

Innovating our sustainable tomorrow

Flexible packaging High-Performance Sustainable Plastic Solutions



Innovating our Sustainable tomorrow

GCR develops and produces high-performance, sustainable plastic solutions, serving brand owners and plastic processors in search of recycled and **recyclable plastics** and **mineral-based compounds.**

We unlock value for our partners, enabling their **growth** and enhancing their market position thanks to our firm commitment to **innovation** and **cutting-edge technology**.

As a result, our materials are more environmentally friendly, lowering carbon footprint and reducing virgin plastic use without relinquishing the features and performance expected from virgin plastic.



A global benchmark





La Bisbal del Penedès, Barberà del Vallès, Castellet i La Gornal







Production Capacity +500.000 MT/y





What makes us unique?

Customer Centric

At GCR, we thrive on close collaboration with our customers and brand owners. There is undeniable power in doing business together, since we progress and succeed collectively.



Quality is not an option but a principle! Our dedication to maintaining high-quality standards, combined with state-of-the-art technology and exceptional expertise, is one of the cornerstones of our pride.



The second s

Material Science

With over 20 years of experience, we have built a strong foundation, which has allowed us to provide customised and specialised high-performance solutions in specific markets. Our company's adaptability and agility make us unique in delivering exceptional outcomes.



We have set up a dedicated space for innovation and co-creation with our clients. Here, we leverage emerging technologies, expert insights, and a user-centric approach to swiftly introduce sustainable solutions to the market.



Certification

Committed to the highest standards





TÜVRheinland CERTIFIED









ISO 9001 Quality Management system

ISO 14001 Environmental Management system

ISCC PLUS Circular and bio-based products

PAS 2050 Carbon Footprint

UNE – EN 15343 Recyled Content & Traceability

Recyclass Recycling Process for pre-consumer & post-consumer

Biodegradability Home & Industrial Compost, Soil Compost

OCS – Operation Clean Sweep Zero Pellet Loss



Why Sustainability is important What is the business value of sustainability?

According to the Paris Climate Agreement, a maximum temperature increase of 2 °C has been set, but the goal of the international community is to limit that increase to 1.5 °C.

A word of warning: if the current trend continues, we would be heading towards a scenario of around +3 °C by 2100.

- Temperature increase
- Extreme phenomena
- Food insecurity
- Water scarcity
- Species extinction and displacement
- Irreversible sea level rise



270,000

Tonnes of CO₂ emissions saved to our customers thanks to our solutions.

Sustainable investment and its relevance in ESG Companies are already incorporating

sustainability criteria at the time of selecting their **partners** (suppliers, clients, investors, etc.).

Investors are closely focused on companies that have a business strategy with ESG criteria. **This is not a trend** but a reality that reflects a shift in investor behaviour.

How companies can help mitigate the effects of global warming:

- Reduce their impact on the planet by establishing science-based CO₂ emissions reduction goals
- Many Sustainability Pledges for 2030, but not much time left.

Company sustainability risks due to sustainability goals failure:

- Jobs at risk
- Economic penalties
- Activity penalties
- Investor blockage
- Supplier entry barriers



Life Cycle Assessment We know that every step matters

LCA is a systematic approach that evaluates the environmental impact of a product or service throughout its entire life cycle, from raw material extraction to disposal.

BENEFITS: calculating the LCA enables customers to make environmentally conscious choices, sustainable fuel demands, support responsible businesses and collectively contribute to a more sustainable future. businesses, and collectively contribute to a more sustainable and resilient future.

- Informed decision-making
- Comparative analysis
- Eco-friendly design
- Reduced environmental footprint

We conduct 'Cradle-to-Gate' Life-Cycle Assessments for our products in compliance with ISO 14040 series standards, and our Carbon Footprint is certified pursuant to the PAS 2050 guidelines. **Raw Materials** Virgin or Minerals recycled Waste Polymer KM 0 supplier prioritization Transport Measuring Impact: from raw material source to our plants Production Low energy consumption technology. Energy from renewable sources **GCR Material** CICLIC GRANIC GCR GCR BIOGRANIC RGRANIC GCR GCR

Packaging Application

Sustainable packaging CO2 savings **Up to 90%***

applications. However, actual reductions may vary based on the final application and the product used. We work with customers to identify suitable products for optimal CO2 reduction. Composition example for Granic® 282 in Hygienic packaging: By adding 30% Granic® 282 +70% mLLDPE virgin polymer you can reduce 21% of CO2 as opposed to using 100% mLLDPE virgin polymer in hygienic packaging.



