



**2008 Annual Report
for the Cooperative Environmental Agreement
Between 3M -Menomonie
and the Department of Natural Resources**

March 15, 2009

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Introduction

This 2008 annual performance report is submitted in part to meet the requirements of Section XIII, Baseline and Periodic Performance Evaluations, of the October 2007 Extended Agreement.

Included in the report is the following information concerning the environmental performance and commitment to superior environmental performance of 3M Company – Menomonie during 2008:

- 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
- 2008 3P (Pollution Prevention Pays) project summaries (goal of at least two approved projects each year through 2010)
- Status of reductions of hazardous waste levels per pound of good output
- 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 7.1 pounds VOC / 1000 pounds good output through 2010 (2005 baseline)
- Status of progress toward the goal of a 20% reduction in non-product output per pound of good output by the end of 2010 (2005 baseline)
- Status of progress toward the goal of reducing energy usage per pound of good output by 20% by the end of 2010 (2005 baseline)
- Status of progress made for Wildlife Habitat Council (WHC) site certification
- Water usage in the facility (2005-2008)
- 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 IX of the Extended Agreement, 3M Menomonie 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 and demonstrates that economic progress and environmental improvement can go hand-in-hand. The Environmental Targets 2010 (ET'10) program is 3M's current generation of corporate goals. These goals are designed to drive continued reductions in volatile organic compounds (VOCs), waste and energy efficiency, and continue the emphasis on the Pollution Prevention Pays (3P) program. Corporate environmental performance targets were established in 2006 reflecting the next 3M initiatives for sustainable development through the year 2010. This new program, called **Environmental Targets 2010 (ET'10)**, began in 2006. ET'10, like the former program Environmental Targets 2005 (ET'05), contains a set of five-year environmental targets. The program runs from 2006 through 2010 with a base year of 2005. The ET'10 metrics were selected based on metric relevancy, 3M's stakeholder's interests, global reach (i.e. no US only goals) and business unit, division and R&D input. Specific Menomonie goals for this program by 2010 (2005 baseline) are:

- **Reduce Waste (Non Product Output) per pound of good output (semi-finished and finished goods only) by 20%**

In keeping with the requirements of the EMS for continual improvement, 3M has elected to change the definition of “good output” more aggressively as finished or semi-finished product only. The previous Agreement considered recycled waste and reuse of materials as “good output” in calculating waste reduction. The waste (NPO) metric in now includes off-site recycled materials. This change in definition from the previous Agreement:

- Supports 3M’s Environmental Policy and drives pollution prevention at the source
- Aligns with entitlement quality
- Moves 3M’s waste management practices to more preferred methods
- Provides more discrete data to determine how waste is managed (% recycled, % reused)

This change identifies byproducts and/or recycled materials generated from manufacturing as wastes that are not equal in value to finished goods and semi-finished goods. This definition is consistent with global definitions used in the European Union and Asia. This approach provides a lesser credit for emission/waste reductions, and thereby a more challenging goal to attain. Waste, defined as “Non-product Output” (NPO), thereby includes recycled waste, off-site reuse of materials, waste to energy (W/E), in plant recycle and reuse, in addition to the previous categories of chemical waste, landfill waste, and air emissions.

- **Sustain or reduce Volatile Air Emissions (VOC) per 1000 pound of good output < 7.1 pounds VOC/1000 pound good output**

The Menomonie plant goal for VOC emissions is to sustain or reduce the ratio of VOC releases based on 2005 levels for the next five years. However, the corporation as a whole has a 25% reduction target for volatile air emissions by the end of 2010. Specific targets for each facility have been determined on a product output basis. These targets are based on input from division/country VOC reduction planning that was completed in 2006. No operations at Menomonie were included in this reduction planning based on the overall impact Menomonie has on corporate VOC emissions. Therefore Menomonie is committed to sustain or improve the ratio of VOC releases based on 2005 levels. In 2008 the Menomonie plant completed a specific capital project that began showing significantly lower VOC emissions from portions of our Ceramic Fibers process (mineral spirits concentrator/thermal oxidizer).

- **Improve Energy Efficiency per pound of good output by 20%**
- **Establish a wildlife management plan and certify the site to Wildlife Habitat Council (WHC) standards**
- **At least two accepted 3P (Pollution Prevention Pays) projects each year**

These goals set the basis for superior environmental performance under the Extended Agreement.

Regarding the Interested Persons Group

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

- Barbara Thomas, Chippewa Valley (WI) Chapter of the Sierra Club
- Mike Beaupre, Director, Indianhead Enterprises
- Keith Bergeson, Dunn County Department of Public Health
- Mark Harings, Wisconsin Department of Natural Resources
- Paul Sterk, Superintendent, Menomonie Wastewater Utility
- Dr. Martin Ondrus, UW-Stout, Chemistry Department
- Ed Smith, City of Menomonie Planning Commission Member

Two meetings of this group were held in 2008. The first meeting was held on March 28, 2008. The purpose of this meeting was to review the content of the 2007 annual performance report prior to submittal to the WDNR. The second meeting was held on November 7, 2008. Refer to the meeting minutes attached as Appendix B of this report.

