



Environmental Stewardship Awards

Ben Venue Laboratories

In 2008, Ben Venue Laboratories received a Governor's Award for Outstanding Achievement in Environmental Stewardship. The award recognizes Ohio companies and organizations committed to environmental compliance and reducing pollution.

Ben Venue Laboratories, Inc. (BVL) is a sterile manufacturer of injectable drugs located in Bedford, Ohio. A part of Boehringer Ingelheim, BVL has about 1,100 employees.

Environmental Management System

The governing document of Ben Venue Labs' Environmental, Health and Safety (EHS) management system is its site-wide EHS policy, incorporating safety, quality and environmental principles. The policy outlines the accountability that each employee has to participate in matters of EHS. This policy, signed by the president and chief operating officer, is displayed throughout the facility. In addition, the policy is reinforced during employee, management and departmental meetings.

Elements of the EHS management system include compliance and systems audits every three years; quarterly inspections and internal audits; supplier audits; and standard operating procedures in all areas of operation including laboratory, production, new product review, waste minimization and recycling, and utility conservation.

Brownfield re-use and re-development

Through its commitment to brownfield re-use and re-development in the environmentally sensitive Tinkers Creek Watershed, BVL entered into the Ohio EPA Voluntary Action Plan (VAP) to clean-up contaminated property in 1999. This Brownfield Redevelopment property was the site of numerous industrial and commercial operations since the 1900's. Under the guidance of Ohio EPA and a certified VAP professional, BVL removed approximately 8,500 tons of contaminated soil. A "no further action" was filed and "covenant not to sue" was issued by Ohio EPA in November 2005.

This property has since been developed with more than \$250 million in new construction and is home to BVL's 91,000 square foot, three-story building addition on its campus. The building has been registered with the U.S. Green Building Council and achieved Leadership in Energy and Environmental Design (LEED) Silver certification. The LEED Green Building Rating System is the nationally accepted benchmark for the design, construction and operation of high performance green buildings.

Ben Venue Laboratories is recognized for:

- Establishing an Environmental, Health and Safety management system that promotes a safe and healthy manufacturing environment while minimizing the footprint of its operations.
- Its brownfield re-use and re-development and LEED certification.
- Recycling and reuse of 35 tons of material in 2005, increasing to 360 tons in 2006 and to 730 tons in 2007.
- A water reclamation system installed in 2006, saving more than 7 million gallons of water in 2006.

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Innovations in the building plan and design included:

- Energy efficient lighting and equipment, automatic on/off controls, day lighting and HVAC occupancy controls;
- Refrigerant management;
- Water efficient plumbing and landscaping with drought-tolerant native plants;
- 27% of the building using recycled content, including steel, office furniture, carpets, concrete and masonry;
- Improved indoor air quality through the use of low emitting flooring, paints, and adhesives; and
- Covered bicycle storage.

Employee Involvement and Innovation

BVL employees are encouraged to participate in environmental stewardship initiatives. In 2007, BVL was a corporate sponsor for the Ohio Canal Corridor Riversweep event. In addition to involvement community clean-up programs, BVL employees started an in-house waste minimization and recycling team in 2005. Successes include:

- Recycling and reuse of 35 tons of material in 2005, an increase to 360 tons in 2006 and to 730 tons in 2007. Recycled materials include cans, bottles, paper, plastic, cardboard, metals, construction debris, wooden pallets, glass vials and fluorescent bulbs. These programs resulted in a \$23,000 savings for the company;
- BVL sent 284 tons of production waste to a waste-to-energy incinerator, saving 468 barrels of oil, 1,760,000 Kwh of electricity and .36 acre feet of landfill space;
- BVL began recycling rejected drug products containing platinum in 2007. Sixty troy ounces of platinum were recovered for a return of over \$50,000; and
- Shredded paper is sent to a local animal shelter to be used as bedding.

BVL has also created a utilities team with EHS, engineering and facility management employees to concentrate on saving natural gas, water and electricity. A system was installed to reclaim clean water from the reverse osmosis process, saving more than seven million gallons of water in 2006. Cost savings of water, chemicals and natural gas amounted to \$108,832. This equates to the reduction of carbon footprint of 477,491 pounds CO₂. A new process was also implemented to decontaminate and clean pharmaceutical equipment without detergents.

Environmentally Preferable Practices

In 2005, BVL implemented an integrated pest management program and green pest control program to reduce the dangers of pesticides in the environment. Pesticides usage is eliminated wherever possible as part of the program. For a sterile facility this is a huge challenge, yet BVL was able to accomplish it through traps, inspections and maintenance. BVL also switched to micro fiber cleaning cloths, reusable mops and cloths, cleaning agents that are biodegradable and non-toxic. To address the issue of pharmaceutical contamination in the environment, all pharmaceutical rejects and contaminated materials (used chemical containers, gloves, wipes, syringes, etc.) are incinerated at BVL. First rinses from all production equipment and laboratories are collected and incinerated. Returned and expired products, taken back from distributors and customers, are also incinerated.

For more information

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If you would like additional information about Ohio EPA's environmental stewardship award program, contact the Office of Compliance Assistance and Pollution Prevention (OCAPP) at 800-329-7518, or visit OCAPP's website at <http://epa.ohio.gov/ocapp/ohioe3.aspx>.