Tetra Pak®
– development in brief
At Tetra Pak® we are specialists in complete solutions for processing, packaging and distribution of food products. Our solutions are specifically designed to be as economical with resources as possible. Dairy products, juices and nectars, ice cream, cheese, dry foods, fruits, vegetables and pet food are examples of products that can be processed and packaged in Tetra Pak processing and packaging lines. We focus on keeping the consumption of all raw materials and energy to a minimum during the manufacturing process as well as the distribution of the packaged products. Our products are divided into several different categories:

- Packages
- Processing equipment
- Filling machines
- Distribution equipment
- Service products

We are able to offer our customers process treatment of products for packaging. The processing solutions are designed to treat the products gently. Equipment includes separators, homogenisers and heat exchangers. There are also eleven packaging systems, which cater to different market requirements. In addition, at Tetra Pak we market a range of conveyors, tray packers, film wrappers, roll-containers and other distribution equipment. We can also offer software service including factory planning, control and monitoring of plants, computerised logistics studies, training, follow-up service and marketing assistance. Through concentrating our research and development on liquid food stuffs, we are able to offer customers thorough expertise and complete responsibility for whole production lines. Complete responsibility is a means of protection for both customer and supplier.
Dr. Ruben Rausing 1895 - 1983

Dr. Ruben Rausing was the founder of Tetra Pak. He was born in Raus, near Helsingborg, Sweden. He graduated from the Stockholm School of Economics in 1918 at the end of World War I. By 1920, he had earned his Master of Science Degree from Columbia University, in New York.

During his studies in the USA, Ruben Rausing received his first exposure to “self-service” stores. He could see that this concept would be adopted in Europe, thus increasing the demand for pre-packaged goods. In 1929, the year of the Wall Street stock market crash that triggered the Great Depression, he and Erik Åkerlund founded Scandinavia’s first specialised factory for packaging in Sweden. The firm, Åkerlund & Rausing, was to become one of the largest packaging manufacturers in Europe, and it was within this company that the first steps in development of a carton for milk took place.
How it all began...

1943 Development work begins on creating a package for milk that requires a minimum of material whilst providing maximum hygiene. This results in the principle on which the tetrahedron-shaped carton is based.

1944 - 1951 Development continues. It involves, amongst other things, the introduction of completely new techniques for coating paper with plastics, and for sealing below the level of the liquid.

The first Tetra Pak model to demonstrate Dr. Ruben Rausing’s idea. Built in 1946.
...and how it developed

**1951** AB Tetra Pak is established in Lund, Sweden, by Ruben Rausing. It starts as a subsidiary of Åkerlund & Rausing. On May 18th, the new packaging system is presented to the press and attracts great attention.

**1952** In September, the first Tetra Pak machine for tetrahedron-shaped cartons is delivered to the Lund dairy, Lundaortens Mejeriförening. The packing of cream in 100 ml cartons begins in November.

One of the first packaging machines for tetrahedron-shaped cartons.
1953  The cream carton becomes increasingly common in Sweden. Mjölkcentralen in Stockholm, Sweden, installs its first Tetra Pak machines. Several other dairy companies follow suit. Polyethylene is introduced as the plastic coating for the paperboard.

1954  The first machines for the packing of milk in 1/2-litre tetrahedron cartons are installed at Mjölkcentralen in Stockholm and Eskilstuna, Sweden. The first Tetra Pak machine to be exported goes to Alster Milchwerk in Hamburg, Germany. A new, high-capacity laminator is started up in Lund, Sweden.
1955 In June, commercial production commences in Helsingborg, Sweden, where milk is packed for the very first time in 300 ml cartons.

1956 Tetra Pak moves into new factory premises in Lund, Sweden, on the site it occupies to this day. The manufacturing activities there consist of the assembly and testing of packaging machines, and the production of packaging material. A machine for the new 25 ml size, for portion-packed cream, is introduced. Development work begins on the aseptic packaging system.
1957 The first machine for milk in one-litre cartons is installed at the Linköping dairy, Sweden. In Lund, Sweden, a new plant for packaging material is ready for production.

Dr. Ruben Rausing together with his sons Gad and Hans with the first model of the packaging machine concept.
1958 The range of Tetra Classic® machines for tetrahedron-shaped cartons is extended to include the T-150 for milk and still-drinks in 200 ml portion-packs.

1959 The production capacity of packaging material is increased, and reaches 1 billion cartons annually. Licensees in eight countries provide additional capacity. Development work begins on the Tetra Brik® package, a brick-shaped carton.
1960 The T/1 machine, for volumes between 200 ml and one litre, makes its first appearance. The factory premises in Lund, Sweden, are extended. The first production plant for packaging material outside Sweden is started up in Mexico.
1961  The T/2 machine, for volumes in the range of 15 to 50 ml, is presented at the Packaging Exhibition in Chicago, USA. In September, the first machine for aseptically filling bacteria-free milk is presented at a press conference in Thun, Switzerland. Tetra Pak makes its first delivery to the USSR, including a number of T-300 and T-500 machines and a line for the manufacture of packaging material.

1962  An agreement is concluded with the Milliken Corporation for the marketing, in the USA, of the packaging system for tetrahedron-shaped cartons. Milliken Tetra Pak is established and construction of a packaging material factory starts at White Stone, South Carolina, USA. Further additions are made to the premises in Lund, Sweden.

1963  The Tetra Brik® package is launched in Sweden, first in Motala and then in Stockholm.

1964  Further premises are added to the Lund plant. The first Tetra Classic® Aseptic machine outside Europe is installed in Lebanon.

The dimensions of the Tetra Brik package comply with the international standards for loading pallets.
The Tetra Brik carton.
Tetra Brik cartons are filled and sealed below the surface of the liquid.
1965  Deliveries of machines for aseptic packaging continue. The trend towards long-life milk as a supplement to pasteurised milk starts in Europe and in several of the developing countries. Åkerlund & Rausing is sold whilst Ruben Rausing retains its subsidiary, AB Tetra Pak. Resources are freed for further development within AB Tetra Pak, which is managed by a small team with Hans Rausing as Chief Executive Officer, Gad Rausing as his Deputy, and Ruben Rausing as Chairman. Production commences at a new plant for packaging material, in Rubiera, Italy. The Tetra Rex® package, a gable-top package, is presented.

In the late 60’s, Tetra Pak began to gain ground within the dairy industry in the then Soviet Union. Here, in the laboratory of the Moscow dairy, we see how discussions are going on.
1966 The 300 ml Tetra Brik® carton is introduced. The first Tetra Rex® machine is installed in Sweden.

1967 A production line for Tetra Rex® cartons is installed in Lund, Sweden.

1968 The first machine in the Tetra Brik® Aseptic system is set up for field trials at the Thun dairy, in Switzerland.
The Tetra Rex gable-top carton.

