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

Community Size ............... 2,500

3 is the preferred employer in area
Products We Make

Abrasives Products

Electronics Products

Hand and Floor Pads
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

#### Environmental Goals Summary

<table>
<thead>
<tr>
<th>2015 Environmental Goals Summary</th>
<th>Cumberland</th>
</tr>
</thead>
<tbody>
<tr>
<td>Metric</td>
<td>2010</td>
</tr>
<tr>
<td>VOC (1000 lbs)</td>
<td>113</td>
</tr>
<tr>
<td>VOC, kg/1000 lbs</td>
<td>112</td>
</tr>
<tr>
<td>Waste (1000 lbs)</td>
<td>1.785</td>
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<tr>
<td>Waste, actual (lbs/1000 lbs)</td>
<td>1.745</td>
</tr>
<tr>
<td>Waste, target (lbs/1000 lbs)</td>
<td>1.745</td>
</tr>
<tr>
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<td>60.9</td>
</tr>
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</table>

#### Annual 3P Results

<table>
<thead>
<tr>
<th>Year</th>
<th>VOC goal</th>
<th>VOC actual</th>
<th>Waste goal</th>
<th>Waste actual</th>
<th>Energy goal</th>
<th>Energy actual</th>
</tr>
</thead>
<tbody>
<tr>
<td>2010</td>
<td>1.705</td>
<td>1.745</td>
<td>1.900</td>
<td>2.130</td>
<td>60.6</td>
<td>60.9</td>
</tr>
</tbody>
</table>

#### VOC lbs/1000 lbs

- **VOC goal**
- **VOC actual**

<table>
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<tr>
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<td>1.900</td>
<td>1.900</td>
</tr>
<tr>
<td>2013</td>
<td>2.130</td>
<td>2.130</td>
</tr>
<tr>
<td>2014</td>
<td>2.365</td>
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#### Energy usage (kBtu/1000 lbs)

- **Energy goal**
- **Energy actual**

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<td>60.6</td>
<td>60.9</td>
</tr>
<tr>
<td>2012</td>
<td>60.3</td>
<td>60.1</td>
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<tr>
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<td>60.1</td>
<td>60.2</td>
</tr>
<tr>
<td>2014</td>
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#### Waste lbs/1000 lbs

- **Waste goal**
- **Waste actual**

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#### Water Use Ratio (US gal/1000 lbs)

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<th>Year</th>
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<tbody>
<tr>
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<td></td>
</tr>
<tr>
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</table>
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
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 $50 billion and reduce greenhouse gases equal to the emissions from about 30 million vehicles. Learn more at www.energystar.gov.
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 spreadsheet in the Green Team Folder > 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 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 Chart]

- $2,500.00 to Boys & Girls Club of Barren County
- $2,500.00 to Cumberland Area Friends of Scouting Inc. 'Scoutland' (year 1 of a 3 year commitment)
- $2,000.00 to Cumberland Elementary NOW - 'Nutrition on Weekends'
- $2,500.00 to Cumberland Schools Academic Excellence
- $3,000.00 to Cumberland Schools at Risk Program/Character Building
- $16,500.00 to Cumberland-Community Giving Campaign - Foundation Match
- $3,500.00 to Cumberland United Fund
- $120.00 to Cumberland Hospital - Progressive Dinner - (2 tickets)
- $1,000.00 to Chamber of Commerce - Cumberland - Golf Marker
- $300.00 to Arts Midwest - 3M to sponsor Welcome Reception for each group (up to $500 per event), 1st of 3
- $300.00 to Cumberland School Districts - Wolf Ridge
- $500.00 to Kinnish Family Fundraiser
- $2,100.00 to total monetary donations to community

*Twist - Teaching within Science/Technology*

- Jim Reidy - HS Science Teacher
- Cumberland invited - No request made.

*Innovative Grants*

- Product Donations
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 Mgmt District
- Barry Rose – CU School Superintendent
- Tom Ryelicka – 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 Hie – Chamber of Commerce Vice-President
- Jon Cagney – WI Dept Natural Resources (Air permits)
- Sonny Zentner – WI Dept Natural Resources (Green Tier)
- Stephen Smith – State Representative (75th District)
- Local neighbors (Judy Owen, ??)
- Louis Muensch – President Cumberland Utility 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 Raziaff – 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

<table>
<thead>
<tr>
<th>Environmental Solutions Product Criteria</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Team developing new criteria for Environmental Solutions Products</td>
</tr>
<tr>
<td>• Technical managers in divisions/countries will work with PRLs to evaluate new products</td>
</tr>
<tr>
<td>• Environmental Solutions product criteria will be available on the Sustainability Center on 3M Source</td>
</tr>
</tbody>
</table>
New Product Goal

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:
ISO CERTIFICATION REPORT (Attached)
Assessment Report.

3M Company  3M Cumberland Plant

DRAFT