Regarding an Evaluation of the EMS

A new third party auditor, BSI (British Standards Institute), conducted a recertification audit of our EMS in November. All clauses and all operational areas were assessed. There were no major or minor nonconformances found during the audit. Eight opportunities for improvement (OFI) were suggested by the auditors to improve the EMS and most of these recommendations will be incorporated into the EMS in 2009. In summary, the final audit report identified these best practices:

- The site is extremely clean both inside and outside.
- After incidents occur, the incident is recreated and training is conducted to find ways to improve the responses.
- Environmental outreach: Performance Track, Wildlife Habitat Council and Cooperative Agreement including Interested Person's Group
- EMS Management Review records has a n action item database
- The utilization of the QSI EMS databases as an EMS tool.

Internal assessments of the EMS were conducted in all operational and service areas (14 internal audits) of the facility during the year. These audits resulted in seven corrective or preventive actions being issued from the fourteen audits conducted. At the present time all corrective actions have been addressed. Regular management review is held at least quarterly with the EMS Core team and members of 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 November 2008. There were three Wisconsin DNR site inspections during the year for hazardous waste management (April), water pre-treatment standards (September), and air permit source review (October). The hazardous waste audit resulted in two recommendations that have been addressed (updated contingency plan to local fire, hospital, and police, and storage of incompatible waste materials. To prevent reoccurrence, the plant ICP (Integrated Contingency Plan) plan has been placed under document control for regular review. The long term storage of corrosive raw materials and waste is being addressed by an engineering request and capital spending project.

Regarding a Summary of 2008 Approved 3P (Pollution Prevention Pays) Projects

The goal under the 3M ET10 program and the Extended Agreement is to have at least two approved 3P projects each year. In 2008 there were six approved projects submitted. A total of 2,325 tons of solid waste were prevented, 3,150 MMBTU of energy saved, 443 metric tons of green house gas (GHG) emissions prevented, and first year savings of 3.6 million dollars. A summary of these projects is shown in Table 1:

Table 1: 3P (Pollution Prevention Pays) Project Summary

Project	Project Description	Pollution Prevented	\$ Saved (first year)
ALCF returnable packaging	Packaging is returned for reuse to avoid purchase of new materials and subsequent disposal of used packaging	18 tons diverted waste from landfill due to returnable packaging back to another 3M location	\$49,000 in replacement and disposal costs
Auto ON/Off Coat	Process improvements in coating produced higher yields, less waste, and better use of raw materials by changing machine logic when coating and making roll splices	55 tons in production scrap and waste	\$ 1.9 MM in raw materials costs, waste disposal costs, and saleable product increases
ACCR Wire Yield Improvement	Through significant improvements in fiber quality, wire line speed, wire yield, and process understanding/capability, scrap wire waste reduced by ~300,000 ft of wire a month.	14 tons scrap 3150 MMBTU energy 443 tons GHG	\$ 1.46 MM in disposal costs, energy costs, and increased sales value of good product
Recycling of Incinerated Material	Coated film that previously was incinerated for waste to energy is now recycled	158 tons	\$ 18,400 savings in disposal costs
EMD Tape Cardboard Reduction	Packaging was redesigned to save material and reduce shipping costs due to weight reductions of the packaging	2 tons	\$ 35,900 in material savings and shipping costs
PET with Acrylic to Recycle from Waste to Energy	Coated film that was previously sent to a W/E facility is now recycled	2,078 tons	\$ 138,863 in shipping costs

Regarding Status of the Goal of Maintaining or Reducing VOC Emissions

Results:

Actual VOC emissions decreased by 10% in 2008 compared to 2007. The actual ratio was 5.8 pounds VOC/ 1000 pounds good output vs. a goal of 7.1 pounds. The impact of the new Ceramic Fiber concentrator/thermal oxidizer in the 3rd and 4th quarter reduced the actual emissions for this area. The impact

of the new emission factors for coated optical film implemented in February also contributed to the reductions in 2008. Even though emissions from the C5 tape coater were virtually the same in 2008 as compared to 2007, the product mix of running lower solvent tapes has reduced VOCs/1000 pounds of good output from the tape coater from approximately 61 pounds VOC in 2005 to 35 pounds in 2008. Results of this goal are shown in Figure 1 and Table 2. Actual emissions by area (2005-2008) are shown in Figure 2.