A Tetra Rex TR/4 packaging machine.
1969 Two further factories for packaging material are ready for production – one in Forshaga, Sweden, and the other in Limburg, Germany.
A major extension of the premises in Lund, Sweden, permits the Development Department to be housed under one roof.
The first series of Tetra Brik® Aseptic machines are built.
Tetra Classic® Aseptic machines, for one-litre cartons, are introduced. The first deliveries go to Spain.
New types of Tetra Rex® machines, the TR/5 and the TR/6 – designed and built in Sweden – are now introduced.
1970 Following a reorganisation of the company, Tetra Pak International AB is set up. AB Tetra Pak becomes a production company and AB Tetra becomes the sales company for Sweden. A new Development Department is set up in Pfungstadt, Germany, comprising the technical nucleus of the recently-acquired Selfpack company. The primary task is to design a small Tetra Brik® machine as a complement to the large model. Manufacture of this new machine starts at Hochheim, the German base for Tetra Pak. In Arganda, Spain, a new plant for packaging material is set up.

1971 The machine programme for Tetra Rex® is extended to include a high-capacity model, the TR/4, which produces 10,000 one-litre cartons per hour. Production of packaging material is extended to two new plants, one in Gotemba, Japan, and the other in Dijon, France. The total production of Tetra Pak packages exceeds 10 billion units.
1972  For the first time, Tetra Pak® exhibits in the People’s Republic of China. This takes place at the Peking Trade Fair. A training centre is opened in Nairobi, Kenya. An agreement is signed with the Soviet dairy industry, for the delivery of 20 Tetra Brik® packaging lines.

1973  Development work in Germany is supplemented by a Tetra Pak laboratory for qualified surface chemistry, based in Stuttgart. The Latina factory in Italy commences the production of packaging material.

Tetra Pak has training centres in all parts of the world. This photograph is from Nairobi, Kenya.
1974 The Tetra Brik® Aseptic system is introduced in North America by Laiterie Cité, Canada. Concentrated juice is packed in 200 ml Tetra Brik Aseptic cartons and becomes a major product for the Swedish dairies. Two development groups, personally directed by Dr. Ruben Rausing, are set up in Denmark. Australia starts its own plant for packaging material.

1975 A major contract is signed with Iran, within the framework of an extensive social programme highlighting the protein supply. In Moerdijk, Holland, and Romont, Switzerland, production of packaging material commences in two new plants.
1976 The first field test concerning the Tetra King packaging system takes place in a small number of shops in the area of Lund, Sweden.

1977 The Tetra Brik® packaging system is introduced in the US and a new company, Brik Pak Inc., is formed. Machines for the Tetra Rex® Flat Top carton are being commissioned by customers. The total production of Tetra Pak® packages exceeds 20 billion units.

1978 The first Tetra King machine is delivered to Hansano Molkerei in Hamburg, Germany, packing cream in 250 ml packages. Tetra Pak® introduces a new system of unmanned trucks for internal transport in the dairy industry. This system, called the Tetra Carrier, is installed at Arla’s new dairy, in Linköping, Sweden. A Tetra Pak plant for packaging material is starting up in Monte Mor, Brazil.

1979 Tetra Pak® delivers the first Tetra Brik® Aseptic machine to the People’s Republic of China. Products to be filled include chrysanthemum tea and sugar-cane juice. A plant for the production of packaging material starts up in Great Britain. It is situated in Wrexham, North Wales.
In Modena, Italy, an assembly and final testing station for filling machines are constructed.

At the DLG Fair in Frankfurt, Germany, a new generation of Tetra Brik® Aseptic machines, TBA/8, is presented. Greater production capacity – 5,000 cartons/hour – is made possible by the introduction of a new sterilisation bath on the machine.

In Portugal, production of packaging material begins in a new factory.

The total production of Tetra Pak® packages exceeds 30 billion units.
The Tetra Pak Group Management moves from Lund, Sweden, to Lausanne, Switzerland, with the establishment of Tetra Pak Rausing SA as the world headquarters. The Lund company, AB Tetra Pak, remains the technological flagship of the Group. The Tetra Brik Aseptic system is approved by the United States Food and Drug Administration. The Tetra King system is launched on a large scale, with installations in several markets in Europe.

The production capacity of packaging material is stepped up, as operations start at new plants in Berlin, Germany, Seishin, Japan and Jurong, Singapore.

Wine in Tetra Brik® Aseptic packages appears for the first time in Argentina.
1982 A new method for offset printing is developed by Tetra Pak®.

1983 On August 10th Dr. Ruben Rausing, founder of Tetra Pak passes away. Tetra Pak® commences production at new packaging material converting plants in Pakistan, Kenya and Finland. A technical training school is opened at Tetra Pak in Lund, Sweden, for the training of staff from customer plants. The school can accommodate 600 students per year. New shapes and sizes of Tetra Brik® cartons are introduced – the 125 ml and the 200 ml Slim.

1984 The roll-fed Tetra Rex® system is introduced. Three additional sizes of Tetra Brik® cartons appear, 375 ml, 500 ml Slim and 750 ml. Two new plants for the production of packaging material are started up, in Denton, USA, and in Venezuela.

1985 More than 37 billion packages are produced by Tetra Pak®. Aseptic packages account for 65 per cent of this total. Bertil Hagman becomes the first person outside the Rausing family, to hold the position of President and Chief Executive Officer of the Tetra Pak Group of companies. He succeeds Dr. Hans Rausing, who becomes Chairman of the Tetra Pak Group Board.
A new shape for Tetra Brik® Aseptic cartons, the 200 ml Slim, is introduced. Tetra Pak acquires Alfa-Laval Logistics AB, a company involved in the developing and marketing of distribution equipment for the dairy and food industry. Two factories for packaging material are added to the list of production plants, one in Argentina and the other in Canada.

1986 More than 400 million Tetra Brik® Aseptic cartons for wine are produced in twelve markets. The first Tetra Top® machine is delivered to Spain, following successful test marketing in Belgium of the latest packaging system for pasteurised dairy products. The Liquipak company in St Paul, Minnesota, USA – manufacturer of machines for gable-top cartons – is bought by Tetra Pak®. The total production of Tetra Pak packages now exceeds 40 billion units.
1987 The inauguration takes place in Beijing, PRC, of a turnkey factory for the production of Tetra Pak® packaging material. The plant, which has a production capacity of one billion packages a year, is operated under a licence agreement by the commune of Beijing. Tetra Pak also starts production at a new packaging material plant in Taiwan ROC. With the start-up in December of two machines in Fiji, Tetra Pak now has machines in 100 markets.

1988 Tetra Pak® signs an agreement with GOSAGROProm, Ukraina, for the creation of a joint venture company. This company, located in Kiev, is to produce Tetra Pak packaging material. Celebrations take place to mark the creation of the Hindustan Packaging Company Ltd – the packaging material joint venture between Tetra Pak and the National Dairy Development Board in India. A Tetra Pak plant in Turkey commences production.

