

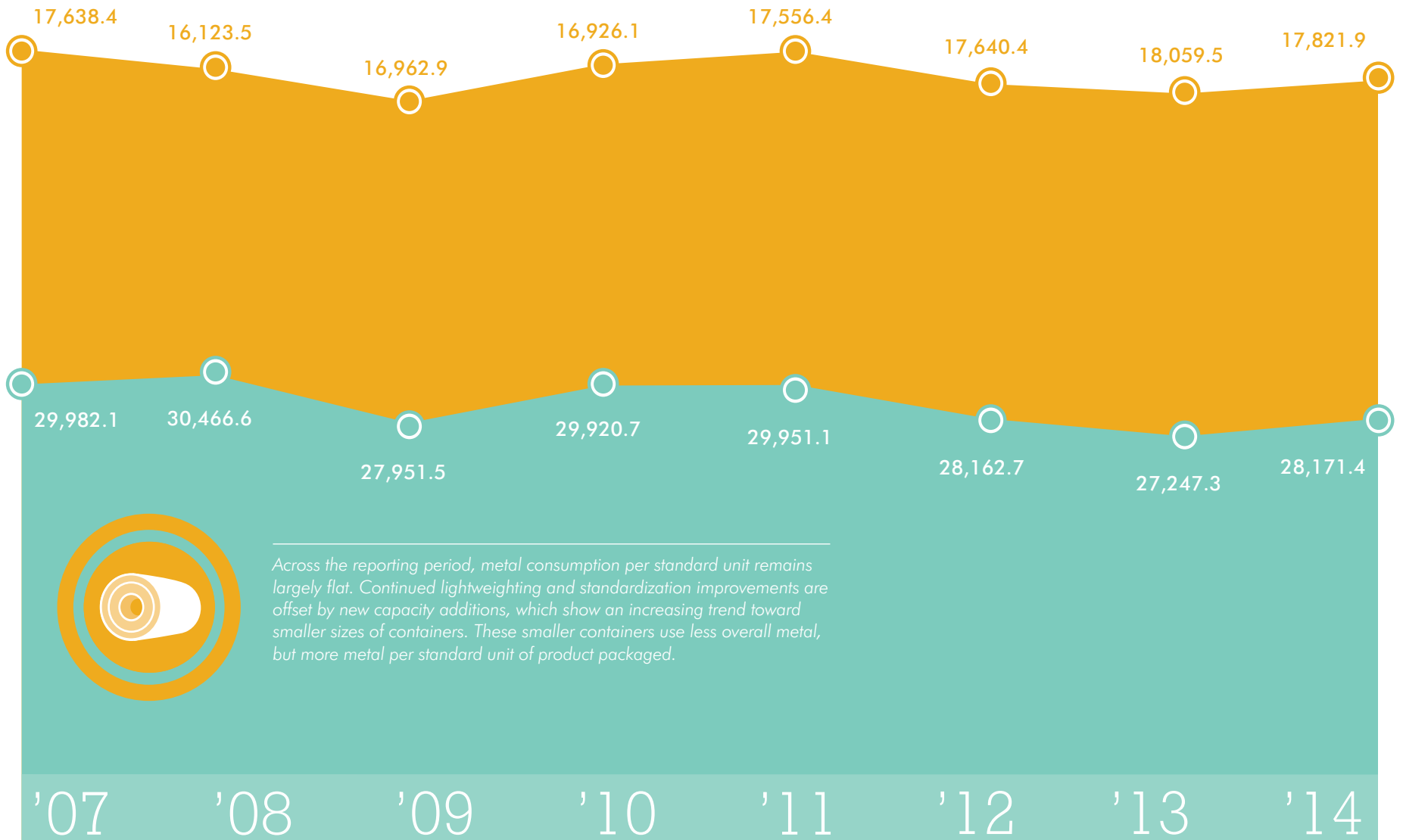
Raw Material Use:

Steel and Aluminum

Aluminum

Steel

(Tons per billion standard units)



