

Wisconsin Business Friend *of the* Environment Award Winners

2009



WISCONSIN BUSINESS FRIEND
of the ENVIRONMENT

POLLUTION PREVENTION

Cook Composites & Polymers
Kikkoman Foods, Inc.
Wal-Mart

ENVIRONMENTAL INNOVATION

The Johnson Foundation
Bell Laboratories, Inc.
WS Packaging Group, Inc.

ENVIRONMENTAL STEWARDSHIP

Applied Ecological Services, Inc.
Plum Creek Timber Company, Inc.
Phillips Plastics Corporation

For the 20th year in a row, the Wisconsin Environmental Working Group®, an affiliate of WMC, is recognizing nine companies with the Wisconsin Business Friend of the Environment Award. This year's winners have been chosen for programs that demonstrate an innovative approach to environmental protection, or a level of effort beyond that which is required by regulatory compliance. These success stories reflect the continued commitment of Wisconsin industry to environmental protection.

This year's award winners represent companies — both large and small — that have made significant improvements in the areas of pollution prevention, environmental innovation and environmental stewardship. Offering specific examples of successful programs, these nine winners demonstrate that sound environmental practices are good for Wisconsin's environment and its economy. They serve as important examples for industry.

Wisconsin Business Friend of the Environment award winners were selected by an independent judging panel that included representatives from industry, the Department of Natural Resources, the environmental community, and the University of Wisconsin.

Cook Composites & Polymers

The Wisconsin Environmental
Working Group and WMC have
recognized Cook Composites & Polymers
as a 2009 Wisconsin Business Friend
of the Environment Award Winner.

The award recognizes companies
that have demonstrated leadership
in environmental protection.



Environmental Protection ...
Wisconsin Industry
Demonstrating Leadership.

Cook Composites & Polymers

Two changes brought big results for a Saukville manufacturer.

The Cook Composites and Polymers (CCP) Saukville manufacturing site is located in the center of the Village of Saukville adjacent to a church, school, and residential neighborhood. The facility is ISO 14001-certified and has carefully cultivated open stakeholder relationships with the local community for the past eight years.

In 2007, operating limitations were identified with an existing thermal oxidizer and a non-hazardous liquid incinerator. Initially inspired to reduce costs, two capital projects were developed that protected the environment and helped neighbors.

In October 2001, driven by increasing burden of hazardous waste incinerator regulation and ongoing community concerns, CCP discontinued the incineration of solvent, and the combustion unit was converted to a non-hazardous wastewater evaporation service. Trucks removed wastes, but it was very costly. A redesign allowed the company to transport waste by rail car to Texas for wastewater treatment and disposal at one-fourth the cost of truck transport, and has a significantly lower carbon footprint. The wastewater incinerator was shut down on May 25, 2008 and the utilities (electricity, natural gas, compressed air) were redirected for other plant uses.

A MegTec thermal oxidizer was constructed at the site in 1996. After 10 years of service, CCP began receiving an increase in odor complaints from its neighbors. CCP discovered the heat exchanger failure to be the most likely source of the increase in community odor complaints. The company switched to regenerative thermal oxidizer (RTO), a more flexible, fuel efficient and environmentally friendly system. The new RTO was installed independently from the existing operating unit in June 2008, minimizing plant shutdown to 4 days. Approximately 300 feet of the new transfer duct also includes Lower Explosive Limit (LEL)

monitoring and control for enhanced safety and feedback control performance improvement. The company has seen an 87 percent reduction in natural gas use.

The company sees three big results – cost savings, environmental protection, and being a good neighbor. Natural gas savings alone were \$500,000. And CCP now enjoys a 92.5 percent reduction in natural gas used for pollution abatement and emission control, and an overall reduction of nearly 40 percent. This gas use reduction corresponds to a similar decrease in green house gas (GHG) emissions. The reduction in natural gas consumption results in an environmental benefit by the reduction of emissions of approximately 2000 tons of CO₂, the equivalent of 5 million miles of driving a mid-size automobile.