1989 The first Tetra Top® square packages are sold in Sweden and the UK. A new shape for Tetra Brik® Aseptic cartons is introduced, the 750 ml Slim, for packing wine in Spain. Further expansion of existing packaging material production facilities takes place in Moerdijk, in the Netherlands, and Forshaga, in Sweden.

The China-Sweden Dairy Training and Product Development Centre is an institution outside Beijing providing Swedish technology training to young Chinese students.
The total annual production exceeds 50 billion packages.
Production starts up at a new plant for packaging material in the Republic of Korea.
A factory in the north-west of the USA, Tetra Pak MatWest, is established for the production of gable-top packages.
The management company at the Tetra Pak headquarters in Lausanne, Switzerland, changes name from Tetra Pak Rausing SA to Tetra Pak International SA.

1990 In March, Tetra Pak® signs a third joint venture contract in the USSR for a plant for the final assembly and testing of packaging machines, as well as a technical service centre and training centre. Also in March, a groundbreaking ceremony takes place for the future Tetra Pak joint venture packaging material plant outside Budapest, Hungary. Liquipak Inc., St. Paul, Minnesota, USA, acquired by Tetra Pak in 1986, changes name to Tetra Pak EquipUS Inc.

1991 Tetra Pak’s acquisition of Alfa-Laval, one of the world’s largest suppliers of equipment and plants to the food industry, processing industries and agriculture, is finalised. The Tetra Pak Alfa-Laval Group is formed under the chairmanship of Hans Rausing. The new company is conducted by a board and management team. The Tetra Pak and Alfa-Laval’s distinct activities continue to be conducted separately by the two corporations.
At the end of August, a packaging material plant for the manufacture of Tetra Brik® Aseptic packaging material is inaugurated in Foshan, in the province of Guangdong in the People’s Republic of China.

Uno Kjellberg becomes President and Chief Executive Officer of the Tetra Pak® Group on September 1.

1992 Tetra Pak is divided into three regions – Tetra Pak Europe/Middle East & Africa, Tetra Pak Americas and Tetra Pak Asia/Pacific. Regional headquarters are strategically placed to serve local needs.

The Tetra Pak Corporate headquarters are moved to Lund.

Research and development for Tetra Rex® packaging machines is moved from Sweden to the US to be in the most competitive area for the gable top packaging. The Headquarters are in Buffalo Grove, Illinois and the manufacturing plant is in Minneapolis.
Tetra Pak and Alfa-Laval present, for the first time, their joint products and services at an exhibition. They are on show at the DLG (Deutsche Landschaftsgesellschaft) exhibition in Frankfurt under the theme “Creating the Future”.

1993 In June 1991 Tetra Pak® and Alfa-Laval formed the company group Tetra Pak Alfa-Laval. During 1992, the organisation gradually restructured, and on January 1, 1993, the company took the name Tetra Laval. The new Tetra Laval Group consists of four industrial groups, Tetra Pak, Tetra Laval Food, Alfa Laval and Alfa Laval Agri. Tetra Laval Holding & Finance holds overall financial control in the Group. The headquarters for the Group are in Lund, Sweden.

Manufacturing and development of Tetra Brik® and Tetra Brik® Aseptic packaging machines were relocated in September from Sweden to Italy. Tetra Brik Packaging Systems S.p.A. is based in Modena, a strategic location on a keenly competitive market. The total production of Tetra Pak packages exceeds 60 billion units.
ReCap™, a new opening device for Tetra Brik Aseptic packages is introduced in November. ReCap features a plastic cap for resealing and a PullTab, which is a tear off strip that makes the package very easy to use.

Total sales of process equipment and lines more than double during the year. This is an immediate effect of the amalgamation of the former Alfa-Laval Liquid Food with Tetra Pak®.

1994 Tetra Pak continues its regionalisation with a fourth region. Tetra Pak Europe, Tetra Pak Central Asia/Middle East & Africa, Tetra Pak Asia/ Pacific and Tetra Pak Americas have regional headquarters to serve local needs.

High Pressure Processing, HPP, is a new technology, jointly introduced by Tetra Pak and Asea Brown Boveri. It uses intense levels of pressure instead of heat to inactivate microbiological activity in foods to make them safe for commercial distribution. The main benefit of the concept is that it provides better flavour, texture and refrigerated shelf life properties than traditional heat processing methods.

Tetra Brik® Square is a new packaging system for pasteurised milk products. In this new
package you will find the slender, easy to handle shape of the gable top, and the space efficient and cost effective construction of the Tetra Brik® carton in the same package.

A new packaging system, Tetra Pouch, is introduced in Argentina for pasteurised milk. Tetra Pouch is a pillow-shaped package made from web-fed multi-layer polyethylene film. The packages are produced in a continuous form/fill/seal process.

Tetra Pak acquires Dynaplast S.A. in Switzerland and adds stretch blow moulded PET bottles to its packaging range.

Gunnar Brock becomes President and Chief Executive Officer of the Tetra Pak Group on September 1.

1995 Tetra Brik Packaging Systems launches a new packaging machine for portion packages, TBA/19. The output of the new machine is 25 per cent higher than that of earlier machine models.

The 100th anniversary of the birth of Dr. Ruben Rausing, founder of Tetra Pak, is celebrated on June 17.
Through its acquisition of Tebel MKT, Tetra Pak® has broadened its competence to include equipment for the manufacture of hard and semi-hard cheeses. Tebel, which has its head office in Leeuwarden in the Netherlands, is one of the leading manufacturers in its sector in the world. Tetra Pak’s sales of UHT plants has increased considerably during recent years. In August, the 1,000th UHT plant, a Tetra Therm® Aseptic Flex with the new Tetra Spiraflo® tubular heat exchanger, was delivered to the Estonian dairy, Paide.

Production of the materials for stretch blow moulded PET bottles takes place at Radici in Italy and Plastimat in Belgium.

The total production of Tetra Pak packages exceeds 70 billion units.

1996 The TBA/21 represents a new generation of Tetra Brik® Aseptic packaging machines. It is an extremely versatile machine, which can take packages in the 125 ml to 1136 ml range.

Tetra Prisma® Aseptic, an octagonal portion package in the 330 ml volume, has been introduced on to the market. Its size and shape make it suitable for adult consumers, and the large PullTab™ opening enables the contents to be served in a glass or drunk straight from the package.

The Tetra Wedge® Aseptic packaging system, which is based on the same reliable technology as the Tetra Brik® system, has been launched in Indonesia. The new package shape means that products are easy to identify on shop shelves, and material usage is kept to a minimum.
Tetra Allink is a new system for retaining the quality of juice. It is a further development of the unique aseptic bulk packaging system, Tetra StarAsept. The Tetra Allink system consists of equipment for aseptically transferring juice of high quality from jumbo bags and bag-in-boxes via a storage tank to the packaging line. It eliminates the need for a second pasteurisation before filling, which not only reduces costs but also retains the quality of the product. In order to meet increasing competition, those units within Tetra Laval that logically belong together have been made part of the same organisation. During the course of the year, therefore, Tetra Laval Food has for the most part been integrated with Tetra Pak®.