Figure 1: VOC lb./1000 lb. Good

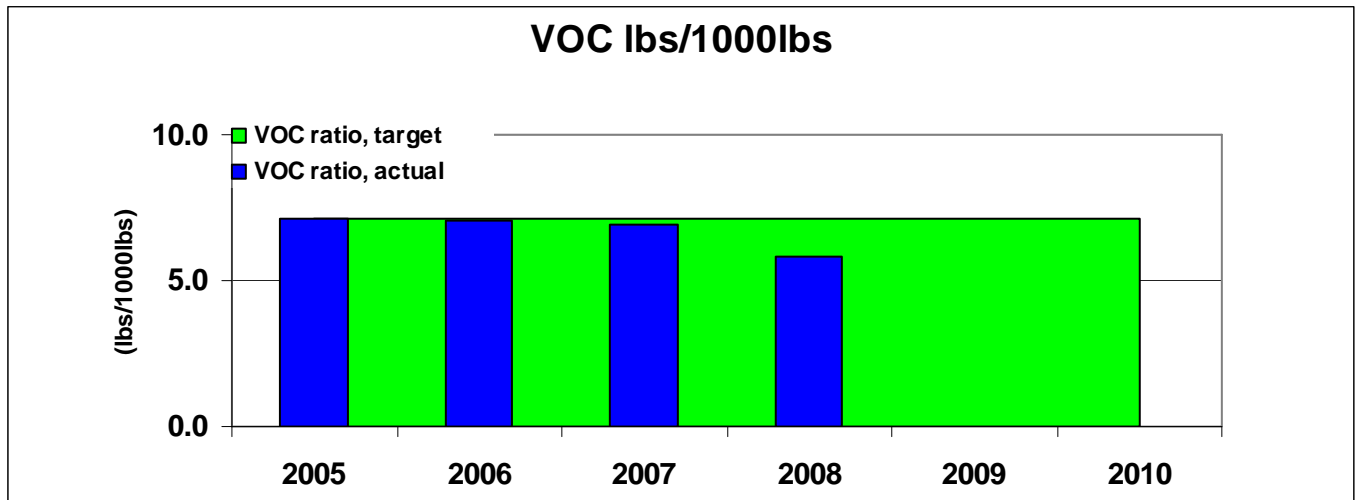
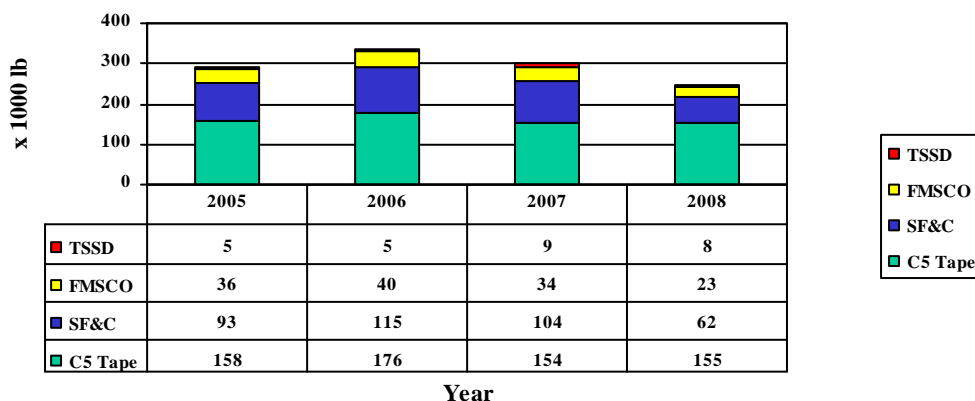


Table 2: VOC/1000 lb. Good Output

Metric	Baseline Year	Goal (%)	Baseline	2005	2006	2007	2008
Total good output (1000 lbs)				41,139	47,291	43,760	42,831
VOC (1000 lbs)	2005	0%	292	292	336	302	257
VOC ratio, actual (lbs/1000 lbs)			7.11	7.11	7.11	6.89	5.80
VOC ratio, target (lbs/1000 lbs)			7.11	7.11	7.11	7.11	7.11

Fig.2 VOCs by Source (2005-2008)



Status of Progress toward Reduction in Non-product Output per Pound of Good Output

Results:

The actual ratio for 2008 was 320 pounds NPO/ 1000 pounds good output. The reduction goal by the end of 2008 was to be down to 273 pounds NPO/ 1000 pounds good output. A slight downturn in production activity affected the final waste ratio, but there was improvement in the ratio from 2007 levels. There is considerable emphasis in the plant on Lean Six Sigma projects that have helped improve process yields and reduced waste. Even though recycled waste film counts against the waste reduction goal, the diversion of coated film waste from waste to energy to recycling was a significant accomplishment in 2008. Almost six million pounds of material were recycled in 2008 instead of incinerated. Results of this goal are shown in Figure 3 and Table 3. As shown in Figure 4, over 86% of the non product output produced in 2008 was either recycled or reused. Refer to Figure 5 to review NPO by type for the period 2005-2008