Enabling Customers to quickly bring to market sustainable solutions

GCR Innovation Hub provides a unique **2000 m2 co-creation space** in which to run collaborative projects and benefit from our technical expertise, capabilities, and cuttingedge technology. With a team of **+40 people**, we also create value during **in-house sessions** by working closely alongside our clients.

Expert Technical Advisers



Highly knowledgeable technical advisers who are ready to provide you with expert guidance and support.

Testing & Homologation



Sustainable Material Science in new formulations, pilot plant trials, testing and up-scaling to production.

Dedicated R&D Centre



Developing solutions that minimise environmental impact.

Cutting-edge Equipment



Incubation and proof of concept from development to pilot plant and final largescale production.

Together, we can turn your product challenges into success stories



Empowering Seamless Development from Concept to Production

Our **Pilot Plant** serves as a versatile and fully-equipped testing ground, enabling seamless upscaling and development opportunities for projects at any stage. With our state-of-the-art equipment and expertise, we offer the development of new formulations, pilot plant trials, testing, and upscaling to production, providing customization capabilities for applications of both Ciclic® Recycled polyolefins and Granic® mineral masterbatch ranges. Whether you are at the early stages of product development or seeking to optimize existing processes, our Pilot Plant supports your journey towards innovation and sustainable solutions.





Cutting-Edge Equipment and Advanced Functionalities





5-Layer Cast and Blown Film Extrusion System

Versatile, modular, quick-change device for blown and cast film that can be expanded to include additional layers. The system features 5-layer co-extrusion technology, 20 components, an MDO stretching unit, and corona treatment for surface modification of the produced films. With an 800 mm width, 100 m/min outlet speed and 350 kg/h throughput, it delivers high-performance capabilities. It handles various materials, from recycled polyolefins to mineral concentrates of any kind.

Engel 300 t Injection Molding Machine

Injection molding machine equipped to test-run all types of injected parts in real industrial conditions, including components for the automotive, appliances, and agricultural sectors.



Collin Twin–Screw Compounder Extruder Fully customizable, especially suitable for high addition rates of mineral and functional fillers. Configured to handle sensitive materials, including biopolymers, natural fibers, and others.





Pipe Extrusion System equipped with Collin Single-Screw Extruder

Versatile and modular equipment for pipe extrusion, covering a wide range of diameters and thicknesses.

Filament Extrusion System equipped with two Collin MDO units

System capable of producing monofilaments from a variety of materials for diverse applications, including raffia, yarns, and others.



Supporting developments at any stage End-to-end-solutions



Our Deliverables

- Co-creation space
- Discovery of new ideas
- Accelerate action to circularity
- Turnkey Projects
- Recyclability Consultancy Services

Note: Developments are subject to volume threshold and binding agreement

Sustainable Flexible Packaging

Understanding industry challenges





Flexible Packaging

Understanding industry challenges

CUSTOMER NEEDS & TRENDS

Businesses are actively refining packaging designs to:

- Create memorable experiences
- **Stand out** in the market
- Address **environmental** concerns
- Meet sustainability goals

OUR EXPERTISE

At GCR, we work to make sure you don't have to sacrifice PERFORMANCE for improved SUSTAINABILITY.

At our Innovation Hub we create, test, and improve sustainable solutions.

STANDARD PACKAGING REQUIREMENTS

The following requirements are likely to resonate with you, and that's precisely where our expertise lies:

- ▶ Effortless Opening Convenience
- Hermetic Seal
- Extended Shelf Life
- Barrier Properties
- High-Quality Printing
- Lightweight Solutions
- Reducing Carbon Footprint
- Recyclability: Mono PE Film designed for recycling





Sustainable JJ Material Solutions JJ

Flexible Packaging Challenges

Performance Challenges

- Effective barrier properties
- Meeting food safety regulations
- Low energy consumption
- Smooth processability
- High-quality printing

Recycling Challenges

- Consistent performance
- Match or surpass the performance of prime POs
- Seeking narrow specifications
- SOI's under control
- Material compatibilization
- Reliable feedstock sources

Sustainability Challenges

- ▼ Reduce: material downgauging
- Reuse: reused or repurposed
- Recycle: monomaterials
- Recycled Content: High-quality PCR resins
- Renewable Materials: recycled & biobased
- EOL: designed for recyclability or biodegradation

SustainableMaterial Solutions

Flexible Packaging Solutions

Finding sustainable solutions that can meet the required properties and performance is key to reduce the environmental impact of flexible packaging.

