

WISCONSIN BUSINESS FRIEND *of the* ENVIRONMENT AWARDS



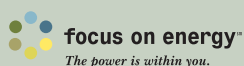
MAY 21, 2015

Milwaukee Marriott West, Waukesha, WI

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WISCONSIN BUSINESS FRIEND *of the* ENVIRONMENT AWARDS

May 21, 2015, Milwaukee Marriott West, Waukesha



2015 Business Friend of the Environment

Award Winners

SUSTAINABILITY

Nucor Cold Finish Wisconsin, Inc.

Masters Gallery Foods, Inc.

Oshkosh Defense, LLC

ENVIRONMENTAL STEWARDSHIP

Meals on Wheels of Sheboygan County, Inc.

Unimin Corporation

Gundersen Health System

ENVIRONMENTAL INNOVATION

Robinway Dairy LLC

MillerCoors LLC

Phillips-Medisize Corp.

2015 Business Friend of the Environment

Program Overview

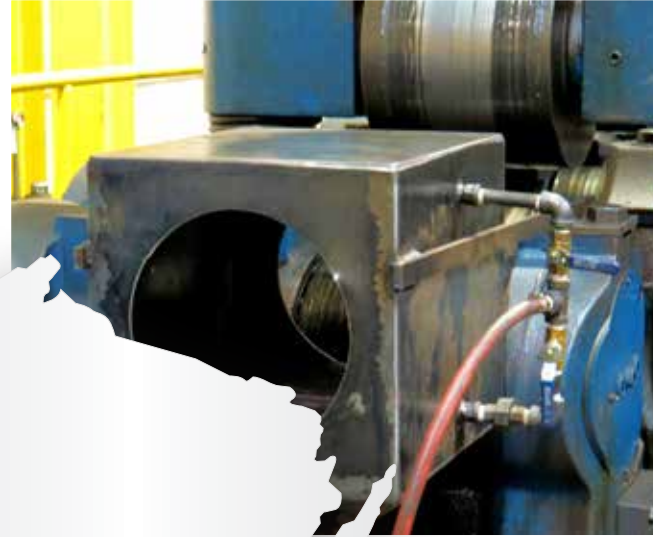
For the 26th year in a row, Wisconsin Manufacturers & Commerce is recognizing nine companies with the Wisconsin Business Friend of the Environment Award. This year's winners have been chosen for programs that demonstrate an innovative approach to environmental protection, or a level of effort beyond 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 sustainability, environmental stewardship and environmental innovation. 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 are selected by an independent judging panel that includes representatives from industry, environmental groups, the Department of Natural Resources, and the University of Wisconsin.

**Honoring Leadership in Sustainability,
Environmental Stewardship and Environmental Innovation**

NUCOR COLD FINISH WISCONSIN, INC.



WHO WE ARE

Nucor Cold Finish is one of the nation's largest steel producers. Nucor is an ISO 14001 certified facility with a major initiative using discarded and recycled steel scrap. The company follows the G.R.E.E.N acronym – Great Expectations, Responsibility, Environmental Excellence, Effective Practices, and Neighborhood Outreach.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

Nucor sets annual environmental objectives and targets, reviewing them throughout the year. An annual management review includes a summation of accomplishments over the last year, improvements that can be made, and goals for the next year. Last year, the company focused on improving yield in their processes to minimize scrap. The company improved in this area through hard work from teammates staying focused on operating as efficiently as possible, and discussing when low yields were had.

Nucor tracks their environmental footprint with the Aspects and Impacts appendix. This chart was designed to focus on the frequency and impact of tasks by allowing the company to concentrate their efforts and update accordingly with each improvement. The company focused efforts on natural resource and energy consumption.

Recently, Nucor focused on minimizing overspray of rust preventative fluid. By designing and installing oiler systems, the company was able to contain and reuse most of the excess oil. In 2015, the company intends to improve efficiency.

In addition, the company is focusing on updating their lighting and incorporating more efficient bulbs. The new fixtures will include motion detectors and will operate only when needed, reducing energy consumption by 77%. With an initial investment of over \$20,000, Nucor considers this a cost savings as well as an environmental improvement, due to the \$8,000 per year projected annual savings.

