

## First in Japan, launch of commercial use for corrugated boxes recycled from aseptic carton packages

### Implementing a circular model with Gold-Pak's Azumino Mineral Water

～ Utilizing plant-derived polyethylene in packaging and caps contributing to a 38% reduction in CO<sub>2</sub> ～

Oji Holdings Corporation (President: Hiroyuki Isono, Headquarters: Chuo-ku, Tokyo, hereinafter "Oji Holdings") announced that, in collaboration with Nihon Tetra Pak K.K (President: Niels Hougaard, Head Office: Minato-ku, Tokyo; hereinafter "Tetra Pak") and Gold-Pak Co., Ltd. (President: Toshio Uji, Headquarters: Shinagawa-ku, Tokyo, hereinafter "Gold-Pak"), recycled corrugated boxes made from paper fibers of aseptic carton packages has been commercially adopted for the first time in Japan as packaging material in the "Azumino Mineral Water (paper pack 1L)" manufactured by Gold-Pak.

Moreover, starting in the spring of 2026, Gold-Pak will switch the polyethylene used in the packaging coating and caps of this product from fossil-based resources to plant-based resources, thereby reducing CO<sub>2</sub> emissions across the entire package-related value chain by 38% (\*1).

These initiatives utilize the recycling scheme jointly developed by Oji Holdings and Tetra Pak to create a model that circulates the production, consumption, collection, resource recovery, and reuse of paper packages for food and beverages within a single product. As a new example of a circular model in the food and beverage industry, we will continue to promote the visualization of resource circulation in the future.

おいしさに、ひたすら、ひたむき。



Recycled corrugated box made from aseptic carton packages and Azumino Mineral Water (paper package 1L)

### ■ Japan's First: Commercial Use of Recycled Corrugated boxes Made from Aseptic carton packages

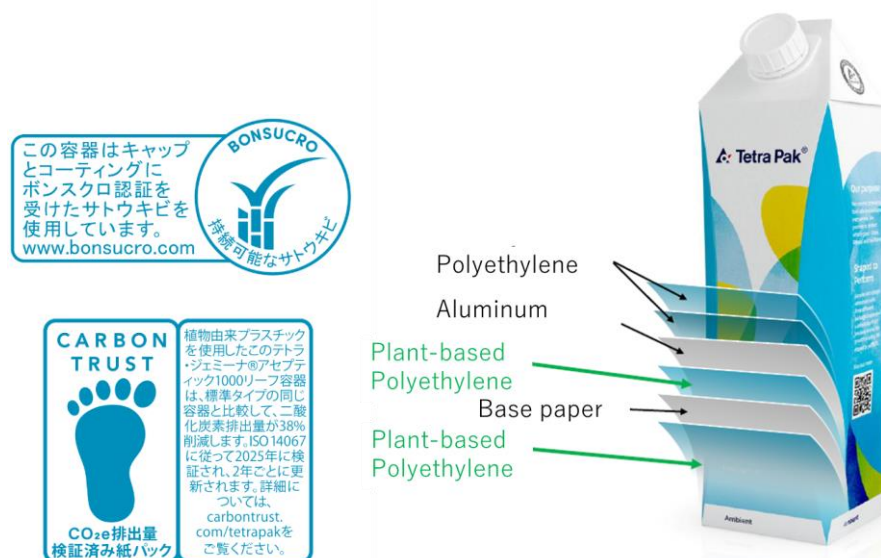
The packaging material for 'Azumino Mineral Water (Paper Package 1L)' utilized a recycling scheme jointly developed by Oji Holdings and Nihon Tetra Pak. The paper packages with aluminum were separated into paper fibers and polyethylene-aluminum layers, and the paper fiber part was subjected to material recycling into corrugated boxes and used as packaging material. This product is primarily sold by the case, which allows promoting its environmental initiatives to consumers through the corrugated boxes.

Recycled corrugated boxes made from aseptic paper packages have been successfully used as packaging material for bottled water distributed at the Nordic Pavilion of the Osaka-Kansai Expo 2025, but this is the first time it is being commercially used as packaging material for a beverage manufacturer's products.

## ■ Japan's First②: Adoption of plant-based polyethylene in large aseptic carton packages

In the spring of 2026, Gold-Pak will switch the polyethylene used in the packaging coating and caps of the aseptic carton packages "Tetra Gemina® Aseptic 1000ml Leaf" by Nihon Tetra Pak, which is used in "Azumino Mineral Water (Paper Package 1L)" from fossil-derived to plant-derived (sugarcane). This increases the renewable resource ratio of the same package from 63% to 82% and reduces CO<sub>2</sub> emissions across the entire value chain related to the package by 38%.

