulated in the **second-level bargaining** agreement, which was renewed in 2023 and extended to Langè employees as well, a participation bonus is paid annually to ICF employees linked not only to the achievement of company profitability targets, but also in proportion to the score obtained during the year on quality and safety issues. The former takes into account, for the ICF and Langè Divisions, the incidence on turnover of the costs of complaints, returns and discounts, while for the ABC Division it takes into account the percentage of non-standard production in relation to the total. The second, on the other hand, is based on the results of the ten inspection visits carried out in the company areas, the situation of accidents at work, spills and participation in safety information and training initiatives. In 2023, **participation bonus** was paid to 126 employees, of whom 15 chose to convert it into welfare while the remainder received it in their pay slips.

In addition, with the renewal of the second-level contract, an increase to € 9 in the value of daily meal vouchers paid to employees was established, effective from 1 January 2024. From 1 January 2025, vouchers will be further increased to € 10.

ICF believes that the indicators to be monitored to ensure the competitiveness and development of Industrie Chimiche Forestali are also to be found in the quality of production processes, products and services and the safety of workers, as well as the protection of the environment, community and region. An improvement in these indicators requires constant adaptation of work procedures but above all effective information and training of workers and, on the part of the latter, strict compliance with company procedures.

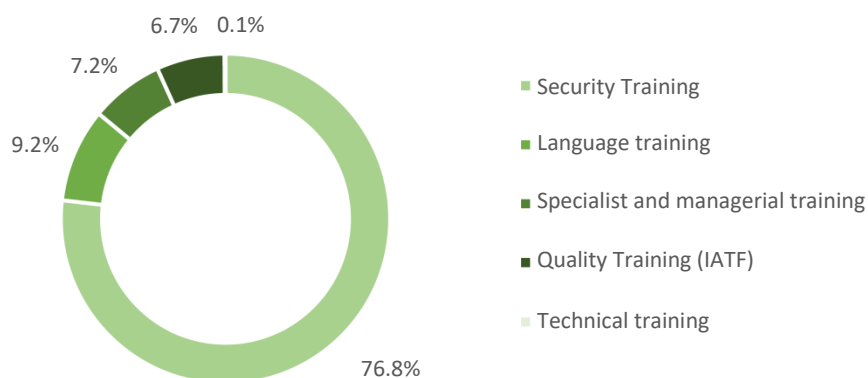
The **training** of all personnel is of fundamental importance for ICF to develop the culture and in-house technical skills. In 2023, 1,677 training hours were delivered, or an average of around 11 hours per employee. With reference to the annual training plan, training hours in 2023 remained in line with 2022 and a share of *e-learning* courses was maintained.

Average hours of training per year per employee				
By gender	Unit of measurement	2021	2022	2023
Women	hours/employees	5.4	12.0	10.8
Men	hours/employees	7.9	12.2	10.6
By professional category	Unit of measurement	2021	2022	2023
Managers	hours/employees	1.8	2.3	2.5
Executives	hours/employees	2.1	9.6	13.1
White-collar workers	hours/employees	5.5	11.1	11.3
Blue-collar workers	hours/employees	11.1	14.6	10.2
Total	hours/employees	7.4	12.1	10.6

The importance attached by ICF to training is also demonstrated by the diversified training offered to its employees in order to give them the opportunity to realise their full potential, encompassing quality, occupational health and safety and the environment, the acquisition and in-depth study of work knowledge or techniques to ensure that they possess the technical and professional requirements to carry out the assigned tasks, and the professional and personal growth of employees.

In particular, in 2023, 77% of the training hours provided were related to occupational safety. Furthermore, as ICF is a company at risk of a major accident, personnel carrying out activities at risk or with significant potential impacts on the environment must have acquired the necessary skill not only through information and education, but also through training activities. The other types of courses delivered in 2023 concern specialised and managerial training, language and quality training related to IATF 16949 certification.

Training in 2023



Finally, newly-recruited personnel, including those on temporary contracts and workers in cooperatives who carry out portage activities for a limited number of hours/days, are provided with a training course to ensure rapid and efficient integration. This course provides information about ICF's structure and products, the organisation of the production plant as well as policies, manuals, procedures and instructions on quality, the environment and occupational health and safety.

3. Attention to the environment and safety



Third revision of the Home-Work Shift Plan
Updating the Quality, Environment and Health and Safety Policy



101 tonnes of atmospheric CO₂ emissions avoided through self-generation via the photovoltaic system

-11% of water discharges at the production site in Marcallo con Casone, compared to 2022

52% of waste for recycling, recovery or re-use



4 is the recordable accident frequency index, one third of the 2022 value

3.1 Environmental Protection¹⁶

The strong sense of responsibility for protecting the environment guided the activities of Industrie Chimiche Forestali from the outset, with a view to continuously improving environmental performance and reducing impacts, such as the consumption of raw materials and water resources, waste production, water discharges, the emission of pollutants and energy consumption.

ICF implemented its environmental commitment in 1998 by joining the Federchimica "**Responsible Care**"¹⁷ project, a voluntary international programme that promotes the Sustainable Development of the Chemical Industry in accordance with values and behaviour aimed at protecting the environment as well as occupational health and safety. In 2023, for the 25th consecutive year, ICF has decided to confirm its participation in the programme.

Also in 1998, ICF defined the **Environmental Policy** of the plant in Marcallo con Casone, which represented the starting point and reference for the identification of environmental objectives and improvement programmes. The Environmental Policy has been updated over the years and became integrated in 2020, with the issuing of the **Quality, Environment and Health and Safety Policy**. Its update in December 2023 emphasised the importance of controlling significant environmental impacts such as emissions, waste, water discharges, energy consumption, noise, possible fires, use of hazardous substances, consumption of raw materials, and end-of-life of products, in order to minimise their effects on the environment. This Policy, in addition to being published on the company's website, is disseminated to all employees through specific training and education meetings and shared with public control bodies and external companies operating on the site.

In the same year (1998), Industrie Chimiche Forestali implemented an **Environmental Management System** in accordance with UNI EN ISO 14001, with the aim of ensuring that the Environmental Policy, now

¹⁶ The reporting scope of environmental aspects and indicators does not include data from Forestali de Mexico S.A. de C.V.

¹⁷ The **Responsible Care** voluntary programme was established in 1984 in Canada by the Canadian Chemical Producer Association (CCPA) and was launched in Europe in 1998 by the European Chemical Industry Council (CEFIC). Since 1992, Federchimica has managed the Programme in Italy.

integrated, is applied, the improvement objectives are updated and the environmental programmes are defined and developed. This certification will be extended to the Robecchetto con Induno site in 2025.

With the desire to enhance and spread more and more the commitment to environmental issues, in 2000 Industrie Chimiche Forestali voluntarily joined the Community Regulation for the Eco Management and Audit Scheme (**EMAS Regulation**¹⁸). As required by the EMAS Regulation, ICF publishes annually the Environmental Declaration of the plant in Marcallo con Casone in which its environmental performance is described, along with the set environmental objectives, improvement programmes and the results achieved. The EMAS certification has also been renewed in 2023.

Moreover, ICF pays great attention to compliance with the environmental regulations to which its activities are subject. In particular, the Marcallo con Casone production plant is one of the companies at risk of a major accident as envisaged by the Seveso III Directive and ¹⁹has a Safety Management System for the prevention of major accident hazards (SGS-PIR) that complies with the provisions of Italian Legislative Decree 105/2015.

