



**Beyond creating
fabrics, we
are weaving
a sustainable
future.**

SUSTAINABILITY REPORT 2024

VANELLI



Introduction

Strategic Approach to
Sustainability

Governance

Social

Environmental



This report has been prepared by Vanelli Textile to transparently share our commitments and performance in the areas of Environmental, Social, and Governance (ESG).

By placing sustainability at the core of our business strategy, we aim to leave a more livable world for future generations.

In this context, we present the steps we have taken and the commitments we have made for the future in line with ESG principles.

At Vanelli, empowered by the trust of our stakeholders, we will continue to create sustainable value for tomorrow.



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— About Vanelli

Founded in 1932, Türkün Holding is one of Turkey's oldest textile manufacturing and export companies and is part of the Türkün family-owned group of companies. Its operations were initiated in 1932 by Ali Vehbi Türkün. In 1947, the company was passed on to the second generation, Saadettin Türkün. In 1976, Erol Türkün, who completed his textile engineering education in Germany, established Erol Türkün Textile Company with the support of his father, Saadettin Türkün. The company moved to the Bursa Organized Industrial Zone, established in 1983 as Turkey's first organized industrial zone. In 1989, Erol Türkün founded Dina Vanelli Foreign Trade Company and began exporting.

In 1991, Türkün Textile was established, followed by the launch of Mega Textile Company in 1993. In 1997, with the vision of Erol Türkün's wife, Tülin Türkün, the Vanelli Confection Company was founded, and the company, which specialized in home textile production, opened the first Deco Center store. At this store, home textile products and home décor items were sold, and a store chain quickly formed. In 2013, Deco Center launched its online sales page. As of January 2022, the Türkün Holding companies—Maga Textile, Türkün Textile, Vanelli Confection, and Dina Vanelli—merged under a single roof as VANELLİ Textile San. Tic. A.Ş. within the framework of corporate sustainability and transformation efforts.





—About This Report

We are pleased to share with you the second edition of our Sustainability Report, prepared with an integrated perspective at Vanelli. Aware of our responsibilities towards the planet, humanity, and the business world, we aim to share our progress on the sustainability journey with you, our valued stakeholders, through our annual sustainability reports.

This Sustainability Report for 2024 includes our Sustainability Strategies, goals, and progress in the areas of Environmental, Social, and Governance (ESG), along with our performance metrics.

In this report, we present our integrated management system, strategies, practices, goals, and the progress we made in 2023 in environmental, social, governance, and financial areas.

Our report also highlights our contributions to the United Nations (UN) Global Compact principles and the "2030 Agenda for Sustainable Development Goals" published by the UN.

Prepared in compliance with the "Core" option of the Global Reporting Initiative (GRI) Standards, our sustainability report covers the reporting period from January 1, 2024, to December 31, 2024.

The reporting frequency is set at one year, and the activities at Vanelli Textile's production facility in the Bursa Organized Industrial Zone are the focus of this report.



United Nations Global Compact (UNGC)



Global Reporting Initiative (GRI) Standards



—Message from the Management



Chairman of the Board

Erol Türkün

We are a family-owned business supported by a passion for interior decoration that has continued for four generations. Our story began in 1932 as a home textile manufacturer. Since then, thousands of people have worked around the looms, weaving their ideas and projects. Today, we can summarize this story in two concepts: Innovation and creativity. Vanelli manufactures home textiles and accessories for both commercial and residential interiors. We provide our customers with high-quality fabrics and set the industry standard for interior fabrics in residential and commercial spaces. We offer a wide variety of woven fabrics, including plain, textured, and jacquard, as well as printed fabrics in narrow and wide widths.

These fabrics are designed for use in curtains, sheer and semi-sheer draperies, upholstery fabrics, and multi-purpose fabrics.

Among our functional fabrics are blackout and low-light permeability curtains, acoustic fabrics, and outdoor fabrics. Vanelli fabrics meet customer demands for the latest trends in interior textiles, incorporating the newest ideas and features.

We provide flawless service to our customers. From the design process to product creation, from selection to production, we rely on our team every step of the way.



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— Vanelli: A Journey Through Time

1947

The second generation took over the management of the companies under the name Türkün Collective Company. Jacquard drapery and upholstery production continued using genuine and artificial silk.

1976

Erol Türkün, one of the 3rd generation, who completed his Textile Engineering education in Germany in 1976, established the company "Erol Türkün Textile", which carried his name, with 8 looms and started textile production in Duaçınarı district.

1989

"Vanelli Foreign Trade", which played an important role in becoming a world brand, was established in 1989.

1991

The second plant, named "Türkün Textile", was established on a 10,000 square meter land in Bursa Organized Industrial Zone and launched its fabric dyeing and finishing activities.

1996

The first link of the "Deco Center" chain of retail stores selling home textile apparel products produced by Vanelli Apparel as well as imported home accessories and decorative products was established.

2011

We became the first and only Turkish textile company to be awarded the "GOLD MEMBER" award by TREVIRACS in 2011-12-13 consecutively. We became the only Turkish company to win the "Most Different and Special" Trevira CS collection award in the world.

2016

Türkün Academy was founded. Vanelli Textile is the first design center in Türkiye

2019

E-commerce and online sales started with Deco Center.

2023

We won the Environmentally Friendly Facility Award in the TAIDER North Star Program. With Sedex, our supply chain is now more sustainable.

2024

Our natural products are certified with European Flax and EU Ecolabel. We placed 1st in the OSB Green Facility Competition.

1932

Textile sector operations were started by Ali Vehbi Türkün.

1948

Türkün and Beylik families continued their production activities together in Yeşil, Umurbey and Namazgah districts.

1983

Erol Türkün Textile received its first incentive certificate and the year after had imported Italian Somet weaving machines - demand for both quality and capacity boomed right after.

1990

The first export was realized in Germany in early 1990. Heimtextile, the world's largest home textile fair, was attended. Vanelli, Dina and Vanelli Concept brands started to take their place in the world market with different product groups.

2007

Our company switched to SAP and Porini system in order to keep up with technology and increase overall performance.

2012

Lean production trainings were initiated to increase performance in our production. ISO 9001 certificate was updated.

2017

New Management System, RP Digital Transformation and Turquality Brand Program were launched.

2021

All the companies were merged under Vanelli.

2022

New technological advancements were made with the transition to the new ERP program. ISO 14001 and ISO 50001 Certificates were received

— 2024 Highlights



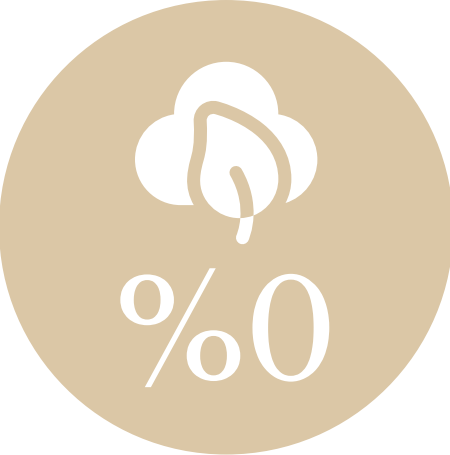
Female Employee Ratio



Customer Count



Annual CoP Statement



Net Zero Emission
Target by 2040



SEDEX Membership



100% BCI Cotton Usage

— 2024 Highlights



Sustainable Chemical
Management



Training per Employee



Employee Turnover Rate



21% of Our Weaving Production
Now Runs on Solar Power



Natural Gas
Savings Rate



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— 2024 HIGHLIGHTS



In 2023, Vanelli became a member of the UN Global Compact and, as of 2024, has started CoP (Communication on Progress) reporting while actively participating in the activities and General Assembly Meetings of the UN Global Compact Turkey Office.



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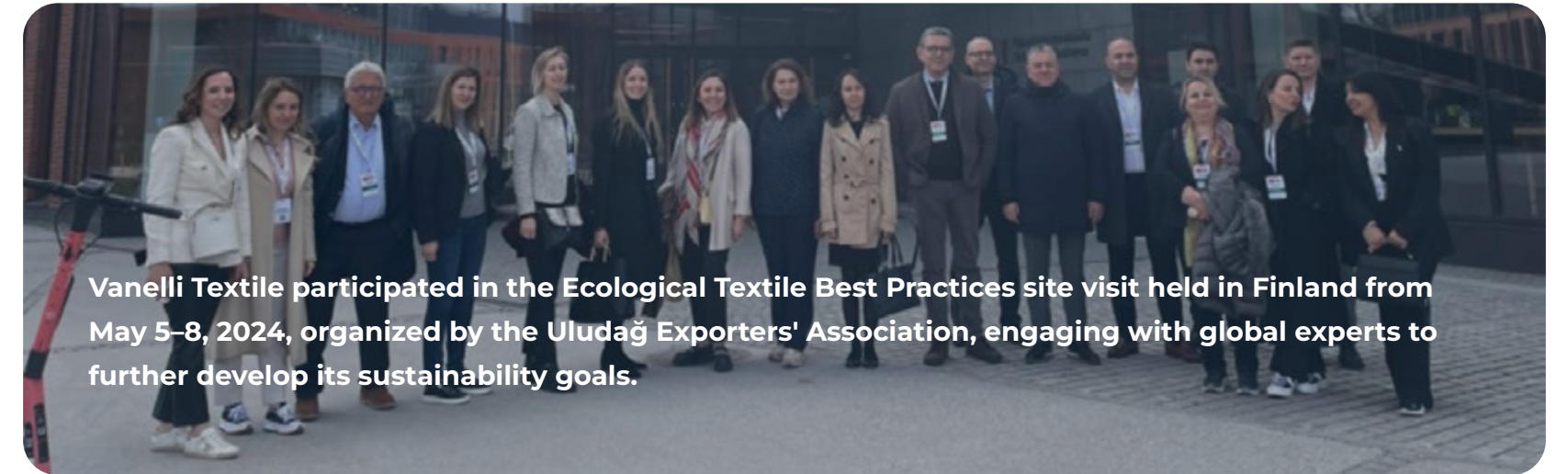
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— 2024 HIGHLIGHTS



Vanelli Textile participated in the Ecological Textile Best Practices site visit held in Finland from May 5–8, 2024, organized by the Uludağ Exporters' Association, engaging with global experts to further develop its sustainability goals.



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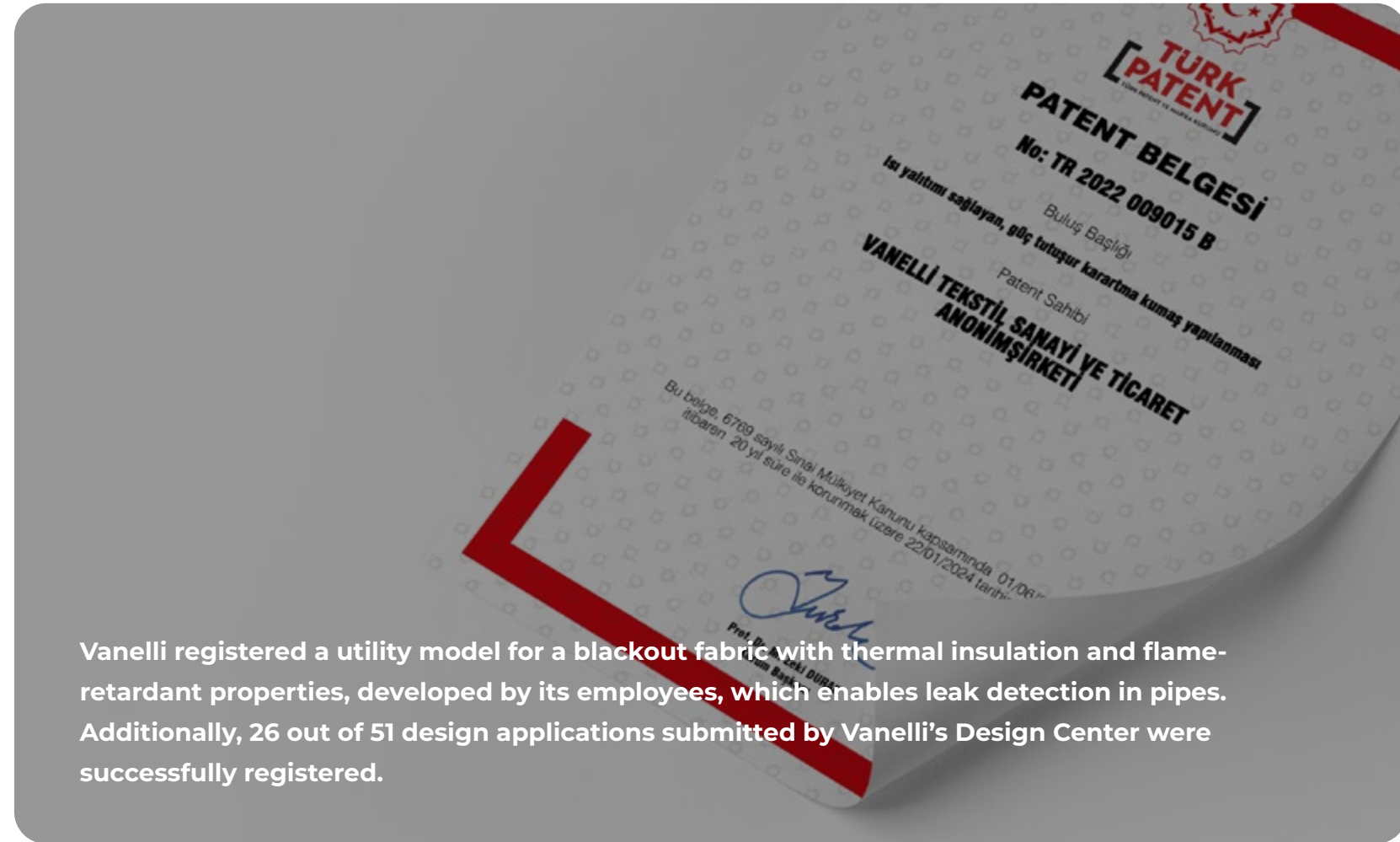
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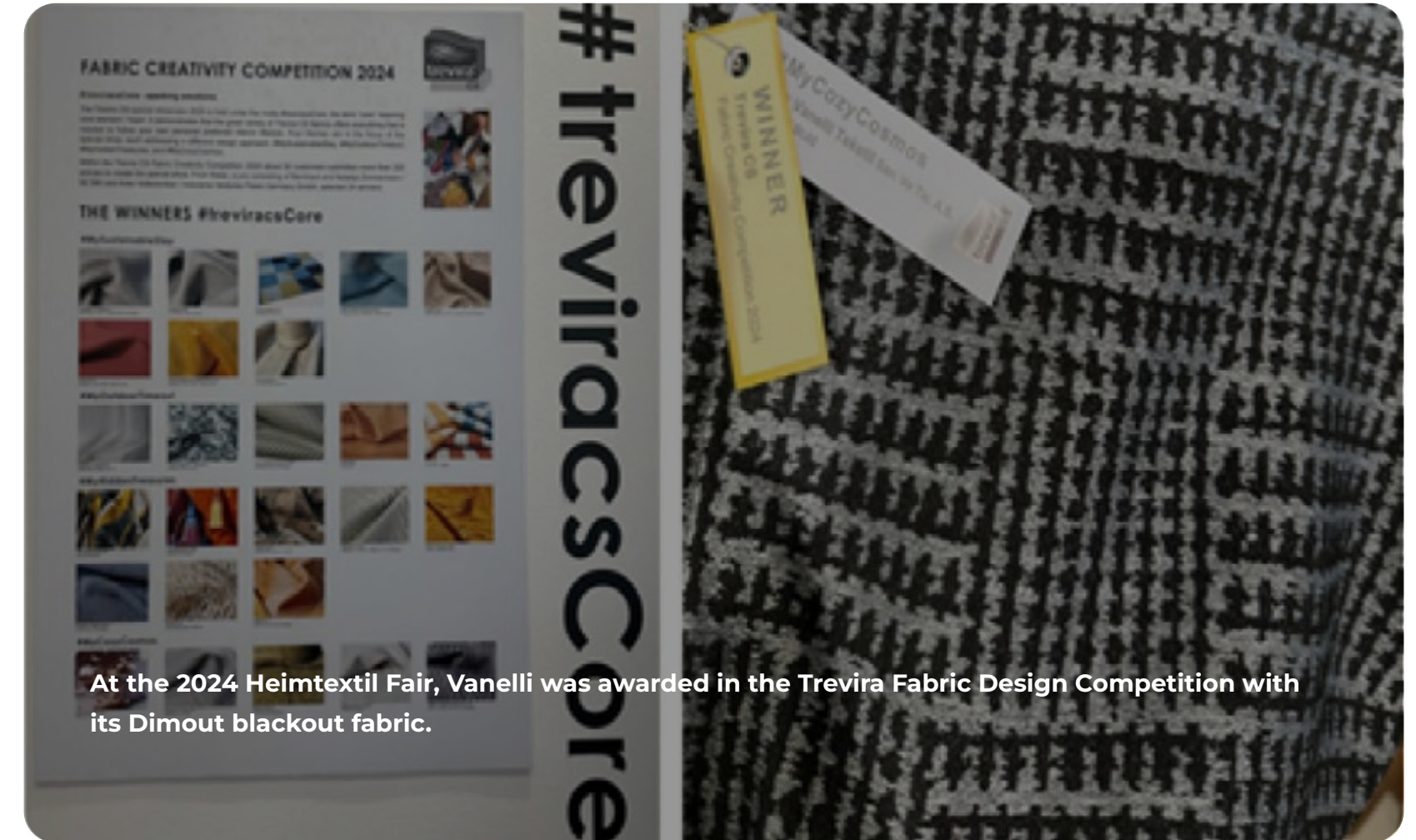