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Kikkoman Foods, Inc.

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Kikkoman Foods, Inc.

Kikkoman Foods makes soy sauce in Walworth with as little impact on the environment as possible.

Using only the finest ingredients, Kikkoman has been brewing soy sauce for more than 300 years. As the first Japanese firm to establish a production facility in the United States, Kikkoman began production in 1973. Currently, the Walworth, Wisconsin operation is the world's largest soy sauce manufacturing facility.

Having these distinctions, corporate lineage, social awareness and responsibility, the Walworth operation developed and implemented practices to protect the environment, reduce pollution, and recycle as much waste and production by-product as possible.

In short, the company strives to minimize impact of the Kikkoman production facility on the environment in a cost effective manner.

The formal decision to fully implement a pollution control and waste recycling process began when Kikkoman decided that their operations would follow the ISO 14001 environmental management protocol with a goal of registration certification. In March 2001 the project was launched. The certification was reached in June 2003.

With the certification obtained, the implementation of the ISO 14001 protocol has produced results in several pollution reduction and waste recycling processes. The company has recycled or re-used 90 percent of its waste in 2008, with a total of 9,583 tons diverted from landfills. Only 967 tons of waste went to the landfill in 2008. Here are some details of Kikkoman's efforts:

1.Reduction of greenhouse gases: From the date of implementation, greenhouse gases have been significantly reduced. These efforts have reduced the volume of CO₂ by 2.3 million pounds and SO₂, by 8,248 pounds.

2.Tracking of wastes: During fiscal year 2008, recycling and/or re-use of byproducts has generated the following:

- Wheat and soybean fiber reused: 300 tons used for cattle feed
- Soy cake reused: 8,000 tons used for cattle feed
- Soy oil reused: 19-tons used for bio-diesel and pet food
- Powdered soy sauce reused: 18 tons used for animal feed

- Calcium Carbonate reused: 625 tons buffering agent for wastewater treatment
- Plastic recycling: 26 tons recycled through vendor services
- Glass recycling: 150 tons recycled through vendor services
- Cardboard recycling: 150 tons recycled through vendor services
- Mixed paper recycling: 30 tons recycled through vendor services
- Comingle glass, plastic, aluminum recycling: 25 tons recycled through vendor services
- Scrap metal recycling: 300 ton recycled through vendor services
- Used Oil recycling: 1 ton recycled through vendor services
- Reduction of solid materials going to the landfill
- Reduction of energy consumption

3.Energy Conservation: In 2008, energy conservation and efficiency has reduced the cost of electricity by \$97,000.

The scope of these projects go beyond normal regulatory compliance because their nature is voluntary.

Kikkoman's aggressive commitment to reduce the impact of its product manufacturing on the environment represents a diverse application of recycling and reuse techniques and processes. The diversity of the recycling and reuse process makes it both innovative and unique.

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Wal-Mart

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Wal-Mart

Beginning just a few years ago, Wal-Mart launched a series of new store designs to reduce the carbon footprint of its huge retail and distribution centers. The corporate goal is to eventually have all Wal-Mart facilities powered 100 percent by renewable power; use the latest in energy-saving technologies to reduce energy use and greenhouse gas emissions by at least 25 percent; and add zero net waste to America's waste stream.

One of the state's newest Supercenters, completed in 2007 in Monona, represents that effort. The Monona store is state-of-the-art in the latest Wal-Mart designs for a northern climate. The new 227,000-square-foot store is larger than the average park in Monona, and the largest retail store in Dane County, and is located near the Yahara River.

The Wal-Mart Supercenter is unique in the sheer breadth and scope of new technologies and practices it utilizes to save energy and reduce its environmental impact. The store's sustainable features began with the selection and preparation of the site upon which the new store sits.