Furthermore, Nucor processed nearly 10,000 more tons from 2013 to 2014 and had similar scrap totals. Their scrap pounds per ton produced dropped from 60.5 to 52.3 from 2013 to 2014. They also had less electricity use per ton (66.8 KWh/ton to 62.3 KWh/ton).

Nucor is very proud of having no releases, spills, or dumps through 2014. The company continues to strive for improvements, and believes team training, programs, procedures, and focus on environmental compliance are the real difference makers.



Oak Creek, WI

ESTABLISHED
1962

SIZE
25,000 Employees Company-wide
74 Wisconsin Employees

WEBSITE
www.nucor.com

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MASTERS GALLERY FOODS, INC.



WHO WE ARE

Founded in 1974, Masters Gallery Foods, Inc. is a second generation national cheese supplier, maintaining one of the largest privately held cheese inventories in the U.S. Their state-of-the-art production facility cuts and wraps cheese products for distribution throughout the U.S. and Puerto Rico, with exports into Mexico and other parts of the world. Masters serves about half of the top retailers in the U.S., many of the nation's largest foodservice chain accounts, restaurants, ingredient and distributors, and the USDA school lunch program. Besides retail and foodservice, Masters industrial sales division remains the backbone of the company, supplying bulk cheese to industrial cheese cutters and wrappers.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

Masters built and completed its first production and distribution facility totaling 40,000 square feet in 1989. Since then, the company has undergone numerous plant expansions. The largest and final expansion was completed in October 2014, expanding the facility to a total of 310,000 square feet. During this most recent expansion, Masters converted their air compressors to supply areas of the plant with heat that would have otherwise been discharged to the atmosphere, also referred to as "free heat." They also retrofitted most of the plant with LED lighting. Masters was awarded the Energy Efficiency Improvement Award from Plymouth Utilities for a 235,433 kilowatt reduction through their equipment audits and upgrades. In addition, they also received the Environmental Stewardship Award from The Wasmer Company for eliminating 1,038,008 kilowatts with lighting upgrades.

Additionally, since 2012, Masters has worked with local companies to find efficient ways to divert waste from landfills. It has since turned the program into a profit center, hiring a full-time employee to manage the waste streams. In 2014 alone, Masters diverted 847,880 pounds (424 tons) from landfills.

In conjunction, the Masters' Green Team coordinates company and public activities to raise environmental awareness, including: Earth Day clean up, recycled shoe drive, recycled art project contest, recycled holiday lights drive, free electronic recycle day, company paper shred, an end of year paper recycle for the local middle and high school, and participation in the Ronald McDonald Tab Toss program. Additionally, Masters conducts proper battery disposal for all batteries used on site, encouraging employees to bring in their batteries from home, as well as used ink cartridges for recycling.

Masters is very proud of their green efforts, and remains diligent in going above and beyond to innovate the necessary changes that benefit our environment.



Plymouth, WI

ESTABLISHED
1974

SIZE
480 Employees

WEBSITE
www.mastersgalleryfoods.com

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OSHKOSH DEFENSE, LLC



Who We Are

The Oshkosh Corporation Defense segment is one of the four business segments comprising Oshkosh Corporation. Defense manufactures heavy and medium military tactical vehicles as well as some commercial vehicles. The trucks are manufactured, assembled and painted at several plants located throughout Oshkosh, Wisconsin.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

Oshkosh Defense has worked diligently to identify and execute energy projects, using innovative technology. Oshkosh Defense joined the Department of Energy's Better Buildings, Better Plant Program in an effort to reduce energy intensity throughout the company by 25% over the next 10 years. Additionally, the company has been selected as one of thirty large energy users for Wisconsin's Focus on Energy Strategic Energy Management Program, which focuses on helping companies create and maintain a sustainable energy management program while making energy awareness a key stakeholder in everyday plant operations.

Recently, Defense management created a Defense Energy Team initiative. This team, consisting of members from various specialties within Oshkosh, in six short months completed energy cost saving projects totaling greater than \$500,000 annually.