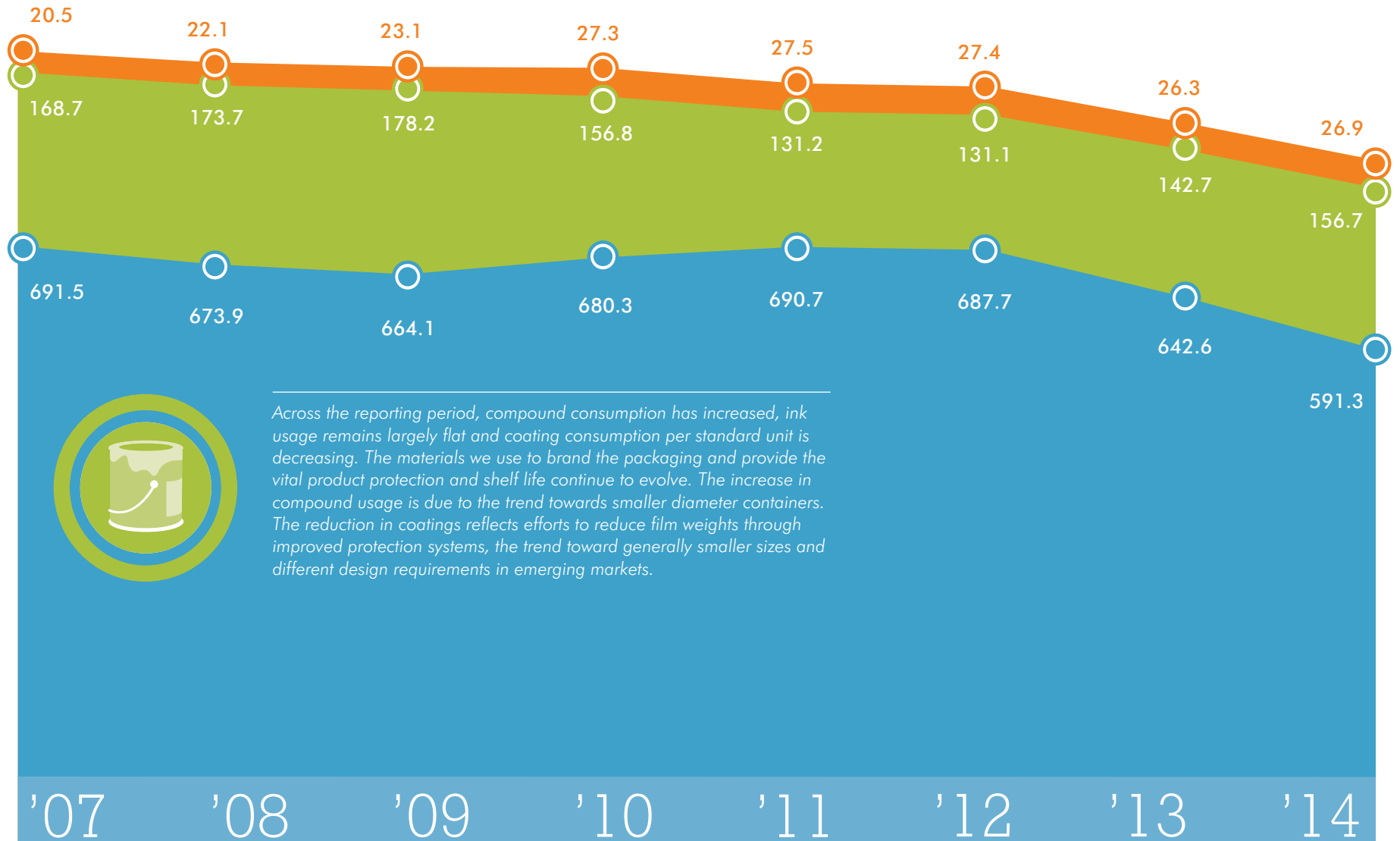
Across the reporting period, metal consumption per standard unit remains largely flat. Continued lightweighting and standardization improvements are offset by new capacity additions, which show an increasing trend toward smaller sizes of containers. These smaller containers use less overall metal, but more metal per standard unit of product packaged.