- **The site.** Wal-Mart chose the site of an abandoned strip mall centered on a vacant K-Mart with a large parking lot that borders on the western edge of a large, environmentally sensitive marsh along the Yahara River. Wal-Mart razed the old building and dug up the asphalt to build a two-story store with a covered, lower-level, 499-space parking lot uniquely designed to keep salt, oil and other contaminants from flowing into the marsh and river. Drains send runoff directly to the municipal treatment plant.
- **Daylight harvesting.** The Monona Store includes a daylight harvesting system that integrates skylights with dimming technologies that reduce or shut off lights as daylight increases. The expected average annual energy savings over a conventional lighting system is 800,000 kilowatt hours per year, enough energy to provide electricity for 73 homes.
- **Recycled building materials.** All new Wal-Mart stores are built by incorporating recycled materials wherever possible.

- **Heating and cooling.** The heating, air conditioning, refrigeration and lighting systems for all U.S. Wal-Mart stores is monitored and can be adjusted from a central location. The Monona Supercenter uses "super" high efficiency heating and air conditioning, 25 percent more efficient than the industry standard. Refrigeration compressors heat 70 percent of the hot water used.
- **Special lighting.** All coolers, signage and displays are lit using light-emitting diodes instead of conventional bulbs. Motion detectors are used so lights are only used when a customer is present. The LED lights use 70 percent less electricity than conventional lights, and installation of this technology has saved 1.34 million kilowatt hours statewide.
- **Reduced water consumption.** The store's bathrooms are installed with toilets that require 20 percent less water to flush and use water power turbines, not electricity, to activate the automatic flush. The bathrooms also have sensor-activated 1/2 gallon-per minute, high efficiency faucets that run for just 10 seconds. Wal-Mart expects Supercenters such as Monona to save 530,000 gallons of water per year over conventional bathroom technology.

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THE JOHNSON FOUNDATION
Wingspread Conference Center

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The Johnson Foundation

In 1959, H. F. Johnson established Wingspread (A Frank Lloyd Wright historical landmark) as its educational conference facility. The Johnson Foundation is a non-profit philanthropic corporation with one purpose: to operate Wingspread as a conference center devoted to the free exchange of ideas.

The mission: To be a catalyst for environmental and community solutions using leading edge convening models in a unique, world-class conference center.

For over 50 years, the Foundation has sponsored thousands of conferences on issues addressing arms control, education, sustainable development, health, and much more. Wingspread, and a main conference facility, is nestled amid 36 acres of woods, ponds, apple orchards, native plantings, and beautifully landscaped gardens. The grounds are a refuge for over 220 species of birds as well as fox, coyotes, deer and other small animals. There are five buildings on the property: Wingspread, The House, The Guest House, The Karen Johnson Boyd Office Building and a maintenance building.

The Johnson Foundation has a long tradition of sponsoring Wingspread conferences that address issues of environmental quality and community – helping people live in harmony with their environment. *The Precautionary Principle*, a landmark statement on environmental risk, was crafted at a Wingspread Conference, as were many of the Leadership in Energy and Environmental Design (LEED) standards for green buildings. More recently, Wingspread conferences led to a Presidential Climate Action Plan (PCAP).

It is not enough, however, that The Johnson Foundation support others in their work to make the world cleaner and more sustainable. The Foundation lives the change that it seeks.

With this in mind, The Johnson Foundation has taken full charge of implementing changes that push us to the forefront of environmental action. The Foundation spent one year working on the achievement of Green Seal Certification and the following items highlight those efforts.

The Johnson Foundation implemented an aggressive conservation ethos at Wingspread that includes solar energy use and resale; establishing a green procurement policy for vendors; conducting and implementing energy audits; recycling and composting; organic grounds keeping; improved energy-efficient lighting; improved water management; and manual snow removal to reduce chemical use.

All of these initiatives were essential to achieve the GS33 Gold Level Green Seal Certification in 2008. The Johnson Foundation is currently the only Gold Level certified property in the U.S.

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Bell Laboratories, Inc.

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Bell Laboratories, Inc.

Bell Laboratories, Inc. of Madison, is ridding an island of rats that invaded the island over 200 years ago.