PRODUCT PORTFOLIO

Recycled Polyolefins



Ciclic® is a high-quality recycled and recyclable polyolefin product line.

Mineral Masterbatches





Granic® is our high-performance mineral-based concentrate product line.

SERVICE LEVELS

- Technical Service
- Material Traceability Monitoring
- Certifications
- Cradle to Gate LCA Calculation (backed by UNESCO Chair in Life Cycle and Climate Change)

INNOVATION HUB

Unmatched expertise and resources, driving innovations to tackle market challenges effectively.

Customisation possibilities*.

Driving the Circular Economy

- Understanding PCR Upcycling
- Designing for recyclability
- Assessing Recyclability

Enhancing Performance and Sustainability

- Innovative Compatibiliser Technology
- Neatly Blending & Odourless Technology
- Lightweight Solutions
- Pioneering Compostable Solutions
- Reducing Carbon Footprint and and LCA assessment

*Subject to MRQ and LT agreements

Sustainable Flexible Packaging Solutions





Hygienic wrap packaging

Granic[®] LLDPE – Ultra-Fine CaCO3

Granic® is a specialised mineral masterbatch designed to deliver a matte effect while preserving the transparency of PE flexible packaging. Excellent alternative solution to HDPE materials.

PERFORMANCE

- Balanced Stiffness: Considerably boosts LLDPE rigidity, matching HDPE stiffness
- Mechanical properties: Significantly enhances strength compared to HDPE
- Matting effect: Adds a matte appearance and silky touch to PE film
- Transparency: Maintains transparency with a similar refractive index to PE resins

KEY ADVANTAGES

- Matting effect
- High transparency
- Better mechanical properties than HDPE (e.g., Tear and Impact Resistance)
- Good optical properties
- ▼ Increase in barrier properties of LLDPE
- Same sealing strength at a lower sealing temperature (for example, instead of 115 °C, it can be reduced to 105 °C

SUSTAINABILITY

Composition Example: 70% mLLDPE + 30% Granic[®] LLDPE | CaCO3

21% CO₂ reduction



- Lower Carbon Footprint
- Energy Efficiency
- Granic[®] is Pas 2050 Carbon Footprint certified
- A complete LCA can be performed on Granic[®]



Hygienic wrap packaging

Ciclic[®] White - rLDPE PCR

KEY ADVANTAGES

- Eco-friendly solution for personal care products
- Odour-free
- Good printability
- Low volatile and moisture content
- ▶ 100% recycled and environmentally friendly product

SUSTAINABILITY

Ciclic[®] added at 50% content

Ciclic[®] rLDPE is 0.136 kg of CO₂ equivalents per kg

46% CO₂ reduction



▶ 100% recyclable solution







Labels, Wrap & Lamination Films

Granic[®] Pearlised BOPP Film

Granic[®] is a calcium carbonate additive specially developed for pearlised cavitated BOPP films.

It provides an optimal balance between low density and stiffness, leading to high tensile strength films for a broad range of converting processes.

PERFORMANCE

- Strength | Achieves optimal stiffness for high-speed converting stages such as cutting and drawing
- ▼ Optics | Provides an exceptional pearlescent effect
- Higher Dosage | With higher dosages, maintains the same film density and replaces a higher percentage of PP

KEY PERFORMANCE

- ▶ Up to 40% dosage (core layer)
- Best cavitation performance (PSD design)
- High Opacity, Less TiO2 needed
- Fewer Impurities (more whiteness)
- No Lubricants or Wax (no migration no delamination)
- No defects no white spots
- Improved Mechanical Properties (higher elongation and modulus)
- Similar Gloss (or slightly higher)
- Uniform thickness (comparable to PBT solution)

SUSTAINABILITY

- Lower Carbon Footprint
- Energy Efficiency
- ▼ Granic[®] is **Pas 2050** Carbon Footprint certified
- A complete LCA can be performed on Granic[®]

TÜVRheinland CERTIFIED







Granic[®] LLDPE – Ultra-Fine CaCO3

strength.