The Harrison St. facility has 1000hp of compressors which creates a tremendous amount of heat in the compressor room. The 110 degree heat at the roof of the compressor room is now being recovered and ducted back into the plant using 48-inch ductwork on the roof and large blower fans which are computer controlled using VFDs to modulate the airspeed and auto dampers that adjust based on plant space temperature. The heat recovery system saves \$27,736 per year in natural gas for the first 600hp, and an additional savings of \$4,622 per 100hp thereafter. Installation of the compressor room heat recovery system has allowed the company to eliminate the third phase of a heating conversion project that would have cost \$393,000 to install.

The Harrison St. facility was recently repurposed to a welding and fabrication facility. Welding creates tremendous amounts of smoke. Oshkosh Defense installed a state-of-the-art weld filtration system which filtered weld smoke from the air without having to exhaust heated plant air. The system consists of 14 repurposed air filtration units and 14 new units which greatly extend filter life, eliminating additional maintenance and waste.



Oshkosh, WI

ESTABLISHED
1917

SIZE
2,400 Employees Company-wide
2,100 Wisconsin Employees

WEBSITE
www.oshkoshdefense.com

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MEALS ON WHEELS OF SHEBOYGAN COUNTY, INC.



WHO WE ARE

Meals On Wheels of Sheboygan County Inc. (MOWSC) is the first meal delivery program in the U.S. to grow substantial amounts of produce and accept significant local food donations to prepare fresh nutritional meals for elderly, disabled and homebound residents. Using produce grown on-site and by local farmers, home gardeners, and organizations has allowed MOWSC to control costs, greatly increase meal standards and aim to be a zero waste facility by using sustainable practices.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

From 1970 to 2012, MOWSC followed the traditional model, used throughout the nation, of hiring hospitals and caterers to prepare meals for the organization to deliver to the elderly, disabled and homebound in the community. In 2010, MOWSC's Board of Directors held a visioning session to discuss the issues of rising food costs, diminishing food quality, and how to provide the most nutritional content to clients. The Board determined that combining the administrative offices with a kitchen, and using local ingredients grown by the organization, home gardeners, and local farmers in meals would increase the organization's efficiency and maximize its ability to meet the needs of the community.

Over the next two years, a site was chosen and planning sessions took place with the Wisconsin Department of Agriculture, state registered dietitians, the local health department, restaurateurs, institutional food service directors, kitchen equipment manufacturers and kitchen designers using LEAN principles.

Green features at the facility include solar tube lights, recycled cork flooring, replaceable carpet tiles, a hood vent that redirects heat to a dish sanitizer, natural light from abundant windows, edible landscaping, and more. The addition of a culinary team and registered dietician doubled the number of staff employed by the organization — but offering an excellent investment, as nutritional value and quality of the meals significantly increased.

The facility was only the foundation of the innovation. Eighteen 200 square foot raised garden beds were built in partnership with Wisconsin Public Service. Eleven additional raised beds, with low tunnels to extend the growing season into December, were built in collaboration with local carpenters and contractors. Together, over 2,000 pounds of produce were grown in 4,480 square feet of gardening space. Additionally, MOWSC accepted 9,000 pounds of produce from local farmers and home gardeners.

To date, over 125,000 meals have been prepared using produce grown on-site or donated to the organization. The meals have improved the lives of clients to the point that they are able to reduce or stop taking medications altogether. Healthier meals have lowered cholesterol and blood pressure for some clients. The facility and MOWSC's produce-processing showcase what local companies and the community can do when working together for the betterment of elderly, disabled and homebound neighbors.



Sheboygan, WI

ESTABLISHED
1970

SIZE
14 Employees

WEBSITE
www.freshmealsonwheels.org

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UNIMIN CORPORATION



WHO WE ARE

Unimin Corporation is one of North America's leading producers of specialty minerals, operating 44 facilities in Canada, the U.S. and Mexico. Unimin's parent organization, Sibelco, is a diverse, privately held organization with a worldwide presence. Guided by a fundamental desire to exceed industry and government standards in safety, environmental management, community relations and operational excellence, Unimin operates with the future in mind.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

Unimin's Tunnel City plant, located just west of Tomah in Monroe County, began construction in November 2011 and went into full operation in 2014. Tunnel City provided Unimin the opportunity to create a completely enclosed site where all mining, processing and shipping could occur. Having all activities on one site is the most efficient way to produce high quality silica sand while reducing potential effects on safety and the environment.