Rat Island is located in the western reaches of the Aleutian Island chain in the heart of the rough and rugged Bering Sea. The island is part of the Alaska Maritime National Wildlife Refuge. It encompasses approximately 11 square miles and has a variety of topographical features that range from sheer ocean-side cliffs to lush grassy meadows. Rat Island was once one of the most prolific breeding grounds for many species of migratory seabirds due to its remoteness, location within many bird species migratory paths, and freedom from ground dwelling predators.

A 1780's shipwreck inadvertently introduced the non-native Norway rat to the island. Since then, the Norway rat population has grown unchecked due to the lack of any natural predators. The most plentiful food on the island was the seemingly limitless supply of seabird eggs and young. Seabirds have no natural defenses to land-based predators such as the Norway rat. As a result, the rats were unchallenged as they ravaged the eggs and young of these migrating birds. Year after year, the seabird populations were decimated by the predation of the non-native Norway rat until finally the island became devoid of any active breeding colonies.

After extensive research and multiple phases of habitat evaluation, the U.S. Fish & Wildlife Service, the Nature Conservancy, and the Island Conservation and Ecology Group determined that eradication of the non-native Norway rat was the only alternative to bringing seabird populations back to the island.

To accomplish this, the creation of a highly specialized rodenticide would be required. Because of its involvement with, and successes in previous island eradication projects, the Island Conservation and Ecology Group approached Bell Laboratories and its technical team to undertake this challenge. The result of nearly two years of development work was the creation of the first United States

EPA registered rodenticide specifically designed for island conservation and use in high moisture conditions – “Brodifacoum - 25W Conservation”.

Some of the most demanding aspects in the development of this very unique rodenticide included developing a unique formula for the specific species that would naturally decompose after 6-10 days without toxic effects, allow for aerial application due to the island's steep cliffs, and remain weatherable despite high levels of moisture and precipitation. These design specifications were met with a final product that does not harm the environment.

Eradication of the Norway rat on Rat Island began September 28, 2008 with the first rodenticide application. Nine days later the most important phase of the project concluded with the second and final bait application.

Scientists and conservationists will return to Rat Island in May 2009 to ensure that the first phase of the project was a complete success and the reintroduction of birds can begin.

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WS Packaging Group, Inc.

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WS Packaging Group, Inc.

WS Packaging Group's facility in Algoma, Wisconsin manufactures pressure sensitive labels, coupons, tags, and decals. In accordance with the company's sustainability program, operational goals have been outlined and benchmarks established. One such goal is to not only provide products that are environmentally sound throughout their lifecycles, but also to continually strive to become a better steward in protecting our environment while conserving energy and natural resources.

As part of the corporation's strategic sustainability program, this facility has focused on reducing the amount of waste sent to the local landfill. In working toward this goal, the company has partnered with Pellet America Corporation, a materials lifecycle management company. Pellet America (PAC), established in 1992, is a leader in the fuel pellet industry and manufactures over 30,000 tons of paper fuel pellets annually.

PAC takes in paper and plastic industrial scrap that cannot be recycled by conventional means, such as wax corrugate, label stock, matrix waste, and paper with plastic lamination, grinds it up, and turns it into 3/4-inch diameter industrial pellets that can be mixed with coal and biofuels to heat buildings and generate electricity. Thereby, the waste from one process becomes the resources for another.

The fuel pellets are equal to coal BTU/lb., are lower in ash, and are much lower in sulfur, making it a cleaner burning fuel. PAC strives to keep as much waste from going to the landfill as possible and is a "greener" alternative.

Since mid-October 2008, the majority of pressure sensitive waste matrix and trim from our production process has no longer been sent to the local landfill. Instead, each month, about 115 tons of waste material is baled and shipped to be converted into fuel pellets.

In January of 2008, WS Packaging Group developed a Corporate Sustainability Committee to further commit each of our 17 facilities to good Environmental Stewardship. The WS Packaging facility has developed a "blueprint" to be followed by each WS Packaging facility across the U.S.