— 2024 HIGHLIGHTS



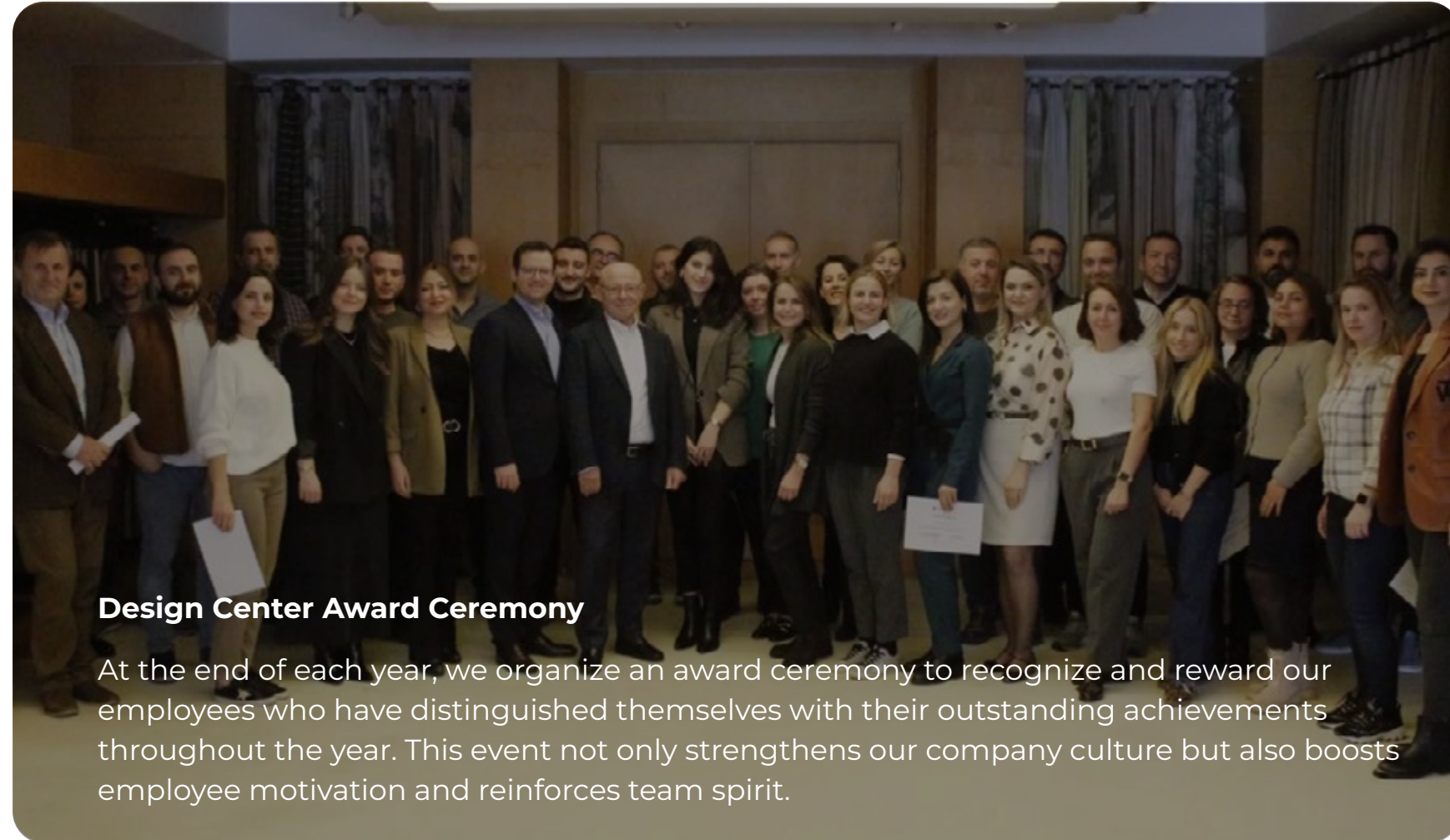
Vanelli registered a utility model for a blackout fabric with thermal insulation and flame-retardant properties, developed by its employees, which enables leak detection in pipes. Additionally, 26 out of 51 design applications submitted by Vanelli's Design Center were successfully registered.

— 2024 HIGHLIGHTS



At the 2024 Heimtextil Fair, Vanelli was awarded in the Trevira Fabric Design Competition with its Dimout blackout fabric.

— OUR AWARDS AND ACHIEVEMENTS



— OUR AWARDS AND ACHIEVEMENTS



— OUR AWARDS AND ACHIEVEMENTS



Sustainable and Traceable Production with European Flax Certification

In 2024, following an audit by an accredited body, we were awarded the European Flax Certification by ensuring transparency and quality across our entire supply chain in accordance with European Flax standards. This certification guarantees our commitment to environmental sustainability, traceability, and high-quality standards.



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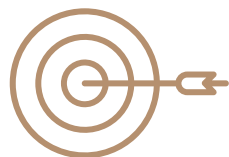
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Every thread, a
part of a cleaner
world.

— VISION, MISSION AND VALUES



Our Vision

To be the leading brand in innovative and sustainable textile products for living spaces.



Our Missions

To create stylish and functional textile products for living spaces.

OUR CORPORATE VALUES

HONESTY

Our primary value in our relationships is to tell the truth directly under all circumstances, to be consistent in our words and actions, and to apply ethical standards equally to everyone.

01

RESPONSIBILITY

We act quickly by protecting individual responsibility and team spirit in our work, protecting the interests of our company and accepting responsibility for our work.

02

RESPECT

In an environment where everyone respects and trusts each other, where employee rights and individual differences are valued, everyone treats others the way they want to be treated.

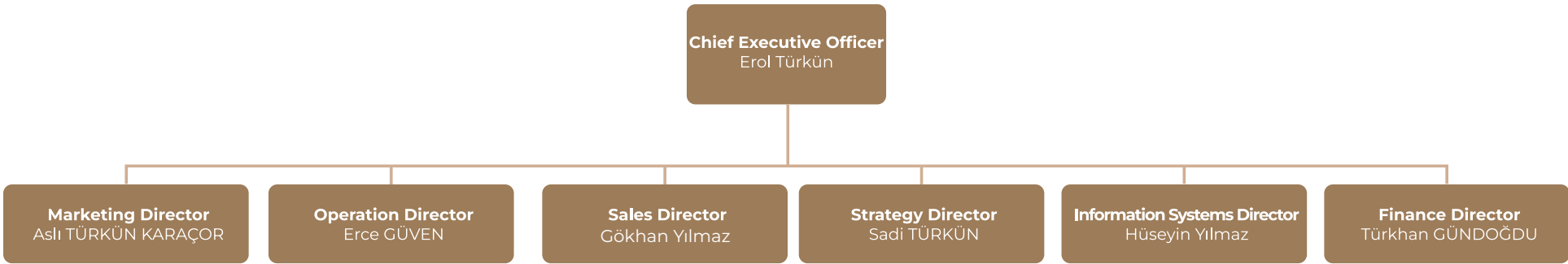
03

EXCELLENCE

We believe in using our resources in the most efficient way to achieve the results we want in our business by doing our job right the first time, differently and with an enthusiasm that creates value.

04

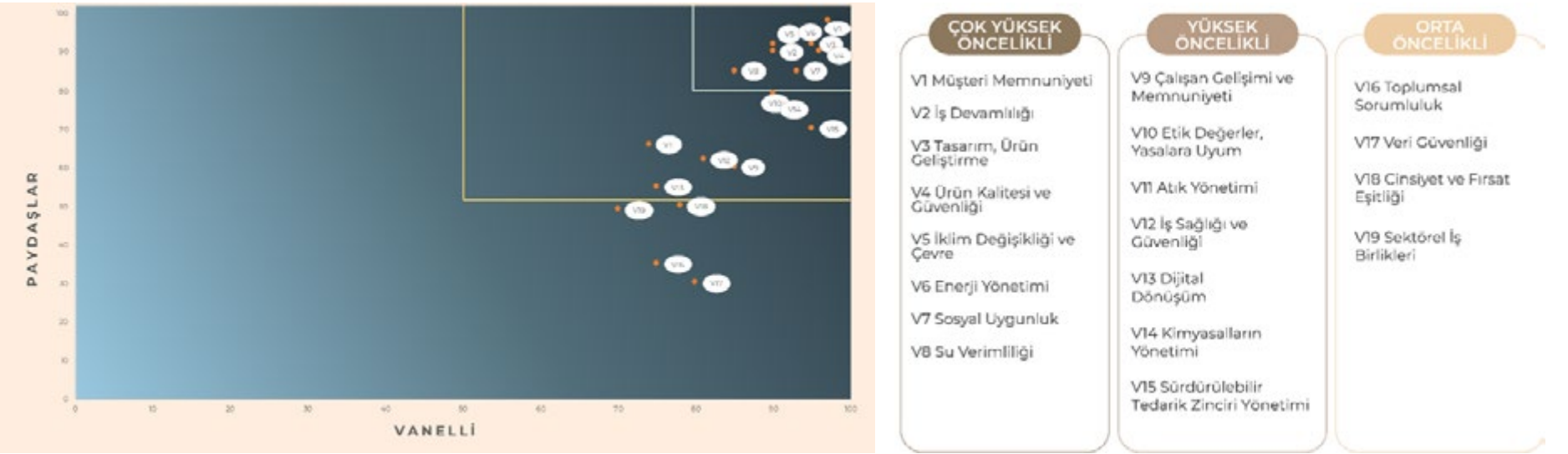
— OUR ORGANIZATIONAL STRUCTURE



— PRIORITIZATION ANALYSIS

In determining our priorities for sustainability reporting, a double materiality assessment has been utilized. Through this assessment method, both the impacts of Vanelli's operations on environmental and social capitals and the impacts of these capitals on Vanelli's activities have been identified in a two-way (double materiality) approach. In line with our evolving sustainability agenda, the existing assessment was reviewed and updated in 2024 to reflect changing conditions.

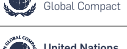
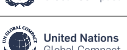
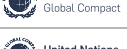
As a result of the evaluation, 19 priority topics were identified.



A Prioritization Matrix was created by mapping the highlighted topics to:

The 10 Principles of the UN Global Compact on human rights, labor standards, environment, and anti-corruption, The 17 Global Goals published by the United Nations (UN), and The economic, environmental, and social dimensions of the Global Reporting Initiative (GRI) Standards. Thus, our SUSTAINABILITY FOCUS AREAS MATRIX was established

— OUR SUSTAINABILITY FOCUS AREAS

Materiality	GRI Code	Topics	 SUSTAINABLE DEVELOPMENT GOALS	01 PAWENET	02 WATER	03 CLIMATE	04 ENERGY	05 ENVIRONMENT	06 WATER	07 ENERGY	08 ECONOMY	09 ECONOMY	10 ECONOMY	11 ENVIRONMENT	12 ECONOMY	13 CLIMATE	14 WATER	15 ENVIRONMENT	16 ENVIRONMENT	17 ENVIRONMENT	
	GRI 306	Waste Management				✓											✓				
	GRI 401, 405	Gender and Equal Opportunity						✓			✓		✓								
	GRI 404	Employee Development and Satisfaction					✓	✓			✓		✓								
	GRI 201	Digital Transformation									✓			✓	✓						
	GRI 302	Energy Management								✓		✓		✓	✓						
	GRI 205	Ethical Values, Compliance with Laws						✓			✓		✓					✓	✓		
	GRI 302	Climate Change and the Environment							✓	✓	✓	✓		✓	✓	✓	✓	✓			
	GRI 201	Business Continuity									✓			✓					✓		
	GRI 403	Occupational Health and Safety												✓	✓					✓	
	GRI 302	Management of Chemicals							✓					✓	✓	✓	✓	✓			
	GRI 416 417	Customer Satisfaction									✓				✓				✓		
	GRI 308, 414	Sectorial Collaborations									✓				✓						
	GRI 303	Water Efficiency							✓					✓	✓		✓				
	GRI 201-4	Design, Product Development									✓	✓			✓						
	GRI 204, 308, 414	Sustainable Supply Chain Management									✓			✓	✓				✓		
	GRI 203	Social Responsibility		✓	✓	✓	✓	✓					✓								
	GRI 416, 417	Social Compliance									✓	✓		✓	✓				✓		
	GRI 416, 417	Product Quality and Safety									✓	✓			✓						
	GRI 418	Data Security																			

 Medium-priority topics

 High-priority topics

 Very high-priority topics

 Economy

 Environment

 Social

— Our Sustainable Development-Oriented Business Approach

At VANELLI, we prioritize society and the needs of future generations in our commitment to sustainability, emphasizing sustainable management strategies in an ever-evolving competitive environment.

We adopt and implement the principle of systematically establishing, managing, and integrating our strategic goals within our management systems.

Our sustainability strategies are embedded across all areas, including Customer, Finance, Internal Processes, and Learning and Development dimensions.

— OUR STRATEGIC GOALS



We design with passion and produce for our planet.

— STAKEHOLDER ENGAGEMENT

At Vanelli, we are aware of the need to establish and implement collaborations that will support our corporate vision and create value by working with all our stakeholders to achieve shared business outcomes. We encourage our stakeholders to share their satisfaction or concerns through various communication channels. Where appropriate, we maintain continuous dialogue with the community and other stakeholders on issues related to our workplace and areas of influence.

Within the framework of a win-win principle, we aim to generate mutual benefits through collaborations and to create increased value by sharing knowledge, resources, and experience. In this context, we value innovation-focused collaboration with all stakeholders within our value chain.



Collaborations for Employees



At Vanelli, we take great pride in launching numerous sustainable collaboration projects dedicated to our employees, who represent the most valuable link in our value chain.

As part of these initiatives, we also place importance on supporting the talents of individuals receiving special education through a socially beneficial approach. In this context, the uniquely crafted handmade products prepared by students with special needs at Nilüfer Vocational School are presented as meaningful gifts during company award ceremonies, farewell events, and special occasions. Through this heartfelt collaboration, we both fulfill our social responsibility and promote the participation of these valuable individuals in the production process.

In addition, to protect the physical and mental well-being of our employees and improve their quality of life, we have established a strategic partnership with a private hospital, making healthcare services more accessible and privileged for them.

At Vanelli, we strive not only for excellence in production processes but also for a people-centered sustainability approach that creates long-term value for the future.



The Project Idea Workshop is a unique platform where employees can bring their creative ideas to life, and successful projects are rewarded. As we advance steadily towards our sustainability goals, Vanelli places great importance on the ideas of our most valuable resource: our employees.



In 2024, Hasan Süner applied for a utility model for the invention titled “A Weaving System.”

All employees, without exception, can apply to the workshop individually or in teams with their projects. Successful projects may be awarded with patents or utility models. The workshop is organized annually.

Project Objective:

To enable two different types of yarns to pass through the same shed simultaneously during fabric weaving, thus becoming part of the weave structure. This system aims to create more cost-effective and efficient woven surfaces.

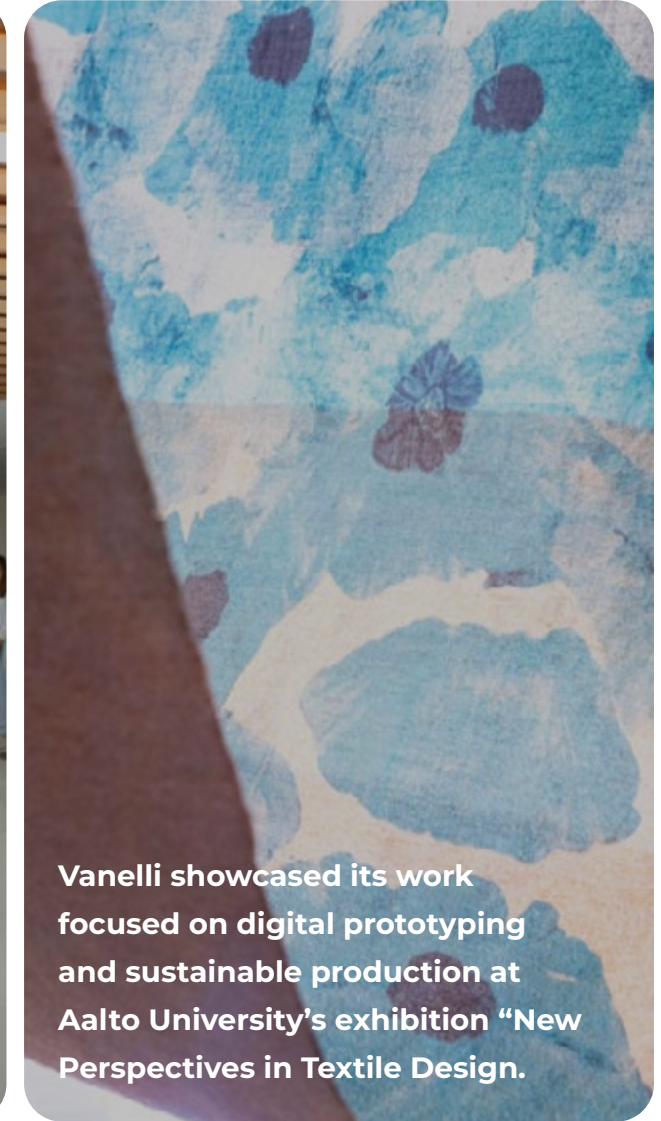
The system operates on the principle of feeding two yarns from different weft motors through separate guides and then into the same shed, with the weaving process performed using a single shuttle motion. However, to ensure that the yarns move smoothly and without breakage during this process, an additional guide sensor is required between the guides and the shed.



As the Vanelli Textile Design Center, we participated in the Turkish Fashion Fabrics Show held from October 9-11, 2024.



Following the Problem-Solving Market, textile companies visited BTÜ MERLAB to gain insights into the laboratory infrastructure and analysis processes.



Vanelli showcased its work focused on digital prototyping and sustainable production at Aalto University's exhibition “New Perspectives in Textile Design.”



Supplier Partnerships

In line with Vanelli's sustainability vision, we continue to establish strong collaborations with both domestic and international suppliers. As part of this effort, we have expanded our environmentally friendly product range by initiating portal membership for the VANELLI brand with the Lenzing product certification, supporting sustainable production. Additionally, through flame-retardant yarn projects developed in collaboration with Trevira, one of the pioneers in the industry and with whom we hold Gold Member status, we have certified our products to international standards.

Furthermore, we are making a significant impact with our R&D-based projects carried out with leading suppliers for sustainable raw material sourcing. Among these projects, the Dimout and Thermal Fabric solutions developed in collaboration with Polyteks stand out. These efforts, using globally certified materials such as GRS and Lenzing, extend beyond production into a scientific framework.

The academic paper prepared based on the outcomes of these projects has been submitted to national and international peer-reviewed journals, contributing to knowledge sharing in our sector and to the scientific literature in sustainability.