In 2021, the two separate Integrated Environmental Authorisations (IEA)²⁰ of the two divisions (ICF and ABC) were combined and renewed, including Morel. The production plant in Robecchetto con Induno, on the other hand, only has a Managerial Permit issued by the Milan Metropolitan City Council for atmospheric emissions, a document which was transferred to ICF following the acquisition of Tessitura Langè.

In addition, during the pre-acquisition phase, ICF performed a complex environmental and safety due diligence on the condition of the equipment and machinery present in Robecchetto con Induno, which revealed a potential risk related to the presence of asbestos items. This involved the implementation of various activities to ensure site safety, including: the appointment of an asbestos manager, the monitoring of airborne fibres within the buildings, a risk assessment of asbestos exposure, the outcome of which confirmed the need to proceed with the remediation of structures within 12 months, the definition of an annual monitoring plan and the scheduling of containment activities.

In relation to the provisions of Legislative Decree No. 34 of 19 May 2020, on the other hand, in 2021 ICF appointed a Mobility Manager and drew up its **Home-Work Commute Plan**, the third revision of which, carried out in 2023 after the appointment of the new Mobility Manager, analyses the commitments made the previous year and the results achieved. The third revision also included the new production site called “Tessitura Langè”, whose improvement plan will be defined in 2024. Specifically, through a questionnaire distributed to employees, the proposals that emerged in previous years were reconfirmed, along with the need to extend the system certifications of the “Tessitura Langè” production site. Among the actions identified, there is also the establishment of a bus stop near the Marcallo con Casone plant and the extension of the cycle path in Via Kennedy, both projects for which responses are awaited from the public transport company and the municipality, respectively.

¹⁸ The Community Regulation for the Eco Management and Audit Scheme (**EMAS Regulation**) is a tool created by the European Community which organisations (companies, public bodies, etc.) can join voluntarily to assess and improve environmental performance and provide stakeholders with information on the environmental management of their activities.

¹⁹ Directive 2012/18/EU, also known as **Seveso III Directive** and implemented in Italy by Legislative Decree 105 of 26 June 2015, is the EU regulations on the control of major-accident hazards involving dangerous substances.

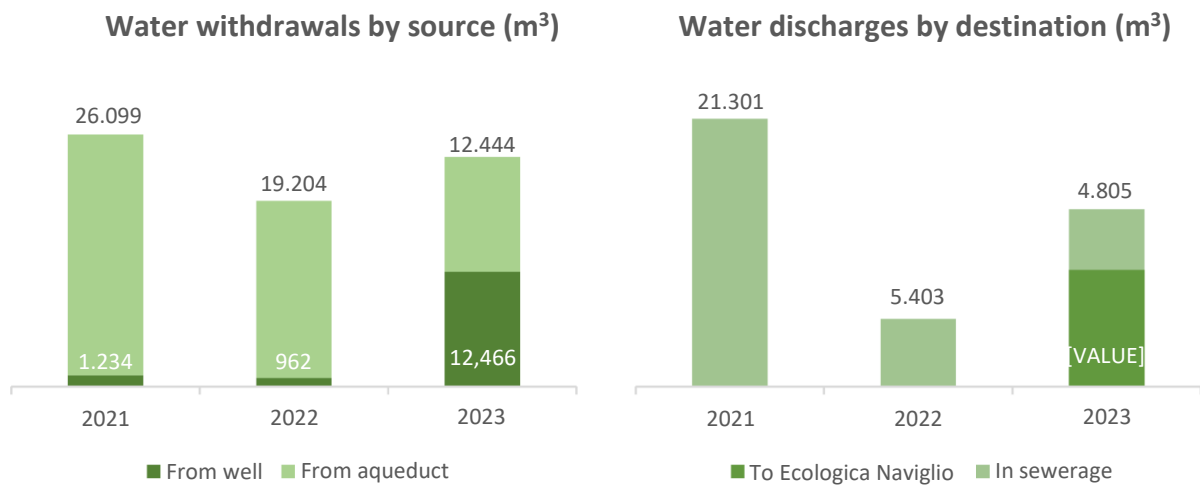
²⁰ The **Integrated Environmental Authorisation** (IEA) is a measure that authorises the operation of a plant under certain conditions, guaranteeing compliance with IPPC (Integrated Pollution Prevention and Control) requirements, i.e. Directive 96/61/EC implemented in Italy by Legislative Decree 152/06 as amended and supplemented.

In the three-year reporting period 2021-2023, no significant financial penalties (i.e. € 10,000) were received by ICF for non-compliance with laws and regulations. In 2021, following an inspection by the Metropolitan City of Milan, which found excess concentrations of iron and ammoniacal nitrogen in water discharges, IF replaced the manhole covers of some wells built in cast iron and banned the use of ammonia-based cleaning products, reducing the concentrations of the two parameters and thus complying with the limits set by the IEA.

3.1.1 Water withdrawal and discharge

Some of the processes carried out at the Marcallo con Casone production facilities, in particular the production of water-based adhesives and the preparation of aqueous dispersions of dressings, and at Robecchetto con Induno, including impregnation, bleaching, dyeing and washing, require the use of water. The supplied water is also used for industrial purposes such as washing and heat exchange (cooling of equipment). The remaining fraction of water consumed by ICF is used for civil purposes (domestic hot water, irrigation and fire-fighting).

The water supply of Industrie Chimiche Forestali is equally distributed between wells and the municipal waterworks. The percentage of supply from the latter increases to 93% (95% in 2022) if only the Marcallo con Casone site is considered. The total amount of water withdrawn²¹ in 2023 is approximately 25 thousand m³, an increase of 24% compared to 2022, following the inclusion of data from Tessitura Langè. Withdrawals in 2021 dropped by 26% in 2022, due to improved production management and a leak affecting the groundwater network, which was later identified.



The water coming out of ICF's production processes, i.e. from the washing operations of the plants, is treated and reused on site where technically possible. In particular, the washing water of the plants is initially conveyed to a primary treatment plant and then treated by reverse osmosis before being stored in special tanks and reused again for washing the plants. In early 2024, the existing sludge treatment plant was dismantled and replaced with a new one, with the aim of improving the wastewater treatment process and its recovery, so as to decrease the percentage of waste sludge.

²¹ All water withdrawn by Industrie Chimiche Forestali is fresh water ($\leq 1,000$ mg/l total dissolved solids) and does not come from water stressed areas.

The wastewater of ICF and Langè thus consists of: water used for cooling the plants and for the various production stages, sanitary water, water from washing the yards and first and second rainwater. Wastewater is monitored for the following parameters: pH, total suspended solids, COD, BOD⁵, sulphates, chlorides, and total hydrocarbons.