Figure 3: Waste (NPO) lbs/ 1000 lb. Good Output

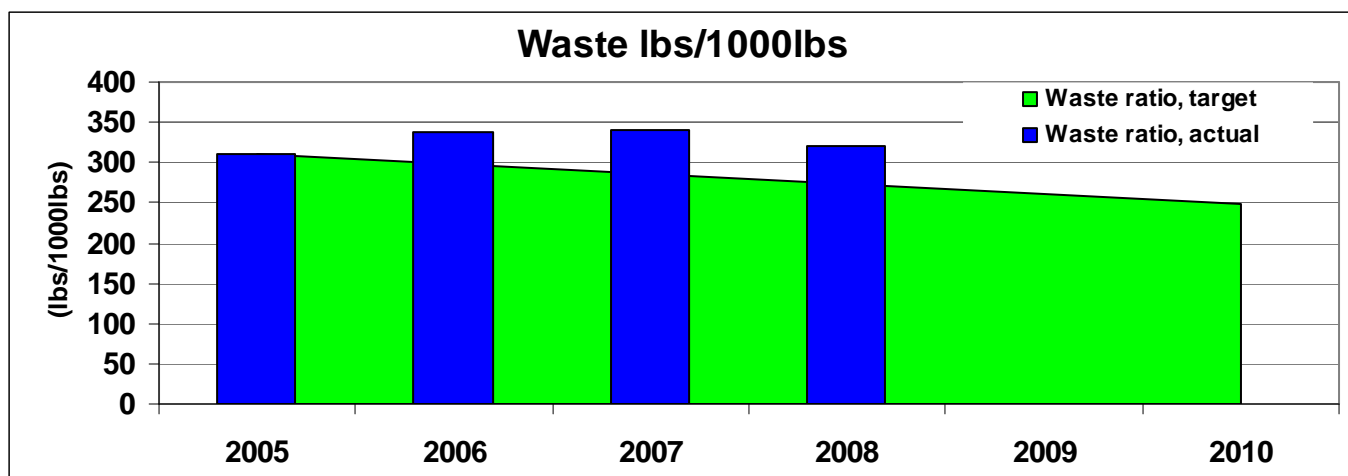
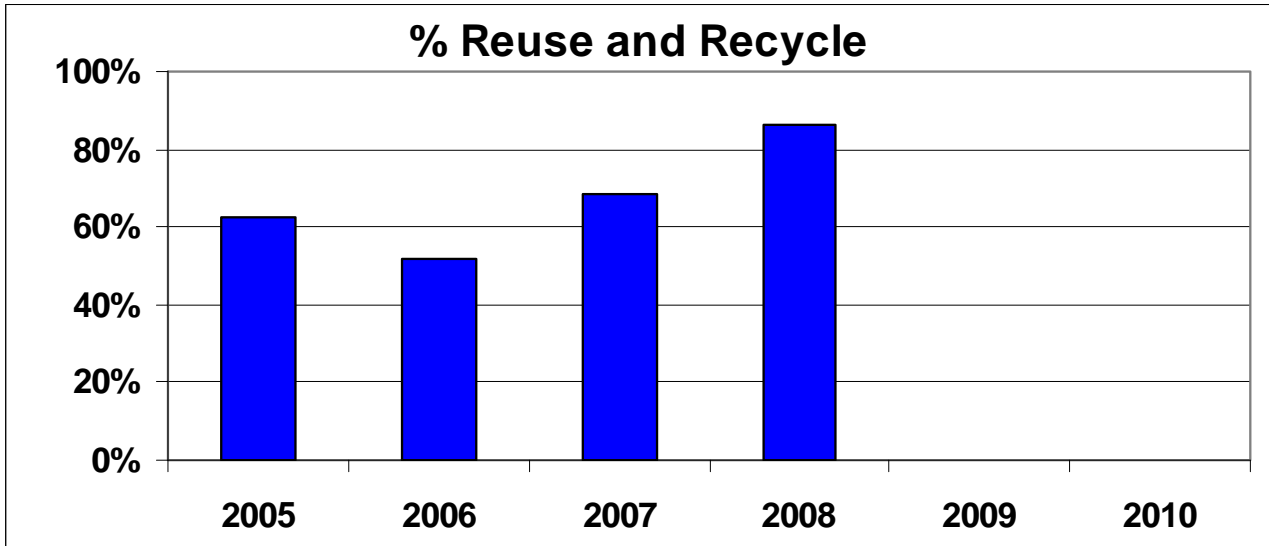


Table 3: Non-product Output / 1000 lb. Good Output

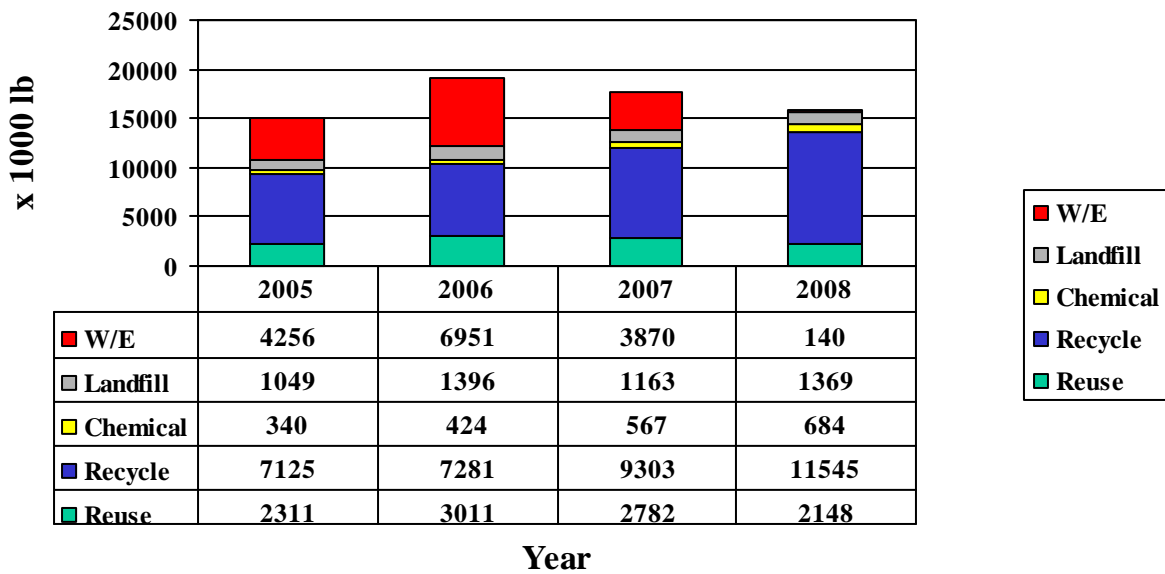
Metric	Baseline Year	Goal (%)	Baseline	2005	2006	2007	2008
Total good output (1000 lbs)				41,139	47,291	43,760	42,831
NPO (1000 lbs)	2005	20%	12,770	12,770	15,253	14,893	13,697
NPO ratio, actual (lbs/1000 lbs)			310.4	310.4	322.5	340	320
NPO ratio, target (lbs/1000 lbs)			310.4	310.4	298.0	285.6	273.2