Tunnel City employs a number of conservation techniques, including LED lighting, the full enclosure and insulation of the plant, recycling of process heat to warm the buildings, and the use of variable frequency drives to reduce electrical consumption. Additionally, by combining several innovative technologies, Unimin created a water recycling plant that recycles more than 97 percent of the process water to reduce demand on the local aquifer.

Unimin implements geomorphic principles in the reclamation design at Tunnel City – taking into account regional climate conditions when designing the final landforms, and employing natural drainages that allow water to flow freely, without causing washouts. This unique design allows for a sustainable landscape with no future maintenance needs.

During initial pre-mine surveys, Unimin discovered that the habitat of the endangered Karner Blue Butterfly (KBB) was itself endangered. Unimin created a long-term KBB conservancy plan for Tunnel City and became the first mining company to partner with both the U.S. Fish and Wildlife Service and the Wisconsin Statewide Karner Blue Butterfly Habitat Conservation Plan. Thus far, approximately 108 acres of KBB habitat have been restored using a diverse seed mix to support the KBB and other pollinators.

Additionally, Unimin discovered that the site had an active bat hibernaculum (the winter quarters of a hibernating animal), which was inside a nearby abandoned railroad tunnel. In partnership with the Wisconsin Department of Natural Resources, a gate was constructed at the tunnel's entrance to allow bat access but prevent unwelcome entry from humans or animal species. Bat populations inside the tunnel have increased from approximately 200 during the initial survey in Winter 2012 to more than 800 during the November 2014 survey.



Tomah, WI

ESTABLISHED
1970

SIZE
2,440 Employees Company-wide
125 Wisconsin Employees

WEBSITE
www.uniminsustainability.com

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GUNDERSEN HEALTH SYSTEM



Who We Are

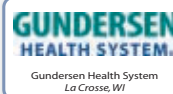
Gundersen Health System is a non-profit, comprehensive integrated healthcare network headquartered in La Crosse, Wisconsin. More than 6,000 employees serve 19 counties in western Wisconsin, southeastern Minnesota, and northeastern Iowa. The network includes a multi-specialty group medical practice, teaching hospital, regional community clinics, regional hospital and clinic partners, behavioral health services, vision centers, pharmacies, and air and ground ambulances.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

Gundersen's environmental program, Envision®, is a model for organizations nationwide. Gundersen Health System is the first in the nation to achieve energy independence. The company began by focusing on their heating and cooling systems, lighting and employee behavior – using low-cost or no-cost measures to improve efficiency and reduce demand. When their efficiency program started, energy costs were rising by nearly \$350,000 a year. Today, total energy savings are more than \$2 million per year and energy efficiency has improved by nearly 50 percent.

The largest project in Gundersen's portfolio is a biomass boiler, representing 38 percent of their goal. It burns clean, organic wood fuel sources – heating water to create steam for the La Crosse campus, and running a generator to produce electricity. Gundersen also teamed with La Crosse County to turn biogas created from waste at the area landfill into electricity and heat for their Onalaska campus. In addition, they partnered with Organic Valley on a wind turbine project, and with Dane County and several farming operations to generate electricity from cow manure. One dairy digester project reduces phosphorous runoff, protecting area waterways. Additionally, the portfolio includes a second wind turbine project, geothermal energy and several solar initiatives.

Gundersen's sustainable efforts help remove fossil fuel CO2 from the air (nearly 243,000 pounds of particulates out of the atmosphere each year), tons of waste from landfills, and phosphorous runoff from lakes. Other program highlights include: construction recycling/reuse rates for new building construction have exceeded 91 percent since 2010; reduced pharmaceutical and hazardous waste by more than 40 percent since 2010; reduced food waste by over 70 percent, and contributions of healthy food to the local Salvation Army several times each week; recycled 43 percent of their waste stream in 2013; and, tons of sterile surgical "blue wrap" has been donated to area organizations and transformed into aprons, tote bags and quilt batting, rather than discarded into the waste stream.



