



**2014 Annual Report
For the Cooperative Environmental Agreement
Between 3M –Prairie du Chien
And the Department of Natural Resources**

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Prepared For:

Wisconsin DNR

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Introduction

This annual performance report is submitted in part to meet the requirements of Section IV, Contract for Superior Environmental Performance, of the March 2014. Included in the report is the following information concerning the environmental performance and commitment to superior environmental performance of 3M Company – Prairie du Chien during 2014:

- Involvement and input from the Interested Person's Group to the Agreement
- Evaluation of the EMS (Environmental Management System), areas of success and areas for improvements beyond those specified, in addition to other objectives and targets set in the previous year's report
- 2014 3P (Pollution Prevention Pays) project summaries (goal of at least four approved projects during 2014)
- Status of the goal of maintaining or reducing the emissions of VOC (volatile organic compounds) per pound of good output (semi-finished and finished goods) to a level equal or less than 3.14 pounds VOC / 1000 pounds good output through 2014 (2010 baseline)
- Status of progress toward the goal of a 10% reduction in waste per pound of good output by the end of 2014 (2010 baseline)
- Status of progress toward the goal of reducing energy usage per pound of good output by 15% by the end of 2014 (2010 baseline)
- General assessment of the success of the Agreement in reducing time and money spent by 3M and the DNR on paperwork and other activities that may not directly benefit the environment

Regarding Commitment to Superior Environmental Performance

As stated in Section II.C of the Contract for Superior Environmental Performance, 3M Prairie du Chien commits to pursue superior environmental performance while achieving a balance between economic, social, and environmental impacts for its efforts. The plant's commitment to reducing its environmental footprint continues to contribute to 3M's reputation in the community, the country, and the world. This demonstrates that economic progress and environmental improvement can go hand-in-hand. The Environmental Targets 2015 (ET15) program is the corporate initiative that will serve as the basis for our commitment to superior environmental performance for the next five year period beginning in 2011. These goals were designed to drive continued reductions or maintenance in volatile organic compounds (VOCs), waste and energy efficiency, and continue the emphasis on the Pollution Prevention Pays (3P) program. Specific Prairie du Chien goals for this program by the end of 2015 (2010 baseline) were:

- Reduce Waste per pound of good output (semi-finished and finished goods only) by 10% by the end of 2015 (2010 baseline)

Waste, as defined in the ET15 program, includes chemical waste sent for treatment, waste sent to waste to energy (W/E) facilities for disposal, and landfill. Plant recycle and reuse of raw materials, and the off-site recycle and reuse of materials sent to waste vendors are considered "neutral" in this program and serve as an incentive for 3P projects for cost reduction and pollution prevention.

- Maintain or reduce Volatile Air Emissions (VOC) per 1000 pound of good output < 4.11 pounds VOC/1000 pound good output each year (2010 baseline)

- Improve Energy Efficiency per pound of good output by 15% by the end of 2015 (2010 baseline)
- Submit at least two accepted 3P (Pollution Prevention Pays) projects each year
- Conduct regular meetings (at least two meetings per year) with the Interested Persons Group for the 3M Prairie du Chien Plant

These goals set the basis for superior environmental performance under the Participation Contract under Green Tier Program.

Regarding Status of the Goal of Maintaining or Reducing VOC Emissions

Actual VOC emissions increased 3,000 lbs or 3.5% in 2014 compared to 2013. The actual ratio of VOC (lbs) to good output (1000 lbs) increased two percent however the actual ratio was still 18% less than the site goal thus the site is at a maintain phase for VOC emissions. Results of this goal are shown in Figure 1 and Table 1.

