

3M & Wisconsin DNR

3



GREEN TIER

Advantage: Business Advantage: Environment

3M Cumberland

Plant and People

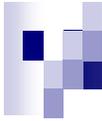
- Plant Size 141,700 ft²
- Property 12 Acres
- Employees/Average age. 193/47 years
- Average length of service 13 years

46% ≤10yrs, 76% ≤15 yrs, 27% ≥ 30yrs

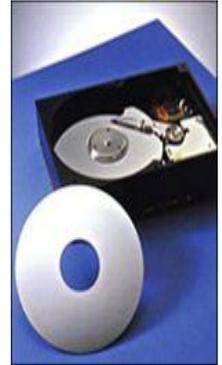
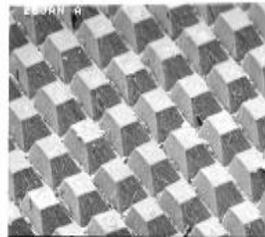
Community Size 2,500

3 *Is the preferred employer in area*





Products We Make



Electronics Products

Abrasives Products

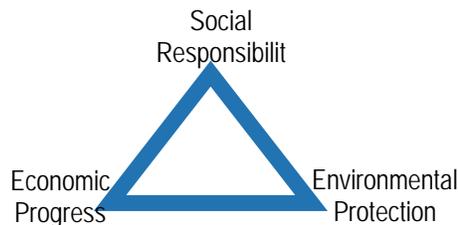


Hand and Floor Pads

3

3M's Sustainability Strategy

Pursuing customer satisfaction and commercial success within a framework of environmental, social and economic values.



All three legs of the triangle are crucial to moving 3M towards sustainability.

The 2015 Sustainability Goals are:

- [Volatile Organic Compound \(VOC\) Reduction](#) 15% by 2015 from 2010 base (*Indexed to net sales*)
- [Waste Reduction](#) 10% by 2015 from 2010 base (*Indexed to net sales*)
- [Energy Conservation](#) 25% by 2015 from 2005 base (*Indexed to net sales*)
- Greenhouse Gas Emissions Reduction 5% by 2011 from 2006 base
- [Water Conservation Plans](#) (*for select sites*)

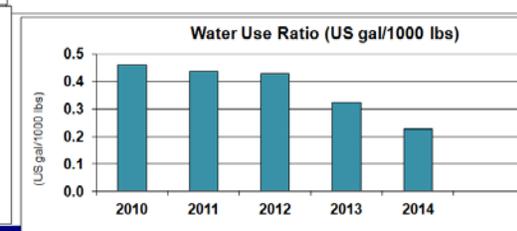
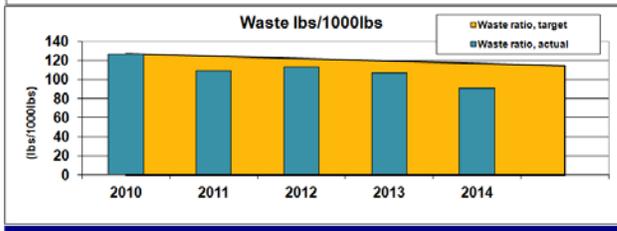
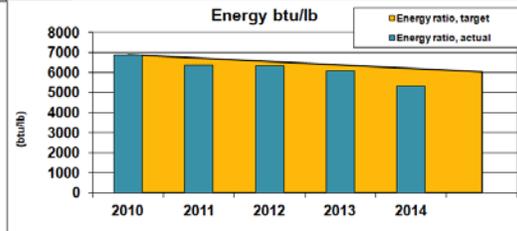
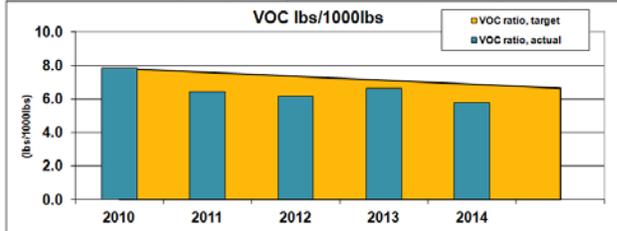
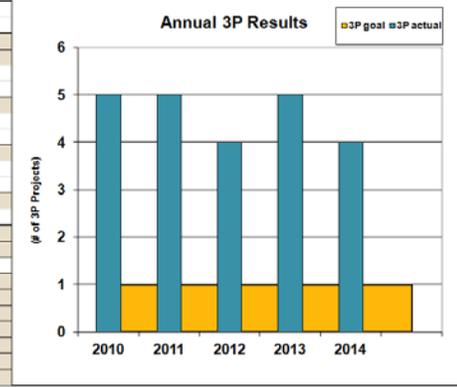
3M Cumberland 2015 Sustainability Metrics