TBA/21 packaging machine can be adjusted to take volumes between 125 ml and 1136 ml.
1997 Seven new factories were opened in 1997, thereby adding substantially to Tetra Pak’s production capacity. The factories are located in China, Columbia, India (two), Italy, Mexico and the UK. Each factory produces packaging material, four of them for various types of plastic package and three for carton-based packages. A new integrated solution for the production of feta cheese was launched in 1997. The cheese is processed in the Tetra Tebel® BAF 6500 production line and packed in Tetra Brik® Aseptic packages.

1998 Tetra Pak® opened two new factories in a single facility in the vicinity of Jeddah, Saudi Arabia. Packaging material for carton packages is manufactured at one of the factories, and preforms for PET bottles at the other. This is the first facility to produce material for both carton packages and plastic bottles.

Feta cheese in Tetra Brik Aseptic packages.
FlexiCap™ is a new closure for Tetra Brik 1000 ml squareline packages. It is a moulded plastic cap which is applied to the packaging material in the filling machine.

Tetra Pak’s factory in Wrexham, Wales was awarded the Wales Environment Award for 1998. The award was made for the factory’s EMAS certification and the active commitment of the staff to the environment.

A new Tetra Top® package – Tetra Top Mini GrandTab 250 ml – was launched in Japan. The new package has a slim profile with rounded corners and a generous opening to facilitate pouring and drinking from the package.

Production of Tetra Pak packages amounted to 85 billion units in 1998.
1999 Tetra Top® packages with the new ScrewCap™ opening were launched in the UK and Cyprus. The new opening is very user-friendly, which is reflected in the substantial increase in sales.

The Tetra Rex® TR/18 ESL packaging system was launched in 1999. The advanced hygiene technology gives dairy products and acidic juice products a shelf life of up to 90 days in Tetra Rex gable top packages.

A new factory for the manufacture of packaging material was opened in Ponta Grossa, Brazil. The factory produces material primarily for one-litre Tetra Brik® Aseptic packages for the domestic market. It has a capacity of 3.5 billion packages a year. The factory has been designed to comply with environmental requirements for handling waste and water spillage, and has an ultrafiltration system for recovering printing ink.
In August, Tetra Pak® acquires the French company Novembal, which develops and markets package openings and closures. The acquisition will increase Tetra Pak’s resources in this area.

2000 Anuga FoodTec in Cologne is the leading International Food Technology Fair. This is the first trade fair of the new millennium to offer an overview of the status and the development trends for the latest technical processes in the food processing sector. Our visitors from more than 150 countries showed particular interest in TBA/22, Tetra Fino® Aseptic, Tetra Top®, TB/21 ESL and DIMC technology, the new shape of the Tetra Rex® Plus carton and the Tetra Plast Aseptic PET line.

Tetra Pak® publishes its first Corporate Environmental Report (CER) for its global operations in 2000. This report describes and illustrates the environmental activities and performance made by Tetra Pak in the year 1999. It shows what Tetra Pak does worldwide to improve the environmental performance of its operations and products in areas such as purchasing, production, transportation, design, customer relations and waste management. An external organisation benchmarks the CER against other companies’ reports and rates Tetra Pak among the reporting leaders, a very good accomplishment, especially for a first report.
2001 A Tetra Tebel® Casomatic cheese production line is installed in Lithuania. This is the sixth line of its type in the world so far. A new volume of the Tetra Fino® Aseptic package, 1000 ml, is launched. This package and its 500 ml and 250 ml counterparts are positioned as competitive containers for UHT milk in emerging markets. In February, the 100th Tetra Fino Aseptic filling machine is produced. The new machine is delivered to China. The introduction of Tetra Top® cartons with reclosable screw caps causes an increase in turnover by 20 per cent of the Austrian Carinthian Milk. The company also launches a new product called “Milk-fit”, a vitamin and mineral enriched functional milk product in 750 ml Tetra Top packages. Novembal opens a new factory in Mexicali, Mexico. The new plant will serve customers principally in North America and Mexico with package openings and closures.
2002 Straws were introduced for Tetra Fino® Aseptic packaging in the 200 ml and 250 ml sizes. These portion packages with straws are popular amongst consumers for instance in China.

Tetra Pak® launches its first integrated processing and packaging line for soya products. The new line is flexible and handles all stages in the processing and packaging of products.

Tetra Pak’s first PET bottle manufacture in a “Hole-through-the-wall” factory at Golden Circle in Brisbane, Queensland, Australia passes 10 million packaging units.

In September Tetra Pak celebrates its 50-year anniversary.

The total annual production of Tetra Pak packaging units passes 90 billion units.
During 2003 the Tetra Laval Group is extended with a third industry group, Sidel, which is one of the world’s leading companies in machinery for plastic bottles. The company’s equipment is developed for liquid foods, such as carbonated drinks, water, cooking oil, milk, tea, fruit juices and beer. Sidel develops, manufactures and markets complete packaging lines as turnkey projects.

A new packaging system has been born. Tetra Recart® is a carton-based packaging system with revolutionary possibilities. Using technology that simultaneously sterilises the packaging material and the packaged product we can offer an alternative packaging solution for a number of food products which have traditionally been packed in cans or glass jars, such as fruit, vegetables and dog and cat food. Tetra Pak® is participating in Anuga FoodTec, the international food fair in Cologne. Under the theme “Meeting of Minds” the company is displaying seven different packaging lines with a large amount of processing equipment for international experts within the food industry.
2004 Tetra Pak produces more than 110 billion packages.
The Tetra Brik® Aseptic family has been augmented by two new large-format package volumes.
The new package can hold products in both two litre and 1890 ml sizes, both with SlimCap™ screw cap. There are now 25 different package sizes and shapes in the Tetra Brik Aseptic segment.
After the first ten months of 2004 Tetra Classic® Aseptic passed the one billion mark. Tetra Pak already supplied almost one billion Tetra Classic Aseptic packages from its factories 21 years ago. A decisive factor for this success has been the new Tetra Pak® A1 machine platform.
Tetra Pak has developed a new machine platform for chilled products. The Tetra Pak® C3/Flex machine is highly adaptable, with features that make it possible for customers to switch between different package volumes as easily as between different products. The machine can be reset between the volumes of 1000 ml and 500 ml in Tetra Brik® Square, and between 1000 ml and 500 ml in Tetra Brik Base.
Tetra Pak became a signatory to the UN Global Compact.
Tetra Rex® TR/22 offers new customers the opportunity to package chilled products in a competitively priced and compact filling system from Tetra Pak. It is also ideal for existing customers wanting to penetrate speciality or niche product segments such as soups and sauces. The packages for large volumes meet the demand for 1890 ml and two litre volumes coming from the juice markets in Western Europe and North America.