Figure 1: VOC lb./1000 lb. Good Output

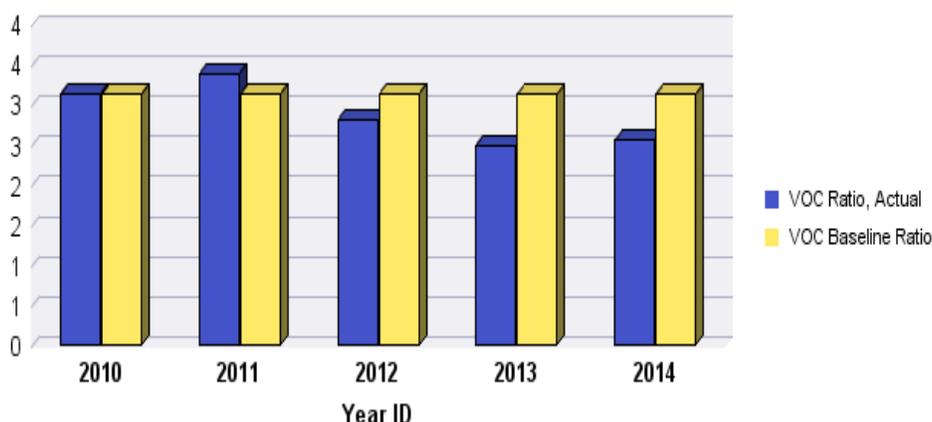


Table 1: VOC/1000 lb. Good Output

Metric	Baseline Year	Goal (%)	Baseline	2010	2013	2014
Total good output (1000 lbs)				28,190	34,624	35,326
VOC (1000 lbs)	2010	0	89	89	87	90
VOC ratio, actual (lbs/1000 lbs)			3.14	3.139765874	2.506931608	2.55905066
VOC ratio, target (lbs/1000 lbs)			3.14	3.14	3.14	3.14

Status of Progress toward Reduction in Waste per Pound of Good Output

The actual ratio for 2014 was 174.45 pounds waste/ 1000 pounds good output. This was a decrease of 21% from the baseline 2010 levels. There was a concerted effort to identify waste streams that were being sent for recycle, thus reducing our waste ratio. Results of this goal are shown in Figure 2 and Table 2. As shown in Figure 3, about 29% of the non-product output produced in 2014 was either recycled or reused. Refer to Figure 4 showing the raw material utilization by waste type for the period 2010-2014.

Figure 2: Waste lbs/ 1000 lb. Good Output

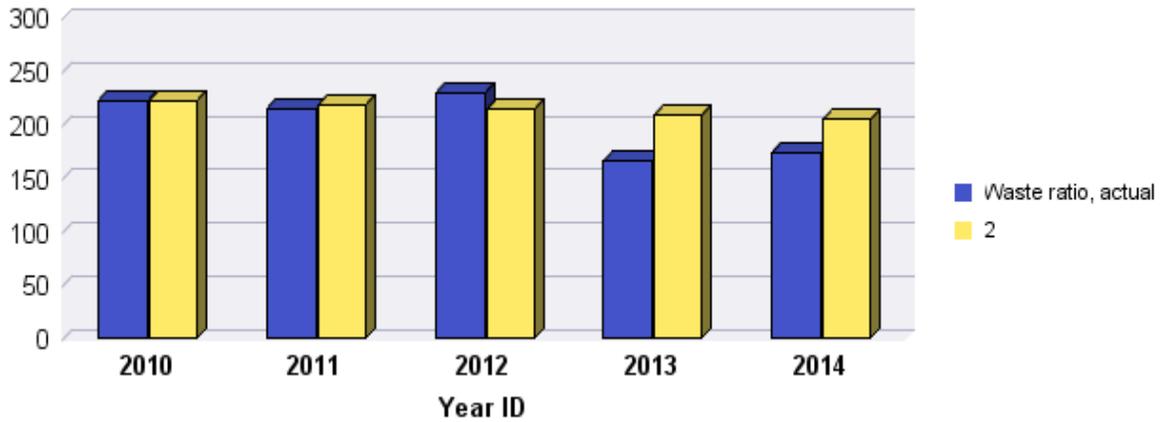


Table 2: Waste / 1000 lb. Good Output

Metric	Baseline Year	Goal (%)	Baseline	2010	2013	2014
Total good output (1000 lbs)				28,190	34,624	35,326
Waste (1000 lbs)	2010	10	6,293	6,293	5,759	6,163
Waste ratio, actual (lbs/1000 lbs)			223.24	223.2351898	166.338378	174.4513894
Waste ratio, target (lbs/1000 lbs)			223.24	223.2351898	209.8410784	205.3763746