Raw Material Use:

Coatings, Inks and Compounds

Protection and Decoration (tons per billion standard units)

- Inks
- Compounds
- Coatings



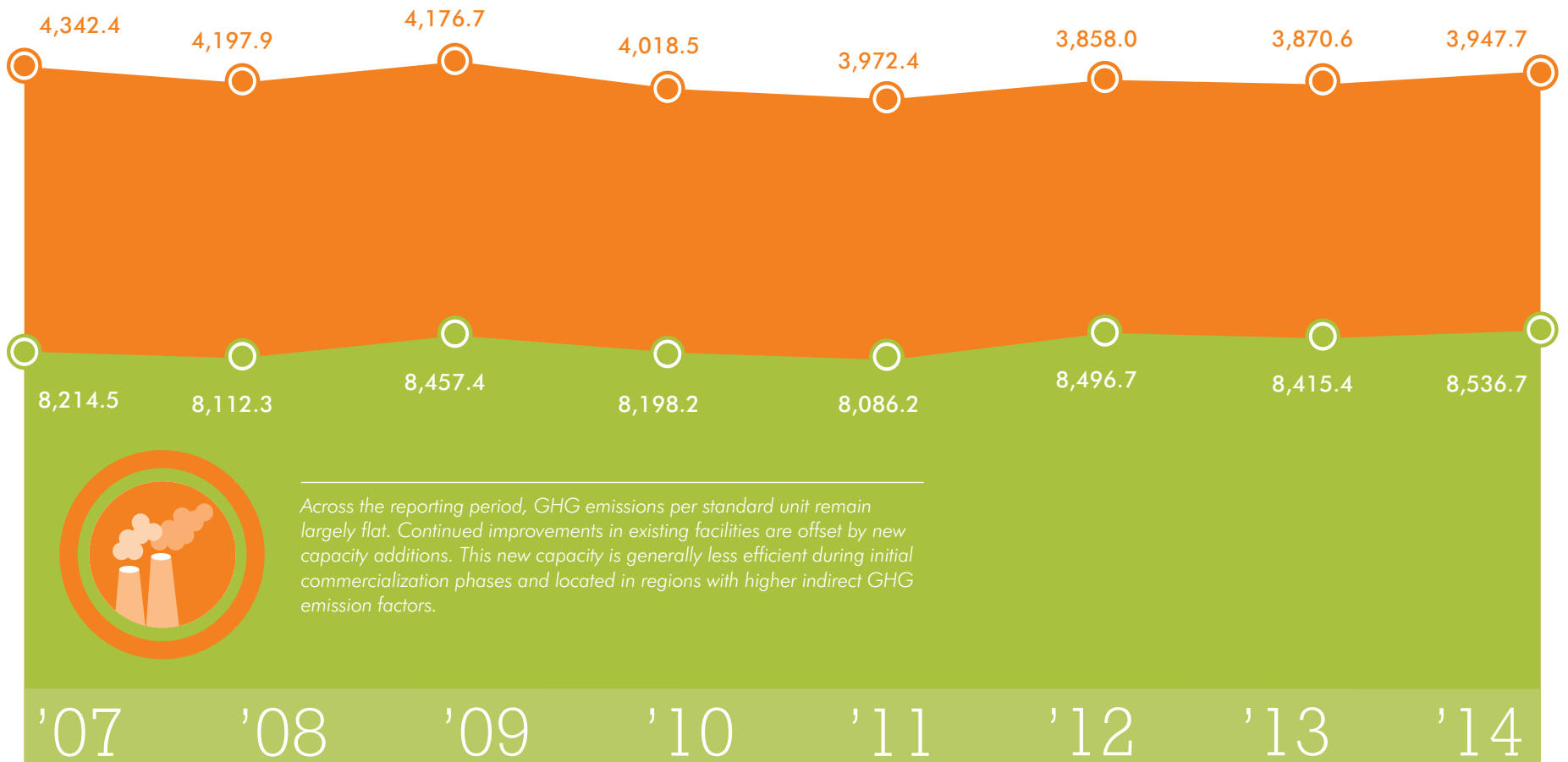
Across the reporting period, compound consumption has increased, ink usage remains largely flat and coating consumption per standard unit is decreasing. The materials we use to brand the packaging and provide the vital product protection and shelf life continue to evolve. The increase in compound usage is due to the trend towards smaller diameter containers. The reduction in coatings reflects efforts to reduce film weights through improved protection systems, the trend toward generally smaller sizes and different design requirements in emerging markets.

Direct and Indirect

GHG Emissions

(Tons per billion standard units)

GHG Direct
GHG Indirect



Across the reporting period, GHG emissions per standard unit remain largely flat. Continued improvements in existing facilities are offset by new capacity additions. This new capacity is generally less efficient during initial commercialization phases and located in regions with higher indirect GHG emission factors.