The company has used lean manufacturing to cut waste in the manufacturing process, switched to energy efficient lighting, curtailed paper for internal order processing, used returnable shipping containers, and other innovations to cut waste.

Although many manufacturers cannot afford the additional operational or transportation costs for a waste conversion program, WS Packaging Group is committed to implementing long-term solutions to balance their environmental goals with their economic health.

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Applied Ecological Services, Inc. — Seneca Meadows Landfill

The Seneca Meadows, Inc. Landfill is the largest active landfill in New York, located about 45 miles east of Rochester, New York. Initially, Applied Ecological Services, Inc. (AES) had a defined, limited role which was to assist in finding wetland mitigation sites for the landfill expansion that was proposed to impact at least 70 acres of highly-altered wetlands.

Upon visiting the site, AES — of Brodhead — soon found that most of the impacts to forested wetlands were not necessary and instead realized that hundreds of acres of forested wetlands could be enhanced as a part of the expansion project. The goal was to restore nearly 1,200 acres of sedge meadow, riparian landscapes, forested wetlands, and eventually create native grassland planting on the closed landfill.

AES found an innovative way to restore 350 acres of these wetlands along with almost 600 acres of restoration acres of former drained agricultural lands and dewatered, forested wetlands as compensation for the 70 acres of impact to highly disturbed wetlands. This project received permits in July 2007 and ecological restoration will occur on approximately 1,200 acres that will be protected by a conservation easement to ensure that science-based management occurs on the land forever.

This project will also involve a nature center, trails, and beautiful scenery throughout, in a county where few such outdoor educational opportunities exist. Starting in the fall of 2007, AES will conduct enhancement work for the higher-quality forested wetlands, primarily focused on brushing and restoring hydrology.

Because of the creativity of the AES scientists in visualizing different ways to work with the wetland impacts, AES has set a new precedent in the state of New York in the permitting of such large impact projects. The USEPA national office calls the project a model on how future large-wetland impacts can address mitigation. The local community is ecstatic about the project, the

expansion, the nature center, and the new open-space system that they will have access to. This project is a great example of how AES's consulting, contracting, and nursery divisions can work together to provide the client, the community, and the environment with a win-win scenario.

AES Consultants are continuing their efforts in visualizing different ways to work with the wetland impacts on site while AES Contracting is currently installing all native areas with locally-collected seed, a large portion of which was procured by AES's affiliate nursery Taylor Creek Restoration Nurseries. To date, AES Contracting has installed over 250 acres of locally-collected native seed.

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Plum Creek Timber Company, Inc.

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Plum Creek Timber Company, Inc.

Wisconsin's economy thrives on good business practices that encourage growth and stability in our great state. Plum Creek takes great pride in maintaining and always improving on business. As the state's largest private landowner with 330,000 acres, Plum Creek helps supply the second largest industry in Wisconsin – forestry.

That commitment was recognized recently when the company was named to the Dow Jones Sustainability World Index, or DJSI World, acknowledging its environmental, social and economic performance. The Index is an elite list of approximately 300 of the leading sustainability-driven companies in the world.

In line with sustainability, the company was again certified under the Sustainable Forestry Initiative® (SFI®) in March 2008 following an intensive 2007 review by independent third-party auditors. The audit put Plum Creek's forestry practices under intense scrutiny through rigorous, on-the-ground assessments of the company's operations in the state, and Plum Creek met those standards. The SFI® program is a comprehensive system of principles, objectives and performance measures developed by professional foresters, conservationists and scientists, among others. The standards combine the perpetual growing and harvesting of trees with the long-term protection of wildlife, plants, soil and water quality.

The audit also praised Plum Creek's environmental stewardship efforts by calling out its participation in the Karner blue butterfly protection program. Along with the Wisconsin Department of Natural Resources and many other statewide partners, the company helps coordinate conservation with the U.S. Fish and Wildlife Service to protect the endangered butterfly, and the larval food sources and adult nectar flower species it depends on for survival.