Figure 4: % Recycle & Reuse



Metric	2005	2006	2007	2008
% Reuse and Recycle	62.6%	52.0%	68.4%	86.4%

**Figure 5: Non-product Output by Type
2005-2008**



The following table indicates the amount, type, and recovered value of recycled by-product or reused materials from the facility in 2008:

Table 4: 2008 Recycled/Reused Materials (NPO)

<u>Recycled Waste</u>	<u>Pounds</u>	<u>\$ Recovered</u>
Plastics	10,072,719	\$ 834,548
Metals	409,164	\$ 1,197,625
Aluminum cans	2,498	\$ 948
Silicone Liner	135,857	\$ 24,413
Cardboard/paper	<u>269,951</u>	<u>\$ 8,752</u>
Total:	10.89 MM	\$ 2.066 MM
Office paper	140,359	
Security waste paper	8,775	
Returnable pallets	1,067,000	
Recycled Drums	2,464 drums	

Status progress toward the goal of reducing energy usage per pound of good output

Results:

2008 energy usage/ pound of good output missed the 2008 target goal again due to several reasons. Energy usage was 8,904 Btus/ pound of good output at the end of 2008 vs. a goal of 6,932. Good output was down slightly in 2008 compared to the previous year. Increased energy usage for building support equipment (HVAC support equipment, compressors, etc.) and seasonal weather conditions greatly impacted the results. The plant energy team remained active in identifying and implementing opportunities to conserve energy. A total of eight energy projects were delivered by the team in 2008 totaling 3,797 MMBTUs and over \$ 192,000 first year savings. Refer to Appendix B for project details and savings. Refer to Figure 6 and Table 5 to review the energy usage results.

Figure 6: Energy Use/ Lb Good Output

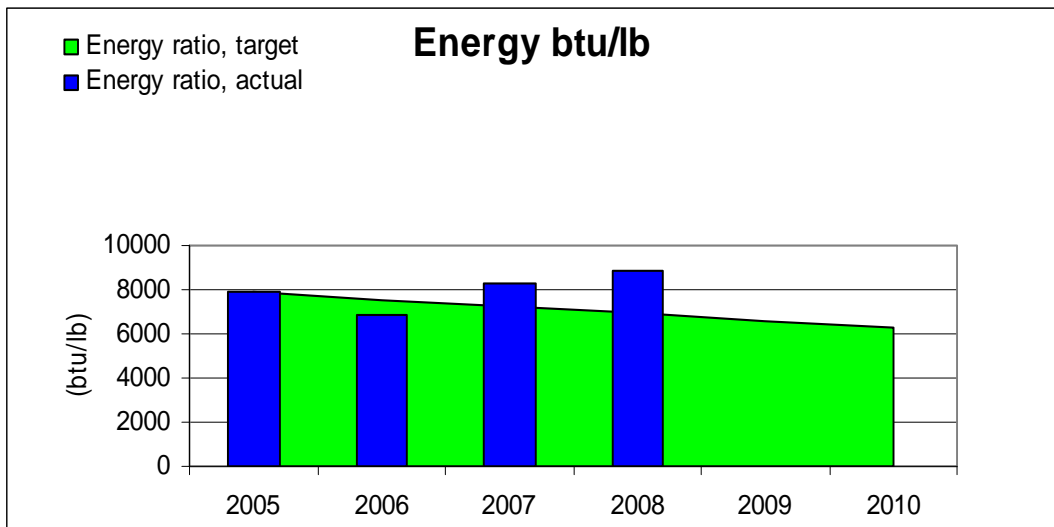


Table 5: Energy Use/ lb. Good output

Metric	Baseline Year	Goal (%)	Baseline	2005	2006	2007	2008
Total good output (1000 lbs)				41,139	47,291	43,760	42,831
Energy Usage (MMBtu)	2005	20%	324,039	324,039	323,682	379,914	381,357
Energy ratio, actual (Btu/lb)			7,877	7,877	6,844	8,682	8,904
Energy ratio, target (Btu/lb)			7,877	7,877	7,562	7,247	6,931