Lenzing

Innovative by nature

Lenzing is a certification that verifies the use of environmentally friendly fibers



Gold Member

Trevira's highest partnership level represents the most advanced collaboration status.



It is a certification that verifies the recycled material content and the environmental/social production criteria.



Collaborations with Customers

At Vanelli, our customer-centric approach is rooted in the vision of offering products and services that exceed expectations.

In this regard, through regular customer visits and periodic Customer Satisfaction Surveys, we meticulously analyze the needs and expectations of our customers. Based on the data collected, strategic action plans are implemented.

In this collaborative process with our customers, products such as upholstery fabrics, curtains, pillows, and tablecloths are specially researched and developed together. The resulting fabrics are produced not only for aesthetic appeal but also with high standards in technical functionality.

The developed fabrics add value to various living spaces with their features of security, comfort, and long-lasting use.

In this scope, our project-based fabrics, developed in collaboration with customers and interior designers, are preferred across a wide range of sectors, including residential buildings, hotels, accommodation facilities, healthcare institutions, commercial spaces, passenger ships, and public buildings, offering both aesthetics and functionality.





Collaborations with Educational Institutions

Collaborative projects have been developed with Uludağ University in Bursa, Pamukkale University, and Aalto University in Finland. Within the scope of sustainability, 3 articles and 2 publications have been produced. These are:

- The scientific article titled "Research on Sustainable Textile Production: Waterless Dyeing of PET and Recycled PET Fabrics", written by Uludağ University faculty members Prof. Dr. Semiha Eren, Dr. Öğr. Üyesi Aliye Akarsu Özenç, and Design Center Manager Nejla Çeven, was published in the internationally respected Textilec journal.
- The scientific article titled "Evaluation of Thermal Comfort and Air Permeability Properties of Lyocell Blended Drapery Fabrics", written by Pamukkale University faculty member Assoc. Prof. Dr. Gizem Karakan Günaydın, Uludağ University faculty member Prof. Dr. Erhan Kenan Çeven, and Design Center Manager Nejla Çeven, was published in the International Journal of Clothing Science and Technology.
- The scientific article titled "Investigation of Some Surface Roughness Properties of Woven Fabrics Produced with Sustainable Yarns", written by Uludağ University faculty members Prof. Dr. Mine Akgün and Prof. Dr. Erhan Kenan Çeven, Pamukkale University faculty member Assoc. Prof. Dr. Gizem Karakan Günaydın, and Design Center Manager Nejla Çeven, was published in the Tekstilna Industrija journal.
- The paper titled "Artificial Intelligence Applications in the Textile and Fashion Industry in the Age of Digital Transformation", prepared by Uludağ University faculty member Prof. Dr. Erhan Kenan Çeven, Pamukkale University faculty member Assoc. Prof. Dr. Gizem Karakan Günaydın, and Design Center Manager Nejla Çeven, was presented at the Aegean Summit – 12th International Applied Sciences Congress.



In the collaborative project with Aalto University in Finland, Vanelli participated in the production process of Venla Elonsalo's "I Weave Clothes" collection. The collection designs four-layered, interwoven garments and accessories that do not require stitching. Each piece is transformed into a three-dimensional form through the special fusion of fabric layers. This collection won the 1st place award at the Näytös24 fashion show held on May 30, 2024.

NGO & Institutional Collaborations

Vanelli Textile creates a broad impact area through sustainable relationships established with external stakeholders, not limiting its leadership approach solely to internal management. We have active memberships in various civil society organizations and associations (TOSAB, BALKANTÜRKİAD, BUSİAD, BOSİAD, TUGİAD, ÜİB, TAİDER, etc.), with contributions from our leaders at an individual level as well as corporate.

Within the scope of collaborations with educational institutions, projects aimed at students are supported, with a goal of integrating young people into the industry.

In addition to projects such as UTİB (TechXtile) and BOSİAD (Generation Z Project), concrete steps have been taken toward sustainable production and carbon-neutral goals through the "Ecological Textiles UR-GE" project, conducted in collaboration with ÜİB and the Ministry of Trade.

At Vanelli Textile, we aim to advance our incentive mechanisms every year. To this end, we set targets by maintaining continuous communication with the management throughout the year, with a focus on enhancing the creative activities and personal development of R&D center staff. In our updated performance evaluation and incentive mechanism, various areas contributing to success are rewarded.

Firstly, awards are given for national and international presentations, papers, and posters. Staff members involved in TÜBİTAK and similar projects are also incentivized. Furthermore, specific rewards are given to those who apply for patents, receive design registration acceptance, or begin or complete postgraduate or doctoral studies.

Staff suggestions on quality improvement, cost reduction, increased efficiency, product development, machine maintenance and efficiency, waste prevention, occupational safety, environmental protection, education, and ergonomics are also rewarded. These suggestions are evaluated according to specific rules and those deemed appropriate are awarded with points.



— RISK MANAGEMENT

For Vanelli Textile's operations, risk and opportunity action plans have been developed by identifying risks and opportunities arising from relevant stakeholders, processes, or external processes. In line with our Integrated Management System, we apply a risk-oriented process management approach to enhance quality, improve energy efficiency, and maintain energy performance, while implementing necessary preventive measures.

In this context, we aim to raise awareness before risks materialize, reduce any hazards and health risks arising from working conditions in work areas, and lower them to levels that do not affect human health. We also identify work accidents, occupational diseases, and health risks, determine potential hazards in the workplace as a result of risk assessments, assess the probability and possible severity/scale of accidents, and define the measures already taken or to be taken swiftly.

Risk and Opportunity Management

During the establishment/updating phase of the Organizational Context, Interested Parties, and Quality Management System, our Risk and Opportunity Management is conducted.

We utilize a SWOT (Strengths, Weaknesses, Threats, Opportunities) analysis to clearly identify risks and opportunities in the management of all our processes. Based on the SWOT analysis, risks and opportunities regarding the operation of our Integrated Management System processes and alignment with company objectives are identified, and Business Plans and Target Monitoring Tables are created. The alignment of our organizational context with the objectives of the Management System processes is ensured through effective management.

Process owners assess the identified risks and opportunities, enter them into the relevant plan, update it, and the process is shaped and periodically updated. Topics with high-risk levels are brought up in Management Review meetings.



Risk and Opportunity Management for Environmental Management System Processes:

Our risk and opportunity management for Environmental Management System (EMS) processes is carried out using the Risk Analysis and Activity Plan and Opportunity Analysis and Activity Plan, which are referenced in the process map for each process owner's authority area and coordination. As a result of the evaluation, process owners assess the emerging environmental risks and opportunities and take action for high-risk areas. The defined risks and opportunities are reviewed periodically to ensure they remain up-to-date. The work conducted is evaluated during Management Review meetings.

Risk and Opportunity Management for Energy Management System Processes:

Risk identification activities related to energy management are carried out across all processes that impact energy performance. In this context, each hazard is addressed separately using SWOT analysis to determine potential risks. A single hazard may have one or more associated risks. When identifying hazards and risks, the effects under key topics, such as issues in the Energy Management System, methods, tools, equipment used, and the implementation of instructions, are taken into account.

Once all potential risks have been identified, measures are defined to prevent the occurrence of risks and avoid non-compliance within the Energy Management System, with additional preventive actions developed accordingly.

—Business Ethics and Transparency

At Vanelli, transparency and ethical business practices are among our core principles as part of our sustainability approach. Within our Social Compliance Policy, we share the management's commitments regarding issues such as Forced Labor, Child Labor, Discrimination, Working Hours and Payments, Mistreatment and Harassment, Freedom of Representation (Unionization), Ethical Business Conduct, Occupational Health and Safety, the Environment, Employee Relations, Supplier Relations, Stakeholder Relations, and Management Systems. Please refer to the Diversity and Inclusion section in this report and the [Vanelli Corporate Website for more details](#).

As part of our certifications, we undergo periodic compliance audits by accredited organizations in accordance with BSCI and SEDEX standards.

At Vanelli, we operate with a fair and honest trade philosophy, ensuring full compliance with ethical rules and legal regulations in all our business processes. We adhere to a zero-tolerance policy towards bribery and corruption. All our employees and business partners are expected to avoid unethical attempts to gain profit. Our Bribery and Corruption Policy is shared through internal training sessions and relevant notice boards.

We are committed to creating a work environment that respects human rights and ensures fair working conditions. We apply a zero-tolerance policy against child labor, forced labor, and discrimination, offering equal rights and opportunities to all our employees. We fully comply with international standards and legal regulations regarding compensation and working hours.

amfori BSCI Code of Conduct

Our enterprise agrees to respect the following labour principles set out in the amfori BSCI Code of Conduct.

amfori BSCI Principles



The Rights of Freedom of Association and Collective Bargaining
Our enterprise respects the right of workers to form unions or other kinds of workers' associations and to engage in collective bargaining.



Fair remuneration
Our enterprise respects the right of workers to receive fair remuneration.



Occupational health and safety
Our enterprise ensures a healthy and safe working environment, assessing risk and taking all necessary measures to eliminate or reduce it.



Special protection for young workers
Our enterprise provides special protection to any workers that are not yet adults.



No bonded labour
Our enterprise does not engage in any form of forced servitude, trafficked or non-voluntary labour.



Ethical business behaviour
Our enterprise does not tolerate any acts of corruption, extortion, embezzlement or bribery.



No discrimination
Our enterprise provides equal opportunities and does not discriminate against workers.



Decent working hours
Our enterprise observes the law regarding hours of work.



No child labour
Our enterprise does not hire any worker below the legal minimum age.



No precarious employment
Our enterprise hires workers on the basis of documented contracts according to the law.



Protection of the environment
Our enterprise takes the necessary measures to avoid environmental degradation.

amfori BSCI Approach



Code Observance
Our enterprise is obliged to protect workers' rights as mandated by the law and the amfori BSCI Code.



Workers' Involvement and Protection
Our enterprise keeps workers informed about their rights and responsibilities.



Supply Chain Management and Cascade Effect
Our enterprise uses the amfori BSCI Principles to influence other business partners.



Grievance Mechanism
Our enterprise provides a system to collect complaints and suggestions from employees.

www.amfori.org



Sustainable Production with Higg FEM

As Vanelli, in line with our sustainability commitment, we have been transparently assessing our environmental impact through the Higg FEM (Facility Environmental Module) since 2022, continuously striving to improve our environmental performance and sharing our results with stakeholders.

Our declared 2024 performance data—including energy and water consumption, waste management, air emissions, and chemical usage—have been successfully verified through an independent verification audit, confirming our compliance with international sustainability standards.

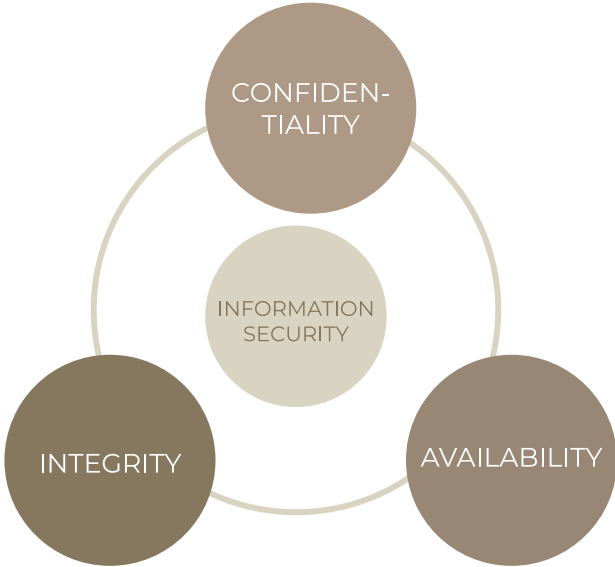


— OUR INFORMATION SECURITY POLICY

At Vanelli, based on a risk-based process management approach, we address confidentiality, integrity, and accessibility in all aspects of our operations. We conduct comprehensive studies to ensure information security and secure communication across individuals, departments, and processes within the organization.

We treat the data of our customers and business partners in accordance with the Personal Data Protection Law (KVKK) and ensure that all legal requirements are met, expanding and developing the necessary processes where applicable.

By establishing and maintaining an information security management system (ISMS) based on the ISO 27001 standard, we safeguard all data used and circulated within the company. This system plays a critical role in reducing the impact and likelihood of potential risks across processes essential to information security and business continuity.





— SUSTAINABLE DESIGN

We believe that sustainability must be embedded at the very beginning of the design phase and integrated holistically throughout the entire product life cycle and value chain. To minimize the negative and harmful environmental impacts of our industry, we prioritize the efficiency and effectiveness of resources, production, systems, processes, and operations.

Sustainable design begins with sustainable materials. Acknowledging the finite nature of our planet's resources, we prioritize natural, recyclable, and environmentally responsible materials. Through a sustainable design perspective, we eliminate unnecessary components from our products, thereby reducing the use of natural resources. Focusing on system optimization, we simplify our processes and merge similar functions to create streamlined production methods.

We place sustainability at the heart of our design philosophy, setting goals to ensure long-term continuity, self-sufficiency, and minimal waste generation. With our commitment to sustainable design, we continue to create value with purpose and responsibility.

In 2024, 10.5% of the total yarn we purchased—the primary raw material of our production—was sourced from recycled yarns.

We are dedicated to developing high-quality products that enrich people's lives. Our collections reflect our commitment to color, quality, simplicity, and innovation. We continuously enhance the aesthetic, technological, and functional aspects of textiles.

As pioneers in our field, we are constantly evolving and remain open to design and collaboration. Our product development approach is defined by cooperation, curiosity, knowledge sharing, responsibility, and respect for the environment. Our work is never truly finished—creating textile inspiration means embracing continuous development.

At our Design Center in Bursa, our team of 25 designers and engineers creates and develops products that combine aesthetics, functionality, and high added value.

With decades of experience, we closely follow fashion trends and deliver creative, original solutions tailored to customer expectations. At the same time, we see the development of innovative and environmentally friendly products as part of our responsibility and integrate the sustainable design approach into all our processes.



— LEAN 24

At Vanelli, ensuring customer satisfaction through a sustainable approach is one of our top priorities. We are fully aware that true satisfaction can only be achieved through accurate analysis of customer needs and expectations. In line with this understanding, we launched our stock streamlining project, Lean 24, in August 2023 to deliver faster and more efficient service. Our project continues to expand its scope throughout 2024.

Lean 24 is a comprehensive company-wide transformation initiative that encompasses supply chain, inventory management, product design, sales, quality, planning, pricing, and digital systems. This structure, shaped by the active involvement of all departments, has laid the foundation for a new value chain philosophy at Vanelli.

Within the scope of the project, we re-evaluated our existing inventory. As a result, we decided to continue with 554 out of 1,452 yarn types and 5,732 out of 9,618 color options. The number of warp combinations was reduced from 73 to 49, and the number of active colorways from 483 to 250. New designs created using the existing yarns were presented to our customers and received significant interest.

Through this transformation, Vanelli evolved from a structure focused solely on material procurement into a system that delivers market-ready products. Our inventory has been restructured into a more sustainable, efficient, and strategic model.

Today, Lean 24 has become a living organism within Vanelli and an integral part of our corporate culture.

By offering the right product, at the right price, and at the right time—and by managing post-sales processes effectively—we are confidently progressing toward our goal of sustainable inventory.

— SUSTAINABLE MANUFACTURING

Guided by the principles of sustainable production, we maintain a balanced and long-term manufacturing process that considers environmental, social, and economic dimensions.

In this context, while we strive to prevent all forms of waste generation during production, we are equally committed to increasing the efficiency of our resources, minimizing environmental degradation, enhancing product quality, and promoting a sustainable structure throughout our operations.

Our expertise spans the entire textile production chain—from yarn dyeing and preparation, weaving, fabric dyeing, finishing, pleating, and both digital and screen printing, all the way to finished products.

This extensive service spectrum enables us to offer a diverse range of high-quality textile solutions globally, from residential interiors to large-scale contract projects.





—SUSTAINABLE MANUFACTURING

YARN PREPARATION

In our yarn doubling and preparation processes, we adopt efficiency-driven methods supported by advanced machinery to minimize waste and optimize raw material usage. By prioritizing sustainable raw materials—such as recycled and organic yarns—we actively reduce our environmental impact.



Designing new fabrics is more than a task for us; it's a passion.





YARN DYEING

200.000kg/month Dyeing Capacity

With a total of 10 yarn dyeing machines, we have a capacity of 200,000 kg/month. Our state-of-the-art dyeing machinery allows us to dye yarns ranging from 2 kg to 400 kg. Our facility is capable of dyeing cotton, linen, viscose, polyester, FR polyester, wool, acrylic, and their blends. Dyeing processes are managed by cutting-edge automation systems, where all chemicals and dyes are dosed automatically into the dyeing machines.

With our expertise in color, we pursue excellence in textile design.

From yarn to fabric, we possess unmatched production capabilities. We love what we do, creating interior experiences through fabrics. By developing our own yarns and colors, we offer a vast yarn library.

WEAVING

130 Weaving Loom

350.000m Weaving Capacity

We transform yarn into finished fabric with our 130 high-tech weaving looms, which provide a weaving capacity of 350,000 meters. Our state-of-the-art weaving machines place us among the most advanced factories in the world.

By employing efficient production techniques and leveraging our energy management systems, we focus on utilizing renewable energy sources in our production processes. We aim to reduce emissions and lower our carbon footprint throughout our operations.



FABRIC DYEING

With a total of 15 fabric dyeing machines, we have a capacity of 180,000 kg/month. Our state-of-the-art dyeing machine park enables us to dye in capacities ranging from 5 kg to 500 kg. Our facility is capable of dyeing cotton, linen, viscose, polyester, FR polyester, nylon, wool, acrylic, and their blends. Dyeing processes are managed by cutting-edge automation systems, with all chemicals and dyes automatically dosed into the dyeing machines.

Our company adopts innovative and sustainable solutions to minimize environmental impacts in fabric dyeing processes. By utilizing low-liquid ratio (LLR) dyeing technologies and advanced techniques that maximize water and energy savings, we enhance resource efficiency. We prioritize the use of heavy metal-free, eco-friendly dyes and certified chemicals, ensuring both employee health and environmental protection.

Improvements in dyeing and washing processes in a single bath have significantly reduced water consumption. Through these actions, we have achieved an 11% water saving.