Figure 3: Percent Recycle & Reuse

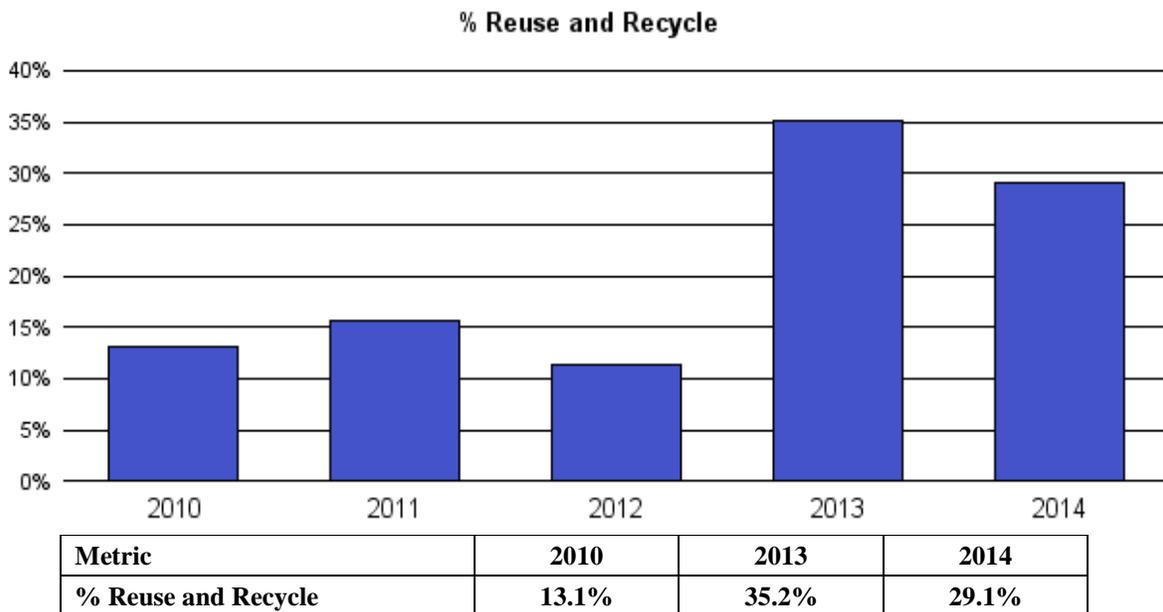
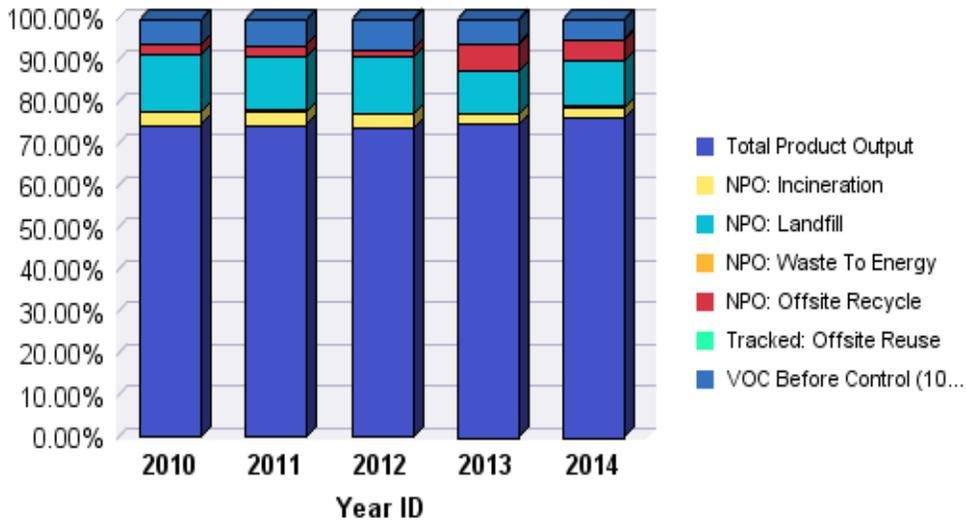