This CO<sub>2</sub> reduction rate is certified by the Carbon Trust, and the corresponding packages have the Carbon Trust certification label printed on them, allowing for visual appeal to CO<sub>2</sub> reduction (\*2). Furthermore, plant-derived polyethylene has obtained Bonsucro certification (\*3), supporting sustainable sugarcane production. Notably, this is the first time that Tetra Pak Japan is using plant-based polyethylene in its aseptic carton packages (large: over 500ml) sold domestically (\*4).



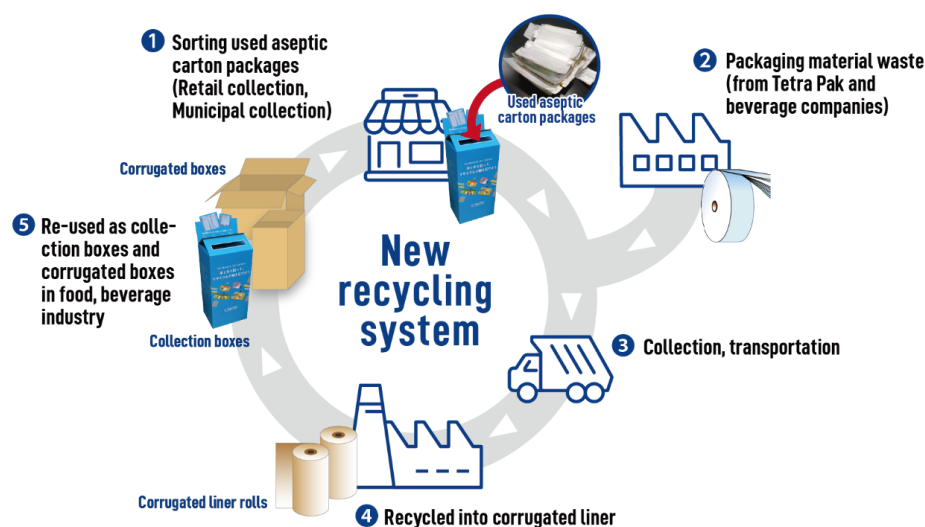
Left: Certification labels on this product  
(top: Bonsucro certification label, bottom: Carbon Trust certification label)  
Right: Structural image of a aseptic carton package

## ■ Significance of the Circulation Model

Traditionally, the majority of aseptic carton packages were mainly subjected to incineration treatment through thermal recycling, while reuse into paper products (material recycling) was limited to only 3.6%(\*5).

In this initiative,  
Switch the raw material of the package to plant-derived polyethylene  
Use the paper fibers from packages as recycled corrugated boxes  
Use the recycled corrugated corrugated boxes for packaging its own products.

By introducing such a system, we have achieved resource recycling within a single product. This model is a new example of sustainability practices in beverage manufacturers, and aims to expand its adoption across the entire food and beverage industry in the future.



#### ■ Comments from each company

##### **Gold-Pak Co., Ltd.**

This renewal is an important initiative aimed at realizing a sustainable society that our company envisions. The adoption of plant-based polyethylene and the introduction of recycled corrugated boxes have enabled us to concretely reduce environmental impact. We will continue to cooperate with Nihon Tetra Pak and Oji Holdings to contribute to the realization of a recycling-oriented society.

##### **Nihon Tetra Pak K. K - Yuko Ohmori, Sustainability Director**

We are very pleased to have established a model in collaboration with Gold-Pak and Oji Holdings, where manufacturing, consumption, collection, recycling, and reuse circulate with a single product. This can indeed be said as an initiative contributing to the SDGs of "responsible production and responsible consumption." Improving the rate of renewable resources in paper packages and the collection and recycling of aseptic carton packages, as well as the utilization of recycled products, are crucial steps towards realizing a circular society as advocated by our company. Going forward, we will continue to encourage consumers to actively collect and recycle carton packages after use, aiming to accelerate further resource circulation.

##### **Oji Holdings Corporation - Keiji Shimatani, General Manager, Recycling Initiatives Dept., Corporate Operations Division**

Recycling aseptic carton packages has long been a challenge for the industry, but through this initiative, in collaboration with Gold-Pak and Nihon Tetra Pak, we have been able to implement a seamless process from collection to product usage. The adoption of recycled corrugated boxes is an important model case that clearly conveys the value of resource circulation to consumers. As part of our corporate partnership-based material recycling brand "Renewa", we will continue to expand the "circle" of resource circulation.