15	Fabric Dyeing Machines	180.000kg/mnth	Dyeing Capacity
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FABRIC PRINTING

No matter the material, our world-class equipment is capable of delivering the sharpest printing quality available today. Whether natural or synthetic, long or short production runs, or large or modest print volumes, Vanelli offers the flexibility, machinery, and capacity to handle any order.

With our extensive printing machines, we have a monthly printing capacity of 200,000 to 250,000 meters. Our operations include devore (burn-out), disperse pigment, reactive and foil printing, and various techniques for digital printing on polyester fabrics.

We also have a monthly capacity of 100,000 meters, with digital pigment printing on mixed backgrounds ranging from 330 cm to 150 cm fabrics, and 5 transfer sublimation printing, continuing our digitalization efforts.

Our range includes cotton, linen, polyester, FR, Trevira CS, and recycled fabrics, as well as light fabrics to heavy curtain and upholstery fabrics, catering to a variety of print surfaces.

250.000mt	Print Capacity
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FINISHING

2.000.000 mt Finishing Process for All Types of Fabrics (150 - 340 cm)

With a monthly capacity of 2,000,000 meters, we are capable of performing finishing processes on fabrics ranging from 150 cm to 340 cm. In addition to these machines, we also utilize Küsters wide-width fabric washing machines to handle all types of fabric finishing.

Our advanced equipment allows us to perform a wide variety of finishing processes including cutting, brushing, coating, hot pressing, calendaring, sanforizing, crush finishing, biancalani, stonewash, and pleating. Additionally, we can apply treatments such as stain-resistant, flame-retardant, antimicrobial, and many other coatings.

— SUSTAINABLE SUPPLY CHAIN MANAGEMENT

At Vanelli, our goal is to reduce environmental and social impacts across our supply chain, promote sustainability principles, and collaborate with suppliers to create a sustainable value chain. In our sustainable supply management practices, we incorporate sustainability criteria into processes such as supplier selection, evaluation, training, collaboration, and performance monitoring.

In our relationships with suppliers, we ensure that our commitments are in line with legal requirements while also supporting the development of our suppliers, fostering mutual benefits.

As Vanelli, we care deeply about the economic, social, and environmental development and improvement of the regions in which we operate and the communities we belong to. In this context, we aim to support local development efforts, ensure the efficient and sustainable use of local resources, support local businesses, create jobs, and improve the quality of life for local communities.

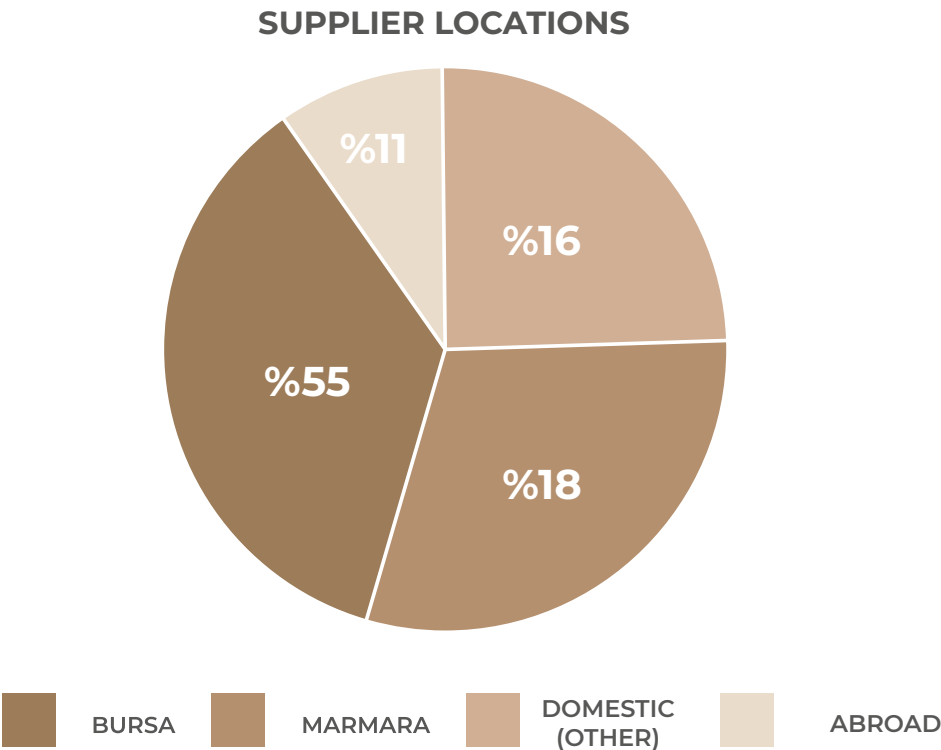
By collaborating more with local suppliers, we are contributing to local development efforts and supporting sustainable and inclusive economic growth.

In 2024, our total procurement volume exceeds 12 million Euros, with 55% of it being managed within the borders of Bursa. This not only supports the development of our city but also ensures that procurement stages are carried out with lower emissions.

— SUSTAINABLE SUPPLY CHAIN MANAGEMENT

Through sustainable supply chain management, we aim to reduce the environmental, social, and economic impacts of our suppliers, foster the adoption of sustainability principles, and collaborate with our suppliers within the framework of the Amfori BSCI Code of Conduct to establish a sustainable value chain.

We manage our relationships with our suppliers based on the following principles:



Vanelli Procurement Management Principles

Environmental Performance

We encourage our suppliers to reduce their environmental impact when sourcing materials and services. This includes energy efficiency, water use, waste management and carbon footprint.

Social Responsibility

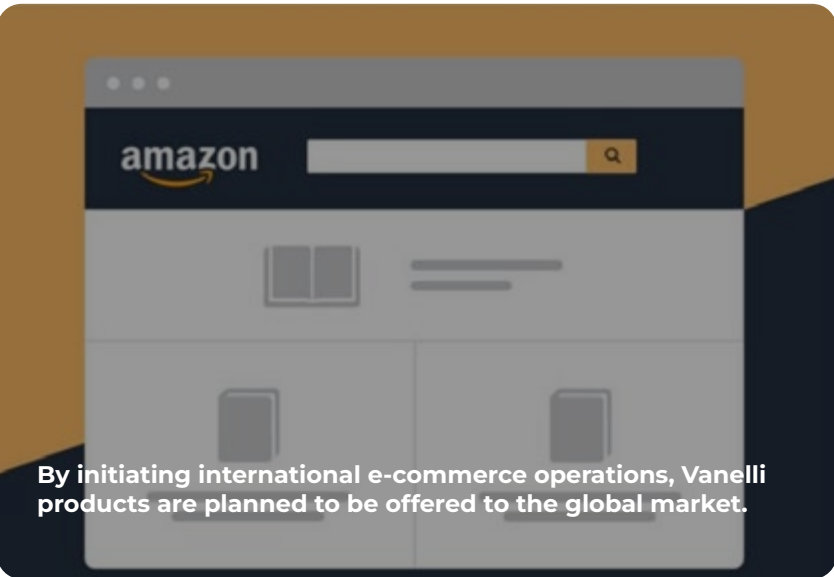
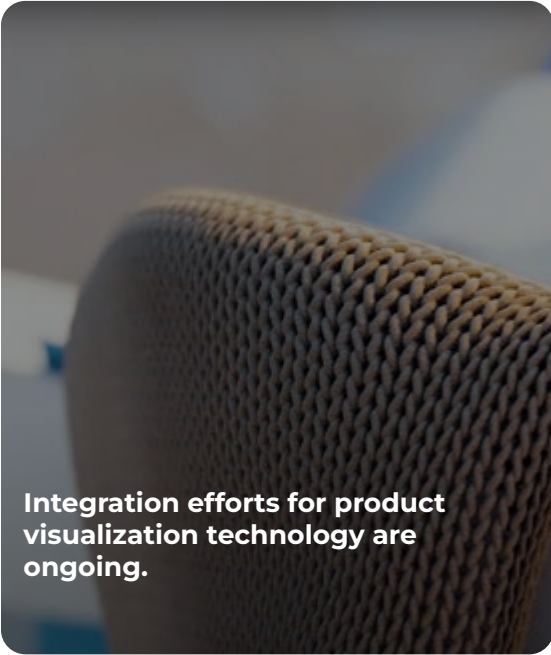
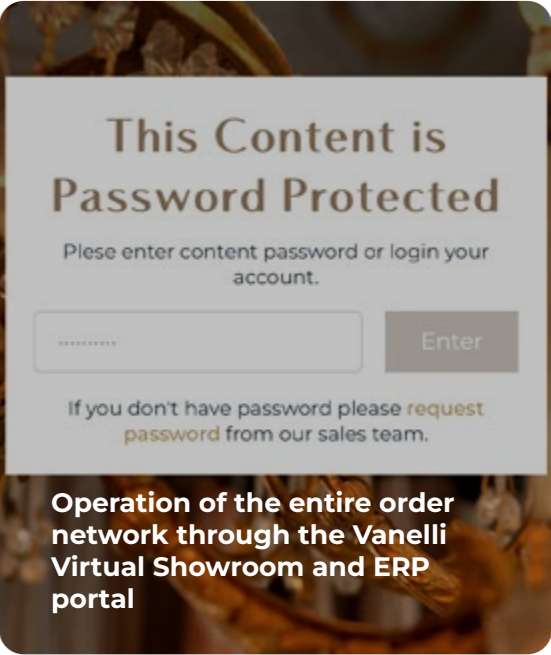
We verify compliance with social responsibility principles such as labor rights, occupational safety and respect for human rights in the supply chain. We advocate for fair working conditions and the fight against child labor.

Economic Development

We encourage our suppliers to contribute to economic development. This means investing in local economies, supporting small businesses and adopting fair trade practices.

—DIGITAL TRANSFORMATION

By prioritizing digital transformation, we aim to enhance efficiency, improve customer experience, and gain a competitive edge by utilizing technology at every stage of our business processes. In this framework, we invest in innovative technologies in areas such as customer-centric digital platforms, smart supply chain management, and digitization in production, while reinforcing our sustainability-driven approaches.



— Digital Fabric Simulation with EAT

In line with its digitalization goals, Vanelli has initiated simulation studies to reduce the amount of physically woven fabrics and yarns sent to customers, thereby contributing to sustainability efforts. Using the EAT software, both yarn and fabric simulations have been implemented as part of this transformation.



FABRIC SIMULATION



WOVEN FABRIC



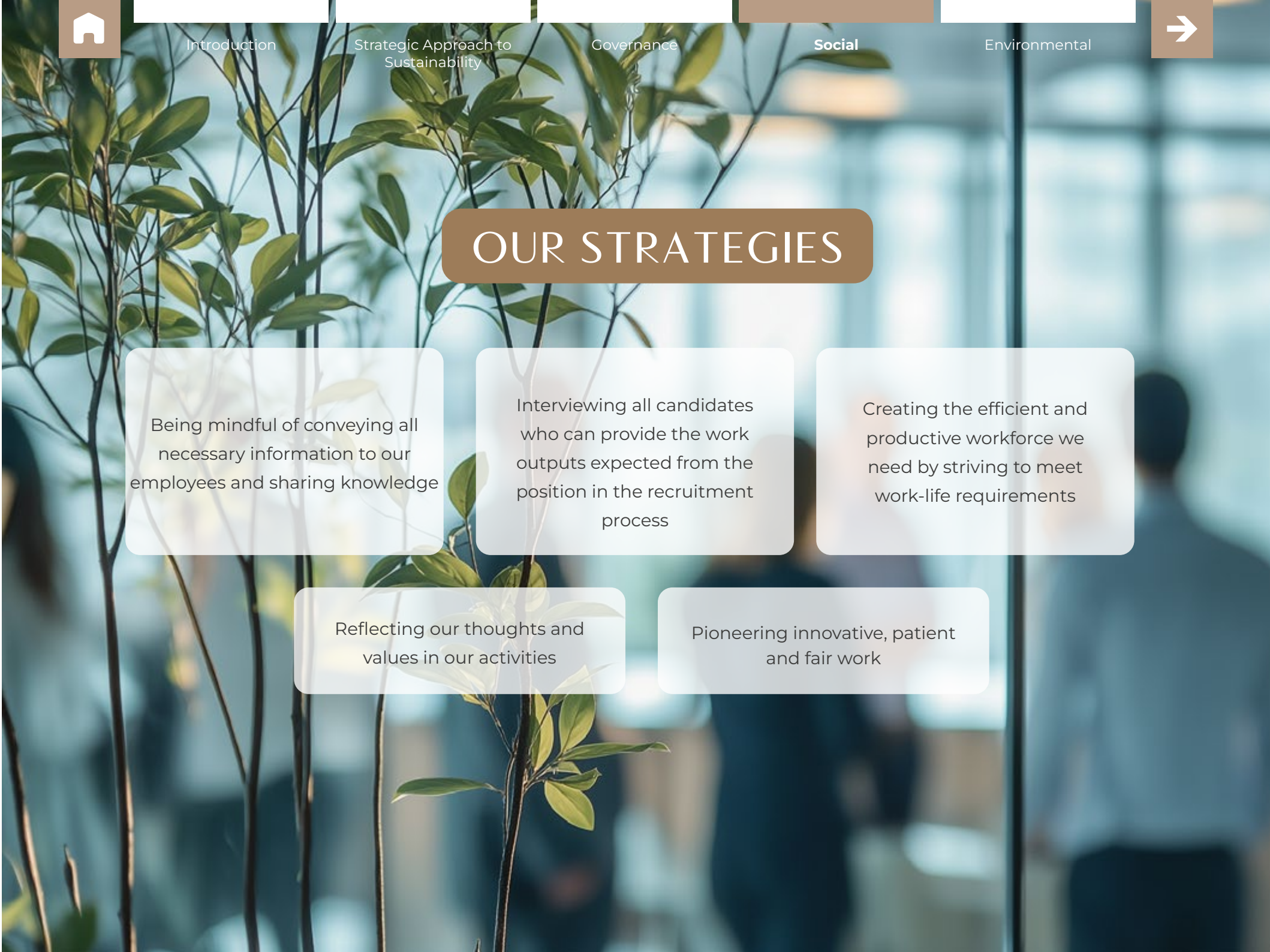
— DIVERSITY & INCLUSION

OUR HUMAN RESOURCES POLICY

At Vanelli Textile, we recognize that our employees are the most valuable asset of our workforce. From recruitment to retirement, we embrace a fair, ethical, and transparent approach across all human resources processes.

Our Human Resources Policy provides a structured framework that promotes employee satisfaction, supports personal and professional development, and enhances contributions toward corporate goals.

We are committed to fostering a productive, dynamic, and value-driven work environment where teamwork is essential, and individuals feel safe, respected, and fulfilled. Our aim is to build and sustain a talent pool aligned with our values and vision—capable of transforming potential into long-term success through strong systems and continuous improvement.



OUR STRATEGIES

- Being mindful of conveying all necessary information to our employees and sharing knowledge
- Interviewing all candidates who can provide the work outputs expected from the position in the recruitment process
- Creating the efficient and productive workforce we need by striving to meet work-life requirements
- Reflecting our thoughts and values in our activities
- Pioneering innovative, patient and fair work

— OUR SOCIAL COMPLIANCE POLICY

We place human life above all else. Guided by a long-term and holistic perspective, we manage our processes with a commitment to sustainability across every component of our value chain—including employees, customers, stakeholders, society, and the environment.

In all our strategies and projects, we stand firmly against any form of discrimination. We conduct our operations with respect for ethical principles, prioritizing trust, equal opportunity, public health, safety, well-being, and happiness.

In our relations with employees and all stakeholders, we pledge to act in full alignment with our established policies and ethical values. We are committed to the effective implementation of the following principles:

We ensure that no discriminatory behavior, harassment, forced labor, or child labor takes place within our workplace.

We prohibit all forms of involuntary labor, including debt bondage and coercion.

We do not employ children or individuals under the age of 18 in roles restricted by law and regulations. For interns, we require parental consent.

We uphold equal opportunity in the workplace and strictly prohibit discrimination based on gender, race, ethnicity, religion, sect, lineage, age, political opinion, marital status, disability, illness, or any other status or identity



— OUR SOCIAL COMPLIANCE POLICY

We apply working hours in accordance with applicable laws and regulations, while maintaining a healthy work-life balance. Overtime is based on voluntary participation, and we offer competitive wages aligned with the labor market in our sector. Salaries, overtime payments, and fringe benefits are processed on time and in full compliance with applicable legislation and employment contracts.

In line with legal requirements and industry standards, we do not discriminate against employees for being members of a union, association, or community, and we fully respect their right to representation and collective bargaining.

At Vanelli, we maintain a strict zero-tolerance policy towards corruption, fraud, embezzlement, and bribery under any circumstances.

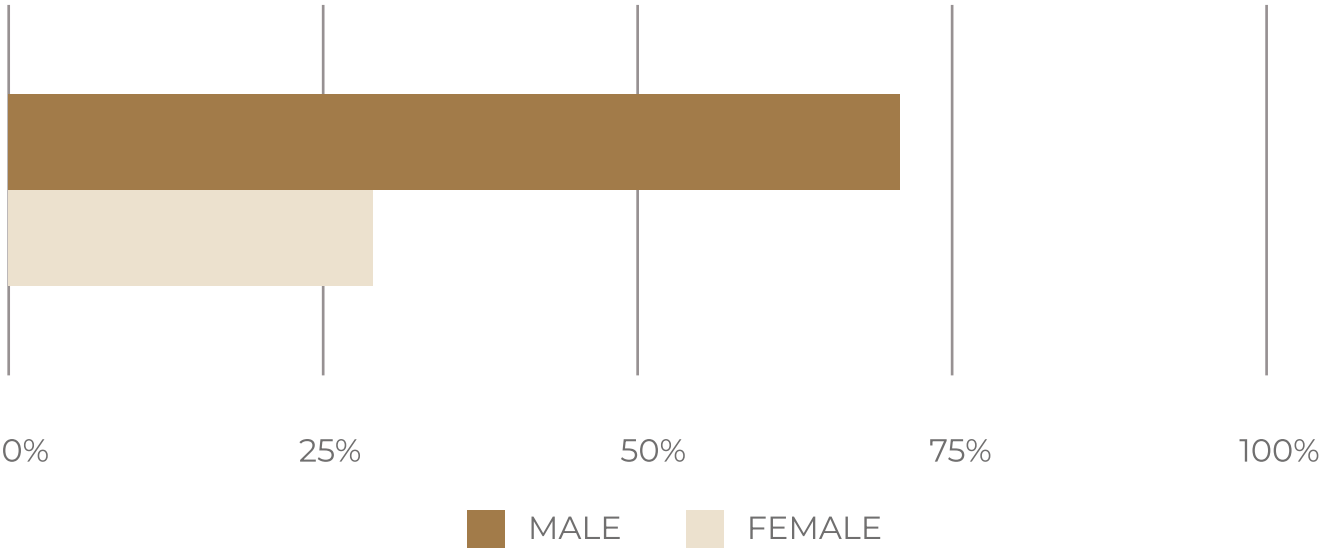
Except where explicitly allowed by law and regulations, we do not impose disciplinary sanctions. We uphold the dignity and personality of our employees and ensure they are not subjected to physical, verbal, or psychological pressure, intimidation, or any form of abuse.