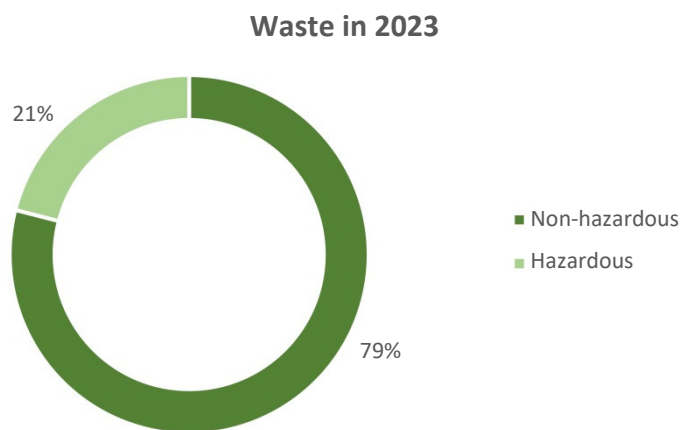
In 2023, the volume of water discharged²² by ICF was 14.1 thousand m³, a threefold increase compared to 2022. However, discharges from Marcallo con Casone decreased by 11% compared to 2022, confirming the downward trend compared to 2021. The increase in total volume is therefore due to the acquisition of the new Langè site, whose effluents are conveyed to Ecologica Naviglio S.p.A., close to the plant.

Ecologica Naviglio

This platform was founded in the 1970s by a consortium of companies, mainly tanneries and dyers in the Robecchetto area, with the aim of being able to convey their waste water and industrial waste from their operations to a purification plant. The consortium companies connect directly to a dedicated and private sewer, with a total length of approximately 6,900 metres of pipeline, for chemical-physical and biological treatment according to the supply and purification contract. Ecologica Naviglio is ISO 9001, ISO 14001, ISO 45001, EMAS certified and has an EIA authorisation and an Organisational Model 231.

3.1.2 Waste

In 2023, waste produced by Industrie Chimiche Forestali amounted to 1,602 metric tonnes, 79% of which was non-hazardous waste and the remaining 21% hazardous waste, and included mainly organic solvents, obsolete or non-compliant adhesives, composite materials, and packaging contaminated with hazardous substances. The waste produced by ICF also includes mixed packaging, plastic packaging, wooden pallets and drums.



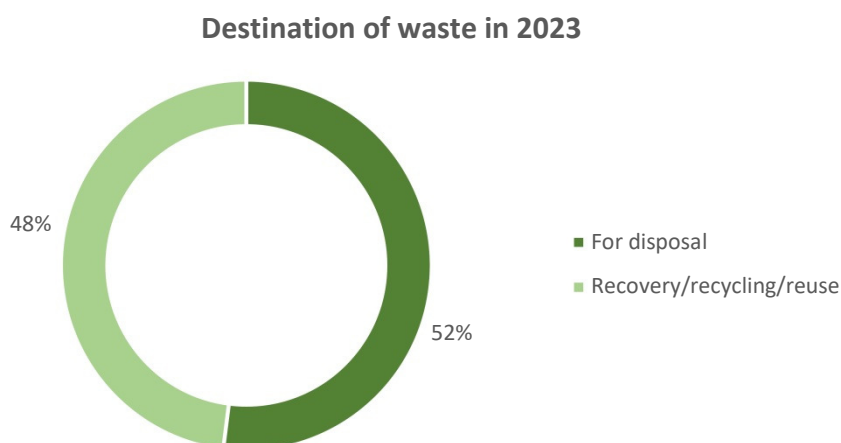
The trend for the three-year period 2021-2023 shows a slight decrease in the amount of waste produced in 2022 compared to 2021, when there was a recovery in industrial production that had declined during the Covid-19 pandemic; while the amount of waste produced in 2023 is slightly up compared to 2022 (+1%), despite the acquisition of Tessitura Langè. This is due to a decrease in the amount of waste produced at the

²² 34% of the water discharged by Forest Chemical Industries has a total dissolved solids content greater than 1,000 mg/l, while 66% is fresh water with a total dissolved solids content less than or equal to 1,000 mg/l.

Marcallo con Casone site, especially in relation to packaging and other materials, which are intended for recycling, reuse and recovery.

Waste produced		2021			2022			2023		
	Unit of measurement	Not for disposal	For disposal	Total	Not for disposal	For disposal	Total	Not for disposal	For disposal	Total
Chemicals and textiles	Tonne	363	580	943	385	637	1,022	337	762	1,099
Packaging	Tonne	428	16	444	419	14	433	364	13	377
Other	Tonne	149	104	253	58	69	127	70	56	126
Total	Tonne	940	700	1,640	862	720	1,582	771	831	1,602

There are some storage areas within the plants. The stock of waste is constantly monitored via loading and unloading registers where the estimated or weighed quantities are reported. All waste, even in small quantities, is disposed of externally at least once a year by specialist third parties who contribute to the correct management of materials.



Specifically, only 30% of the hazardous waste is sent for disposal while, for non-hazardous waste, the figure rises to 58%. Used solvents, classified as hazardous waste as they derive from the washing of the reactors, are transferred to an external company which, through the distillation process, recovers part of the solvent. The process generates residues that are subsequently disposed of, while the solvent recovered may be used in other processes.

Waste not sent for disposal ²³		2021		2022		2023	
	Unit of measurement	Hazardous	Non-hazardous	Hazardous	Non-hazardous	Hazardous	Non-hazardous
Preparation for reuse	Tonne	161	0	122	0	119	530
Recycling	Tonne	136	114	130	61	122	0
Other recovery operations	Tonne	6	523	8	541	0	0
Total	Tonne	303	637	260	602	241	530

Waste sent for disposal ²⁴		2021		2022		2023	
	Unit of measurement	Hazardous	Non-hazardous	Hazardous	Non-hazardous	Hazardous	Non-hazardous
Incineration (with energy recovery)	Tonne	0	0	0	0	0	0
Incineration (without energy recovery)	Tonne	0	0	0	0	0	0
Delivery to landfill	Tonne	0	0	0	0	0	0
Other disposal operations	Tonne	107	593	93	627	101	730
Total	Tonne	107	593	93	627	101	730

A campaign for the recovery and recycling of paper, cardboard and plastic, which would otherwise be sent for disposal, has been in place since 2020 to minimise the quantity of waste disposed of. Furthermore, returnable drums and tanks are used for the transport of adhesives, enabling considerable savings.

Specifically, please note that between the end of 2019 and the beginning of 2020, ICF installed an accumulator (powder spreader type) in the final part of the RAM, which avoids the slowdown of the fabric production line in the sampling phase and/or truck change. The benefits of the project include a significant reduction in waste and second-grade materials, as well as an increase in production capacity, obtained by eliminating production line slowdowns.

Cigarette butt collection

Lastly, during 2021, Industrie Chimiche Forestali signed an agreement with a cooperative for the collection of cigarette butts. The initiative, renewed in 2023 and soon to be extended to the Langè site, makes it possible not only to reduce the amount dispersed in the environment, but also to recover cellulose acetate destined for the luxury market. During the year, 11 kg of cigarette butts, equivalent to almost 37,000 cigarettes, were recovered and, through a purification and recycling process, more than 5 kg of plastic material was produced that can be used in various sectors. Through an LCA, the co-operative estimated that it avoided 26.53 kg of CO₂ equivalent.

²³ Waste is managed at sites external to ICF.

²⁴ Waste is managed at sites external to ICF.

3.1.3 Emissions of pollutants

The emissions of ICF consist mainly of process emissions and, to a lesser extent, emissions due to the suction points of the laboratory hoods, the air exchange in the production rooms and the heating systems.

As prescribed in the EIA for the Marcallo con Casone production site, all process emission points are monitored and sampled periodically according to predefined programmes²⁵. The results of the emission analyses, which were made available to the monitoring authority, were always below the legal limits.