VOC and NOx Emissions

(Tons per billion standard units)



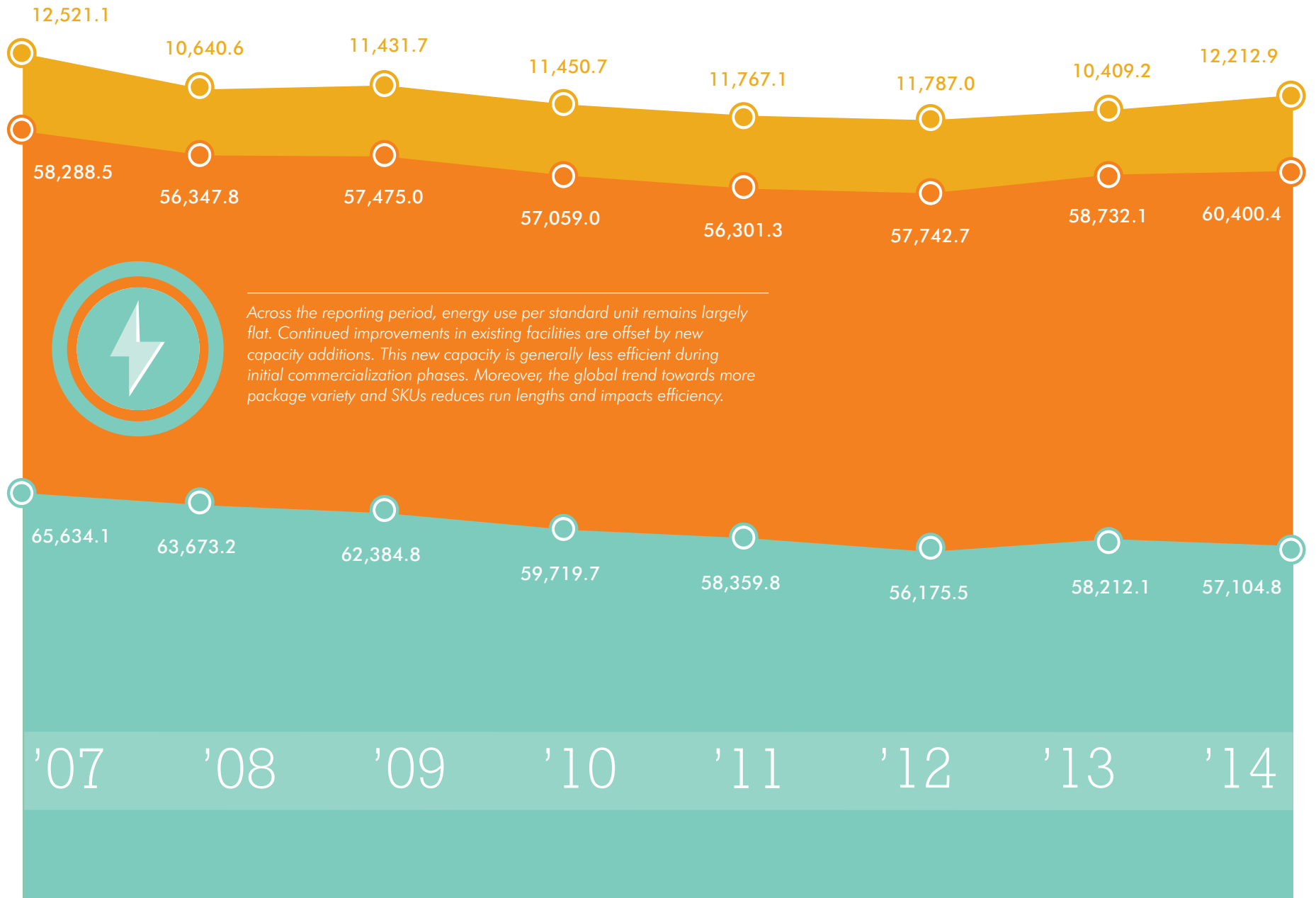
Across the reporting period, VOC emissions per standard unit continue to decrease, but at a slower rate than during the previous reporting period. VOC emissions are a result of Crown's coating operations where optimization of coating film weights, continued investment in control technologies and use of water-based materials drive the downward trend. However, this is largely offset through changes to food coatings as we move away from epoxy-based materials to materials that require higher coating weights and therefore more coating mass to achieve adequate protection. This offset should become more significant in future reporting periods.