EMPLOYMENT

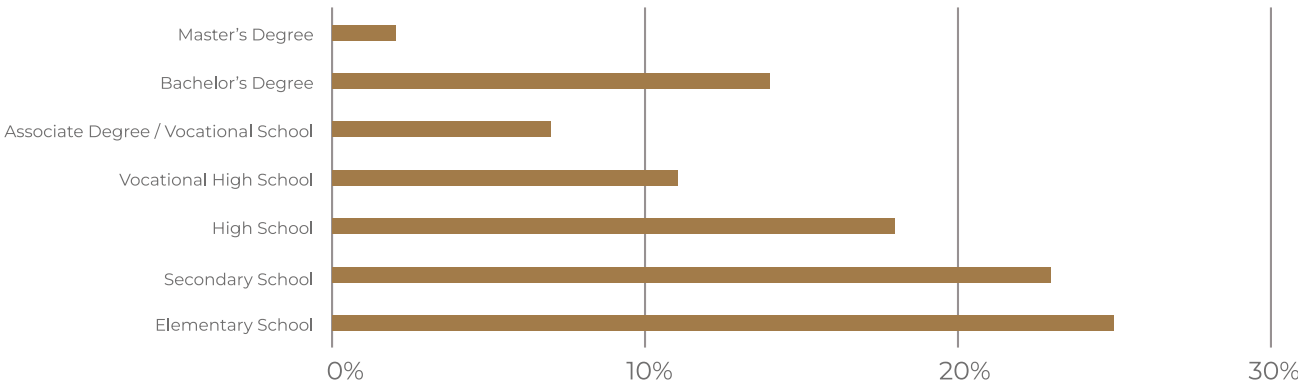
In line with our field of activity and expanding business volume, we continuously strengthen our workforce by increasing employment and welcoming new team members. Through this effort, we contribute to the sector by fostering a pool of skilled labor.

As of 2024, the ratio of female to male employment in our company stands at 29%. We remain committed to advancing gender equality in the workplace and continue to implement initiatives that empower women in their professional lives.

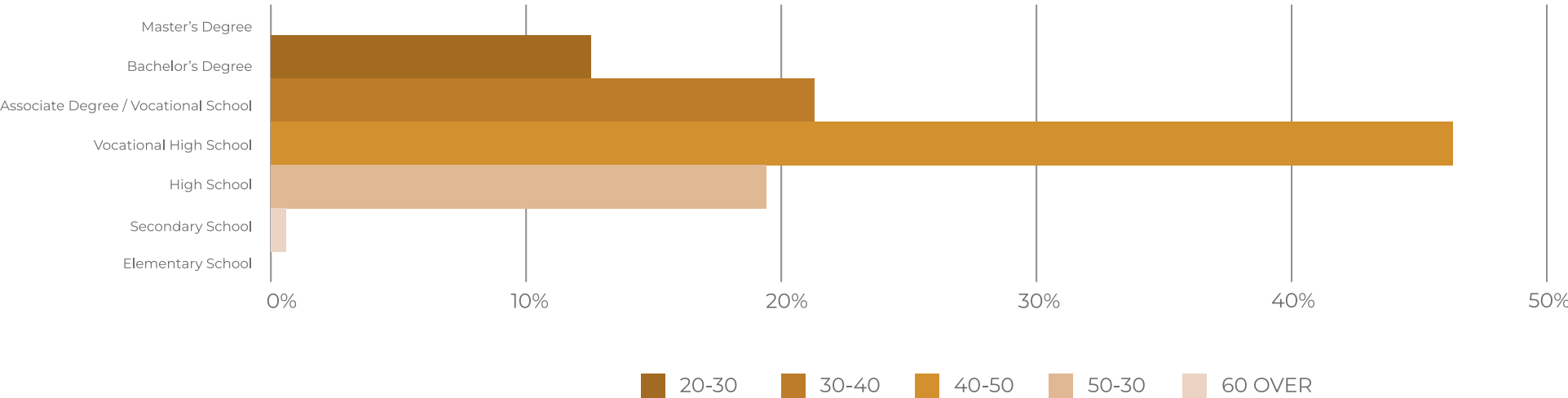
GENDER DISTRIBUTION OF EMPLOYEES



Percentage of Employees by Education Level



Employee Profile by Age Range



— EMPLOYMENT

We prioritize the happiness and development of our employees. We aim to maintain a happy and satisfied work environment that fosters a culture of collaboration and continuous learning, maximizing the potential of our workforce. Supporting our employees in realizing their full potential and achieving success is one of Vanelli's core missions. To this end, we continue our efforts to enhance employee development and satisfaction.

Fair Employment and Working Conditions:

We create a fair workplace environment by offering equal opportunities to all employees. By adhering to transparent and fair policies regarding compensation and benefits, we strive to earn the trust of our employees. Transparency and fairness are at the forefront when determining working hours.

As a company, we establish fair living wages based on the results of surveys we conduct. These wages are determined through measurable, transparent, balanced, and fair evaluations. We utilize livelihood wage analyses to maintain a balance between internal and external compensation, supported by industry salary research. With an objective approach, we aim to implement more competitive, motivating, and rewarding practices, taking into account our country's economic indicators and industry market data.

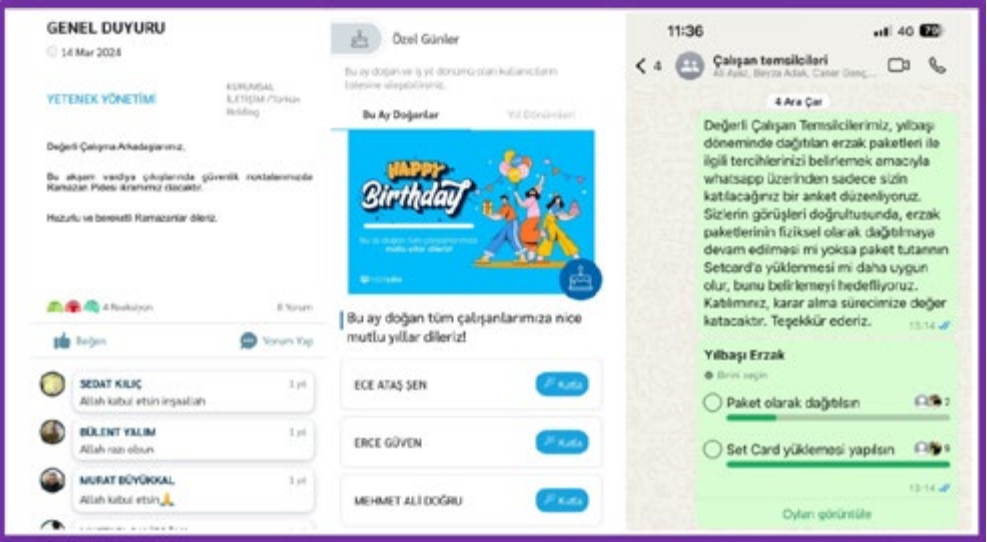
Gender	Percentage	Share in Total Compensation
FEMALE	29,0%	32,2%
MALE	71,0%	67,8%

As part of our fair living wage policy, our company offers the following benefits:

- Annual bonus
- In-kind card assistance during Ramadan and for the period of July to December
- Marriage assistance, Birth assistance, Funeral assistance
- Child assistance, Educational assistance, Circumcision assistance
- Scholarship assistance, Discount agreements with private healthcare institutions
- Interest-free loan advances

Communication and Participation:

We value the ideas and feedback of our employees by creating an open communication and collaboration environment. By promoting effective communication in the workplace, we ensure that our employees have the opportunity to express themselves and contribute.





Social Activities for Employee Well-being and Engagement

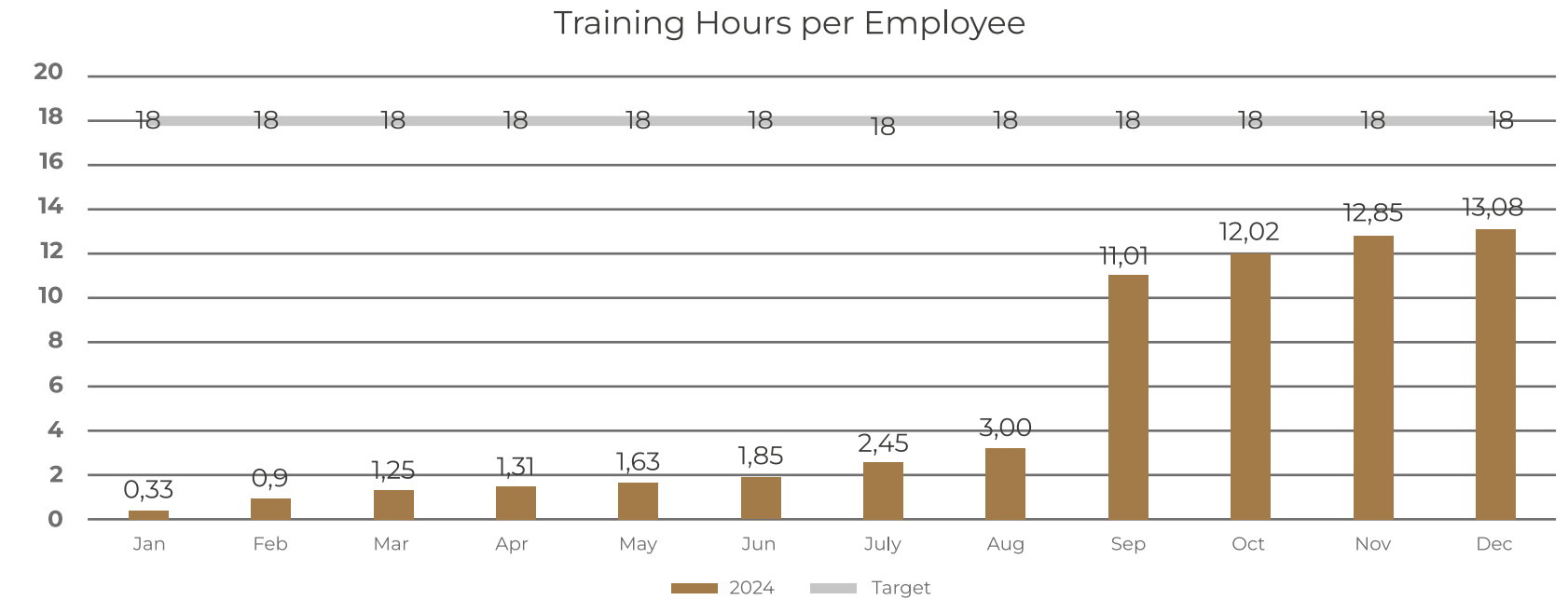
We recognize that focusing on social issues to enhance the happiness and well-being of our employees is critical to the long-term success of our company. In this regard, we ensure the effective implementation of our social strategy and provide the necessary support for our employees to fully benefit from social activities.

To improve employee well-being, enhance the workplace environment, and strengthen our company culture, we organize various social activities. By hosting team-building events, picnics, meals, and cultural activities, we strengthen loyalty and collaboration among our employees.



— EDUCATION

We are establishing a systematic framework to increase the work efficiency, quality, and personal development of new employees joining the Vanelli family, as well as to track the competencies of our current employees.



Within this plan, we provide orientation training for new employees, while for existing employees, we collect training requests, create an annual training plan, and conduct evaluations after the training events.

By encouraging the personal and professional development of each employee, we ensure that they unlock their full potential.

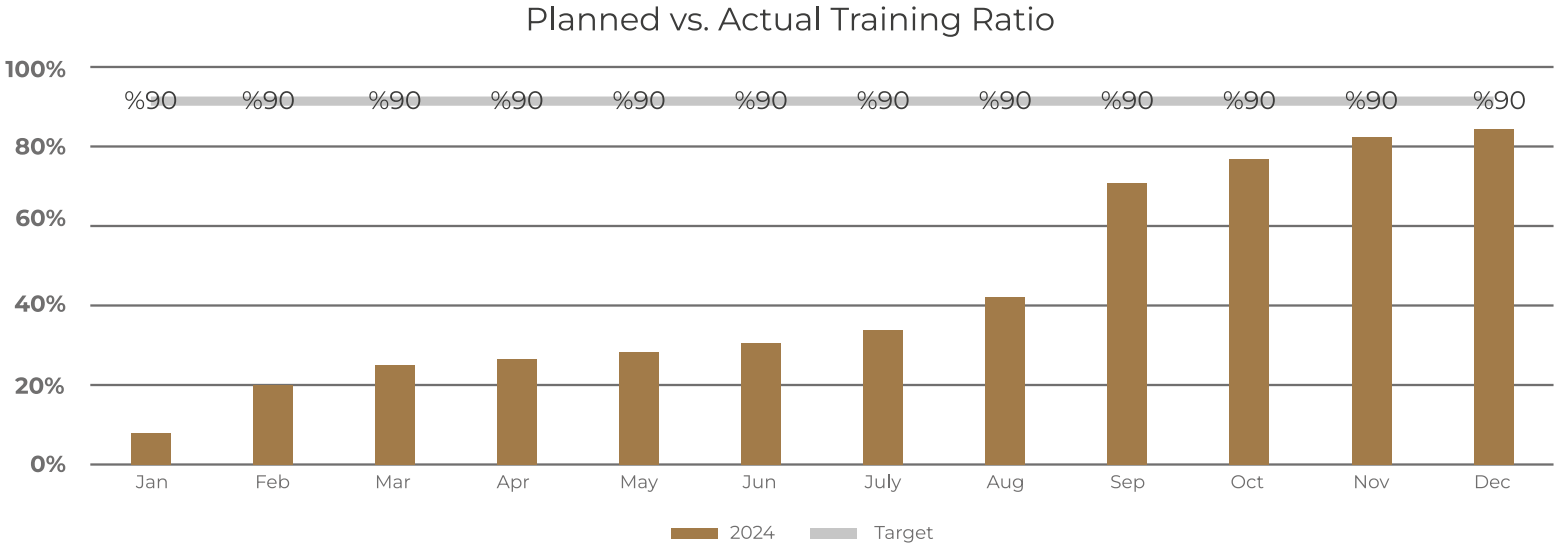
Personal and Professional Development

At Vanelli, we are deeply committed to fostering the personal and professional growth of our employees, recognizing that continuous learning is essential to maintaining excellence in textile innovation and craftsmanship. Our learning and development strategy is designed around a structured approach that includes needs analysis, program planning, and effectiveness evaluation.

Through close collaboration with department managers, we identify development areas based on performance reviews and operational needs. This allows us to craft targeted training programs that nurture the technical competencies and creative abilities of our workforce — from loom operations and dyeing processes to textile design and innovation.

Each training session is designed not only to enhance professional capabilities but also to support individual growth, ensuring our teams are empowered to contribute to both the aesthetic and functional dimensions of our textile creations.

With this approach, we aim to unlock the full potential of our employees, elevate overall job performance, and drive Vanelli’s long-term success through talent development that bridges tradition with contemporary excellence.

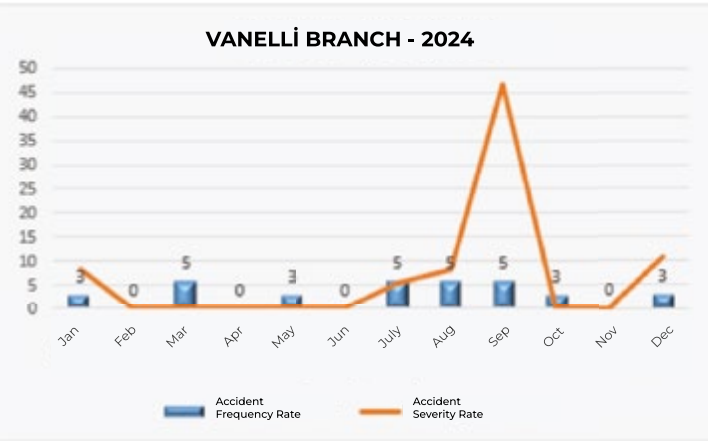
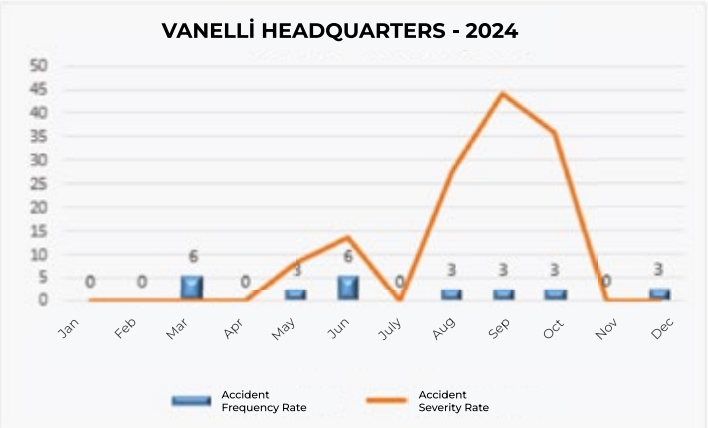


Occupational Health and Safety

We are establishing a systematic framework to increase the work efficiency, quality, and personal development of new employees joining the Vanelli family, as well as to track the competencies of our current employees.