Granic[®] LLDPE | CaCO₃ is

applications, enhancing the

mechanical properties of the

material, particularly in sealing

well-suited for pouch packaging

PERFORMANCE

- Structure= 3 Layers (20|60|20)
- Thickness= 113 µm. Granic® allows to reinforce the film and reduce thickness
- Granic[®] LLDPE | CaCO₃ can be used in the sealing layer at up to 25% to seal at lower temperatures without losing sealing strength

KEY ADVANTAGES

- Enhanced mechanical properties
- Approved for Food Contact
- Sealing strength
- Good optical properties

SUSTAINABILITY

Composition Example: 25% dosage of Granic in film

20% CO₂ reduction

compared to using 100% LLDPE virgin polymer



- Lower Carbon Footprint
- Energy Efficiency
- ▼ Granic[®] is **Pas 2050** Carbon Footprint certified
- A complete LCA can be performed on Granic[®]





PE Bags Improved barrier properties

Granic[®] | Enhanced barrier properties

Are you looking for a competitive and transparent MB Filler with enhanced barrier properties?

Granic® offers a specialised mineral masterbatch grade designed to significantly improve the barrier properties of PE, including OTR and WVTR, while maintaining transparency.



KEY ADVANTAGES

- Barrier properties are significantly improved
- Good optical properties
- Excellent balance between stiffness and flexibility
- Great Performance
- Ease extrusion
- Energy Saving | less energy is needed to melt and homogenise the blend

SUSTAINABILITY

- Lower Carbon Footprint
- Energy Efficiency
- Granic[®] is Pas 2050 Carbon Footprint certified
- A complete LCA can be performed on Granic[®]





Paper-like Food Packaging

Granic[®] HDPE – Ultra-Fine CaCO3

PERFORMANCE

- Higher Stiffness
- Good Drop Impact
- Excellent stackability

KEY ADVANTAGES

- Luxury Appearance
- Soft Touch
- Superior Mechanical Properties
- Exceptional Print Quality
- Recyclability
- Enhanced Impermeability to Fats and Moisture Highly Versatile and Replicable for Multiple Applications, even with the same structure
- Provides a paper-like folding experience, adding body and stiffness to the packaging
- Enables a reduction in thickness without compromising performance
- Eliminates the need for post-treatments like waxing or coatings
- Easy to Seal and Highly Resistant

SUSTAINABILITY

- Lower Carbon Footprint
- Energy Efficiency
- Granic[®] is Pas 2050 Carbon Footprint certified
- A complete LCA can be performed on Granic[®]



Granic® HDPE grade is a mineralbased masterbatch containing extra white, treated, and ultrafine calcium carbonate with an excellent dispersion rate. It is ideal for paper-like films, also referred to as synthetic paper.

Granic® HDPE grade can replace up to 80% of virgin HDPE, enhancing key properties such as printability, foldability, stiffness, and soft touch. Additionally, thanks to its whiteness and opacity the pigment dosage required can be reduced.



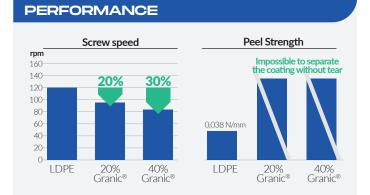


Coating Sachets

Granic[®] LDPE - CaCO3

Granic® provides a specialised mineral masterbatch tailored to meet the rigorous demands of the extrusion coating process, even under high-temperature conditions.

Its unique formulation blends specially treated CaCO3 with a high-quality LDPE carrier, offering a sustainable solution that efficiently replaces substantial quantities of PE.



KEY ADVANTAGES

- Excellent Processing | Enables high line speed without die build-up
- Adhesion | Outstanding adhesion to paper, cardboard, and aluminium
- Stable Sealing | Good sealing properties, ensuring airtight and secure packaging
- Energy Efficiency | Contributes to lower power consumption, promoting cost savings and sustainability

SUSTAINABILITY

- Lower Carbon Footprint
- Energy Efficiency
- Granic[®] is Pas 2050 Carbon Footprint certified
- A complete LCA can be performed on Granic[®]







Heavy Duty Sacks | FFS

Delivered to over 100 countries, Including extreme climates

Granic[®] STRENGTHENS FFS



Granic® provides a specialised mineral masterbatch formulated with highly technical and ultrafine CaCO3, ensuring an excellent dispersion rate. When combined with highquality LLDPE, it significantly enhances the mechanical properties of the film, resulting in increased toughness and tear resistance.