Hormel Chili and Stagg Chili from Hormel Foods were launched in Tetra Recart packages during the year. Hormel Foods is upgrading its trademark profile as well as increasing user-friendliness for the consumer by using Tetra Recart® packages. Tetra Recart is easy to open by means of its laser perforated opening.

A Tetra Recart packaging line was inaugurated in Del Fuerte’s newly constructed factory in Mexico in July. Eight different types of vegetable, including zucchini and corn, are packed here.

In Italy, Columbus, a co-packer, is packaging tomatoes for customers including Sainsbury’s, one of the leading grocery chains in the UK. Four different tomato sauces and crushed tomatoes were launched in Tetra Recart packages in October.

During the year, Tetra Recart received four different awards from outside organisations including an Ameristar award as well as one from the Institute of Food Technologists. This particular prestigious award, the “Industrial Achievement Award”, is awarded to a company which has developed a unique innovation that contributes to advancement in food technology.
A new machine platform, Tetra Pak® R2, for Tetra Recart® packages is on field test with Swedish pet food producer Doggy AB. Tetra Pak introduces a new standard of packaging material for all ambient and roll-fed chilled liquid product packages. Even though the material is stronger, it is 20 per cent thinner and requires fewer polymers to produce.

Tetra Therm® Aseptic Sensa is launched. It is based on a new technology for blending and pasteurisation of fruit-based beverages. The concentrated premix is preheated and pasteurised in-line by direct steam injection.

A new Tetra Pak® A1 packaging line enables customers to enter markets at competitive price points. The new line produces 10,000-13,000 Tetra Classic® Aseptic packages per hour.

2005
2006 Tetra Pak® A1 filling machine is the world’s most cost-efficient one with a capacity of 9,200 Tetra Fino® Aseptic packages per hour for the 250 ml size. This packaging is cost-effective to produce, easy to transport and requires little display space.
Tetra Therm® Aseptic Flex sets a new standard for efficient UHT production.
High production availability combined with small product loss gives the lowest possible operation costs.
Production of Tetra Pak® packages exceeds 129 billion units in 2006, whereof China produces 23 billion packages.
Tetra Pak became a partner to WWF Climate Savers.

2007 Tetra Gemina® Aseptic is the world’s first roll-fed gable-top shaped package with full aseptic performance for juice and dairy liquid products. It is a packaging system that combines the perception of freshness with the aseptic performance and cost efficient production known from the roll-fed Tetra Brik® Aseptic concept.
For the first time the screw cap on Tetra Top® packages offers the same functionality as bottles as it is opened in one single twist. In addition to being easier to open, the new one-step opening uses less plastic than the closure with membrane underneath the screw cap. It’s available on packages ranging from 250 ml to one litre.
The new Tetra FlexDos ingredient-dosing unit enables the food and beverage industry to develop modern and innovative consumer products both safely and cost-effectively, with healthy margins and excellent growth potential. The
Tetra FlexDos system provides flexible in-line aseptic dosing of additives. Functional ingredients, colours or aromas are injected into the base product for final heat treatment, just before filling into retail containers. The Tetra FlexDos solution means quick and accurate delivery of additives and ingredients, which allows products to be changed over rapidly with minimal product loss, facilitating short runs and full traceability.
In June, Tetra Recart® expanded its product portfolio by launching three new packaging sizes in addition to the Tetra Recart 390 Midi package. Now the Tetra Recart Midi family consists of three packaging sizes (340, 390 and 500ml) all having the same bottom format. As a complement to the Tetra Recart Midi family, the small Tetra Recart 200 Mini package has been launched. It is a convenient, efficient and cost competitive portion package for vegetables, sauces and beans. The square shape of the Tetra Recart package offers excellent space efficiency and visibility on retailers’ shelves. Consumers appreciate the conveniently shaped package, which is based on renewable resources and fit into existing recycling systems.

Tetra Pak launches the first ever liquid food carton carrying the FSC™ (Forest Stewardship Council™) label, the gold standard in responsible forest management.

2008 Tetra Pak® produces more than 140 billion packages.

Tetra Pak invests in a state-of-the-art packaging material manufacturing plant in Hohhot, China to support the country’s growing dairy and beverage industry. With a planned capacity of 8 billion packages per year, this new facility will be a strategic addition to Tetra Pak’s existing production capacity.

Operator Certification is a Tetra Pak service product designed to maximise equipment performance and production results by ensuring that filling equipment operators have the required skills to run Tetra Pak machines in the safest and most effective way. In early 2008, four operators at Nidan Juices, one of Russia’s top four producers of juices
and nectars, shared the distinction of becoming the 1,000th operator certified globally.

Tetra Pak® A3/Speed iLine, the new packaging solution for the Tetra Brik® Aseptic 125 Slim package, runs up to an amazing 24,000 packages per hour. This popular package is used for fruit purée for infants, children’s juice drinks, school milk, tomato purée etc. Operational cost for the new Tetra Pak A3/Speed iLine is reduced by up to 40 per cent.

2009 In June, we announced the global launch of Tetra Brik® Edge, the packaging solution for chilled liquid dairy products designed for consumers of all ages. The package is easy to use – whether you are young or old - so much so that it is endorsed by the Swedish Rheumatism Association, which also chose it as their ‘Package of the Year’.

The world’s first hermetic direct-driven dairy separator – Tetra Centri® AirTight Eco - cuts energy consumption by up to 35 per cent compared to conventional paring disc separators. This new generation separator is a further development in our proven range of separators using a number of breakthrough innovations to deliver higher operational efficiency and lower environmental impact than ever before.
On September 30th, World School Milk Day, we announced our support of two additional school milk programmes – in Ecuador and Morocco – as well as the expansion of existing programmes in Romania, Thailand, Mexico and Iran. More than two billion Tetra Pak cartons carry the FSC™ (Forest Stewardship Council™) label.

2010 Tetra Pak received the 2010 Klimatpris (Climate Award) from the Swedish Forest Industry Federation. The award was delivered by H.R.H. Prince Carl Philip, to Finn Rausing at a ceremony in Stockholm on April 20. During this year, many of our UK and Irish customers launch the FSC™ (Forest Stewardship Council™) label across the nation’s favourite brands with the aim to cover over 1.5 billion packages. This development is a first in Europe, where a liquid food and drink packaging manufacturer is able to launch such a wide-scale roll out. Furthermore we will enable customers in several other countries to initiate launch of FSC-labelled packages while carefully managing the constraint of limited supply of FSC™-certified paperboard.
A variety of products recycled from post-consumption cartons made their debut at the world Expo 2010 in Shanghai. 2000 green benches each of which was made from 856 used cartons, were the result of a milk carton recycling campaign.

Thanks to the HAAD (High Acid Ambient Distribution) technology, the Tetra Top® package can be used for distribution of ambient still drinks. The products are filled in a TT/3 HAAD filling machine. This filling machine enables manufacturers to package high acid still drinks such as ice tea, fruit drinks and sports drinks without using the chilled chain and this provides producers with new growth opportunities.