We eliminate all risks that could threaten the health of our employees, including occupational diseases, work accidents, and injuries, by taking preventive measures. We ensure the continuity of safe, healthy, and efficient working environments through innovative techniques, involving our employees in these processes. With the awareness that occupational safety is a value given to human life, we take preventive actions in the area of occupational health and safety. Emergency plans for natural disasters, accidents, epidemics, etc. have been prepared by our company, and emergency drills are conducted every six months across three shifts.

In accordance with the Health and Safety Conditions Regulation, the equipment used in our facilities is subject to periodic inspections by authorized companies and teams at least once a year, with standard intervals maintained. Additionally, any deficiencies identified during inspections are addressed and rectified, and appropriate periodic control reports are obtained.



Occupational Health and Safety

At Vanelli, creating a healthy and safe working environment is one of our foremost priorities. In this regard, we are committed to minimizing any potential material or non-material losses by implementing comprehensive preventive and protective measures to eliminate hazards and reduce risks that may lead to employee injury or health deterioration during our operations.

We place great importance on the active participation of our employees in all processes of the Occupational Health and Safety Management System, valuing their input and fostering a culture of open communication. Their involvement is essential to the continual enhancement of workplace safety.

By conducting regular Occupational Health and Safety (OHS) training sessions, we aim to strengthen our employees' awareness and cultivate a strong safety culture across all departments. We ensure full compliance with all applicable legal and regulatory OHS requirements—both national and international—without exception.

Within the framework of our continuous improvement principle, enhancing the performance of our safety systems while maintaining strict adherence to health and safety standards remains one of our key organizational objectives.

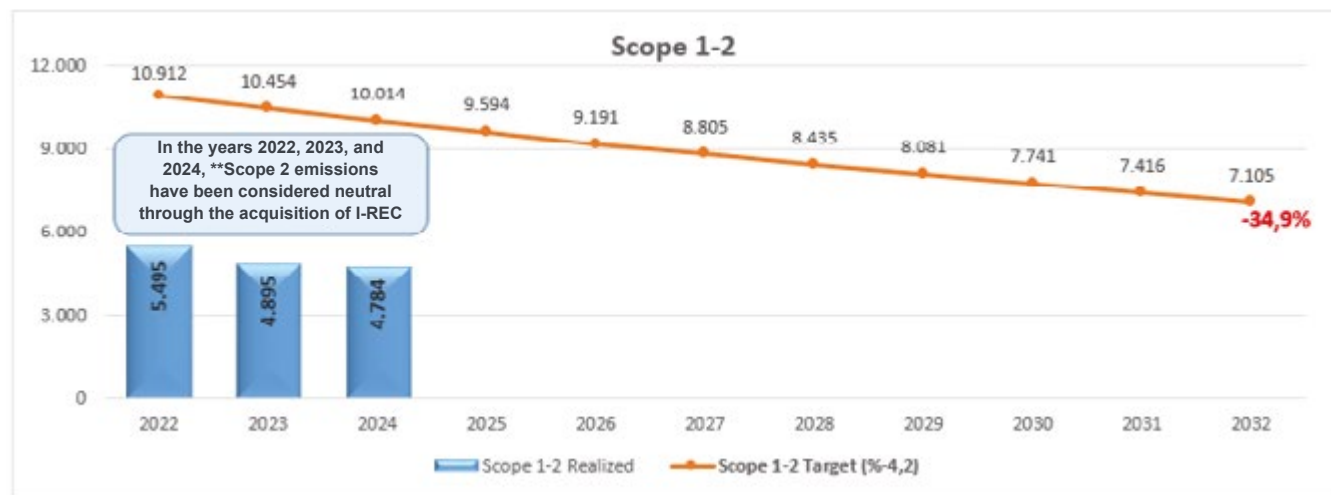


CLIMATE CHANGE AND DECARBONIZATION

The textile industry provides intermediate goods to a wide range of sectors, including home textiles, decoration, packaging, and automotive, with a significant emphasis on apparel. Due to the broad scope of our industry and the extensive nature of our supply chain, we have a considerable impact on several environmental parameters, especially greenhouse gas emissions. In line with the Science Based Targets initiative (SBTi) guidelines outlined in the “Apparel and Footwear Sector” document, we are committed to setting an absolute emission reduction target. To achieve this, we will monitor and measure Scope 1 and Scope 2 emissions separately. However, emissions arising from our stationary equipment—namely natural gas and electricity consumption—will be tracked using a combined target value, in accordance with Article C10 of the same guideline.

To contribute to limiting global warming to 1.5°C above pre-industrial levels, a minimum annual linear reduction of **4.2%** has been established as a benchmark.

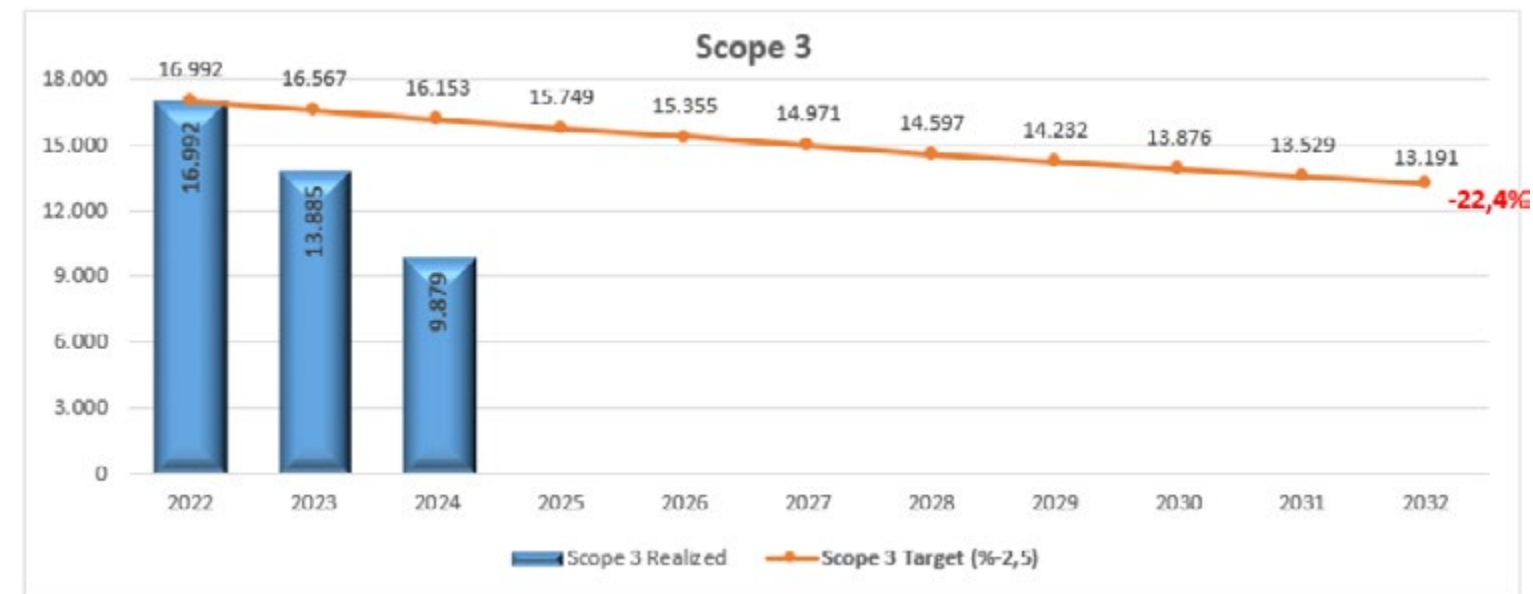
Accordingly, we commit to reducing our emissions by 35% by 2032, based on our 2022 baseline year.



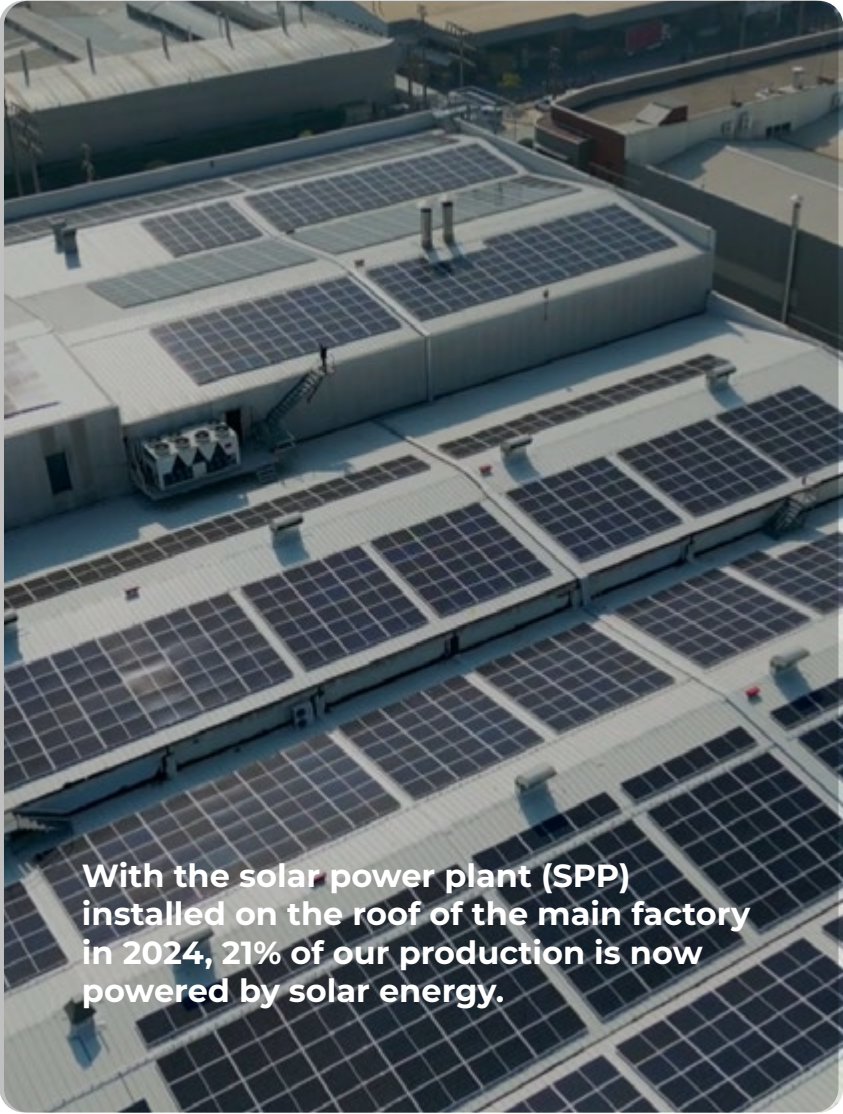
In textile production, greenhouse gas emissions primarily originate from processes such as energy supply for manufacturing operations, the production of raw materials, transportation activities, and waste management.

According to the criteria outlined in the Science Based Targets initiative’s (SBTi) “Apparel and Footwear Sector” guidance document, a minimum linear reduction of 2.5% per year is targeted for Scope 3 emissions to align with the global warming limit of 2°C above pre-industrial levels.

Vanelli is committed to reducing its Scope 3 emissions by 22.4% by 2032, taking 2022 as the base year.



Decarbonization



— OUR NET ZERO STRATEGY

In an era where the transition to a carbon-neutral world is at the core of building a sustainable future, we have developed our Net Zero Strategy, focusing on the climate-related risks our sector faces. As a company, we are firmly committed to reducing our carbon footprint and achieving our Net Zero emissions targets.

Aligned with Türkiye's 2053 Net Zero Emissions goal, we originally set our target in 2023 to reduce our company's greenhouse gas emissions to net zero by 2050. However, in 2024, taking into account evolving customer expectations and our internal sustainability ambitions, we have elevated this goal and now pledge to reach Net Zero emissions by 2040.

%0

We are committed to achieving Net Zero Emissions by 2040.



— ENERGY EFFICIENCY & RENEWABLE ENERGY

One of our key strategies is the preparation of an energy management report that outlines our goals, strategies, action plans, and performance targets for operating our energy management system in accordance with international standards, while keeping our stakeholders informed and engaged.

Under the umbrella of energy management, Vanelli continues to implement actions focused on efficient energy use, reduction of greenhouse gas emissions, and increasing the share of renewable energy sources.

Between 2022 and 2024, 100% of the electricity consumed in our production and office operations has been sourced from I-REC Certified renewable energy.

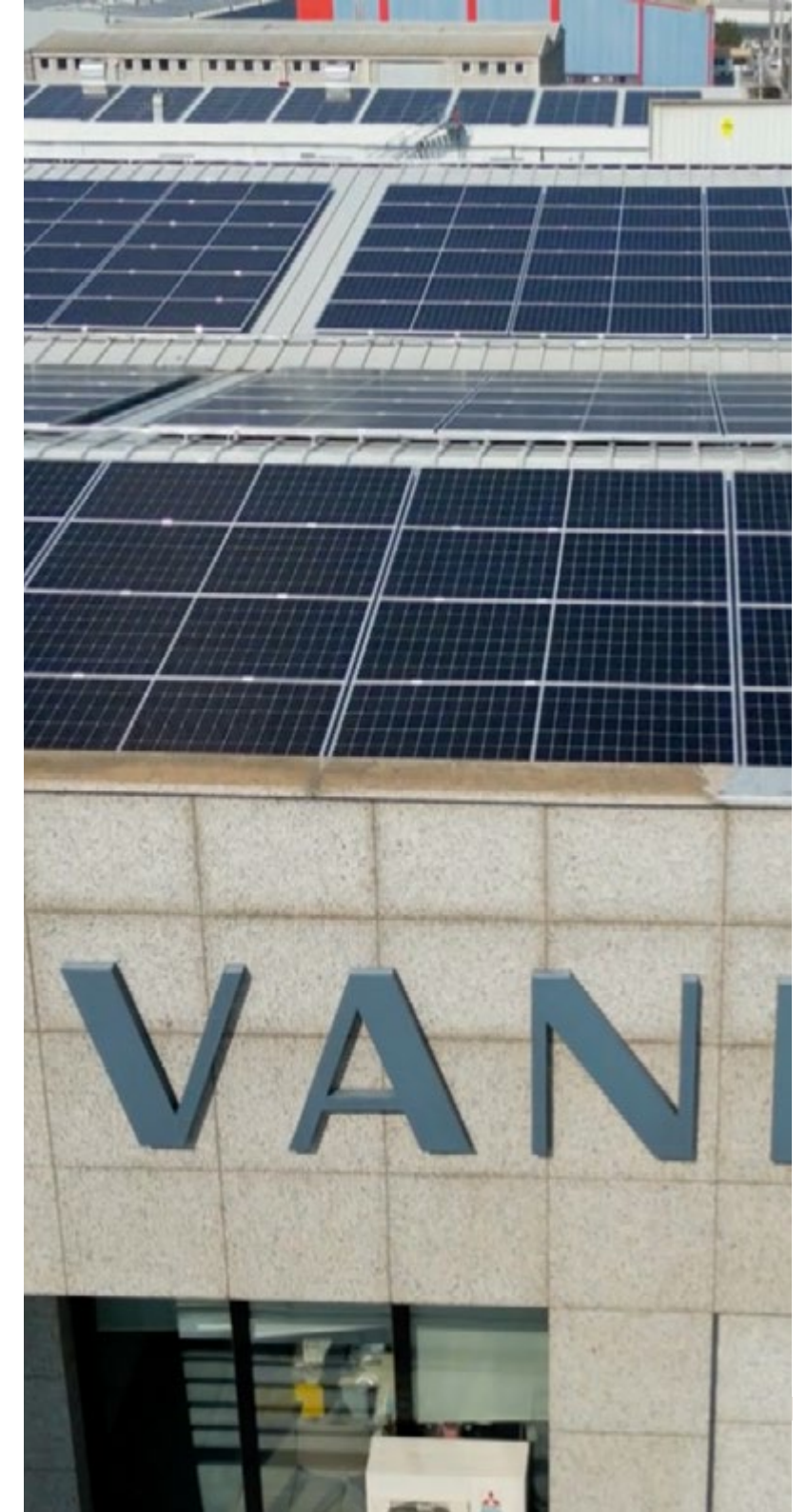


The International Renewable Energy Certificate (I-REC) is a globally recognized document that certifies the electricity consumed is generated from renewable energy sources.

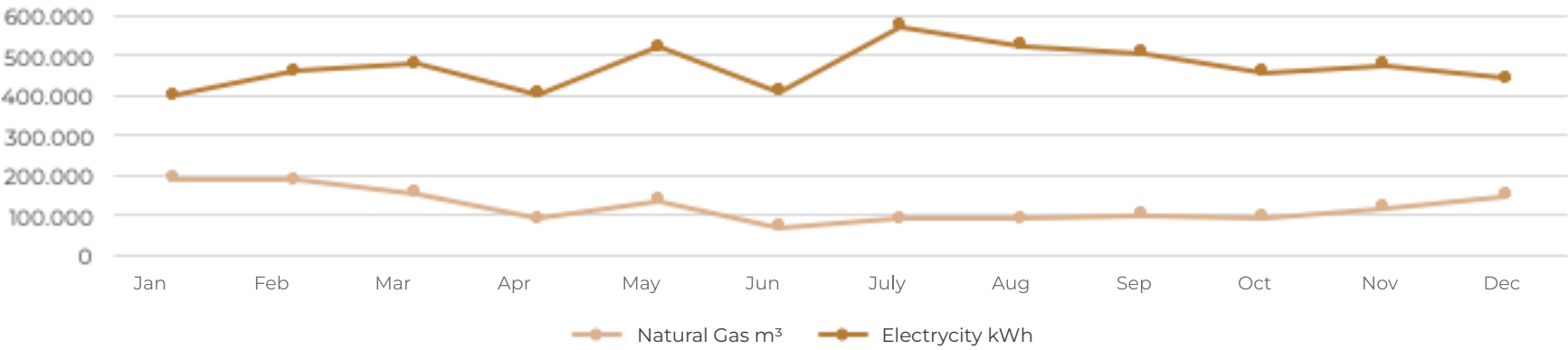
As we continue to grow our operations, we are simultaneously taking firm steps to minimize our environmental impact. In line with this commitment, we continuously enhance our environmental management principles in the field of energy and remain dedicated to our journey toward carbon neutrality.

In 2024, we launched a rooftop solar panel project at our central production facility, and as of November, energy generation has officially begun. With this investment, 21% of our weaving production is now powered by solar energy. This marks a significant step toward eco-conscious manufacturing and reinforces our contribution to sustainable production. While preserving natural resources, we are also investing in the future.