Across the reporting period, NOx emissions per standard unit remain largely flat with an increase in 2014. Continued improvements in existing facilities are offset by new capacity additions. This new capacity is generally less efficient during initial commercialization phases. Moreover, the global trend towards more package variety and SKUs reduces run lengths and impacts efficiency.

Energy Consumption

(Tons per billion standard units)

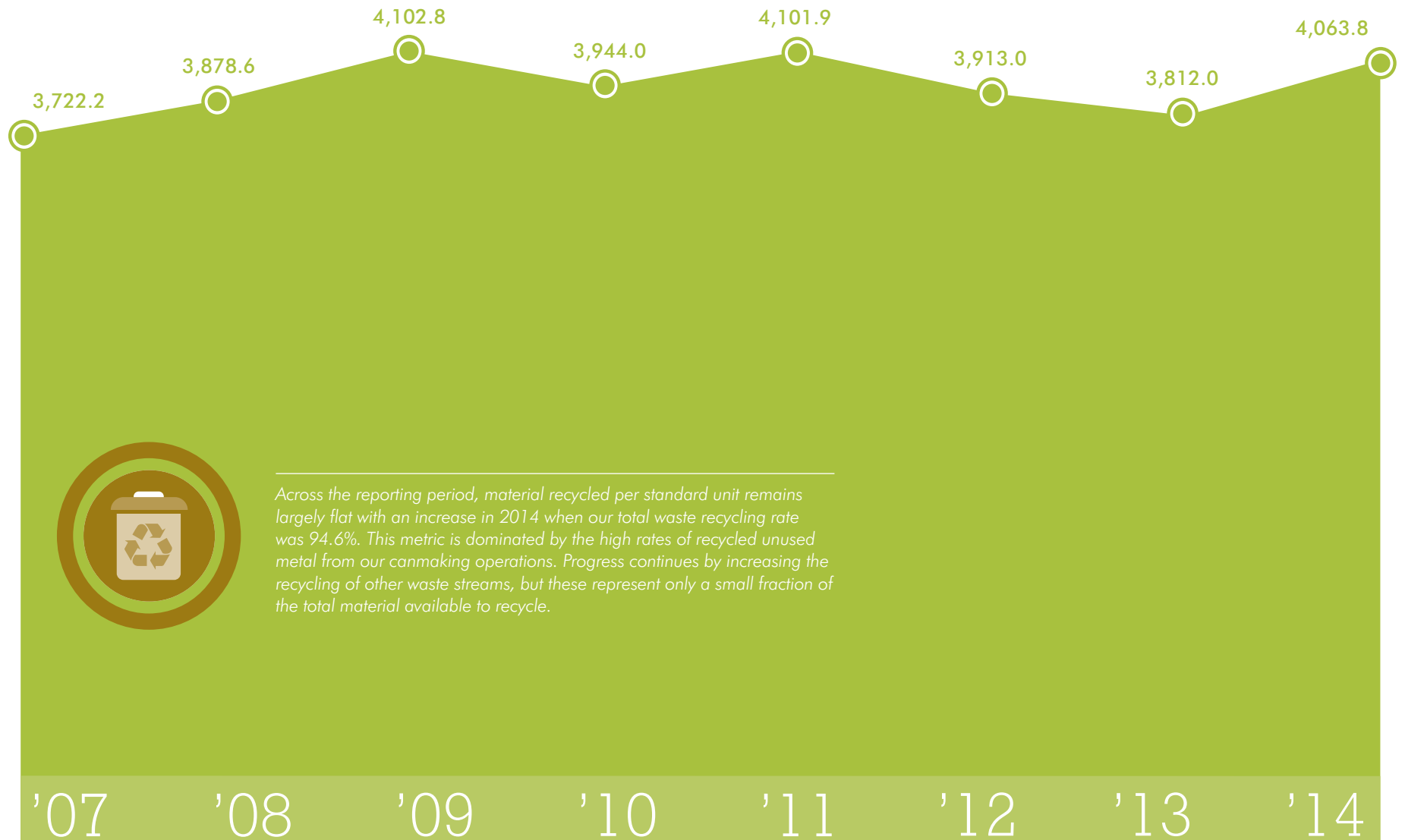
- Propane (Direct)
- Electricity (Indirect)
- Natural Gas (Direct)



Waste Recycling and Reuse

Recycled

Recycled (tons per billion standard units)