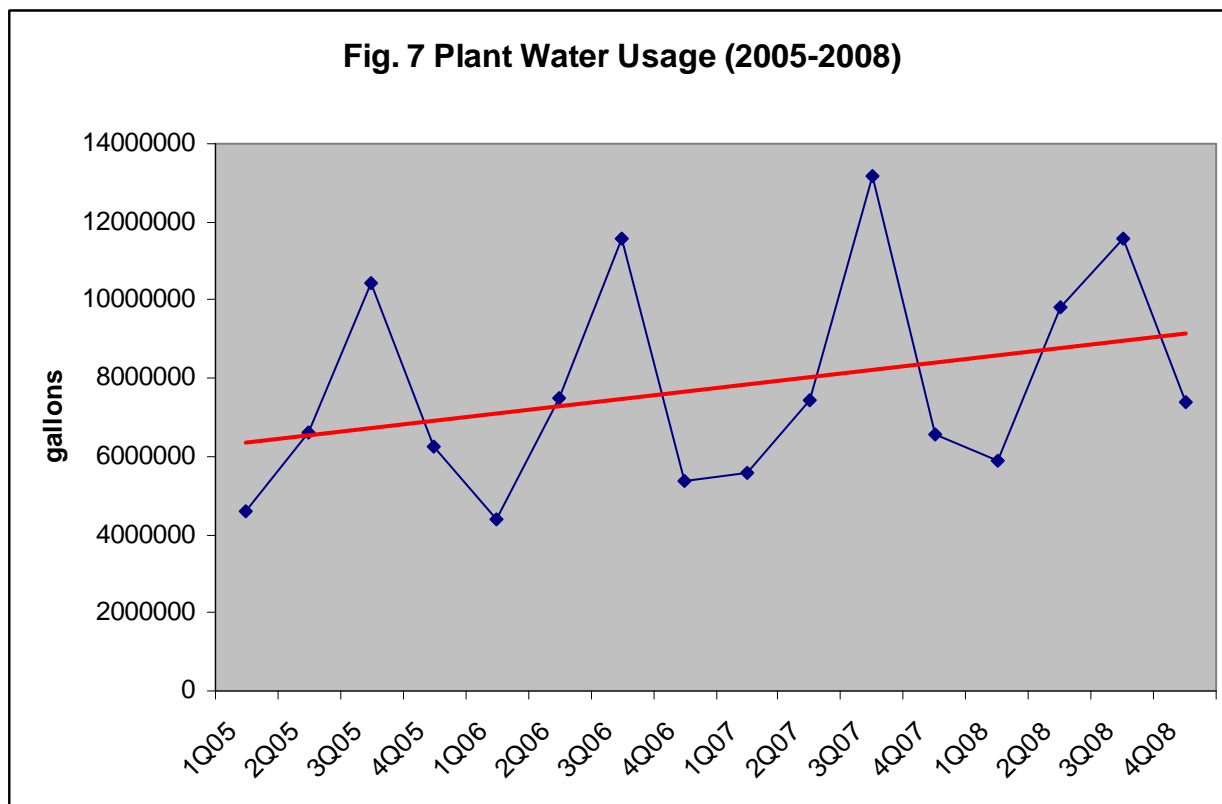
Status of progress made for Wildlife Habitat Council (WHC) site certification

Results:

The site received Wildlife Habitat certification in November. Certification was based on the application, references from persons outside 3M that have been involved with the site on various wildlife projects, a comprehensive wildlife plan, and results of at least one wildlife project. For the third straight year the team conducted nest box monitoring for bluebirds and wood ducks. The blue bird project was again quite successful with 43 confirmed bluebirds raised from the 15 nest boxes. Another project completed by the team was the planting of 125 wildlife trees and shrubs on the property to provide habitat for future wildlife. Future plans call for an expansion of the nest box program on additional acreage and the establishment of a small prairie meadow on the northwest side of the property. Again in 2008 the plant provided funding for the Menomonie public schools for their annual Earth day activities and provided volunteers for the event. See Appendix D for a local news article discussing the plant's wildlife certification.

Regarding Actual Water Usage (period 2005-2008)

Although water usage is not part of the Agreement environmental commitments, water usage is tracked as part of the overall corporate ET10 reporting. Water usage, although essential and important to our environmental impact, is not a significant resource consumed in the facility. The majority of the water used by the plant is for makeup water used by the plant chilled water cooling towers. The addition of two plant chillers because of plant expansions explains the upward trend in water usage. Refer to Figure 7 for water usage in gallons for the period 2005-2008.



Regarding Actual Waste Reductions

A summary of 2007/2008 3M-Menomonie wastes and air emissions are shown in Table 6:

**Table 6: 2007/2008 Waste & Air Emissions
(Lb.)**

Type of Waste	2007	2008	% Change	Comment
Regulated Hazardous Waste (NPO)	333,244	357,153	+ 7 %	Most hazardous waste is sent to the corporate waste incinerator in Cottage Grove, MN. The majority of this waste is made up of solid and liquid flammable and corrosive wastes. All corrosive liquid waste is now sent to a 3 rd party TSD (treatment, storage, & disposal) facility.
Non-regulated chemical waste	226,405	256,863	+ 14 %	A slight increase from 2007 levels. The majority of this waste is non-hazardous scrap adhesives sent to the

Type of Waste	2007	2008	% Change	Comment
(NPO)				corporate waste incinerator.
Landfill waste (NPO)	1.162 MM	1.37 MM	+ 18 %	Landfill waste is sent to Dunn County Waste Management. Total landfill waste was slightly higher than in 2007.
3M waste to energy (NPO)	3.87 MM	140,000	- 2600 %	All but one waste stream is now recycled rather than sent to a waste to energy facility.
VOC emissions	302,000	247,000	- 10 %	The impact of the new Ceramic Fiber concentrator/thermal oxidizer in 3 rd and 4 th quarter reduced the actual emissions for the year in this area. Emissions from the C5 tape coater were reduced due to product mix (lower solvent tapes) and reduced production volumes
Reportable TRI (toxic release inventory) chemicals releases	145,000 (RY 2006)	133,000 (RY 2007)	- 8 %	Toluene from the C5 tape process accounts for most of the reported releases as air emissions. 2008 releases will be reported by 7/1/2009

Regarding Operational Flexibility:

Requests for operating flexibility are summarized in Appendix C at the end of this report. Savings in both administrative and start-up times are estimated in the table in the Appendix.

Regarding Additional Time Requirements for Fulfilling this Agreement include:

Requirements Added:

Additional Time

Compiling this Performance Report
 Coordinating the Interested Persons Group

30 hours/year
 20 hours/year

Regarding Overall Assessment of the Success of the Agreement:

3M Menomonie and DNR have again substantially reduced the administrative time and startup time on the pre-approved projects completed or started in 2008. In both pre-approved projects this year the ability to expand product manufacturing capability in such a short time has given 3M a real competitive advantage over dealing with the traditional ways of meeting the environmental requirements. 3M Menomonie has an effective EMS and continues to strive for superior environmental performance as outlined in the agreement.