Air pollutant emissions from the ICF plant consist mainly of VOC emissions (69% of the total in 2023), corresponding to total process emissions from the adhesives production plants of both ICF divisions and the Rameuse plant in use at Langè. The remaining part of the emissions consists of NO_x and CO, emitted by the post-combustion plant at the ICF Division's solvent adhesives production department and by the two natural gas-fired boilers for steam production at the Robecchetto con Induno site.

In 2022, ICF acquired a new certification for a water-based adhesive used in insulation, achieving class A+ for legal requirements regarding VOC emissions and CMR regulation. In particular, for the samples used and tested in air chambers, the recorded VOC values were far below the minimum legal requirements.

Emissions of pollutants				
	Unit of measurement	2021	2022	2023
CO	Kg	6.6	6.6	351.1
NO _x	Kg	33.2	17.8	834.8
VOC	Kg	2,500.0	2,400.0	2,607,5

ICF is equipped to handle emergency situations inside and outside the plant, such as chemical spills, blocking internal and yard extinguishing water and preventing it from flowing into the sewer and collecting spilled products with special absorbent and filtering materials. In 2023, there were 3 spills of non-hazardous chemicals, considered insignificant in relation to the type of materials involved and the quantities leaked, totalling 163 litres. In 2022, there had been one spill of non-hazardous chemicals (245 litres) that did not cause any environmental damage, while in 2021, there had been two spills of material within the departments (150 litres). The increase in the number of spillage reports compared to the past, despite smaller overall quantities, is linked to the introduction of a reward reporting system that incentivises employees to report these events even when they are minor. These episodes are regularly managed in accordance with internal procedures, keeping spills to a minimum and implementing a series of both procedural and engineering plant-based actions to prevent them from happening again.

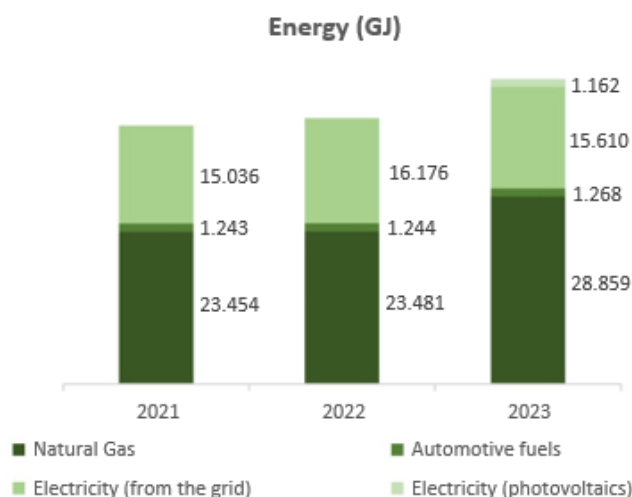
3.1.4 Energy consumption and greenhouse gas emissions

ICF's energy consumption, which in 2023 amounted to 46,899 GJ, is mainly due to the consumption of natural gas, of about 62%, and electricity, of about 35%. Natural gas is used to feed the burners of the impregnator oven, for the steam production of the Morel impregnator, for the generation of hot water needed in the production of the ABC Division, for the afterburner used for the abatement of emissions in the production of solvent adhesives of the ICF Division, and to feed the steam boilers and RAM of the Robecchetto con Induno site. The remaining portion of the consumption is for heating the working environment. Electricity, mostly purchased from the grid and partly self-generated, is used to power production processes, mainly for the production of tips and counters in the fabric department, and for

²⁵ The data relating to the emissions of pollutants into the atmosphere was estimated based on annual samples, since they were not included in the continuous IEA sampling of these pollutants. Consequently, the overall trend in emissions over the three-year period is subject to potentially high variability, due to which no assessment is provided.

room lighting, which consists entirely of LED lights. The 15% increase in energy consumption 2022 can be attributed to the acquisition of Langè, as ICF's consumption has decreased over the past year.

The remaining part of energy consumption (3%) is related to automotive fuels and, in particular, to the diesel consumption of the company car fleet and, as of 2023, of the truck and van acquired by Tessitura Langè, and, to a lesser extent, to petrol consumption related to the company van. The total fuel consumption figure remains in line with the 2022 results, with a slight increase in diesel consumption and a decrease in petrol consumption. Charging stations for electric vehicles were also installed during the year.



In March 2023, the **photovoltaic system** installed on the roofs of the Marcallo con Casone plant went into operation. The system, which employs 777 crystalline silicon photovoltaic modules with a peak power of 460 kWp, produced around 352,000 kWh of energy during the year, 92% of which was consumed internally, with the remainder sold to the grid. By 2023, self-production avoided the emission of about 101 tonnes of CO₂ into the atmosphere.

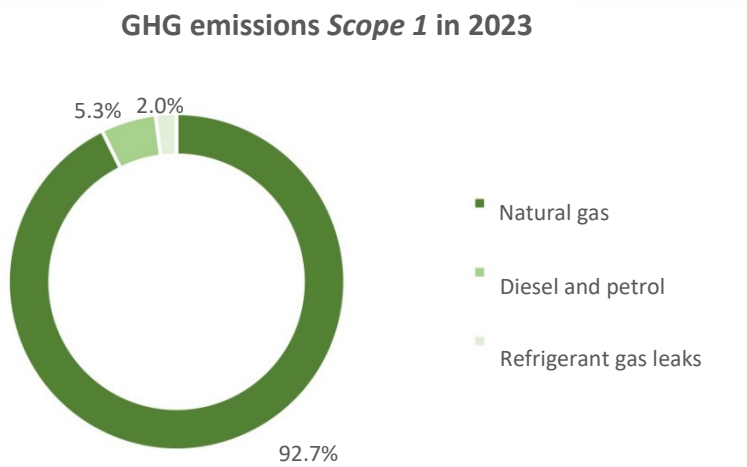
During 2022, several actions were carried out to improve energy efficiency, first and foremost the widespread installation of the **Dinapsio** system for continuous monitoring of energy consumption on almost all facilities. The adoption of this digital platform, developed on cloud technology, allows the precise measurement of consumption and the evaluation of possible plant improvement interventions aimed at containing consumption and optimising production lines. Real-time readers, in fact, make it possible to identify waste, optimising energy demand and production planning in relation to time slots, but also to make the most of resources and installations, ensuring, for example, that the photovoltaic system is always at peak efficiency or by reporting any faults in a timely manner. In 2023, the installation of the Dinapsio system also started at the Robecchetto con Induno site. In addition, a **new boiler**, which allows recovery of some of the dispersed heat, and **new evaporative coolers** were installed during 2022, which improve thermal comfort in the work rooms with minimal energy consumption. These systems do not involve the use of refrigerant gases, as they are based on warm air passing through water-wet cellulose panels, which give up some of the heat as they cool.