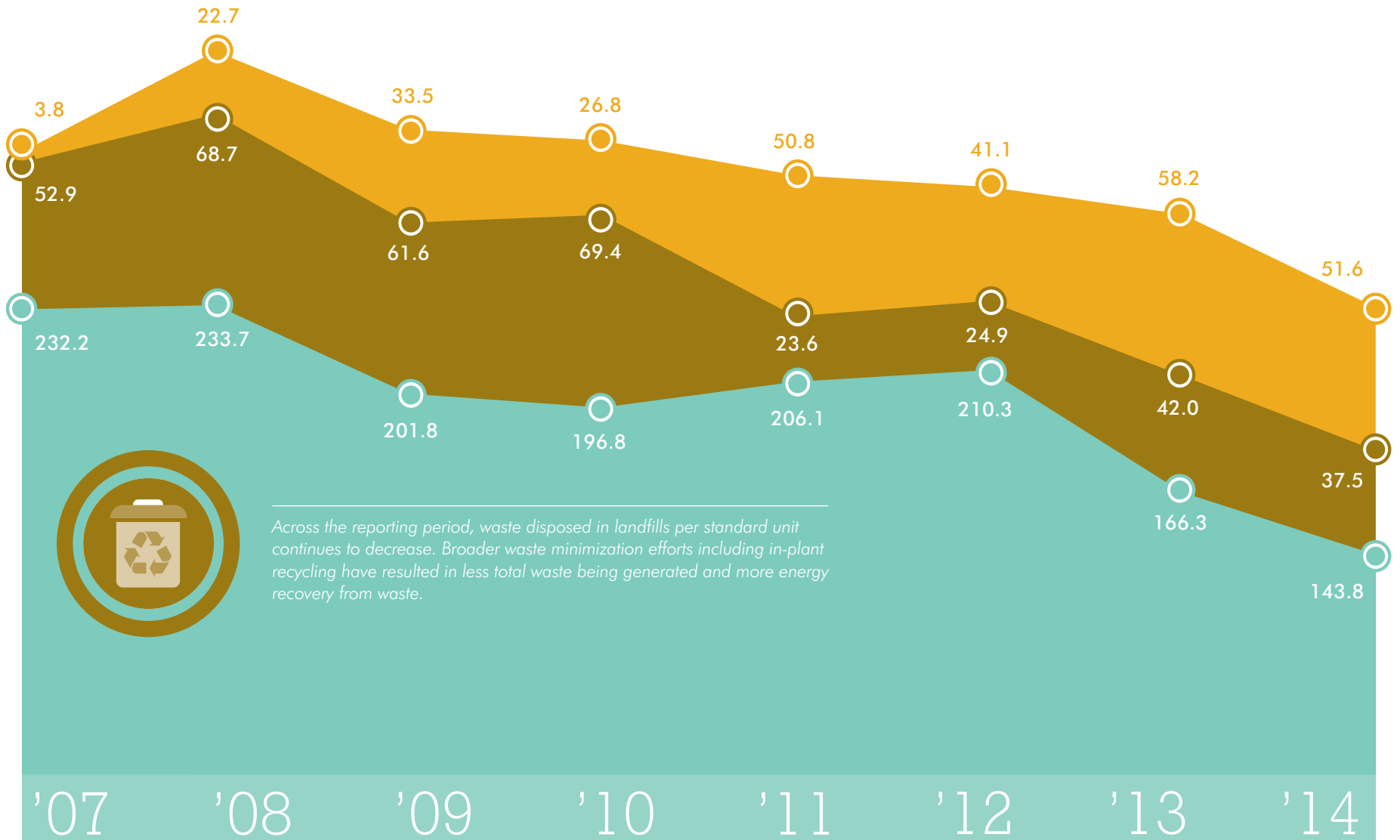


Across the reporting period, material recycled per standard unit remains largely flat with an increase in 2014 when our total waste recycling rate was 94.6%. This metric is dominated by the high rates of recycled unused metal from our canmaking operations. Progress continues by increasing the recycling of other waste streams, but these represent only a small fraction of the total material available to recycle.

Waste Disposal

(Tons per billion standard units)

- Energy Use
- Other Disposal
- Landfilled



Across the reporting period, waste disposed in landfills per standard unit continues to decrease. Broader waste minimization efforts including in-plant recycling have resulted in less total waste being generated and more energy recovery from waste.