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

3M Company – Menomonie Plant
1425 Stokke Parkway
Menomonie, WI 54751
Phone: 715/235-5541
E-mail: mrwendt@mmm.com

Appendix A: IPG Meeting Minutes

Meeting Minutes - Interested Persons Group (IPG) March 28th 2008

Attendees

Mark Harings – WDNR
Keith Bergeson – Dunn Co Public Health
Mark Mc Dermid - WDNR
Ed Smith - City of Menomonie
Gary Lewis – 3M
Barb Thomas – Sierra Club
Sonny Zetner – WDNR
Jim McSweeney – 3M
Mark McDermid - WDNR
Mike Wendt – 3M
Karen Donnelly -3M
Mike Beaupre – Indianhead Enterprises

Meeting welcome and introductions

Jim McSweeney gave an update of the Menomonie plant changes since the last meeting.

EHS Information

Title V permit renewed in January 2008

Business Highlights for 2007 & 2008

Menomonie Site Expansions

Inquiry on Fuel Cell business – KB

Barb asked about the Cooperative Agreement for the next 5 years.

Mark Mc Dermid - Do we have a process in place for bring new products on line? – “Green”

Do we capture the environmental aspect for new projects? (captured in Management of Change [MOC] process)

Solar film, Fuel Cell - Do we keep track of the environmental performance for new products? 3M has a “Green Catalog” that can be obtained. Environment Performance stories

Mike Wendt

Cooperative Environmental Agreement

Make reports understandable to the public.

Mark H – We are now including recycle as a waste demonstrating the difference in numbers.

An understanding that recycling is good but not the goal. Efficiency is the goal.

Mark H – 3P emphasizes efficiency. Could look at emission savings also

Chiller efficiency - energy efficient decisions on the new addition. Stressed the importance of sharing the information.

Mark M. - Substantial interest in Madison for Mike Wendt's presentation

Barb (Visioning Committee) – Get out information on the positives that are being generated. The community thinks the plant is an environmental concern (air emissions).

Add success story with our florescent light bulb sales at 3M for employees.

3M funds two teachers to the Key Stone institute. We will fund the Earth Day this year as well. Donated money for 13 acre upper Red Cedar Cut off Property West Wisconsin Land Trust?

Mark H. - curious as to how much of the TRI is due to cleanup?

DNR saved a conservative 400 hours in administrative & compliant review

Open for questions

Mark M. – Green Tier 2008

Other companies environmentally would implement some of the same programs that Menomonie has. Agreement is until 2011. Need new application in the program by July of 2009 hoping legislation will pass. Budget will have to pass first. Will watch – suggest 3M get an application in. Over 30 are enrolled in the Green Tier program. Impact is much larger. Working towards a Superior Environment controls. Green Tier- 3 to 10 year agreement.

Mark H. – Cumberland has been accepted in to the Performance Track program.

Minutes by Karen Donnelly

Meeting Minutes – Interested Person Group (IPG) November 7, 2008

Attendees

Mark Harings – WDNR

Barb Thomas – Sierra Club

Ed Smith – City of Menomonie

Keith Miller – 3M St. Paul

Dave Wefring - 3M Public Affairs

Jim McSweeney – 3M

Mike Wendt – 3M

Glen Nale – 3M

Terri Krueger – 3M

Tim Bischoff – 3M

David Sowatzke – 3M

Meeting welcome and introductions

Jim McSweeney gave an update on changes in the business since March 2008:

Discussed the new thermal oxidizer for Ceramic Fibers

New hook making line in PCD

Change in organization from OS to Film Manufacturing and Supply Chain

Holograph imagery possible future business for coater areas

Keith Miller presentation on Sustainability (Our Future)

Discussed the Diversity of 3M

Globe Standards

40 Core Technologies

Guided by core values

Meeting needs of Society today –respecting the ability of future generations

9 Years in Dow Jones Sustainability Index Member

3M has reduced total GHG emission world wide by 62%

Reduce VOC by 95% U.S. (Barb asked about goals based on net sales)

Product Life Cycle Management - Solution for a better Environmental

Environmental Leadership – Social Responsibility – Economic Sustainability

Mark – one suggestion to a sustainability group could as a company? Keith suggested - Do you have sustainability system already in place to track operations?

Mike – what pressure from customers are we seeing? Keith- becoming more and more. Check our website 3M Sustainability .com

Mark – How much credit are company take for what is done in research (other companies)? Green

Washing- Keith – agrees some company do that – but it does drive the process in the end.

Mike Wendt - Environmental Performance

Discussion on March Meeting Minutes

Mark -Important that the Interest Person Group meet -there is an annual audit.

What should 3M Menomonie do if Green Tier program ends? Pilot companies could possible move in to a Tier II. Our Cooperative agreement ends 2012 we need to move to Green Tier.

3M has everything in place that would meet the Green Tier II. Possible automatic move to Green Tier II (grandfather?).

EMS Goals

Reduce Waste

Sustain or reduce VOC – Recuperative Thermal Oxidizer 99% efficient

3P Projects

Reduce Energy Consumption

Wildlife Council Certification

Barb –total VOC actual- (less than in 2007) downward trend.