2015 Environmental Goals Summary

Cumberland



Metric	Baseline Year	Reduction Goal (%)	Baseline 2010	2011	2012	2013	2014
Total good output (1000 lbs)			14,137	15,167	14,664	15,690	16,229
VOC (1000 lbs)	2010	15%	111	98	91	104	106
VOC ratio, actual (lbs/1000 lbs)			7.85	6.44	6.18	6.63	5.79
VOC ratio, target (lbs/1000 lbs)			7.85	7.61	7.38	7.14	6.91
Waste (1000 lbs)	2010	10%	1,797	1,654	1,655	1,678	1,663
Waste ratio, actual (lbs/1000 lbs)			127.1	109.1	112.9	106.9	91.2
Waste ratio, target (lbs/1000 lbs)			127.1	124.6	122.0	119.5	114.4
Energy usage (MMBtu)	2005	25%	97,369	96,953	92,868	95,722	97,356
Energy ratio, actual (Btu/lb)			6,888	6,392	6,333	6,101	5,341
Energy ratio, target (Btu/lb)			6,888	6,716	6,544	6,371	6,199
3P actual	2010		5	5	4	5	4
3P goal			1	1	1	1	1
TRI (1000lbs)			na	na	na	na	na
Water (US gals)			6,516	6,620	6,294	5,860	4,132
Water Ratio (US gals/1000 lbs)			0.5	0.4	0.4	0.3	0.2
Onsite Recycle + Reuse			3,882	3,218	3,255	3,311	3,315
Offsite Recycle			0	0	0	0	0
% Reuse and Recycle			311	332	321	348	395
VOC Used (1000 lbs)			117	113	119	124	131
VOC Before Control (1000 lbs)			111	98	91	104	106
RM Utilization %			86%	88%	88%	88%	8900%



AIR-

3M Cumberland continues to pursue improvements toward air emission reduction through new product development and reformulation of existing products.

VOC Goal

"Reduce VOC 15% by 2015 from 2010 Base Year, Indexed to Net Sales"



Objectives:

- Key divisions and countries drive reductions through R&D, product mix and/or capital \$'s
- Facilities work to maintain uptime and efficiency of control equipment

Internal Targets

All Facilities and Division/Countries:
Maintain or reduce VOC emissions indexed to good output

Select Divisions/Countries:
Drive reductions on prioritized basis

What's the Same as ET'10:

- Continue tracking & reporting of VOC
- De minimus color coding
- Potential to adjust baseline if needed



ENERGY

2014 Marks the 10th consecutive year that 3M has received the EPA energy start award



Our Actions **Made** a Difference

By improving our energy efficiency by 10% we've met the ENERGY STAR Challenge for Industry.

3M Cumberland

As a partner with the U.S. Environmental Protection Agency's ENERGY STAR® program, we're committed to protecting the environment through energy efficiency. If the energy efficiency of U.S. commercial and industrial buildings improved by 10 percent, Americans would save about \$20 billion and reduce greenhouse gases equal to the emissions from about 30 million vehicles. Learn more at www.energystar.gov.



LAND

Cumberland Green Team

Charter – Coordinate and implement activities to reduce, reuse and recycle to conserve energy and natural resources



3M Cumberland established a GREEN TEAM to focus on recycling efforts. For 2014, the team accounted for over 115 tons of paper and cardboard, over 22 tons of plastic, over 20 tons of copper, over 2 tons of brass and over 0.5 tons of aluminum. This totals to over 159 tons of recyclable materials.

The GREEN TEAM also coordinates the Adopt a Highway Program for the Cumberland facility, as well as, special events such as tree seedling sales, and park cleaning.

Green Team



Charter – Coordinate and implement activities to reduce, reuse and recycle to conserve energy and natural resources

Reduce, Reuse, and Recycle are employee expectations. Below are a few **PATHWAYS** covering these.

Recycling path in MDI – access your lotus notes > MDI > Plant Documents > Environmental, Health, & Safety > scroll to the bottom - Waste Disposal Recycling>QEHS 0045.

