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Energy
- Electricity from the public grid
- Fossil fuel (gas, oil, coal) for steam and electricity generation
- Purchased steam (only a few cases)

Water
- Cooling water
- Process water

Process aids:
- retention aids
- tensides
- defoaming agents
- biocides
- lubricants
- acids and alkali
- flocculation agents

Product aids:
- fixing agents
- dry or wet-strength agents
- dyes
- optical brighteners
- other aids depending on the properties of the product
- anti scale agents

Additives

Major raw materials:
- chemical pulp
- Fillers
- Coating pigments (^{1})
- Binders (^{1})
- Sizing agents
(^{1}) for coated grades only

Non-integrated paper mill

Stock preparation	Refining	Paper machine
Sizing (optional)	Coating (optional)	Dyeing (optional)
Calendering (optional)	Boiler house or cogeneration plant	Waste water treatment / Waste handling

Products:
- different grades of paper (fine paper, tissue, speciality paper)

Other valuable output
- Residues for utilisation
- Electricity in some cases

Noise

Waste heat to air and water

Energy

Air emissions

From energy generation:
- SO_2, NO_2, CO_2, CO, HCl,
- dust; emission depend on:
  - type of energy supply
  - type of fuels used

From the process:
- small amounts of volatile organic compounds (VOC) (^{2})
- visible plume
- odour (^{3})

(^{2}) only for a few paper grades
(^{3}) can mostly be avoided

Waste water
- Organic substances (COD, BOD)
- Chlorinated organics (AOX)
- Nitrogen, phosphorus
- Suspended solids
- Salts
- Coloured substances
- Surfactants

Solid waste
- Sludge from raw water treatment
- Primary sludge (fibres, fillers, coating pigments)
- Biosludge
- Rejects
- Ashes from steam/power generation
- Sludge from chemical waste water treatment
- Small amounts of other types of waste

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