Finally, the innovative **Plate Chiller** system for cooling the machinery was introduced, which centralises the production of chilled water for the entire plant, significantly increasing efficiency and reducing the environmental impact of production. Specifically, a saving of 700 kWh per day and a reduction of over 100 tonnes of CO₂ per year has been estimated. The system, consisting of a chilled water tank and stainless steel plates, allows the optimisation of the use of the compressors that produce cold water and the

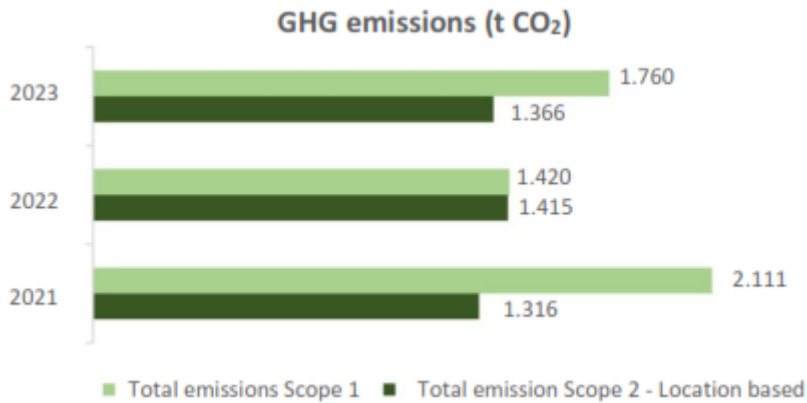
elimination of both the recirculation pumps, with consequent energy savings, and the existing heat exchangers.

These energy efficiency activities, which are essential from an environmental sustainability point of view, also allow the company to reduce energy costs, which have been particularly critical over the past years.

Energy consumption includes greenhouse gas emissions (hereinafter GHG), both Scope 1, or direct emissions, i.e. emissions from sources owned by or under the direct control of ICF and Scope 2, or indirect emissions, due to the consumption of energy purchased by ICF. In 2023, Scope 1 emissions of Industrie Chimiche Forestali S.p.A. amounted to 1,760 t CO₂, 92,7% of which was due to natural gas consumption, 5,3% to fuel consumption (diesel oil and petrol) for the company fleet and 2% to refrigerant gas leaks from air conditioning systems. *Scope 1* emissions increased by 24% compared to 2022, as a result of increased consumption due to the acquisition of Tessitura Langè.



ICF's *Scope 2* emissions, on the other hand, are entirely related to the consumption of electricity purchased from the grid and are therefore slightly decreasing compared to 2022 due to the installation of the photovoltaic system. In 2023, Scope 2 emissions were 1,366 t CO₂, calculated using the Location-based²⁶, while with the Market-based²⁷ approach they are higher and equal to 1,982 t CO₂, as Industrie Chimiche Forestali does not currently purchase electricity with guarantee of origin (GO) certificates.



²⁶ The **Location-based** approach involves the use of national average emission factors related to the specific national energy mix for electricity production.

²⁷ The Market-based approach takes into account any certificates purchased by the Company attesting to the supply of electricity from renewable sources, and where they are not present, envisages the application of emission factors associated with the production of energy from thermoelectric plants, excluding renewables.

3.2 The health and safety of workers and customers

Health and safety in the chemical industry represent a "key" value: they are found in processes and products, as well as being of fundamental importance for people and the environment. Ensuring a safe workplace for all its employees and the surrounding area has always been a goal that ICF has pursued over the years in order to ensure the prevention and control of risks related to its activities and its products and processes.

Since 1998, Industrie Chimiche Forestali has been a member of Federchimica's voluntary **Responsible Care** programme, which aims to develop a constant focus on continuous improvement not only in environmental protection but also in the area of occupational health and safety.

ICF's commitment is also reflected in the maintenance of the **Safety Management System**, for which it has been certified for the production plant in Marcallo con Casone in compliance with the OHSAS 18001 standard since 2009. In 2020, despite the complicated macroeconomic scenario, ICF worked to achieve the transition to **UNI EN ISO 45001:2018**, undergoing an intensive audit, which enabled it to successfully obtain the relevant certification at the beginning of 2021. The management system has a two-fold value both internally and externally: internally, it represents a fundamental guide to the actions and behaviour of Industrie Chimiche Forestali personnel; externally, it allows it to maintain the trust of citizens, neighbouring companies, public bodies responsible for safeguarding safety, customers and suppliers, ensuring a positive and lasting relationship of collaboration. The 45001 certification will be extended to the Robecchetto con Induno site in 2025.

For all matters relating to the protection of occupational health and safety, Industrie Chimiche Forestali complies with the provisions of Italian regulations, and in particular with the requirements of **Italian Legislative Decree 81/2008**. Consequently, ICF has drawn up a **Risk Assessment Document (RAD)** in which it has defined specific procedures for the analysis and classification of risks and has identified suitable prevention and protection measures to limit and manage them, through the introduction of innovative technological solutions and the reorganisation and updating of operating procedures. The RAD is a continuously revised document; in fact, the most recent version was approved in late 2022, although some specific assessments such as: ionising radiation risk, electrical risk, mechanical risk, fire risk and noise risk have since been updated.

Falling within the scope of application of Italian Legislative Decree 105/2015, therefore falling within the list of "companies at risk of a major accident" (see paragraph 3.1 *The Protection of the Environment*), ICF has drawn up the **"Major Accident Prevention Policy Document"** in which, in compliance with the safety of its employees, the surrounding environment, the population and neighbouring activities, it describes how ICF identifies and pursues the objectives to prevent the occurrence of major accidents and mitigate any harmful effects.

With a view to risk prevention, and with the aim of raising the awareness of all workers, Industrie Chimiche Forestali encourages all ICF personnel to **report any hazardous situations** by filling in the appropriate forms. The factory supervisor is then responsible for identifying the causes of such situations and the corrective actions necessary to prevent them from occurring again. Everything is then recorded and organised by the Health and Safety Officer (HSO). This practice contributes to the calculation of the **safety indicators** used to obtain the **profit-sharing bonus** provided for by ICF's second-level bargaining. These indicators are calculated on the basis of the scores obtained in the year during ten inspections carried out by a special commission in previously identified company areas and consider accidents at work, any spills into the soil and subsoil and the participation of workers in training and information initiatives on safety and the environment. As of July 2023, this system was also extended to the Robecchetto con Induno site.

In terms of health, an **occupational health specialist** has been appointed who, together with the HSO, draws up the annual **health plan** in order to monitor workers' health through a **protocol of health assessments**, also in relation to exposure to the risks identified in the RAD. The 2023 update of the health plan provided for the discontinuation of monitoring of the urinary metabolite 2,5-hexanedione, thus eliminating the relevant test that was foreseen for workers exposed to chemical risks, due to its continued impossibility to be dosed in all samples collected between 2019 and 2022.

For **Tessitura Langè** in 2023, the safety managers were defined, assigning the same employer, Prevention and Protection Service Manager and occupational physician as in the Marcallo con Casone operating site, while the person already appointed in the role of Workers' Safety Representative was confirmed. The RAD for the plant remained the one approved in 2022, although some specific assessments were updated, including the vibration and noise risk, and new assessments were carried out regarding the asbestos risk and the Artificial Glass Fibres (AGF) risk. The health surveillance protocol was integrated to make it uniform with that adopted for the employees of the Marcallo Con Casone plant.

During 2023, there was one minor recordable accident²⁸, which occurred at the Marcallo con Casone site and was attributable to worker distraction, which is why it was not necessary to change existing procedural aspects. Moreover, in the three-year period covered by the report, there were no recordable occupational diseases or related deaths.

Accident rates have improved markedly: compared to 2022, accidents have fallen as the number of employees has increased and the number of hours worked has also increased (+8%).