Figure 4: Raw Material Utilization (2010-2014)



Metric	2010	2013	2014
RM Utilization %	74.7%	75.1%	76.5%
Total Product Output	28,190	34,624	35,326
NPO: Incineration	1,201	1,083	1,170
NPO: Landfill	5,092	4,639	4,992
NPO: Waste To Energy	0	37	0
NPO: Offsite Recycle	947	2,976	2,367
Tracked: Offsite Reuse	0	153	166
VOC Before Control (1000 lbs)	2,301	2,621	2,182

NPO= Non-Product Output

Status of Progress toward the Goal of Reducing Energy Usage per Pound of Good Output

In 2014 the two percent increase in production (1000 lbs) helped to compensate for the five percent increase in overall energy usage (MMBTU). The energy ration increased by 3% in 2014 over 2013. This ratio even after the increase is still ten percent below the goal of 10,276 btu/lb for the plant. 3M Prairie du Chien is embarking down the road of ISO 50001 and is confident that the process and activities of ISO 50001 will provide an increased benefit to the plant in the energy goals for the plant and 3M corporation overall.

The Prairie du Chien plant was recognized by the 3M Corporate Energy Management Department as a 2014 Silver Level Energy Award recipient. To achieve this award, the plant was required to complete a combination of activities resulting in energy efficiency improvement, energy projects being implemented and to support aspects of an energy management system through the function of a plant energy team. Through contributions and efforts from 3M locations like Prairie du Chien, 3M achieved the 2014 ENERGY STAR® Partner of the Year Award with Sustained Excellence for the tenth

consecutive year. By developing, executing and maintaining practices that strive for sustainable company-wide growth, 3M's continued efforts to improve efficiency not only helps the bottom line, but it also demonstrates our commitment to sustainability - both of which are requirements for business success. Refer to Figure 5 and Table 3 to review the energy usage results for 2014.