A new Tetra Pak® Technology Centre is inaugurated in Pudong, Shanghai, China. With the new centre Tetra Pak can provide Chinese customers with a one-stop service in food processing and packaging solutions.

In 2010, Tetra Pak expanded its support for school milk programmes in Pakistan, Senegal, Ukraine, Bosnia and Herzegovina, Gaza and the West Bank.
2011 Milk in the Tetra Evero® Aseptic package is proving highly popular in Spain, with CAPSA Alimentaria Penasanta, the first Spanish customer to commercially launch this combination. Tetra Pak releases a new Tetra Rex® One-Step Opening cap. The new TwistCap™ OSO 34 cap adds the ability to pour milk, yoghurt or juice and to reseal the package with one simple twist. Nestlé Brazil is the first customer to launch two popular milk brands in carton packaging with caps made of plant-based polyethylene plastic. This is an important step for Tetra Pak towards its goal of producing 100 per cent renewable packaging. The renewable polyethylene has been developed by Braskem, Brazil’s largest petrochemical company, and is made from sugar cane.

In November, Tetra Pak’s ninth Product Development Centre opens in Shanghai, China. Tetra Pak inaugurates a new packaging material factory in Lahore, Pakistan. The factory is certified as World Class Manufacturing (WCM) standard and has a potential for 16 billion packages.
In April, the new Tetra Brik® Aseptic 1000 Edge LightCap 30 is globally launched for milk, juices, nectars, wines, and other liquid products. DreamCap™ 26 has been awarded a Scanstar for its functionality and convenience. Scanstar is an annual competition started in 1969 by the Scandinavian Packaging Association.

Tetra Pak® has invested in a Coconut Knowledge Centre in Singapore. The investment is designed to meet customer needs across the growing Southeast Asian market and to improve the company’s competitiveness in coconut beverage innovation in other parts of the world.

The French retailer Casino has launched chopped tomatoes and passata, a purée made from ripe tomatoes, in Tetra Recart® packages in its own stores. The retailer will gradually replace cans with cartons for its own-brand foods.

Tetra Pak is supporting a school milk programme run by the municipality of Dakar, Senegal. Our company provides administrative expertise and guidance on milk procurement, distribution, storage, as well as waste collection and parent awareness of milk’s benefits. The milk programme started in 2010, and has now reached 84,000 children.

26.4 billion FSC™-labelled packages reach consumers in 37 countries around the world. This means that they can make an active choice for responsible forestry by choosing food in FSC™-certified carton packages.
2013 Tetra Pak® has designed an automated secondary packaging solution and reengineered the Tetra Pak® A1 filling machine to meet food safety standards for co-packer California Aseptic Beverages, marking the carton’s return to the North American market after 30 years since being licensed to a third party in the 1960s. Food manufacturer Kids’ Healthy Foods chose Tetra Classic® Aseptic packages for its juice and flavoured water product Mickies Slices, which are provided in several US schools and are available at retail.
The first products packed in Tetra Pak cartons were milk and cream. Dairy products are still the most important products. They account for about 2/3 of the total volume of the food stuffs packed in Tetra Pak packages. A wide variety of food products are process-treated and aseptically packaged. Thanks to the aseptic processing and packaging systems, these products retain their taste and nutritional value, even when stored for months without refrigeration. Tetra Pak’s aseptic packaging systems have also facilitated rational and economical distribution in ambient temperature of products in large volumes such as milk and milk-based products, juices and fruit drinks, tea drinks, soy drinks, tomato products and wine.

The number of products packed in Tetra Pak packages is very large. The largest group consists of milk products, juice and fruit drinks, tea drinks, soy drinks, tomato products and wine.
Tetra Pak provides complete processing and packaging systems, incorporating processing equipment, packaging machines, distribution equipment and complementary software services. Thus, customers need only turn to one supplier for their entire packaging needs. This amounts to single-source responsibility, a long-standing Tetra Pak commitment to customer service. The Tetra Pak range of packaging systems comprises eleven alternatives:

**Tetra Brik®**
The Tetra Brik package was introduced in 1963. It is rectangular or square in shape and available with a large number of different openings. The Tetra Brik Aseptic carton, which was introduced in 1969, is the most frequently used package for long-life products.

**Tetra Classic®**
Tetra Classic is the name of our tetrahedral package. It was the first package launched by Tetra Pak in 1952. An aseptic variant was released in 1961.

**Tetra Evero®**
Tetra Evero Aseptic was launched in 2011. It is the world’s first aseptic carton bottle for ambient white milk.

**Tetra Fino®**
Tetra Fino Aseptic is a carton-based pillow-shaped package, which was introduced in 1997. This roll-fed packaging system offers good economy for producers as well as for consumers.
Tetra Gemina®
Tetra Gemina Aseptic is the world's first roll-fed gable-top shaped package with full aseptic performance for juice and liquid dairy products. This packaging system, which was introduced in 2007, is based on the reliable Tetra Brik Aseptic concept.

Tetra Prisma®
Tetra Prisma Aseptic is an octagonal package made in accordance with the principle of the Tetra Brik Aseptic system. The package was launched in 1997. The package has excellent grip and pouring performance and is available with resealable StreamCap for added convenience.

Tetra Recart®
Tetra Recart is a carton packaging system with revolutionary possibilities. This is an alternative packaging solution for a variety of food products that have traditionally been packed in cans or glass jars. These are products such as fruits, vegetables and pet food.

Tetra Rex®
The Tetra Rex package is rectangular with a gable-shaped top. The first Tetra Rex packaging machine was installed at a customer's site in Sweden in 1966. The package is used throughout the world for pasteurised products.

Tetra Top®
The Tetra Top package was launched in 1986. It is a reclosable, square package with rounded corners and has a polyethylene lid, which is injection moulded and sealed to the package in a single process. The opening device makes it easy to open, pour from and reclose.

Tetra Wedge®
The Tetra Wedge Aseptic package was introduced in 1997. Its innovative shape enables products to be easily distinguished on shop shelves and keeps packaging material consumption to a minimum.
Tetra Pak has plants worldwide for the manufacture of carton based packaging material. This material is delivered in rolls – for efficient and economical handling in the warehouse and during transport.

The layers of the Tetra Brik Aseptic package, from the outer layer inwards:

- polyethylene
- printed design
- paper
- polyethylene
- aluminium foil
- polyethylene
- polyethylene
The packaging material for carton-based packages is composed of a laminate of paper, polyethylene and, for aseptic packages, aluminium foil. This combination of material varies to suit each separate product category, but in each case the only material to touch the contents of the package is foodgrade polyethylene. The material may be printed using flexography, rotogravure or offset lithography. Paper makes the packages stiff. Plastic renders them liquid-tight, and aluminium foil blocks out light and oxygen. Tetra Pak® customers are never far from one of the many Tetra Pak packaging material plants throughout the world. This guarantees prompt deliveries to more than 8,700 Tetra Pak packaging machines currently forming, filling and sealing Tetra Pak packages.
Tetra Pak® offers higher production efficiency and product safety, in combination with lower environmental impact and increased profitability. All this is delivered along with our technical service for both new and existing facilities. We have broad expertise and experience in food and beverage processing technology and develop innovative solutions to help our customers increase their competitiveness. We specialise in the following key categories: dairy, beverages, cheese, prepared foods and ice cream.