Injuries and injury rates				
	Unit of measurement	2021	2022	2023
Recordable work-related injuries	no.	2	3	1
of which serious injuries	no.	0	0	0
of which fatal injuries	no.	0	0	0
Annual hours worked	no.	223,625	230,392	249,769
Recordable injury frequency rate	no.	8.94	13.02	4.00
Serious injury frequency rate	no.	0.00	0.00	0.00
Fatal injury frequency rate	no.	0.00	0.00	0.00

The awareness that in some of the production activities carried out there are dangerous substances and chemical processes related to major injury risks stimulates ICF to revise and rework its production process not leaving room for randomness but interpreting and assessing all the indirect indicators such as near misses. These analyses make it possible to identify preventative measures ensuring safety for employees and the environment, thus reducing the occurrence of any accident.

All personnel participate in quarterly information meetings on major injury risks, and checks are carried out monthly by means of checklists and multiple-choice questions on the knowledge by plant personnel of operating procedures and instructions and emergency procedures.

Moreover, having always been committed to safeguarding the health and safety of its employees, in 2021 ICF purchased two automated external defibrillators (AEDs) - one for the plant and one for the offices - with

²⁸ It should be noted that one commuting accident also occurred in 2023. In line with the GRI Standards, this injury was not considered for reporting purposes.

the aim of improving the timeliness of any life-saving intervention. An AED is a device that can automatically analyse the heart rhythm, autonomously establish the need for a shock and guide the rescuer using voice instructions.

Production requirements often call for changes to machinery; for this reason, ICF relies on the collaboration of an external firm, which assesses modifications and all new installations of equipment and provides for the amendment of reports of correspondence to UNI standards and the **Machinery Directive** (as per Title V of Legislative Decree 81/08²⁹). During 2023, a machine risk assessment was carried out on: RAM Forestry and Morel, powder, hot-melt and Meyer coaters, cutter, co-extruder, laboratory frame machines and laboratory equipment.

The attention shown by ICF in protecting the occupational health and safety of its employees can also be seen in relation to its consumers. While in previous years there was a tendency to focus on better-performing products and new, highly durable materials, today the emphasis has shifted to the formulation of products that are increasingly safe for workers but also for end customers, both in terms of health and the environment. In fact, the continuous focus on and increased consumer awareness of health and safety is gradually leading to a **development of products towards reduced toxicity**.

ICF is committed to complying with national and international regulations applicable to its products and, in particular, falls within the scope of the **REACH Regulation**³⁰ ("Registration, Evaluation, Authorisation of Chemicals") of the European Union, aimed at ensuring not only respect for the environment, but also the protection of human health from the risks of chemical substances. It also complies with Regulation 878/2020, which amends the REACH Regulation with regard to the information to be included in Safety Data Sheets (SDS). In compliance with this regulation, which came into force definitively on 1 January 2023 following the repeal of the previous Regulation 830/2015, in 2022 ICF worked to revise all SDSs of its products in accordance with the requirements. In particular, the regulation introduced the concepts of the exposure scenario and the extended safety data sheet (eSDS), understood as a document that includes information on exposure scenarios so as to enable the recipient to use chemical substances and mixtures safely. To manage these new developments, ICF has also purchased a new module of the software already in use for drafting safety data sheets, which allows the entry of one or more exposure scenarios of the individual substances making up the hazardous mixture and the creation of the eSDS for downstream communication of safe use conditions.

ICF is required to comply with the **CLP Regulation**³¹ dedicated to the identification of hazardous chemicals and to informing users about the hazards related to them. As a chemical industry, ICF also complies with all sector-specific regulations or those related to the specific use of the products, such as the Biocides, Construction and Ecolabel Regulations.

²⁹ Legislative Decree 81/2008, which is better known as the "Consolidated Law on Safety governs the sale and use of non-EC certified machines. Annex V of Legislative Decree 81/2008 is therefore mainly applied to machines manufactured in the absence of legislative and regulatory provisions, and specifically, before the implementation of the "Machines Directive" 2006/42/CE.

³⁰ **REACH** (from the acronym of "Registration, Evaluation, Authorisation of Chemicals"), EC regulation No. 1907/2006 of the European Parliament and of the Council, concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals, which stipulates the registration of all substances produced or imported into the European Union in quantities exceeding one tonne per year.

³¹ **CLP** (from the acronym of "Classification, Labeling and Packaging"), EC regulation No. 1272/2008 on classification, labelling and packaging of chemical substances and mixtures, which aligns the previous European legislation to the GHS (Globally Harmonised System of Classification and Labelling of Chemicals), a United Nations system to identify hazardous chemicals and inform users about these hazards.

ICF's attention to health and safety already begins in its laboratories, where attention is paid not only to the creation of specific products in response to particular requests from its customers but also to the formulation of products containing raw materials that are not dangerous for man and the environment (as detailed in paragraph 2.2 *Careful selection of materials*). In particular, a software package was purchased in 2022 to verify the compliance of each individual product with the restrictive lists provided by customers. This need has emerged following requests from customers in the luxury sector who declare the absence or presence in very low concentrations of certain substances in their products.

In the three-year period of reference, **there were no cases of non-compliance with product safety regulations**, thanks to the care and solid control processes set up by Industrie Chimiche Forestali.

Methodological note

The Sustainability Report of Industrie Chimiche Forestali S.p.A. is related to the 2023 financial year (from 1 January to 31 December) and contains, where available, performance trends for the three-year period from 2021 to 2023 for comparative purposes. The reporting period coincides with that of the Financial Statement, approved by the Board of Directors on 28 March 2024. The report is published annually starting from 2019.

The Report has been prepared in accordance with the GRI Sustainability Reporting Standards defined by the *Global Reporting Initiative*, according to the “*With reference*” option, as set out in Standard 1: Foundation 2021, chapter 3.

This Report presents the main environmental, social and economic aspects that characterise ICF. The reporting scope includes Industrie Chimiche Forestali S.p.A. and the subsidiary company Forestali de Mexico S.A., and coincides with that of the Consolidated Financial Statements. The aspects and indicators of Forestali De Mexico S.A. are excluded from environmental reporting. Note that the 2023 figures also include information on the business unit of Tessitura Langè, which was acquired in April 2023.

The registered and administrative headquarters of ICF are in Marcallo con Casone (MI), Via Fratelli Kennedy 75.

At the date of publication of this Report, no significant events had occurred in 2023, except as already reported in the text. It should be noted that no restatement was carried out concerning data and information from previous years.

This document has not been audited by an independent third party.

This document was approved by the Shareholders' Meeting of Industrie Chimiche Forestali S.p.A. on 29 April 2024.

The principles for defining the contents and for quality assurance of the Report

In accordance with the *GRI Standards* (GRI 1 - Foundation), this Report has been prepared according to the following general principles:

- **Accuracy:** the information is reported accurately and in sufficient detail to allow an assessment of the Company's impacts;
- **Balance:** positive and negative impacts are presented objectively and fairly;
- **Clarity:** information is presented in an understandable and accessible manner;
- **Comparability:** information is selected and reported in a consistent manner to enable an analysis of changes in the organisation's impacts over time, and to compare them with those of other organisations;
- **Completeness:** the information provided is sufficient to enable an assessment of the organisation's impacts during the reporting period;
- **Sustainability context:** information on the organisation's impacts is reported in the broader context of sustainable development;
- **Timeliness:** this document is drawn up on a regular basis so that the information is available in good time to enable users of the data to take decisions;

- **Verifiability:** data are collected, recorded, compiled and analysed so that the quality of the reported information can be assessed.