Plant Recycling Map in MDI - access your

Green Team folder – T-Drive > EHS General > EHS Subgroups > Green Team

To view recycle weights spread sheet in the Green Team Folder >6 Sigma data > Weights

To view Department breakdown in the Green Team Folder >Jeannie Martin notes, & pics > Department breakdown

- **Green Team Members**
- **Kathy Sue Stumpf**
- **Clare Saffert**
- **Brenda Shelby**
- **Jacob Pabst**
- **Shelley Kallsen**
- **Jeff Strickland**
- **Suzanne Dodge**
- **Al White**
- **Michele Dutilly**
- **JoAnne Brock**
- **Michael Peterson**
- **Tammy Bertelsen**

Environmental Activism

- Adopt a Highway
- ICA activity volunteers
- ICA – board involvement
- Hunt Hill relationship/support



3M Cumberland 3P (Pollution Prevention Pays) contributions:

3M Cumberland completed four 3P projects in 2014 which contributed to reductions of 245 metric tons per year of CO2 and reduction of 5.71 tons of solid waste that would have been sent to landfill or incineration.

Pollution Prevention Pays (3P)

3P Overview



Dr. Ling launched 3M's Pollution Prevention Pays program in 1975

"Pollution is ... unused raw material. By reducing the amount of pollution, ... [3M can] save money both on pollution control and on raw materials the next time around. It's a win-win situation."-Ling

SOCIAL RESPONSIBILITY

3M Cumberland provides support for a wide variety of community programs as identified below:



Social Responsibility

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3M Cumberland 2014 Community Support		
City Community Relations Council Funds (13000-4000)		
JM Funds allocated to Wisconsin (Cumberland's portion)		
Boys & Girls Club of Barron County	\$ 1,500.00	Supplies for Schools - Spring 2014
Heart Island Family Enrichment Center	\$ 1,500.00	JM Products - several pallets to each school
Kinship of Cumberland & Turtle Lake - Mentoring	\$ 1,500.00	1 Rice Lake High School
Cumberland Area Friends of Scouting Inc. "Scoutlets" (year 8 of 3 year commitment)	\$ 1,500.00	2 Cumberland High School
Cumberland Elementary NOW - "Nutrition on Weekends"	\$ 1,000.00	3 Shell Lake High School
Cumberland Schools Academic Excellence	\$ 1,500.00	
Cumberland Schools at Risk Program/Character Building	\$ 8,000.00	Supplies for Schools - Fall 2014
	\$ 16,500.00	JM Products - several pallets to each organization
		1
		2
		3
Cumberland - Community Giving Campaign - Foundation Match		
Cumberland United Fund	\$ 3,900.00	
		Supplies 4 Non Profits - Fall 2014
		JM Products - several pallets to each organization
		1
		2
		3
		4
		5
Additional Sponsorship		
Sponsorship in the form of money (Plant Expense)		
Cumberland Hospital - Progressive Dinner - (2 tickets)	\$ 120.00	
Chamber of Commerce - Cumberland - Golf Mixer	\$ 1,000.00	
Boys & Girls Club Fundraiser (Table for 8)		
Light A Legacy (Table for 8 = 2 sponsored Card Table)		
Arts Midwest - JM to sponsor Welcome Reception for each group (up to \$500 per event) - Spring	\$ 500.00	
Cumberland School District - Wolf Ridge		
Boys & Girls Club - Taste of Cumberland (4 entry tickets)		
Chamber of Commerce - Cumberland - Golf Event (2 golf entries, 2 dinners) June 13, 2014		
Arts Midwest - JM to sponsor Welcome Reception for each group (up to \$500 per event) - Fall	\$ 500.00	
Kinship Yearly Fundraiser (Send 2 couples)	\$ -	
	\$ 2,120.00	
Total Monetary Donations to Community	\$ 22,520.00	

INTERESTED PARTIES GROUP

3M Cumberland has made efforts to engage the community with the facility operations by inviting community members and government officials to the Cumberland Facility for outreach meetings on an annual basis.