Looking ahead to 2025, we aim to install a ground-mounted solar power plant (GES) on a strategically selected site. This initiative will allow us to generate renewable energy beyond our internal consumption needs, thereby contributing positively to the national energy grid and our country's green energy goals.

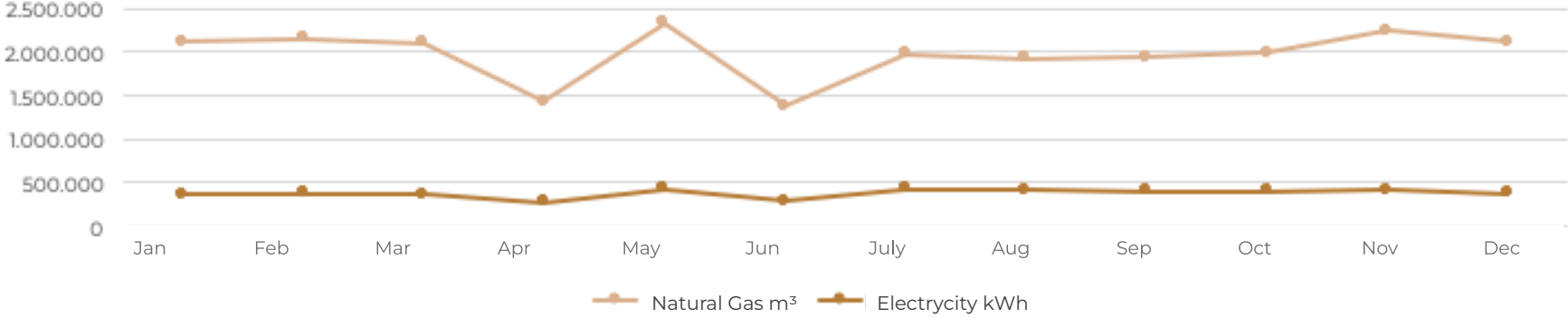


WEAVING ENERGY CONSUMPTION



Weaving Facility Electricity/Natural Gas Consumption

DYEHOUSE ENERGY CONSUMPTION



Dyehouse Facility Electricity/Natural Gas Consumption

Click Here for Vanelli Energy Consumption Details

At Vanelli, we aim to ensure the efficient use of resources and reduce energy costs by managing energy consumption across all our operations through a systematic approach.

In this context, we are committed to implementing and maintaining an energy management system that continuously improves energy performance and efficiency.

To reach our goals, we adopt an effective, inclusive, realistic, and integrated energy management approach aligned with our principles.

Our energy management policy not only ensures compliance with legal requirements but also enables us to set measurable targets to enhance energy efficiency in our operations, monitor these targets periodically, and continually improve our energy performance.

We are dedicated to reducing our energy consumption and using energy efficiently. We support projects aimed at minimizing energy use per unit of production, and we allocate the necessary budget, human resources, and technology to achieve these objectives.

Integrated Management System KPI Targets	Unit	2024 Target	Achieved in 2024
Weaving – Reduction of Electricity Consumption	(kWh/mt)	2,8	2,65
Garment – Reduction of Electricity Consumption	(kWh)	4069	3567
Yarn Dyeing – Reduction of Electricity Consumption	(kWh/kg)	1,429	1,221
Yarn Dyeing – Reduction of Natural Gas Consumption	(kWh/kg)	4	3,84
Yarn Dyeing – Reduction of Water Consumption (Industrial)	(m3/kg)	0,086	0,083
Yarn Dyeing – First-Time-Right Production (RFT %)	%	87%	85%
Finishing – Reduction of Electricity Consumption	(kWh/mt)	0,14	0,146
Finishing – Reduction of Natural Gas Consumption	(kWh/mt)	1,5	1,422
Finishing (Washing) – Reduction of Water Consumption (Industrial)	(m3/mt)	0,0048	0,0047
Finishing – First-Time-Right Production	%	99%	98,68%
Dyehouse – Reduction of Electricity Consumption	(kWh/kg)	0,375	0,311
Dyehouse – Reduction of Natural Gas Consumption	(kWh/Kg)	7,5	7,681
Dyehouse – Reduction of Water Consumption (Industrial)	(m3/kg)	0,125	0,12
Dyehouse – First-Time-Right Production (RFT %)	%	80%	82%
Printing – Reduction of Electricity Consumption	(kWh/mt)	0,19	0,248
Printing – Reduction of Natural Gas Consumption	(kWh/mt)	2,2	3,446
Printing – Reduction of Water Consumption (Industrial)	(m3/mt)	0,026	0,033
Printing – First-Time-Right Production	%	98%	98,6%
Packaging – Reduction of Nylon Consumption (Headquarters)	(kg/mt)	0,03	0,0193
Packaging – Reduction of Nylon Consumption (Branch)	(kg/mt)	0,04	0,0193
Packaging – Reduction of Carton Consumption (Headquarters)	(kg/mt)	0,026	0,029
Packaging – Reduction of Carton Consumption (Branch)	(kg/mt)	0,011	0,0317
Reduction of Hazardous Waste Generation	(kg/mt)	0,0017	0,002

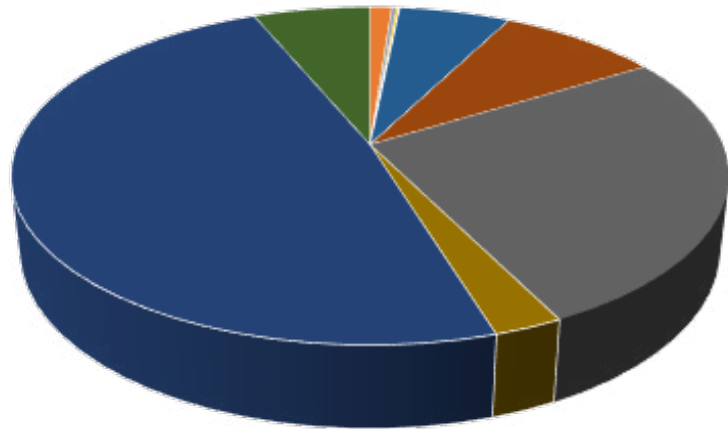
— WASTE MANAGEMENT

We implement waste management practices with an environmentally conscious and sustainable approach. In this context, we strive to use resources more efficiently to achieve our zero-waste target. Through continuous improvement efforts, we aim to minimize waste generation by preventing it at the design stage of our operations.

We eliminate environmental risks and contribute to the circular economy by sending hazardous waste to licensed disposal companies and non-hazardous waste to licensed recovery companies.

Despite a 5.4% increase in our total production volume from 2023 to 2024, we achieved a 22.6% reduction in the amount of hazardous waste generated.

	2022 (kg)	2023 (kg)	2024 (kg)	Change (%)
Production Volume	8,863,186	9,306,282	9,809,910	+5.4%
Hazardous Waste Amount	16,715	15,279	11,821	–22.6%
Non-Hazardous Waste Amount	501,706	467,956	496,980	+6.2%



HEADQUARTERS

- Contaminated Packaging

Plastic Bobbin

Nylon Waste

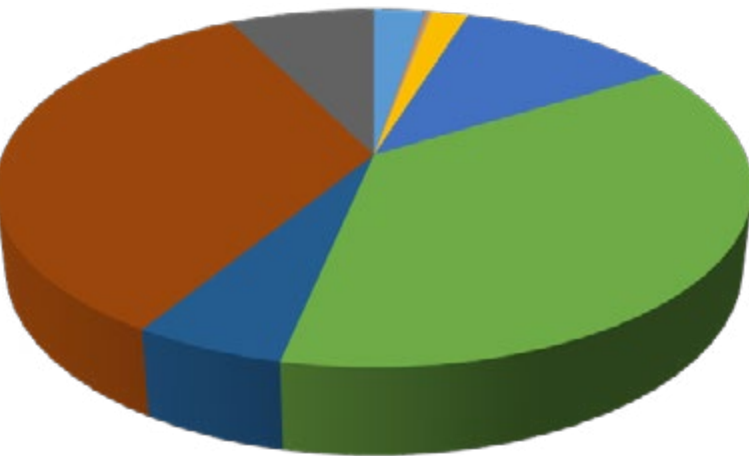
Industrial Waste

Pallet
- Organic Solvents and Sludges

Plastic Bobbin with Yarn

Cotton Waste + Fabric Scraps + Textile Waste

Paper Waste



BRANCH

- Contaminated Packaging

Plastic Bobbin

Nylon Waste

Industrial Waste

Pallet
- Organic Solvents and Sludges

Plastic Bobbin with Yarn

Cotton Waste + Fabric Scraps + Textile Waste

Paper Waste

— WATER MANAGEMENT

Water is an indispensable necessity for all living beings on our planet. Every drop is vital to sustaining life. The sustainable use of water is not only essential for preserving ecosystems and ensuring food security, but also part of our collective responsibility to leave clean water for future generations.

Water is a fundamental component in the textile industry, utilized in nearly every stage of the production process. As a representative of a water-intensive sector, Vanelli is fully aware of this responsibility. We actively monitor our water footprint and develop projects focused on water conservation.

While the textile industry’s average water consumption is approximately 120 liters per kilogram of production, Vanelli’s water usage stands at only 61 liters per kilogram — nearly half the industry average.

Total Blue Water Footprint:	197,134 m³/year	Total Grey Water Footprint:	1,327,012 m³/day
Headquarters Blue Water Footprint:	14,773 m³/year	Headquarters Grey Water Footprint:	75,959 m³/day
Dyehouse Blue Water Footprint:	122,390 m³/year	Dyehouse Grey Water Footprint:	1,251,052 m³/day



SU AYAK İZİ RAPORU
2024

VANELLI

— CHEMICAL MANAGEMENT

At Vanelli, we prioritize the safe management, use, transportation, storage, and disposal of chemicals across all our production processes to minimize their impact on both people and the environment.

In line with our commitment to sustainable manufacturing, we meticulously manage chemical processes and aim for full compliance with industry standards. As part of the ZDHC (Zero Discharge of Hazardous Chemicals) program, we use ZDHC MRSL-compliant chemicals in our operations, and our chemical suppliers are selected based on strict sustainability criteria.

We maintain transparency by sharing information about all chemicals used and their compliance levels through the ZDHC / InCheck module.

According to the declarations made in 2024, our InCheck Verification Audit, conducted by an authorized body, resulted in a 100% compliance rating.

Ø ZDHC

It is a sustainability certification aimed at eliminating hazardous chemicals.



A concise and easy-to-understand performance report that demonstrates a facility's chemical inventory compliance with the ZDHC MRSL (Manufacturing Restricted Substances List).

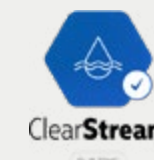
In addition, we ensure compliance with international standards such as REACH, GOTS, and OEKO-TEX®, as well as local regulations, to minimize the use of substances harmful to human health and the environment. Our employees receive regular training on the safe storage, handling, and use of chemicals, the use of personal protective equipment (PPE) is encouraged, and safety measures are implemented to minimize risks.

In wastewater management, analyses are conducted in accordance with the Supplier to Zero – ZDHC Wastewater Guidelines. As part of our sustainability commitments, our company continually improves its chemical management system, aiming to leave behind a cleaner production model for future generations. Within this scope, wastewater analysis results are shared transparently with all stakeholders via the ZDHC / ClearStream module.

Furthermore, in compliance with local regulations, unannounced wastewater samples are collected quarterly by the Organized Industrial Zone (OIZ), and in addition, COD (Chemical Oxygen Demand) levels in our wastewater are regularly monitored every three months on our own initiative.

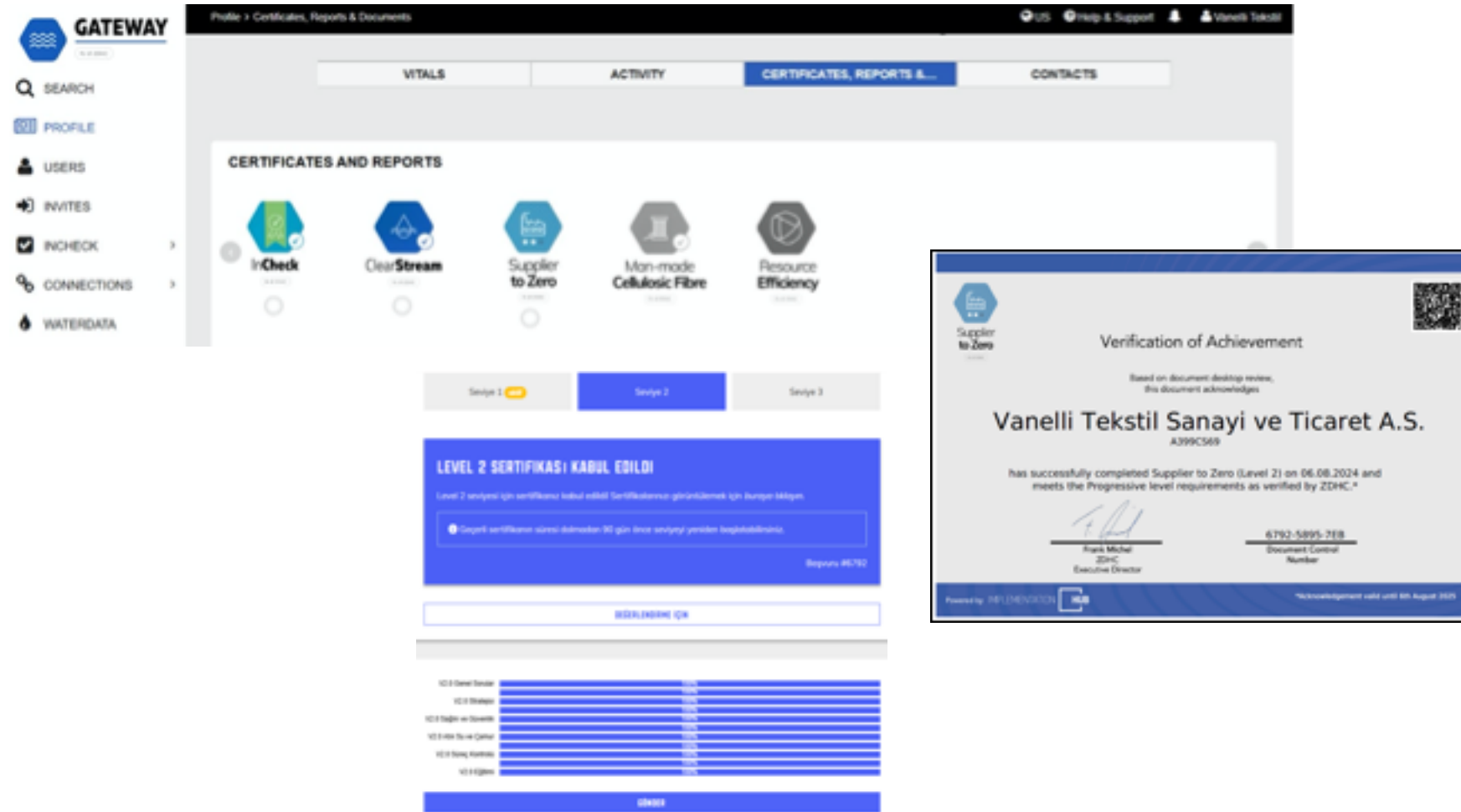


It is a sustainability certification aiming for zero discharge of hazardous chemicals.



It is an easily interpretable report that demonstrates a facility's compliance with ZDHC wastewater management standards and is recognized by leading global brands.

— CHEMICAL MANAGEMENT



— ENVIRONMENTAL AND SOCIAL COMPLIANCE PROGRAMS

WATER MANAGEMENT



WASTE MANAGEMENT



ENERGY MANAGEMENT



CHEMICAL MANAGEMENT



SOCIAL COMPLIANCE



Certificates



You can generate a QR code linking to your certification details.