Material topics

As stated in the introductory chapter, the topics covered in the Report are based on the results of the materiality analysis conducted by ICF. The table below shows for each material theme, the associated impacts and descriptions, and the related GRI Disclosures.

Material Topics	Impacts	Description	GRI Disclosure
Diversity and equal opportunities	Failure to protect equal opportunities of employees	<i>The working environment should ensure inclusiveness, respect and appreciation of differences of all kinds (e.g. gender, ethnicity, religion, etc.). Any absence of policies and initiatives promoting and protecting these aspects may not guarantee equal opportunities for the employees concerned.</i>	GRI 405: Diversity and Equal Opportunities (2016)
Emissions of pollutants	Negative effects on human health and ecosystems caused by air pollutant emissions	<i>In the chemical industry, production activities generate emissions of pollutants into the atmosphere, mainly VOCs, NOx, and CO. Any exceeding of legal limits for the release of chemical compounds into the atmosphere could cause harm to people's health.</i>	GRI 305: Emissions (2016)
Energy and climate change	Climate change due to greenhouse gas emissions	<i>Throughout ICF's value chain, direct and indirect greenhouse gas emissions are generated that contribute to climate change: examples are emissions from the generation and transport of raw materials and the use of fossil fuels in the production process.</i>	GRI 305: Emissions (2016)
	Reducing energy availability due to inefficient production processes	<i>Failure to implement energy efficiency measures in ICF's production processes and along the entire value chain can lead to excessive energy consumption, reducing energy availability.</i>	GRI 302: Energy (2016)
Training and education	Development of employees' professional and personal skills	<i>Among the prerogatives of a company that values its employees is the continuous contribution to the enhancement of their skills, abilities, talent and managerial qualities. Each year ICF invests in special training and development programmes, contributing to the professional and personal development of its workers.</i>	GRI 404: Training and education (2016)
Waste Management	Environmental pollution due to limited sending of waste for recycling/reuse	<i>The negative impact of waste generation is mainly determined by the failure to implement reuse and recycling practices along the entire value chain. This results in waste being sent to landfill and increased risks of pollution and deterioration of the surrounding environment.</i>	GRI 306: Waste (2020)
Raw materials and supply chain	Depletion of primary resources due to consumption of virgin raw materials	<i>The chemical sector uses large quantities of raw materials, the exploitation of which contributes to a reduction in overall availability. ICF mainly buys solvents, resins and polymers, along with different types of fabrics.</i>	GRI 301: Materials (2016)
			GRI 308: Environmental evaluation of suppliers (2016)
Water Withdrawals and Discharges	Pollution of water resources	<i>ICF's production processes and activities throughout the value chain can lead to the generation of wastewater that, if not properly treated, can pollute water basins or groundwater in neighbouring areas.</i>	GRI 303: Water and effluents (2018)
	Depletion of water resources due to water consumption in production processes	<i>The withdrawal of water for production processes can affect the increasingly limited availability of this resource. This impact may be more extensive upstream in the value chain, especially in water-stressed areas.</i>	
Industrial relations	Enhancing employee well-being	<i>ICF invests constantly to generate a positive impact on people in terms of well-being, welfare measures and the</i>	GRI 402: Labour Management

Material Topics	Impacts	Description	GRI Disclosure
		<i>right balance between work and personal sphere, also through the definition of second-level contracts.</i>	and Labour Relations (2016)
Occupational health and safety	Damage to the health and safety of workers	<i>Everyday work activities, such as the manual handling of loads or exposure to harmful chemicals, can cause damage to workers' health, which can be attributed both to sub-optimal working conditions and to unsuitable behaviour on the part of the workers themselves.</i>	GRI 403: Occupational health and safety (2018)
Customer health and safety	Negative health effects on users	<i>In the chemical industry, product formulations must be increasingly safe for end users. Failure to do so can lead to serious effects on their health and safety.</i>	GRI 416: Customer health and safety (2016)
Product sustainability	Promotion of eco-design and product sustainability through continuous research and development	<i>ICF has always been very active in the research and development of increasingly sustainable products. The activities focus mainly on the use of regenerated and recycled materials, as well as the production of certified products (such as GRS, FSC, OK biobased, GOTS, BCI, ReMade in Italy). ICF is also committed to promoting the eco-design of finished products. In fact, thanks to its contribution in drafting the Product Category Rule (PCR) 'Fabrics', in 2023 it became the first company in the footwear industry worldwide to obtain EPD certification for its extruded and impregnated fabrics.</i>	Non-GRI topic
Territorial and community development	Increased employment rate, valorisation of local suppliers and community development	<i>ICF contributes to the economic and social development of the communities in which it operates, generating and distributing value in the area. In addition, ICF prefers local suppliers and provides jobs for citizens living in the areas in which it operates, thus contributing to increasing the supply chain of the communities in which it is present. Finally, it contributes to local welfare through dedicated initiatives such as partnerships with universities, donations, sponsorships and membership contributions.</i>	GRI 201: Economic Performance (2016) GRI 204: Procurement practice (2016) GRI 401: Employment (2016)
Violation of human rights	Violation of human rights	<i>Along the entire value chain, there may be negative impacts on people related to the non-respect of human rights of workers involved in the different stages of the chain, such as child or forced labour. Failure to check this could result in a lack of protection for the workers concerned.</i>	GRI 414: Social evaluation of suppliers (2016)

The reporting process and methods of calculation

The qualitative and quantitative information of a social, environmental, economic and financial nature contained in the Sustainability Report was collected through direct interviews with the managers of the various company departments and by sending special data collection forms, according to a reporting process set up on an annual basis.

The main methods of calculation and assumptions for the performance indicators reported are shown below, in addition to those already indicated in the Report:

- For the calculation of the health and safety indices, travel accidents were excluded, except for those where transport was organised by the company.
- The injury frequency rate has been calculated as follows:

$$\text{Frequency rate} = \text{number of injuries} / \text{hours worked} * 1,000,000.$$

- For environmental data, where not available, conservative estimation approaches have been adopted, i.e. the assumptions associated with ICF's less positive environmental performance have been chosen.
- The conversion factors used for the calculation of energy consumption are as follows:
 - the conversion factor used for natural gas comes from the table of national standard parameters published annually by the Ministry of the Environment and Protection of the Land and Sea for 2021, 2022 and 2023;
 - the conversion factors used for diesel oil and petrol come from the annually updated Defra (*Department for Environment, Food and Rural Affairs* of the United Kingdom) database for 2021, 2022 and 2023.
- Greenhouse gas (GHG) emissions have been calculated as follows:

*Greenhouse gas emissions = activity figure * corresponding emission factor.*
- The emission factors used for the calculation of GHG emissions are the following:
 - *Scope 1 Emissions*: the emission factor used for natural gas comes from the table of national standard parameters published annually by the Ministry of the Environment and Protection of the Land and Sea for 2021, 2022 and 2023; the emission factors for diesel oil, petrol and coolant gases come from the Defra database, updated annually, for 2021, 2022 and 2023;
 - *Scope 2 Emissions - Location based*: the emission factor used for electricity purchased from the national electricity network according to the Location based method comes from Terna International Comparisons, 2019 edition (for 2021, 2022 and 2023), based on Enerdata data;
 - *Scope 2 Emissions - Market-based*: the emission factor used for electricity purchased from the national electricity grid according to the market-based method comes from AIB - European Residual Mixes, 2020 edition (for 2021), 2021 edition (for 2022) and 2022 edition (for 2023).