\*1: Verified by Carbon Trust™ - based on Tetra Pak Carton CO<sub>2</sub> Calculator model version 11. Scope: Measure the entire product lifecycle (from raw material procurement to disposal) by comparing the Tetra Gemina® Aseptic 1000ml Leaf, which uses plant-based polymer for coating and cap, with the standard Tetra Gemina® Aseptic 1000ml Leaf (world average excluding Europe). The reduction amount may vary slightly depending on the specifications of the packaging materials and accessories.

\*2: Carbon Trust is an international climate change consultancy agency that operates based on the mission of accelerating the transition to a decarbonized future. For more than 20 years, we have been pioneering the support of decarbonization for businesses, governments, and various organizations. We are a global leader in the field of carbon footprints, verifying the

carbon footprints of organizations and value chains worldwide. In the case of Tetra Pak, it shows the carbon reduction rate achieved by switching from conventional packaging (using fossil resource-derived polymers) to paper packages using plant-derived polymers. The certification process evaluates the entire lifecycle of paper packages, but does not include the contents of the paper packages.

\*3: Bonsucro is a leading global sustainability platform and certification standard in the sugarcane sector. This is a global organization aimed at accelerating sustainable production and use of sugarcane by focusing on addressing climate change, respecting human rights, and creating value in the supply chain. The international network of Bonsucro has more than 300 members from over 50 countries. For more details, please visit [www.bonsucro.com](http://www.bonsucro.com)

\*4: According to Nihon Tetra Pak (as of January 2026)/A survey focusing on large aseptic carton package (500ml or more) sold domestically by Nihon Tetra Pak .

\*5: "Report on the Recycling Flow of Beverage aseptic carton Packages (2023 Fiscal Year)", (Printing Industry Association Liquid Carton Subcommittee / Dynax Urban Environment Institute Ltd.).

### About the Gold-Pak

Gold-Pak is soft drink manufacturer with 66 years in the business, that was the first to commercialize vegetable juice in Japan. At five domestic factories (Eniwa City, Hokkaido; Hirosaki City, Aomori; Omachi City, Nagano; Azumino City, Nagano and Matsumoto City, Nagano), we manufacture beverages in various packages and liquid types. Along with our main vegetable and fruit-based beverages that deliver fresh vegetables and fruits with their delicious taste, we are working to expand the contract production of beverages that contribute to the health of our consumers, thereby contributing to people's "wellness" (healthy living).

Website: <https://www.gold-pak.com/>

### About Tetra Pak

Tetra Pak is a world-leading company in food processing and carton packaging systems, founded in Sweden in 1951. We are committed to ""making food safe and accessible everywhere"" by providing advanced food manufacturing systems. In more than 160 countries worldwide, over 24,000 employees collaborate with customers and suppliers to continuously protect food in a sustainable manner every day.

Under the motto ""PROTECTS WHAT'S GOOD™"" , we protect food, people, and the planet. Tetra Pak is a registered trademark of the Tetra Pak Group.

Website: <https://www.tetrapak.com/ja-jp/>

### About Oji Holdings

Oji Holdings is a leading comprehensive paper and packaging manufacturer in Japan. The company is engaged in a wide range of businesses, including paper and pulp, packaging materials afforestation, with more than 200 consolidated subsidiaries both domestically and internationally, and employs approximately 39,000 people. We nurture healthy forests and create products utilizing these forest resources to deliver to society, tackling global warming and environmental issues, aiming to drive the era towards a hopeful future for the Earth.

Website: <https://www.ojiholdings.co.jp/en/>

#### ■ Related Releases

- Establishment of a recycling system from liquid paper packages to corrugated boxes, initiating towards realizing a circular economy of paper resources

Oji Holdings and Tetra Pak Japan's joint initiative

<https://www.ojiholdings.co.jp/portals/0/resources/content/files/news/2024/jp02tp08.pdf>

- Paper recycling enters ""the next stage"" Oji Group launches new brand 'Renewa'  
Expanding the circle of resource circulation and contributing to the realization of a sustainable society  
[https://www.ojiholdings.co.jp/news/detail\\_002337.html](https://www.ojiholdings.co.jp/news/detail_002337.html)

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