La Crosse, WI

ESTABLISHED
1902

SIZE
6,000+ Employees Company-wide
5,000+ Wisconsin Employees

WEBSITE
www.gundersenhealth.org

FOR MORE INFORMATION ABOUT ENVIRONMENTAL STEWARDSHIP EFFORTS, PLEASE CONTACT:
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ROBINWAY DAIRY LLC



Who We Are

Robinway Dairy LLC is a multi-member limited liability corporation located outside of School Hill, Wisconsin. Under the care of 25 Wisconsin employees, 1,150 dairy cows are milked daily and another 700 steers are raised on-site. 1,400 acres of crop land is farmed annually and 600 acres is irrigated. The dairy is currently expanding while simultaneously taking great strides in reducing their environmental footprint.

Robinway Dairy LLC
Kiel, WI

Kiel, WI

2015 BUSINESS FRIEND OF THE ENVIRONMENT

Known for its progressive, industry leading approach to dairy farming, Robinway Dairy is one of the first dairies in Wisconsin to install the Livestock Water Recycling (LWR) Manure Treatment System. The LWR System uses a patented water treatment technology that has been specifically designed and manufactured for manure treatment. The three-component process integrates to eliminate pathogens, concentrate nutrients, and produce an abundant supply of clean, reusable water.

This innovative technology will treat millions of gallons of liquid manure annually, turning it into clean, drinkable water, liquid nutrient concentrate containing ammonium sulfate and potassium, and solid fertilizer that will capture organic nitrogen and 100% of the phosphorus. The water will in turn be used for washing out the barn, watering the livestock, and crop irrigation. The fertilizer nutrients will be strategically and appropriately applied to crops.

Manure application restrictions have resulted in expensive hauling costs. Dairies are fundamentally protective of their local environments, and Robinway is no exception. The dairy recycles, recovers, and reuses everything possible. Until now, they haven't had a tool to safely and effectively manage their manure. The water that Robinway Dairy will produce with the LWR system will be clean enough to drink. The system will also reduce the number of trucks on local roads which will keep the roads in better shape.

Robinway expects to reduce their well water withdrawals by up to 40%, and the odor associated with dairy manure will be significantly reduced. Only 25% of the original volume of manure will be stored on site in the form of liquid and solid fertilizer – the rest will be clean water that will be reused around the farm.

It is estimated that by the year 2050 farmers will need to increase world food production by 70% in order to meet the needs of 9 billion people. With this increased demand, the agricultural sector is under extreme pressure to improve how it uses water resources. By installing the LWR System, Robinway will reduce the risk of ground water contamination through strategic and surgical nutrient application.

Size

25 Employees

FOR MORE INFORMATION ABOUT ENVIRONMENTAL INNOVATION EFFORTS, PLEASE CONTACT:

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MILLERCOORS LLC



WHO WE ARE

Through its diverse collection of storied breweries, MillerCoors brings American beer drinkers an unmatched selection of the highest quality beers steeped in centuries of brewing heritage. Miller Brewing Company and Coors Brewing Company offer domestic favorites such as Coors Light, Miller Lite, Miller High Life and Coors Banquet. Tenth and Blake Beer Company, the craft and import division, offers beers such as Leinenkugel's Summer Shandy from sixth-generation Jacob Leinenkugel Brewing Company, Blue Moon Belgian White from modern craft pioneer Blue Moon Brewing Company, and Crispin Cider, an artisanal maker of pear and apple ciders using fresh-pressed American juice. The company imports world-renowned beers such as Italy's Peroni Nastro Azzurro, the Czech Republic's Pilsner Urquell and the Netherlands' Grolsch. MillerCoors also offers pioneering new brands such as the Redd's franchise, Redd's Wicked and Smith & Forge Hard Cider. MillerCoors seeks to become America's best beer company through an uncompromising promise of quality, a keen focus on innovation and a deep commitment to sustainability.