For information and details on this document, please contact:

Industrie Chimiche Forestali S.p.A. - icfspa@forestali.it

GRI Content Index

Statement of use	Industrie Chimiche Forestali S.p.A. has reported the information mentioned in this GRI Content index for the period 01.01.2023-31.12.2023 with reference to the GRI Standards.
GRI 1 used	GRI 1: Foundation 2021
Relevant Sector Standard GRI	N/A

STANDARD GRI	INFORMATION	LOCATION
GENERAL INFORMATION		
GRI 2: General Information 2021	2-1 Organisational details	The process of preparing the Sustainability Report 1.2 Our organisation Methodological note
	2-2 Entities included in the organisation's sustainability reporting	Methodological note
	2-3 Reporting period, frequency and point of contact	Methodological note
	2-4 Restatements of information	Methodological note
	2-5 External assurance	Methodological note
	2-6 Activities, value chain and other business relationships	1.2 Our organisation 2.2 Careful selection of materials Methodological note
	2-7 Employees	2.3 Our team
	2-8 Non-employee workers	2.3 Our team
	2-9 Governance structure and composition	1.2.1 Governance
	2-10 Appointment and selection of the supreme governing body	1.2.1 Governance
	2-22 Statement on Sustainable Development Strategy	Letter to Stakeholders
	2-27 Compliance with laws and regulations	3.1 Environmental protection
	2-28 Membership of associations	1.2.3 Associations
	2-29 Approach to stakeholder engagement	The process of preparing the Sustainability Report
	2-30 Collective agreements	2.3 Our team
MATERIAL TOPICS		
GRI 3: Material Topics 2021	3-1 Process for Determining Material Subjects	The process of preparing the Sustainability Report

STANDARD GRI	INFORMATION	LOCATION
	3-2 List of material topics	The process of preparing the Sustainability Report Methodological note
Diversity and equal opportunities		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 2.3 Our team Methodological note
GRI 405: Diversity and equal opportunities 2016	405-1: Diversity in governance bodies and among employees	2.3 Our team
Emissions of pollutants		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 3.1.3 Emissions of pollutants Methodological note
GRI 305: Emissions 2016	305-7 Nitrogen oxides (NOX), sulphur oxides (SOX), and other significant air emissions	3.1.3 Emissions of pollutants
Energy and climate change		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 3.1.4 Energy consumption and greenhouse gas emissions Methodological note
GRI 302: Energy 2016	302-1 Energy consumption within the organisation	3.1.4 Energy consumption and greenhouse gas emissions
GRI 305: Emissions 2016	305-1 Direct GHG emissions (Scope 1)	3.1.4 Energy consumption and greenhouse gas emissions
	305-2 Indirect GHG emissions from energy consumption (Scope 2)	3.1.4 Energy consumption and greenhouse gas emissions
Training and education		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 2.3 Our team Methodological note
GRI 404: Training and education 2016	404-1 Average hours of training per year per employee	2.3 Our team
Waste Management		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 3.1.2 Waste Methodological note
GRI 306: Waste 2020	306-1 Waste generation and significant waste-related impacts	3.1.2 Waste

STANDARD GRI	INFORMATION	LOCATION
	306-2 Management of significant waste-related impacts	3.1.2 Waste
	306-3 Waste generated	3.1.2 Waste
	306-4 Waste diverted from disposal	3.1.2 Waste
	306-5 Waste directed to disposal	3.1.2 Waste
Raw materials and supply chain		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 2.2 Careful selection of materials Methodological note
GRI 301: Materials 2016	301-1 Materials used by weight or volume	2.2 Careful selection of materials
GRI 308: Environmental evaluation of suppliers 2016	308-1: New suppliers which were assessed using environmental criteria	2.2 Careful selection of materials
Water Withdrawals and Discharges		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 3.1.1 Water withdrawal and discharge Methodological note
GRI 303: Water and water discharge 2018	303-1 Interactions with water as a shared resource	3.1.1 Water withdrawal and discharge
	303-2 Management of water discharge-related impacts	3.1.1 Water withdrawal and discharge
	303-3 Water withdrawal	3.1.1 Water withdrawal and discharge
	303-4 Water discharge	3.1.1 Water withdrawal and discharge
Industrial relations		
GRI 3: Material Topics 2021	GRI 3: Material Topics 2021	The process of preparing the Sustainability Report 2.3 Our team Methodological note
GRI 402: Relations between workers and management 2016	GRI 402: Relations between workers and management 2016	2.3 Our team
Occupational health and safety		
GRI 3: Material Topics 2021	3-3 Management of Material Topics	The process of preparing the Sustainability Report 3.2 The health and safety of workers and customers Methodological note
GRI 403: Occupational health	403-1 Occupational health and safety management system	3.2 The health and safety of workers and customers

STANDARD GRI	INFORMATION	LOCATION
and safety 2018	403-2 Hazard identification, risk assessment and incident investigation	3.2 The health and safety of workers and customers
	403-3 Occupational health services	3.2 The health and safety of workers and customers
	403-4 Worker participation and consultation and communication on occupational health and safety	3.2 The health and safety of workers and customers
	403-5 Worker training on occupational health and safety	3.2 The health and safety of workers and customers
	403-6 Promotion of worker health	3.2 The health and safety of workers and customers
	403-7 Prevention and mitigation of occupational health and safety impacts within business relationships	3.2 The health and safety of workers and customers
	403-9 Work-related injuries	3.2 The health and safety of workers and customers
	403-10 Work-related ill health	3.2 The health and safety of workers and customers
Customer health and safety		
GRI 3: Material Topics 2021	GRI 3: Material Topics 2021	The process of preparing the Sustainability Report 3.2 The health and safety of workers and customers Methodological note
GRI 416: Customer health and safety 2016	GRI 416: Customer health and safety 2016	3.2 The health and safety of workers and customers
Product sustainability		
GRI 3: Material Topics 2021	GRI 3: Material Topics 2021	The process of preparing the Sustainability Report Methodological note
Territorial and community development		
GRI 3: Material Topics 2021	GRI 3: Material Topics 2021	The process of preparing the Sustainability Report 1.2.2 Economic performance 2.2 Careful selection of materials 2.3 Our team Methodological note
GRI 201: Economic performance 2016	GRI 201: Economic performance 2016	1.2.2 Economic performance
GRI 204: Procurement practices 2016	GRI 204: Procurement practices 2016	2.2 Careful selection of materials
GRI 401: Employment 2016	GRI 401: Employment 2016	2.3 Our team
Violation of human rights		

STANDARD GRI	INFORMATION	LOCATION
GRI 3: Material Topics 2021	GRI 3: Material Topics 2021	The process of preparing the Sustainability Report 2.2 Careful selection of materials Methodological note
GRI 414: Social evaluation of suppliers 2016	GRI 414: Social evaluation of suppliers 2016	2.2 Careful selection of materials