Our production solutions cover everything from key components to complete production facilities. They include automation solutions with full traceability and technical services - from intake to distribution.
**Dairy**
The invention of the continuous milk separator by Gustaf de Laval in 1878, made it possible to separate cream from milk. Our food processing business is still based on this invention today! But over the years, we have continuously developed and improved our production solutions for the dairy industry and created a global business.

Our latest generation best-practice lines are tailored to suit specific product and production requirements. Thanks to the optimal exploitation of resources and the industry’s lowest production losses, it enables milk producers to raise efficiency, achieve more consistent product quality and greater flexibility. Results are guaranteed and evaluated.

Tetra Therm® Aseptic VTIS is our UHT unit for continuous aseptic processing of heat-sensitive dairy products. Since it is able to limit the effects of heat treatment, this equipment delivers superior product quality. High production stability also means Tetra Therm Aseptic VTIS is suitable for products with an extended shelf life.

**Beverage**
In the beverages category, we focus on customers who process juices and nectars, tea, carbonated and non-carbonated drinks, water and new health drinks with value-added ingredients. Our innovative solutions for beverages offer new levels of performance, enabling producers to raise operational efficiency and environmental performance. The consumption of water and energy are significantly reduced, and advanced automation increases efficiency while securing food safety through full traceability. Our pasteurizer, Tetra Therm® Aseptic Drink, for beverages, is the most important building block in these lines.
Cheese
For over fifty years, we have been offering cheese producers a range of proven systems and equipment with the latest technology. Nowadays, the production of cheese is a high-tech industry. Tetra Pak is a complete supplier and provides a broad range of equipment and customized solutions for the entire cheese production process.
Our best-practice lines for cheese are based on our unique experience and expertise within cheese and whey production. By combining milk reception, cheese production, whey processing, filtering, evaporation, drying and powder handling, we can deliver tailored solutions for almost all types of cheeses and a series of new, rapidly emerging whey-based products. Tetra Tebel® Casomatic for the production of hard and semi-hard cheese types is our fully automated and continuous system for whey draining, pre-pressing, cheese block shaping and moulding.

Prepared Food
Tetra Pak® offers best-practice line solutions based on a comprehensive range of processing equipment for prepared foods, as well as a team of world-class experts on rheology. Most of the treated products are very viscous and often contain pulp and particles, which places special demands on the processing and application expertise. We offer flexible and efficient production solutions for products such as soups, sauces, desserts, fruit preparations, tomato products and baby food.
The Tetra Therm® Aseptic Visco UHT unit – now also available for high-viscosity products – is an example of the continuous development of Tetra Pak’s processing technology for prepared foods, which offers maximum production flexibility, high food safety and operational efficiency.
Ice cream

As world-leaders in ice cream, we manufacture and deliver complete production solutions, equipment and consumable products for the processing and packaging of ice cream. We help our customers to satisfy the taste of retailers and consumers for both traditional and new, innovative ice cream products.

Our ice cream equipment begins with raw materials processing and continues with mixing, continuous freezing, and systems for the addition of ingredients such as chocolate, nuts, jam and sauces; it can produce all types of ice cream with the desired mix of ingredients, shape, taste, colour and size.

Our best-practice line solutions for ice cream production provide high efficiency and profitability with the highest standards of hygiene. The first step in the transformation of ice cream mix into delicious and attractive ice cream products is continuous freezing and mixing with air. Tetra Hoyer® Frigus freezers for continuous deep-freezing offer high performance with very little temperature variation, which results in excellent product stability.
Automation solutions
Modern processing and packaging solutions for food depend on automated control systems to operate the facility, gather data, optimise production and ensure product quality. Our family of open, scalable, integrated automation solutions – Tetra PlantMaster® – are continuously being developed.

The solutions are tailored to match each customer’s needs, optimise their production and minimise interruptions, waste and energy losses. Tetra PlantMaster consists of module-based solutions, based on open industry standards, combined with our comprehensive knowledge of food and beverage production. These automation solutions are unique and give customers total control over their process, entire lines or a complete processing and packaging facility – from the intake of raw materials to delivery of the packaged product. Tetra PlantMaster automation solutions are scalable and future-ready, growing and changing according to the customer’s needs, ensuring that customers get all the necessary information to make production more efficient and profitable, and to avoid quality problems.
Food safety
Tetra Pak has been a pioneer in the development of food safety technologies. One example of this is UHT (Ultra High Temperature) treatment, which makes it possible to safely store and transport milk and other products at room temperature.

Food safety starts at the drawing board, with hygienic design to ensure everything that comes into contact with food – from single components to connections and welds – is made using approved materials and built in such a way as to enable correct and efficient cleaning. Tetra Pak is a member of EHEDG – the European Hygienic Engineering Design Group – and follows the guidelines on hygiene for the manufacture of safe and healthy food and beverage products. Food safety is also ensured through our advanced CIP (Cleaning in Place) technology, and supported by the traceability we offer through our Tetra PlantMaster automation solutions.

Technical sales and service
Our customized service solutions, Tetra Navigato™, maximise our customers’ production while minimizing costs and environmental impact. We offer a complete range of services and solutions that ensure consistent product quality every time. Our several hundred experts deliver services around the world, in such a way as to keep customers’ production functioning with maximum efficiency and without disruption.
Key components
Separators, heat exchangers and homogenizers are key components in our processing solutions. We are the only supplier that manufactures all three types of high-technology equipment, as well as aseptic processing systems, flow equipment and automation.

Separators
Centrifugal separators are mainly used to separate cream from milk. They are also frequently used as clarifiers for milk and beverages. In certain dairy and cheese applications, the separator can be used as a bactufuge unit, to remove anaerobic spores and reduce heat-resistant micro-organisms. For more than a century, we have set the standard for centrifugal separation, most recently with our Tetra Centri® AirTight design.
Heat exchangers

Heat exchangers are used in the food industry to heat and cool products. Plate, tube, spiral or scraped-surface heat exchangers are used to transport energy to or from the product. Our heat exchangers are highly specialised for food processing with high thermic efficiency which enables low energy consumption. They are highly efficient and secure gentle product treatment and excellent hygiene.