KEY ADVANTAGES

- Mechanical properties enhancement | Impact and Tear testing
- ▼ Good resistance to creep | Guaranteed, as elongation is kept far below the non-acceptance limitation
- Efficient Impact Energy Dissipation
- Allows to achieve thickness reduction

SUSTAINABILITY

Granic[®] added at 30% content

21% CO₂ reduction

- Lower Carbon Footprint
- Energy Efficiency
- Granic[®] is Pas 2050 Carbon Footprint certified
- A complete LCA can be performed on Granic[®]





Flexible Tubes

Granic[®] HDPE - CaCO3

Granic® provides a tailored mineral masterbatch for HDPE tubes, using fine calcium carbonate to enhance tube performance, particularly in varying temperatures.

PERFORMANCE

Stiffness and flexibility balance | Granic[®] HDPE - CaCO3 provides strength and an optimal balance between stiffness and flexibility.

KEY ADVANTAGES

Dosage up to 30%

- Matte effect
- Soft touch
- Excellent processability
- Enhance dimensional stability

SUSTAINABILITY

Granic[®] added at 30% content

23% CO₂ reduction



- Lower Carbon Footprint
- Energy Efficiency
- Granic[®] is Pas 2050 Carbon Footprint certified
- A complete LCA can be performed on Granic[®]





Collation Shrink Film

PERFORMANCE

- Good optics
- Good processability
- Maintains Shrinkage up to a dosage of 30%
 Note: Limited availability

KEY ADVANTAGES

- Good tear resistance
- Allows for reverse printing. Film clarity
- Excellent processability
- Low gel and impurity content

SUSTAINABILITY

LDPE prime is 1.91 kg of CO2 equivalents per kg

 $\text{Ciclic}^{\scriptscriptstyle{(\!\!R)}}$ rLDPE is 0.136 kg of CO2 equivalents per kg

Ciclic[®] rLDPE at 50% content.

46% CO₂ reduction



Ciclic[®] – rLDPE

Ciclic[®] rLDPE provides

an outstanding mechanical performance when used in the central layer of collation film structures. It can successfully replace a significant amount of virgin polymer in transparent film, and even higher in opaque films.

It has been especially designed to replace partially or completely virgin polymer formulations. Ciclic[®] enables compliance with legal requirements for recycled content.





Recyclable Soil & Fertiliser Bag B&W Films

Ciclic[®] - rLDPE PCR

Ciclic® stands out as a premium rLDPE PCR solution, making it possible to replace up to 80% of LDPE virgin polymer while benefiting from its outstanding processability.

Ciclic[®] products are designed to replace high polymer content, enabling manufacturers to certify their products with labels such as Blue Angel.

PERFORMANCE

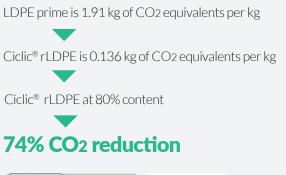
Sustainable Soil Bag 80% Ciclic

| Thickness | 60 µm | T.Strength MD | 25N |
|----------------|--------------|-------------------|------|
| Film structure | 3 layer coex | T.Strength CD | 25N |
| Capacity | 20 L | Impact Resistance | 300g |
| PCR Certified | RecyClass | | |

KEY ADVANTAGES

- Enhanced Whiteness | Ciclic[®] can save some % TiO2 MB thanks to its strong white colour
- Successful Virgin Replacement | Very good COF, puncture, dart and elongation performance. No impairment of mechanical properties
- **Smooth Productio**n | Contains no bubble-bursting gel
- Good Printability

SUSTAINABILITY









Recycled E-Commerce Protection Air cushions

PERFORMANCE

E-commerce Air Cushion

| Puncture Test (ASTM D5748) | PASS |
|------------------------------|------|
| Tensile Strength (ASTM D882) | PASS |
| COF Test (ASTM D 1894) | PASS |
| Seal Window (InternalMethod) | PASS |

KEY ADVANTAGES

- High Quality PCR | Ciclic[®] runs smoothly in the blown film line at high quantities, enabling stable and high output film production
- Maintains Full Functionality | No performance loss is appreciated in comparison with the original virgin polymer structure

SUSTAINABILITY





Ciclic[®] — rlldpe PCR

The e-commerce market continues to grow, and Ciclic[®]

presents a sustainable plastic solution tailored to this industry. It enables a reduction in film thickness while maintaining excellent mechanical properties and optimal functionality in product usage.

50% LLDPE virgin polymer can be successfully replaced by Ciclic[®].





Courier Bags B&W Films

Ciclic[®] – rLDPE

Replace up to 80% of virgin LDPE with Ciclic® high-quality LDPE PCR grade, ensuring excellent processability and a more sustainable product.