Figure 5: Energy Use/ Lb Good Output

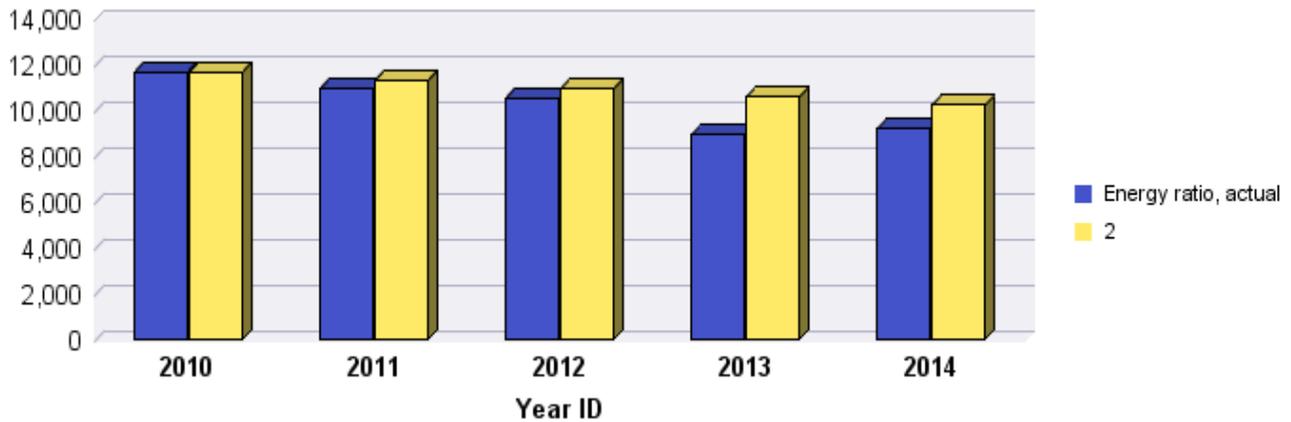


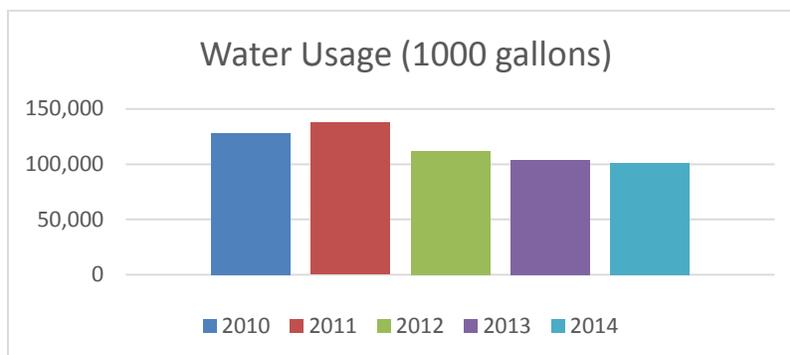
Table 3: Energy Use/Lb. Good Output

Metric	Baseline Year	Goal (%)	Baseline	2010	2013	2014
Total good output (1000 lbs)				28,190	34,624	35,326
Energy Usage (mmbtu)	2010	15	329,183	329,183	310,686	326,526
Energy ratio, actual (btu/lb)			11,677	11,677	8,973	9,243
Energy ratio, target (btu/lb)			11,677	11,677	10,626	10,276

Regarding Actual Water Usage Ratio

Although water usage is not part of the Agreement environmental commitments, water usage is tracked as part of the overall corporate ET15 reporting. Water usage, although essential and important to our environmental impact, is not a significant aspect under the facilities Environmental Management System (EMS). Refer to Figure 6 for water use ratio in gallons for every 1,000 pounds of good output in 2010 - 2014.

Figure 6: Plant Water Use Ratio



Regarding the Interested Persons Group

The 3M Company–Prairie du Chien Interested Persons Group (IPG) is composed of representatives from business, government and citizens in the Prairie du Chien area who are interested in environmental stewardship and the impact of manufacturing on local communities. Group members include the following individuals:

- Ken Pankow – Prairie Memorial Hospital
- Sylvia Gilbert – Neighbor
- Russ Gillitzer - Neighbor
- Cory Mezera – Neighbor
- Don Rueblow - Neighbor
- Harry Remz – Prairie Fire Department
- Robert Irvine – 3M Plant Engineering
- Mike Pettit– 3M EHS Engineer
- Joel Arnold – 3M Plant Engineering Manager
- Thomas Harris 3M Plant Manager

Interested Person Group meetings were held on May 27, 2014 and November 19, 2014. The group was engaged and interested in the topics discussed. Community asked if 3M would consider offering information to other local businesses on the Green Tier program and the benefits.

Regarding an Evaluation of the EMS

A third party auditor, BSI (British Standards Institute), conducted a surveillance audit of our EMS October 7, 2014. The audit resulted in five minor non-conformities that required that an action plan response to BSI. The response plan was submitted and accepted by BSI in early December 2014. Several non-conformities dealt with inconsistent practices and procedures in managing aspects, training records, and the effective control of documents to verify the most current version is available to the population that uses the document. Corrective actions are in the process of being implemented, and the effective implementation of the plan will be verified at the next BSI audit visit (September 2015).

Internal assessments of the EMS were conducted in all operational and service areas of the facility during the year. These audits resulted in twelve corrective or preventive actions being issued from the fourteen audits conducted. Regular management reviews are held in May and November of each year the plant management team to review progress towards the plant environmental goals and targets. An annual review of all EMS elements was held with upper management during early May 2014.

A self –assessment audit called GEMSA (Global Environmental Management Self-Assessment) that reviews environmental regulatory and other requirements to which 3M subscribes was reviewed and approved by plant management in April 2014. Overall score was 100 %.

Summary of Projects Completed by the 3M PdC Green Team

3M Prairie du Chien has a Green Team and a Sustainability Team for the site. The Green Team is focused on external projects and activities that benefit the community around the plant and the Sustainability Team is focused on obtaining and maximizing the project benefits for Waste, Water and VOC reductions. The Sustainability Team is involved with the 3P projects discussed in Table 4 and the tracking of metrics associated with the plants ET15 or Sustainability Goals 2015 which are also the EMS objectives and Targets.