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— VANELLI'S ENERGY TARGETS

APPENDICES

INTEGRATED MANAGEMENT SYSTEM KPI TARGETS	UNIT	2023	2024	ACHIEVED IN 2024
		ACHIEVED	TARGET	
Ratio of downtime due to malfunction	(kWh/mt)	2,91	2,80	2,65
Increasing the percentage of incidental work orders to 90%	kw.ort/gün	1.926	1926	1928
Weaving - Reducing Electricity Consumption	kw.ort/gün	845,8	845	731,9
Luwa1-Reducing Electricity Consumption	kw.ort/gün	775	775	700
Luwa2-Reducing Electricity Consumption	kw.ort/gün	92	91,7	57
Luwa3-Reducing Electricity Consumption	kw.ort/gün	2.992	2.992	2.843
Kops twisting cooling system - reducing electricity consumption	(kWh/mt)	0,0129	0,129	0,011
Entire compressor - reducing electricity consumption	(kWh)	4.069	4069	3567
Weaving_4/Chiller - Reducing Electricity Consumption	(kWh/kg)	1,184	1,10	1,221
Apparel - Reducing electricity consumption	(kWh/kg)	4,086	4	3,840
Yarn Dyeing - Reducing Electricity Consumption	(m3/kg)	0,078	0,075	0,083
Yarn Dyeing - Reducing Natural Gas Consumption	%	84%	87%	85%
Yarn Dyeing - Reducing Water Consumption - Industrial	(kWh/mt)	0,145	0,140	0,146
Yarn Dyeing - Right production in the first run (RFT %)	(kWh/mt)	1,559	1,5	1,422
Finishing - Reducing Electricity Consumption	(m3/mt)	0,0153	0,015	0,0047

INTEGRATED MANAGEMENT SYSTEM KPI TARGETS	UNIT	2023	2024	ACHIEVED IN 2024
		ACHIEVED	TARGET	
Finishing - Reducing Natural Gas Consumption	%	98,66%	98,66%	98,68%
Finishing (WASHING) - Reducing Water Consumption - Industrial	(kWh/kg)	0,381	0,375	0,311
Finishing - Right production in the first run	(kWh/Kg)	7,623	7,5	7,68
Dye - Reducing Electricity Consumption	(m3/kg)	0,125	0,125	0,120
Dye - Reducing Natural Gas Consumption	%	76%	80%	82%
Dye - Reducing Water Consumption - Industrial	(kWh/mt)	0,218	0,190	0,248
Dye - Right production in the first run (RFT %)	(kWh/mt)	2,763	2,20	3,446
Printing - Reducing Electricity Consumption	(m3/mt)	0,058	0,026	0,033
Printing - Reducing Natural Gas Consumption	%	97%	98%	98,6%
Printing - Reducing Water Consumption - Industrial	(kg/mt)	0,035	0,03	0,0193
Printing - Right production in the first run	(kg/mt)	0,039	0,038	0,017
Packaging - Reducing Nylon Consumption (Main Building)	Sayı	0	0	0
Tedarikçilerin kimyasalları ZDHC uyumlu hale getirmesi	%	---	70%	92,4%
Konvensiyonel Pamuk Liflerinin BCI Pamuk Lifleri Olarak Değiştirilmesi	%	---	100%	100%

Natural Resource Consumption Improvement Projects Energy Management 2021–2024

Electricity 2021–2024

Implementation Date	Project / Activity Name	Explanation	Electricity Consumption (Before) [KWh/day]	Electricity Consumption (After) [KWh/day]	Electricity Consumption Gain [KWh/year]
2021	Compressor Inverter Application	An inverter was installed to control the speed of the Robot 140 fixed-speed compressor for energy savings	1,623	519	331,200
2021	Chiller – Luwa 1	In the first hall, energy-efficient new fans made of flexiglass were installed instead of metal-blade fans for the Luwa air conditioning system	2,326	1,978	104,400
2021	Evaporative Coolers – Cop Twist	High-energy consuming Roca gas-based cooling devices were replaced with low-energy consuming FES evaporative cooling devices	1,356	250	199,080
2021	Itema Looms – Jacquard – 1st Batch (20 machines)	The old type Sommet brand Jacquard looms used in the weaving hall were replaced with technological, high-speed, energy-efficient Itema machines	0.000229	0.000204	39,479
2021	Printing Dispersions on Digital Machines	During printing, energy consumption during washing was minimized by using a more portable machine	-	-	2,910
2022	Chiller – Luwa 2	In the second hall, energy-efficient new fans made of flexiglass were installed instead of metal-blade fans for the Luwa air conditioning system	1,181	895	85,920

Implementation Date	Project/Activity Name	Description	Electricity Consumption (Before) [KWh/day]	Electricity Consumption (After) [KWh/day]	Electricity Consumption Savings [KWh/year]
2024	Factory Roof - Solar Energy System (GES)	A solar energy system was installed on the roof of the central factory and put into operation	-	-	1,182,996
2024	Air Valve Replacement	Existing Tork brand air valves used at the loom entrances in the central factory were replaced with SMC brand valves	688	233	5,460
2024	Air Pressure Supply Adjustment	The air demand of the Titan-5 device in the Central Factory Laboratory was met by a separate piston compressor, allowing the existing compressors in the main compressed air system to operate at 0.5 bar lower set pressure	87,430	83,730	44,400
2024	Process Improvement	Improvements in dyeing processes / single-bath dyeing process implemented to shorten process times	0.39	0.34	48,115

Natural Gas; 2021-2024

Implementation Date	Project / Activity Name	Explanation	Natural Gas Consumption (Before) [kWh/charge]	Natural Gas Consumption (After) [kWh/charge]	Natural Gas Consumption Gain [kWh/year]
2021	Ram Machine Heat Recovery Filter System	The waste flue gas generated during Ram operation was passed through the system to heat cold water without mixing, saving gas in the process.	6.184.052 kwh/yıl	5.207.307 kwh/yıl	976.744 kwh/yıl
2021	Printing Dispersions on Digital Machines	During printing, energy consumption during washing was minimized by using a more portable machine.			70.500
2022	MCS Machine Replacement – 200 kg	The old machine with high energy (electricity, natural gas, water) consumption was replaced with a new low-energy consuming machine.	332	332	149.400
	Canlar – 200 kg		237	237	106.650
	Canlar – 25 kg	A smaller machine was acquired for smaller production pieces to consume less energy.			
	Transition to Low Flotation				42.750
2022	Canlar 200 kg Heat Insulation Application	Insulation was applied to the machine's heat surfaces to save natural gas.	237	170	30.191
2022	Canlar 25 kg Heat Insulation Application	Insulation was applied to the machine's heat surfaces to save natural gas.	41	36	2.196
2022	Printing Pigments on Digital Machines	During printing, energy consumption during washing was minimized by using a more portable machine.			352.500
2023	Central Plant - All lines and machines underwent condensate measurements	Condensate traps that were missing were replaced.			70.436
2023	Branch Plant - All lines and machines underwent condensate measurements	Condensate traps that were missing were replaced.			979.500
2024	Process Improvement	Process improvements in the dyehouse were made by shortening process times through single-bath dyeing.	8,09	7,51	558.136

Water; 2021-2024

Implementation Date	Project / Activity Name	Explanation	Water Consumption (Before) [m³/charge]	Water Consumption (After) [m³/charge]	Water Consumption Gain [kWh/year]
2021	Printing Dispersions on Digital Machines	During printing, energy consumption during washing was minimized by using a more portable machine.			510
2022	MCS Machine Replacement – 200 kg	The old machine with high energy (electricity, natural gas, water) consumption was replaced with a new low-energy consuming machine.	5	5	2.340
	Canlar – 200 kg		4	4	1.800
	Canlar – 25 kg	A smaller machine was acquired for smaller production pieces to consume less energy.			
	Transition to Low Flotation		1	1	540
2022	Printing Pigments on Digital Machines	During printing, energy consumption during washing was minimized by using a more portable machine.			2.500
2024	Washing Water Recovery	mprovements made in the softening system to recover washing water and reduce salt consumption.			133.785
2024	Process Improvement	Process improvements in the dyehouse were made by shortening process times through single-bath dyeing.	10.356	9.864	5.904

— VANELLI ENERGY CONSUMPTION

WEAVING CONSUMPTIONS				DYEING PLANT CONSUMPTIONS		
JANUARY	400.024,05	5.951		JANUARY	360.666,45	63.550
FEBRUARY	458.449,80	5.829		FEBRUARY	372.272,25	64.328
MARCH	479.315,40	4.842		MARCH	368.442,75	63.799
APRIL	403.453,35	2.956		APRIL	281.012,85	43.787
MAY	519.211,20	4.366		MAY	428.407,20	71.944
JUNE	409.456,35	2.269		JUNE	293.991,75	43.352
JULY	570.498,90	2.998		JULY	422.845,80	63.345
AUGUST	522.595,65	3.045		AUGUST	412.440,60	61.942
SEPTEMBER	505.287,00	3.330		SEPTEMBER	409.628,85	61.802
OCTOBER	457.758,00	3.062		OCTOBER	405.623,00	62.292
NOVEMBER	474.706,20	3.725		NOVEMBER	418.657,50	68.435
DECEMBER	442.735,05	4.647		DECEMBER	372.279,15	63.964
TOTAL	5.657.570,4	47.020		TOTAL	4.546.268,2	732.540

— VANELLI LEAN 24

LINE LABELS	MAIN CODE STATUS	%
A - Active	465	%32
D - To Be Deleted	15	%1
G - RnD and Purchase Blocked	18	%1
I - Inactive	617	%42
K - Stock Evaluation	90	%6
P - Project	18	%1
R - RD is Blocked	105	%7
Turteks	133	%9
Z -Production Blocked	2	%1
A - Active	3144	%26
D - To Be Deleted	259	%2
G - RnD and Purchase Blocked	25	%0,5
I - Inactive	3205	%27
K - Stock Evaluation	449	%4
P - Project	34	%0,5
R - RD is Blocked	2448	%20
Turteks	2456	%20

— VANELLI'S GREENHOUSE GAS INVENTORY

Cate- gory	COMPARISON OF GREENHOUSE GAS RESULTS				2019 tCO²eq		2022 tCO²eq			2023 tCO²eq			2023 tCO²eq	
	Category	Emission Type	Emission Source	Location										
1	1.1 Direct Emissions from Stationary Combustion	Stationary Combustion	Natural Gas	Branch	6340,439	6.997,48	5115,603	5,495,05	5,495,05	4535,415	4895,34	4895,34	4.784,10	4.784,10
				Main	273,167		247,682			240,512				
	1.1 Direct Emissions from Stationary Combustion	Stationary Combustion - Generator	Diesel	Branch	0,487		0,568			0,511				
				Main	0,649		0,521			0,487				
	1.2 Direct Emissions from On Road Combustion	On Road Combustion	Diesel	-	59,430		73,382			53,822				
	1.2 Direct Emissions from On Road Combustion	On Road Combustion	Gasoline	-	38,664		32,213			40,928				
	1.4 Leakage Emissions from Anthropogenic Systems	Leakage Emissions	Refrigerant Gas Leaks	-	264,224		24,954			23,284				
1.4 Leakage Emissions from Anthropogenic Systems	Leakage Emissions	Fire Extinguishing System Gas Leaks	-	0,422	0,125	0,385								
2	2.1 Indirect Emissions from Purchased Electricity	Purchased Electricity	-	3088,414	7302,49	2245,232	5.416,75	0,0	2085,518	4.648,68	0,00	4.523,95	0,00	
			-	4214,072		3171,523			2563,163					
3	3. Indirect Emissions from Transportation	WTT-All Fuels	-	1089,551	2825,75	889,442	2.229,30	2.229,30	792,679	1905,88	1905,88	2.112,18	2.112,18	
	3.1 Indirect Emissions from Transportation and Distribution of Raw Materials	Emissions from Transportation of Raw Materials	-	206,628		316,134			200,614					
	3.2 Indirect Emissions from Transportation and Distribution of Products	Emissions from Transportation of Products	-	1280,589		782,040			676,514					
	3.3 Indirect Emissions from Employee Commuting	Indirect Emissions from Employee Commuting	-	26,184		137,090			139,742					
	3.5 Emissions from Business Travels	Emissions from Business Travels	-	222,802		104,590			96,333					
4	4.1 Indirect Emissions from Purchased Materials	Emissions from Raw Materials	-	13649,171	13,823,13	14118,903	14.259,43	14.259,43	11.771,90	11.908,54	11.908,54	7.368,11	7.368,11	
	4.1 Indirect Emissions from Purchased Materials	Indirect Emissions from Water Supply	-	79,871		37,136			33,233					
	4.3 Indirect Emissions from Solid and Liquid Waste Disposal	Indirect Emissions from Water Treatment	-	87,002		89,512			89,512					
	4.3 Indirect Emissions from Solid and Liquid Waste Disposal	Indirect Emissions from Wastes	-	5,225		11,495			10,999					
	4.3 Indirect Emissions from Solid and Liquid Waste Disposal	Indirect Emissions from Waste Transportation	-	1,378		2,083			2,727					
	4.4 Emissions from the Use of Leased Assets	Indirect Emissions from the Use of Leased Assets	-	0,487		0,302			0,623					
5	5.3 End-of-Life Cycle Emissions of Products	Indirect End-of-Life Cycle Emissions of Products	-	503,03	503,03	503,03	503,03	503,03	503,03	503,03	503,03	75,91	75,91	
TOTAL					30928,856	31.431,89	27903,561	27903,561	22.486,81	23861,476	23861,476	19.512,80	19186,951	14.663,0

— VANELLI’S HAZARDOUS WASTE AMOUNTS

MAIN BUILDING		
Waste Type	Quantity (Kg)	Waste Treatment Method
Medical Waste	5	D9
Contaminated Packaging (15 01 10)	2808	R12
Organic Solvents and Sludges (08 01 11)	650	R12
Contaminated Rags, Towels (15 02 02)	300	R12
Fluorescent Lamps (20 01 21)	20	-
Electrical and Electronic Equipment (20 05 35)	100	-
TOTAL	3,883	-

BRANCH		
Waste Type	Quantity (Kg)	Waste Treatment Method
Contaminated Packaging (15 01 10)	7,138	R12
Organic Solvents and Sludges (08 01 11)	400	R12
Industrial Waste (08 01 21/04 02 16/16 05 06/20 01 21/16 07 08)	400	R13
TOTAL	7,938	-

— VANELLI’S NON-HAZARDOUS WASTE AMOUNTS

Location	Waste Type	Quantity (Kg)	Waste Treatment Method
CENTER	Plastic Bobbin	14,440	R12
BRANCH	Plastic Bobbin	4,940	R12
CENTER	Threaded Plastic Bobbin	20,980	R12
BRANCH	Threaded Plastic Bobbin	30,560	R12
CENTER	Paper	63,660	R12
BRANCH	Paper	98,980	R12
CENTER	Nylon	6,360	R12
BRANCH	Nylon	14,660	R12
CENTER	Waste + Trim	117,120	R12
BRANCH	Waste + Trim	90,220	R12
CENTER	Pallet	15,200	R12
BRANCH	Pallet	19,860	R12

— VANELLI’S WATER USE

Date	Dyeing Plant			Main Building		
	Domestic (1st Quality) (m3)	2nd Quality Process (m3)	Dispenser size water (m3)	Domestic (1st Quality) (m3)	2nd Quality Process (m3)	Dispenser size water (m3)
1.01.2024	461	16.726	95	906	0	95
1.02.2024	478	14.329	30	951	3	30
1.03.2024	397	14.865	0	1.107	3	0
1.04.2024	358	12.176	30	942	33	30
1.05.2024	538	19.228	10	1.260	29	10
1.06.2024	407	11.830	28	1.211	90	28
1.07.2024	499	16.317	31	1.546	100	31
1.08.2024	489	13.763	8	1.481	148	8
1.09.2024	482	14.551	23	1.403	96	23
1.10.2024	511	15.067	38	1.228	0	38
1.11.2024	487	14.788	5	1.080	0	5
1.12.2024	533	13.108	0	1.154	0	0
Total (m3)	5.640	176.748	297	14.269	502	297

Total Blue Water Footprint

197.164

m3/yil

— DYEING PLANT GRAY WATER FOOTPRINT

Pollutants	Value	Unit	Maximum Limit	Unit	Pollutant Load	Unit	Grey Water Footprint	Unit
Chemical Oxygen Demand (COD)	1801	mg/L	2750	mg/L	56775.01	kg/day	59826.14	m³/day
Suspended Solids	91	mg/L	880	mg/L	1780.46	kg/day	2256.60	m³/day
Oil & Grease	130	mg/L	132	mg/L	2366.92	kg/day	1183460.00	m³/day
Other Chemicals								
Sulfate	546	mg/L	1870	mg/L	2690	kg/day	2031.72	m³/day
Total Phosphorus	6.2	mg/L	27.5	mg/L	60	kg/day	2816.90	m³/day
Total Kjeldahl Nitrogen (TKN)	29	mg/L	110	mg/L	6.5884	kg/day	81.34	m³/day
Total Cyanide (T.CN-)	0.009	mg/L	1.1	mg/L	0.137	kg/day	125.56	m³/day
Fluoride (F-)	3.5	mg/L	16.5	mg/L	0.003	kg/day	0.21	m³/day
Phenol	0.5	mg/L	195.15	mg/L	20.000	kg/day	102.75	m³/day
Metals								
Chromium (VI) (Cr+6)	0.009	mg/L	0.55	mg/L	0.084	kg/day	155.98	m³/day
Total Chromium (Cr)	0.009	mg/L	3.3	mg/L	0.084	kg/day	25.64	m³/day
Total Lead (Pb)	0.009	mg/L	2.2	mg/L	0.03	kg/day	15.41	m³/day
Total Cadmium (Cd)	0.009	mg/L	0.11	mg/L	0.01	kg/day	83.55	m³/day
Total Mercury (Hg)	0.009	mg/L	0.055	mg/L	0.002	kg/day	36.69	m³/day
Total Copper (Cu)	0.09	mg/L	3.3	mg/L	0.084	kg/day	26.29	m³/day
Total Zinc (Zn)	0.16	mg/L	22	mg/L	0.169	kg/day	7.73	m³/day
					Total Grey Water Footprint		1.251.052,50	m³/day

— MAIN BUILDING GRAY WATER FOOTPRINT

Pollutants	Value	Unit	Maximum Limit	Unit	Pollutant Load	Unit	Grey Water Footprint	Unit
Chemical Oxygen Demand (COD)	738	mg/L	2750	mg/L	56775.01	kg/day	28218.20	m³/day
Suspended Solids	506	mg/L	880	mg/L	1780.46	kg/day	4760.59	m³/day
Oil & Grease	70	mg/L	132	mg/L	2366.92	kg/day	38176.13	m³/day
Other Chemicals								
Sulfate	18	mg/L	1870	mg/L	2690	kg/day	1452.48	m³/day
Total Phosphorus	12	mg/L	27.5	mg/L	60	kg/day	3870.97	m³/day
Total Kjeldahl Nitrogen (TKN)	116	mg/L	110	mg/L	6.5884	kg/day	-1098.07	m³/day
Total Cyanide (T.CN-)	0.009	mg/L	1.1	mg/L	0.137	kg/day	125.56	m³/day
Fluoride (F-)	0.29	mg/L	16.5	mg/L	0.003	kg/day	0.17	m³/day
Phenol	0.5	mg/L	195.15	mg/L	20.000	kg/day	102.75	m³/day
Metals								
Chromium (VI) (Cr+6)	0.009	mg/L	0.55	mg/L	0.084	kg/day	155.98	m³/day
Total Chromium (Cr)	0.009	mg/L	3.3	mg/L	0.084	kg/day	25.64	m³/day
Total Lead (Pb)	0.009	mg/L	2.2	mg/L	0.03	kg/day	15.41	m³/day
Total Cadmium (Cd)	0.009	mg/L	0.11	mg/L	0.01	kg/day	83.55	m³/day
Total Mercury (Hg)	0.009	mg/L	0.055	mg/L	0.002	kg/day	36.69	m³/day
Total Copper (Cu)	0.04	mg/L	3.3	mg/L	0.084	kg/day	25.88	m³/day
Total Zinc (Zn)	0.15	mg/L	22	mg/L	0.169	kg/day	7.72	m³/day
					Total Grey Water Footprint		75.959,64	m³/day

NOTES

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VANELLI

OSB. Turkuaz Cd. No: 24 16140 Nilüfer, Bursa, Turkey
T. +90 224 242 7070 info@vanellitextile.com

vanellitextile.com



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