Ciclic® grades can adapt to a variety of aesthetic, physical, and mechanical properties.



- Enhanced Whiteness
- Optimal sealing properties
- Successful Virgin Replacement | No impairment of mechanical properties
- Smooth Production | Contains no bubble-bursting gel

SUSTAINABILITY



Estimation of the Carbon Footprint Reduction

| | | Reference | New Solution |
|---|---|-----------|---------------------|
| Α | LLDPE | 85% | |
| | White-constant component | 15% | 15% |
| | Ciclic [®] rLDPE | | 85% |
| В | LDPE | 90% | |
| | Granic [®] LLDPE - Ultrafine CaCO3 | | 20% |
| | White-constant component | 10% | 10% |
| | Ciclic [®] rLDPE | | 70% |
| С | LLDPE | 97% | |
| | Black-constant component | 3% | 3% |
| | Ciclic [®] rLDPE | | 97% |

Total CFP reduction with 25/50/25 as a structure: 92%

| Layer | CFP Reduction for each layer (approximative values) |
|-------|---|
| A | 93,1% |
| В | 90,9% |
| С | 93,1% |

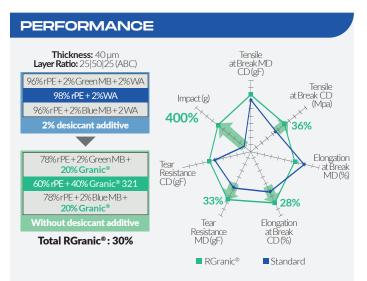
CO2 emission for the virgin polymers extracted from GaBi 4 database according to GWP (Global Warning Potencial). Ciclic® and Granic® values obtained by Life Cycle Assessment (LCA) carried out by TÜV Rheinland.





Flexible Packaging Films

RGranic[®]



KEY ADVANTAGES

- Strengthens rPE
- Moisture scavenger savings.
- ▶ High virgin PE replacement
- Improves bubble stability

SUSTAINABILITY

- Lower Carbon Footprint
- ▶ RGranic[®] is **Pas 2050** Carbon Footprint certified
- A complete LCA can be performed on RGranic[®]



RGranic[®] is a sustainable advanced mineral masterbatch treated with ultrafine CaCO3 and our **Ciclic**[®], 100% recycled PE, offering excellent performance.

This product is highly recommended for flexible films, especially when PCR is used, such as consumer bags, agricultural film, industrial film, and construction film.





High—quality sustainable plastics for flexible packaging

Comprehensive packaging solutions.

PERFORMANCE & SUSTAINABILITY

Our innovative materials combine the best of both worlds: an exceptional performance and a commitment to sustainability. •

We work to ensure you don't have to sacrifice PERFORMANCE for improved SUSTAINABILITY.

CHALLENGES

We understand and solve flexible packaging challenges such as superior durability, **barrier properties**, hermetic sealing, good **printability** or **smooth processability**, offering design flexibility to enhance recyclability and reduce CO₂.

INNOVATION HUB

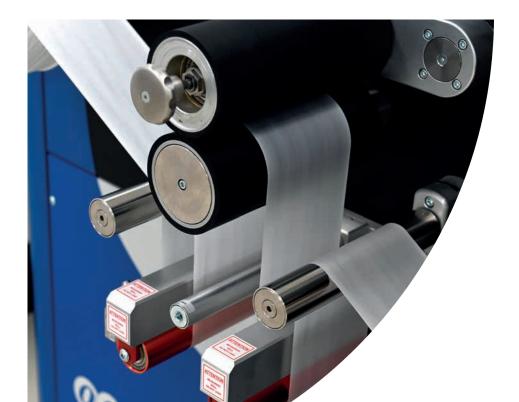
We can support **customised solutions at any stage of the development** process through our innovation hub capabilities. Testing and homologation services can be offered in-house or on the customer's premises.

TRACEABILITY

Our plastics are sourced responsibly, incorporating recycled content and renewable resources that are traceable throughout our manufacturing process. This not only reduces our carbon footprint but also promotes a circular economy.

COMPREHENSIVE SOLUTION

Join us in revolutionising packaging – where excellence meets sustainability.







GCR Headquarters Sustainable Plastic Solutions

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Production Plants

La Bisbal del Penedès

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Barberà del Vallès

Carrer Gorgs Lladó nº16-30 Pol. Ind. Can Salvatella, 08210, Barberà del Vallès, Barcelona, Spain.

Castellet i la Gornal

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