In 2014 the 3M Prairie du Chien Green Team conducted maintenance activities to the 3M PdC Prairie located on the corner of N. Marquette Road and Fredrick Street. These maintenance activities ensure the health and diversity of the prairie are optimal. This team also conducted an Adopt-a-Highway cleanup, and a Mississippi River cleanup.

Regarding a Summary of 2014 Approved 3P (Pollution Prevention Pays) Projects

A standing EMS goal for the facility is to generate at least 2 approved 3P projects each year. In 2014 there were nine approved projects submitted. A summary of these projects is shown in Table 4: 3P (Pollution Prevention Pays) Project Summary

Table 4: 3P (Pollution Prevention Pays) Project Summary

Project	Project Description	Pollution Prevented/Energy Saved
Roll Coat Roll Scrap 2014-11593	Decrease the rolls per cleaning cycle from 6.5-1.5	0.5 tons of waste reduced
Extrusion Die Modification 2014-11531	Modified a Die to gain productivity and yield	68.04 tons of waste reduced
Spray booth enclosure 2014-11204	Redesign spray booth to increase productivity, safety and decrease time during changeovers	5.9 tons of waste reduced
Recycle our Polypropylene scrap for reuse in out extrusion process 2014-11530	Reuses of waste material as raw materials	90.72 tons of waste reduced
Reduction of scrap mixes by blending into Medium 2014-11324	A mix that would have been scrapped was blended into the process to avoid waste cost and RM Costs	1.15 tons of waste reduced
Salvage of Unitized Slabs 2014-12271	Better utilization of the slabs to decrease waste created	1.95 tons of waste reduced
PdC Sorbent Distribution 2014-11392	Move the distribution of sorbent material from one 3M facility to the PdC plant. Eliminated over packaging and saved on transportation	92.3 tons of waste 5820 gallons diesel 60.26 CO2 equivalents reduced
Roll Length Increase	Increase density of roll without changing size	195.1 tons of Waste reduced

Project	Project Description	Pollution Prevented/Energy Saved
Eliminate process waste	Utilized the ends of semi-finished product rolls as a new SKU	4.99 tons of Waste reduced
Total Pollution Prevented/ Energy Saved & First year Savings:		460.6 tons/ 815 MMBTU

Regarding Operational Flexibility:

3M Prairie du Chien obtained there Flex Title V permit in March of 2014 and are continuing to operate under it as it was obtained. Any future projects will be discussed with the agency under the flex permit requirements.

Regarding Additional Time Requirements for Fulfilling this Agreement include:

<u>Requirements Added:</u>	<u>Additional Time</u>
Compiling this Performance Report	30 hours/year
Coordinating the Interested Persons Group	20 hours/year

Regarding Overall Assessment of the Success of the Agreement:

In 2014 3M Prairie du Chien (PdC) was able to utilized the operational flexibility provided in this agreement in a project for the Belt Making Area and the installation of an adhesive meter mix system to the department.

We look forward to the business advantage of the operational flexibility allowed under this contract and the ability to expand product manufacturing capability in such a short time frame.

Questions and requests for additional information should be directed to Michelle Dupey, EHS Department, at the address below:

3M Company – Prairie du Chien Plant
801 N. Marquette Road
Prairie du Chien, WI 53821
Phone: 608/326-2466 ext 2224
E-mail: mdupey@mmm.com

Appendix A



By Royal Charter

Certificate of Registration

ENVIRONMENTAL MANAGEMENT SYSTEM - ISO 14001:2004

This is to certify that:

3M Company
Abrasive Mfg Organization
801 N. Marquette Road
Prairie du Chien
Wisconsin
53821
USA

Holds Certificate No:

EMS 540200

and operates an Environmental Management System which complies with the requirements of ISO 14001:2004 for the following scope:

The management of environmental risks associated with the assembly, forming, converting and extrusion processes for the manufacturing of non-woven mats, abrasive cleaning and polishing products at 3M Company, Prairie du Chien, WI, USA

For and on behalf of BSI:

Pietro Foschi - Strategic Delivery Director

Originally registered: 01/15/2001

Latest Issue: 01/07/2015

Expiry Date: 01/14/2018



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