Homogenizers

Homogenization is a process used to disperse fat in dairy products, as well as to improve their shelf-life and product texture. The homogenizer can also be used for beverages with a high fruit pulp content to minimise sediment, increase viscosity or create a better texture. The Tetra Alex® series is a family of homogenizers based on over 80 years’ of pioneering design. They offer durable, efficient and flexible technical solutions which guarantee safe and operationally secure production, while reducing energy consumption.
Ecodesign

Ecodesign is about reducing environmental impact both in the production and use of new products. Care for the environment is an important part of Tetra Pak’s development processes and we strive to reduce impacts in the entire life cycle of our products, without compromising our customers’ need for safe, functional and cost-effective products.

The concept of product development with evaluation of environmental impact is called Design for Environment (DfE) and is an integral part of Tetra Pak’s innovation process. In practice, DfE means thinking in terms of life cycle throughout the development process in order to identify, evaluate and reduce the product’s impact on the environment from ”the cradle to the grave”. DfE enables the reduction of impacts associated with using our equipment, in the form of energy and water consumption, waste of food products, cleaning requirements and use of materials.
Tetra Pak®, Lund, Sweden, is the home of our company. With its approx. 3,800 employees, it forms an impressive show-case of Tetra Pak’s innovative development, housing the largest of the Tetra Pak Research and Development Centres. The facilities, which additionally house the largest Tetra Pak plant for the manufacture of packaging material and the assembly of packaging machinery, also include a training school for customers’ machine operators and the technicians of the International Service Pool.
Another key function of the Lund plant, is to act as a display and demonstration centre for commercial visits, by means of which the company’s customers are given an overall picture, from the drawing board to the finished packaging system. In addition, customers can avail themselves of the state-of-the-art packaging plant.
Tetra Pak International is responsible for the overall management and coordination of the Tetra Pak Group, for which it lays down marketing, technology and finance guidelines. Tetra Pak® is part of the Tetra Laval Group, which was formed in January 1993. The three industry groups Tetra Pak, DeLaval and Sidel are currently included in the group.

DeLaval is a full service supplier to milk producing farmers and offers complete systems for milk production and animal husbandry. Sidel is one of the world’s leading companies in packaging solutions for liquid food, such as carbonated drinks, water, cooking oil, milk, tea, fruit juices and beer. The company covers three major categories of packaging: glass bottles, plastic bottles (PET, HDPE and PP) and metal cans. Sidel develops, manufactures and markets complete packaging lines as turnkey projects.
The Tetra Pak Group’s largest research and development unit is in Lund, a university city in southern Sweden.
Our commitment to sustainable development

In Tetra Pak’s vision, code of conduct and mission, we explicitly describe our goals for the business as follows: “responsible industrial leadership, to create profitable growth in harmony with environmental sustainability and the ambition to be a good and accountable citizen in society”. For a long time now, we have carried out activities such as environmental improvements, school milk programmes, and environmental training and development programmes for the agricultural and dairy sectors.

We are members of the UN Global Compact initiative and have undertaken to support and promote its ten principles, gathered into four sections; anti-corruption, human rights, work and environment. Since 2006, Tetra Pak has had a global cooperation agreement with the WWF on issues concerning forestry and climate change.

Code of conduct

Our company management structure provides employees with clear rules of play: they cover our core values, our business code of conduct, and our policy statements, procedures and guidelines.

All those in leadership positions have signed an undertaking to follow the rules in Tetra Pak’s code of conduct. This covers issues concerning equal treatment and recruitment of employees, the avoidance of conflicts of interest, careful control and financial reporting, requirements to follow applicable laws, and an absolute prohibition on fraudulent conduct or accepting bribes. The code also covers a commitment not to exploit child labour, as well as an undertaking to run our company in an environmentally sound and sustainable manner.
**Social & Economic development**

Tetra Pak® promotes sustainable economic and social development through the building of strong partnerships between national governments, private industry, voluntary organisations and international and national development bodies. Experience shows that a partnership to make milk available for school meals, for example, can be a catalyst for sustainable local production and processing of food, while improving the children’s health and study performance. In order to accelerate the development of these partnerships, Tetra Pak has set up a “Centre of Expertise” for “Food for Development”, with the aim of making know-how and expertise available to introduce and support programmes for school meals and nutrition education, as well as development programmes for the agricultural and dairy sectors in developing countries.

Tetra Pak undertakes to run its activities in an environmentally sound and sustainable manner. We establish goals for continuous improvement in our development, purchasing, manufacturing and transport activities.

For 50 years we have helped customers, governments, international and local organisations and farmers to provide children around the world with milk. They have been able to deliver close to seven billion cartons of milk to 51 million schoolchildren in schools in over 50 countries all over the world.

The school milk programme can have a considerable influence on the local community and its economy. It not only improves health and the children’s ability to learn but also often acts as a catalyst for the development of agriculture and the broader economy.
The school milk programme plays an important role in our business strategy and our commitment to customers around the world to ‘make food safe and available everywhere’.

**Environment**

Environmental excellence is an integral part of Tetra Pak’s business strategy and activities. We work systematically to utilise resources and energy more efficiently. We choose sustainable materials and continuously improve the entire value chain. In this way, we help ourselves and our customers become more competitive – through lower costs and reduced environmental impact.
Recycling: We have undertaken to support the recycling of our packaging to ensure that it is used as a resource for new products. We work in close cooperation with the paper industry and other stakeholders in various parts of the world to increase recycling; we support further expansion of the infrastructure – from improved collection of used packaging to the development of more efficient recycling technologies. An important part of this work is to increase consumer awareness. The global recycling of used Tetra Pak packages increased from 13 per cent in 2001 to 22.9 per cent in 2012. From 12 billion carton packages recycled in 2001, we went on to recycle 39 billion packages in 2012. We have set a goal of reaching 40 per cent global recycling by 2020.

Climate: Tetra Pak has established a global climate target for 2020 to reduce environmental impact throughout the value chain; from our suppliers, within our own organisation, our customers’ production and recycling of used packaging. We want to ensure that the reduction of our climate impact is equal to the extent of our growth, and remains at the same level in 2020 as it was in 2010. Since 2006, Tetra Pak has been part of the WWF’s Climate Savers initiative.
**Environmental management:** Our packaging material factories are certified according to the environmental management standard ISO 14001.

**Renewable raw materials:** The principal raw material used in our packaging is paper, a product which is manufactured from wood – a natural and renewable resource. Using renewable raw material that continues to grow is a good environmental choice. Our guidelines for forestry management guarantee full traceability of our materials, and our ultimate goal is for all the wood fibre in our carton packaging for food and beverages to come from certified forests and to live up to the highest standards of responsible forest management, FSC™ (Forest Stewardship Council™). In 2012, Tetra Pak delivered over 26 billion packaging items with the FSC™ stamp. We are extending the use of renewable materials and have introduced polymers for our caps produced from a bio-based resource, sugar cane.

**Environmental performance:** We strive continuously to improve the environmental performance of our processing and packaging solutions. By making our solutions more efficient, impact on the environment will decrease and costs will also be reduced. This reinforces both our customers’ competitiveness and our own.
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