Interested Parties

- Nancy Bentz – Members of Beaver Dam Lake Management District
- Tom Schroeder – President Beaver Dam Lakes Mngt District
- Barry Rose – CU School Superintendent
- Tom Mysicka – Cumberland Mayor
- Keith Hardie – Cumberland Public Works Director
- Katie Goin – Cumberland Wastewater Treatment
- Tom Goldsmith – Cumberland Aldermen (Ward 4)
- Doris Laursen - Cumberland Aldermen (Ward 4)
- Jon Hile – Chamber of Commerce Vice-President
- Jon Dague – WI Dept Natural Resources (Air permits)
- Sonny Zentner – WI Dept Natural Resources (Green Tier)
- Stephen Smith – State Representative (75th District)
- Local neighbors (Judy Owen, ?)
- Louie Muench – President Cumberland Utilities Commission
- Gaby Zappia – 3M Corporate Environmental Eng
- Chris Nelson – 3M Corporate Environmental Eng
- Mike Lukes - 3M Corporate Environmental Eng
- David Wefring – 3M Public Affairs
- Keith Seelig – 3M Environmental Eng
- Kevin Becker – 3M Maintenance Eng
- Mark Ratzlaff – 3M Plant Manager
- Also attended: 3M – JoAnne Brock, Jeff Walsh
- Also attended:

Those in blue were able to attend



ECONOMIC PROGRESS

- Further Enhance Sustainability Attributes of New Products
- Review Progress on Standards for Suppliers

New Product Goal

"Further Enhance the Environmental Sustainability Attributes of New Products"



Objectives:

- Address increasing stakeholder interest in sales of products with an EHS and/or energy advantage
- Provide business units with sales data in this growing market area
- Demonstrate increasing 3M innovation in this market
- Track in New Product Portal

Environmental Solutions Product Criteria

- Team developing new criteria for Environmental Solutions Products
- Technical managers in divisions/ countries will work with PRLs to evaluate new products
- Environmental Solutions product criteria will be available on the Sustainability Center on 3M Source

New Product Goal

New Products Portal (NPP) - Secure Welcome: Maria | [My Preferences](#) | [Contact Us](#) | [Log Off](#)

[Enter Project Number or Name to Search] x

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Projects	Project Name: *	Maria SKU Test 1	Project Number:	16264																																																																																	
Quick Data Entry	Project Category:	NPI	Division/Laboratory: *	CHIM																																																																																	
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Help/Training	<table border="1"> <thead> <tr> <th>Summary</th> <th>General</th> <th>Description</th> <th>Phase Gates</th> <th>Stock Numbers</th> <th>Financials</th> <th>Launch Calendar</th> <th>Issues and Actions</th> <th>Big B Metrics</th> </tr> </thead> <tbody> <tr> <td>NPP - Explore</td> <td>Big Business Priority: *</td> <td>3 - All Other Opportunities or Programs</td> <td>Business:</td> <td>C&OB</td> <td>Project Champion:</td> <td></td> <td>Market Tier:</td> <td>Tier A</td> </tr> <tr> <td>NPP - Data Analysis</td> <td>Strategic Intent:</td> <td>1 - Grow the Current Core Business</td> <td>Project Code:</td> <td></td> <td>Division Project Code:</td> <td></td> <td>Share this project?:</td> <td>Yes</td> </tr> <tr> <td></td> <td>R&D Country:</td> <td>United States</td> <td>Project Type:</td> <td>Standard</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Probability of Success:</td> <td>Technical: * 50 % Business: * 50 %</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>High Growth Market Space: *</td> <td>Not a High Growth Market Space</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Environmental Sustainability Attributes:</td> <td>Select One</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Cluster Name:</td> <td>Select One</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Division Priority Ranking:</td> <td>Yes No Interim write</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>				Summary	General	Description	Phase Gates	Stock Numbers	Financials	Launch Calendar	Issues and Actions	Big B Metrics	NPP - Explore	Big Business Priority: *	3 - All Other Opportunities or Programs	Business:	C&OB	Project Champion:		Market Tier:	Tier A	NPP - Data Analysis	Strategic Intent:	1 - Grow the Current Core Business	Project Code:		Division Project Code:		Share this project?:	Yes		R&D Country:	United States	Project Type:	Standard						Probability of Success:	Technical: * 50 % Business: * 50 %								High Growth Market Space: *	Not a High Growth Market Space								Environmental Sustainability Attributes:	Select One								Cluster Name:	Select One								Division Priority Ranking:	Yes No Interim write						
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3M Expectations of Suppliers

- "Standard for Suppliers: Environmental, Health, Safety, Transportation & Labor/Human Resources"
 - *Global applicability*
 - *Applies to selection & retention of suppliers worldwide*
 - *Intent is to drive continuous improvement*

- Publicly available on the 3M Sustainability Website:

http://solutions.3m.com/wps/portal/3M/en_US/global/sustainability/resources/policies/



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ISO CERTIFICATION REPORT (Attached)



Assessment Report.

3M Company 3M Cumberland Plant

DRAFT

Report Author **Mark Donnelly**
Visit Start Date **01/06/2015**

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