Over the past few years, bird enthusiasts across the state have enjoyed sightings of the Kirtland's Warbler in Wisconsin's Adams County on some of Plum Creek's red pine plantations. Plum Creek's management efforts for this species include a combination of clear cutting, herbicide applications, and replanting, which mimic the effects of wildfires and attract the bird.

In addition to Plum Creek providing free and open public recreational use on nearly 98 percent of its 330,000 acres of Wisconsin land, the company is also helping conserve important parts of our state's heritage.

Since 2002 alone, Plum Creek has worked to establish permanent conservation programs on more than 45,000 acres in northern Wisconsin. One of the most recent efforts involved working with the Wisconsin Department of Natural Resources and the Wisconsin Sharp-tailed Grouse Society to conserve 320 acres of land in the northwestern part of the state. The land became part of the 30,000-acre Crex Meadows Wildlife Area in Burnett County, which is home to 270 species of birds and 600 species of plants.

Plum Creek is also proud of the role it plays in maintaining the state's forests. In the spring of 2008, the company planted approximately 1.5 million seedlings statewide in an effort to regenerate and grow Wisconsin forests for future generations. Replanting is a large undertaking as the red pine seedlings used are usually planted by hand, one at a time. The science Plum Creek applies to that effort has evolved and improved as well, in the last few years, as foresters look for ways to redefine the company's seed development, sowing, irrigation, fertilization, pruning, and harvesting technologies to produce healthy and viable seedlings.

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PHILLIPS PLASTICS CORPORATION™

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ENVIRONMENTAL STEWARDSHIP

Phillips Plastics Corporation

A total commitment to environmental stewardship helps this manufacturer save money, protect the environment and keep jobs in Wisconsin.

Phillips Plastics Corporation (PPC) is a precision design and build plastics and metals company that produces intermediary and final products for markets such as medical, consumer, automotive and defense. All manufacturing operations are located in Wisconsin and employs roughly 1,600 employees and operates 15 buildings in 7 Wisconsin communities.

All primary production facilities are certified to the ISO 14001:2004 standard via BSI. PPC maintains a corporate certification for all production facilities, and there is a company-wide commitment to environmental stewardship from the shop floor to top management.

PPC's efforts are interrelated and support a holistic environmental stewardship program. It is the result of each related project, topic, posting, communication, recycling, clean up, and sponsorship that contributes to success. It is not one specific project nor individual that fosters environmental excellence, but the collective effort of the individual parts that demonstrates their pursuit of true environmental performance.

PPC's environmental efforts are structured around the framework that supports their ISO 14001 Environmental Management System (EMS). The executive management team is highly motivated to ensure the longevity and sustainable environmental performance for PPC. PPC has had a corporate certification since 2002 for the various manufacturing facilities. The evolution of the EMS has been dramatic over the past year as the focal point for environmental excellence has actively embraced four key element topics concerning: waste reduction, energy reduction, involvement, and Wisconsin green tier participation.

PPC has created institutionalized recycling, energy efficiency, involvement, and participation in the Wisconsin Green Tier effort. Employees are trained to recycle and reduce waste at every step of the manufacturing process. Energy audits at all PPC facilities led to energy-efficient lighting installations

and other equipment changes that resulted in 8.7 million Kilowatt savings and the reduction of 6,200 metric tons of carbon output – the equivalent of taking 1,100 cars off the roads for a year.

In 2007, discussions began with the Department of Natural Resources (DNR) about entering into the Green Tier Program. During the 2007/2008 corporate management reviews, it was determined that as an organization Green Tier achievement would be identified as an overall company EMS objective, and individual facilities have been actively pursuing acceptance into the program. PPC chose to participate and partner with the Wisconsin DNR through the Wisconsin Green Tier Program to celebrate successes in environmental protection, and to demonstrate a commitment to environmental excellence. The first plant has been certified for the Green Tier program.

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