

3M CUMBERLAND GREEN TIER- ATTACHMENT 2

ENVIRONMENTAL PERFORMANCE

AIR-

3M Cumberland Oven Capacity Project

A new oven configuration has provided operation flexibility to reduce certain oven zone temperatures and increase recycle air flow in the drying process. These adjustments reduced VOC generation within the oven and, because the air flow recycle loop passes through a burner, additional VOC reduction is being achieved by thermal oxidation.

2006- Baseline (pre-oven project)	55.7 Tons VOC emissions
2007-	34.9 Tons
2008-	31.7 Tons

WATER-

Suspended solids discharge is listed as a significant aspect in our EMS, therefore, this is considered an opportunity for continuous improvement. In order to minimize water discharge and associated solids discharge to the local POTW, process mixing vessels were coated with a specialized non-stick coating and the top of the vessels were lined with a sacrificial film barrier to allow for a "dry" cleaning process. After a mix is used, the vessel is allowed to dry and the residual is scrapped from the vessel and disposed. Additional water usage minimization projects include plans to separate solids from wash water by filter press or cyclonic separation and recycle the water back to the process.

LAND-

A new packaging container was redesigned which eliminated the use of an intermediate corrugated box that was part of a master container, this ultimately reduced downstream landfill waste by 18.5 tons.

NATURAL RESOURCES-

3M Cumberland is subject to Corporate initiatives such as Environmental Targets 2010 (ET10), this program sets and tracks environmental goals for all facilities which coincide with the Company's sustainability programs. The present targets are as follows:

- Reduce waste (non-product output) per pound of product by 20%
- Reduce volatile air emissions per pound of product output by 25%
- Improve energy efficiency per pound of product by 20%
- 800 accepted pollution prevention pays (3P).

The Cumberland facility also provided a grant to the local school district for a Community service day. This sponsored event served the Rice Lake/Cumberland, WI area where students, staff and volunteers worked on a variety of projects to maintain and improve the biodiversity of the community. This served to teach the participants important intangible lessons of taking ownership of the environment. Additionally, 3M Cumberland has taken on a partnership roll with the Island City Research Academy, a pilot program for the Cumberland School System providing a non-traditional alternative for 7th and 8th grade students. This program provides an environmental focus to teaching science, math, language arts, and social studies.