Barb – How many lights are still Metal Halide? - Replace all Metal Halide in Plant

3M has an Energy Reduction web site – anyone can make a suggestion

Barb – water usage (less than in 2007) downward trend. Where does the water come from?

City

Barb – How does 3M property context to the park? Prairie Restoration needs attention – County Park

ISO audit coming up in two weeks, (Audit with BSI.), this will be a recertification. Water and Air sources visited by the DNR.

Jim would like to improve community out reach.

Mark – How and why a business develops sustainability? Mark commented -Community could learn from 3M.

Barb - Who would be the contact for Sustainable Dunn. Jim or Mike would be the contact.

Mark asked where Keith worked? - Keith discussed working with 3M Brazil and in Europe.

Appendix B

Energy Projects 2008

Project Name	Description	MMBTUs Saved (1 st year)	\$ Saved (1 st year)
Bldg 5 Warehouse lighting	Replace 48 sodium and metal halide lights in Building 5 with the extra T5's hanging in Building 12 that are not enabled.	352	\$5,952
Orion Energy metal halide lighting replacement	Replace metal halides in E-Beam, Library Systems, PE Shop, M2, CRPL (99 Fixtures)	725	\$12,322
High Bay Light Replacement (E3/Beltmaker Bay)	Replace 78 Metal Halide fixture in E3/Beltmaker bay	571	\$ 9,984
High Bay Lighting Replacement (Hookline Bays)	Replace 400 watt metal halides in Hookline 1, 2, 4, and PCD Compounding bays.	1,062	\$ 18,560
High Bay Lighting Replacement (SF&C/TSS Bays)	High Bay Lighting Replacement--CF1/CF2, Back Hallway, Alpha/Pi, E-Beam Pack/B2 Corridor, TSS #3 Room/Storage/Laser Prep	820	\$ 14,358
Fan Powered HEPA filter setback	Program fan powered HEPA filters in clean rooms to allow half to be shutoff when the coating line and oven are not operating.	267	\$ 66,000
Inspection Light savings	Light inspection systems were not automatically dimmed or turned off when production line stops. Program would automatically dim lights when production line is not running. Programming has been completed and installed on MRC1, 2, 5, 6, 7, 8 & 9	TBD	TBD
OSD - Outside Air Temperature Mode	Implement controls via PLC to monitor production line speed / status and adjust exhaust fans according to outside temperature state. Program changes have been made on MRC1, 2 & 5	TBD	Est. \$ 65,000
Total		3,797	\$ 192,176

Appendix C

Title V Part III Pre-approved Projects – 2008

Project			Startup			
No./Name	Description	Date notified	Startup Date	Notification Date	Est. admin time saved (3M Only)	Estimated startup time saved
012/Athena Coating line	Web coating line to make privacy film for computers.	08/08/2007	03/18/2008	04/16/2008	100 hours (est.)	3 months
014/CF7 Fiber Line	Installation of a new ceramic fiber line with mineral spirits concentrator and thermal oxidizer	08/29/2007	07/17/2008	08/16/2008	100 hours (est.)	3 months
					Total hours saved: 200	

It is estimated DNR saved a conservative **400 hours** in permit, administrative, and compliant review for the above mentioned pre-approved projects

Appendix D

Updated: 11/18/2008 11:37:01 PM

Menomonie 3M plant gains national conservation honor

By Pamela Powers
Menomonie News Bureau



Bluebirds nested in a wooden box at the 3M plant in Menomonie. The plant has been recognized by the Wildlife Habitat Council for its efforts to improve habitat on the company's land.

Contributed photo

MENOMONIE - Employees at 3M in Menomonie earned international attention this week from the Wildlife Habitat Council for their contributions to wildlife habitat conservation. The council is a nonprofit organization dedicated to increasing the quality and amount of wildlife habitat on corporate, private and public lands. The Menomonie plant, on the city's northeast side, was one of 214 sites recognized Monday and Tuesday in Baltimore for creating a Wildlife at Work program. About 100 of the 540 acres 3M owns in Menomonie west of the plant are forests, prairies and wetlands that drain to Lake Menomin. Wildlife seen in the area include deer, turkey, fox, raccoon, badger, mallard ducks, wood ducks, Canada geese,, sand hill cranes and blue heron. Other birds include robin, bluebird, brown thrush, goldfinch, red-tailed hawk and eagles.

A wildlife team at the plant has been active since 2006 conserving, managing and restoring local natural and semi natural habitat on the property. "It is a chance for employees to be good neighbors to wildlife and be good stewards," said Mike Wendt, environmental health and safety specialist with the Menomonie plant and chairman of the Wildlife at Work team. A prairie restoration project is planned for part of the site, he said. As part of Earth Day activities in 2007, the Menomonie High School environmental science class inventoried wildlife on the property. Students built wood duck and bluebird houses for the plant site as well, Wendt said. Last summer, the land was home to nests for 42 bluebirds and 26 tree swallows, he said. Employees have planted 125 shrubs to provide habitat and food for wildlife, Wendt said.

Robert Johnson, Wildlife Habitat Council president, congratulated 3M for the company's efforts. "WHC members are continuing to lead the way to further define and demonstrate how corporations can use their lands to preserve our biodiversity, while preparing new generations through conservation education to understand how to be better leaders and managers for tomorrow's sustainable businesses and communities," he stated in a news release. "Congratulations to 3M Menomonie for their volunteer-based efforts to preserve the biodiversity of their community and the world and to connect people to nature."

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