2015 BUSINESS FRIEND OF THE ENVIRONMENT

In late 2013, the Milwaukee brewery set a goal to reduce its final wastes and become landfill free by the end of 2014. This marked a target end for a journey that reduced waste by approximately half from 2008 to 2013, re-tooling the "end-of-life" stage into "new life" for hundreds of tons of waste. The final goal was achieved in December 2014 by implementing best practices from six other MillerCoors landfill free breweries, working with external partners, and establishing a brewery green team that was led by shop floor employees. These initiatives contribute to an engaged and environmentally tuned-in employee culture.

By repurposing, reusing and recycling virtually everything, the Milwaukee landfill free brewery dramatically reduces the energy and water used to manufacture virgin inputs in items like aluminum, cardboard, paperboard and glass cullet – while also significantly reducing related manufacturing emissions. As an added benefit, these efforts overall currently result in a cost savings of approximately \$90,000 per year for the brewery.

In addition, in 2014, the Milwaukee brewery reduced its water use to just 3.26 hectoliters of water per 1 hectoliter of beer produced. Likewise, it reduced its energy consumption to 118 megajoules per hectolitre of beer produced. These significant cultural step changes are further evidence of the Milwaukee brewery's deep commitment to environmental sustainability and well-being of its community.



Milwaukee, WI

ESTABLISHED
2008

SIZE
8,134 Employee Company-wide
600 Wisconsin Employees

WEBSITE
www.millercoors.com

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PHILLIPS-MEDISIZE CORP.



WHO WE ARE

Headquartered in Hudson, Wisconsin, Phillips-Medisize is a global-leader in technology-driven manufacturing. With unparalleled experience in advanced molding and assembly, Phillips-Medisize has become a dominant force in the medical device and diagnostics, drug delivery, primary pharmaceutical packaging, and commercial markets. The company has annual sales of over \$600 million with 80% of the total revenue coming from drug delivery, medical device and diagnostic products, such as: disposable insulin pens, glucose meters, specialty inhalation drug delivery devices, single-use surgical devices and consumable diagnostic components.



Eau Claire, WI

2015 BUSINESS FRIEND OF THE ENVIRONMENT

In 2009, Phillips-Medisize Wisconsin facilities and its executives set upon the path to become a zero landfill organization. The company quickly found out that the pathway to true "0" is very difficult and the logistics at their facilities was not conducive to directly taking wastes to a co-gen facility; however, the company could develop plans to off-set landfill wastes to become Net "0." This Net "0" Waste-To-Energy process has allowed Phillips-Medisize to create value from true waste – creating a pathway where waste becomes fuel, to provide power for the company and the grid.

Phillips-Medisize partnered with Advance Disposal, Xcel Energy's French Island Generation Plant (a waste fired electrical power station), and La Crosse County Department of Solid Waste. Since Phillips-Medisize has 13 unique facilities across 6 communities throughout the state, each facility had various regional Advance Disposal facilities that service each location. Each facility needed to collectively come to an agreement on the methodology to account for all wastes to allow for a traceable record, which would ensure all wastes were indeed identified and off-set properly. It was determined that the costs associated with the program would then be shared among the facilities based upon the waste volumes generated, and the billing cycle would then be reflective of the costs to implement this program. This would ensure that facilities generating the most waste have a larger ownership of the program – helping drive future continuous improvement.

Upon completion of the agreement, Advance Disposal then worked with various regional transportation/shipping carriers to arrange for the RDF (Refuse Derived Fuel) to be delivered to the French Island facility. The carriers all had to be pre-approved and a system set up to account for the tonnage. A contract was signed in 2014 and waste has been, and will continue to be, shipped to the French Island Co-Gen. facility. In 2014, as a combined Wisconsin aggregate, Phillips-Medisize generated 322.6 tons of landfill waste. The company will ship 322.6 tons of RDF to off-set the wastes generated by their facilities. Phillips-Medisize has now become a true Net "0" Wisconsin company.

ESTABLISHED
1964

SIZE
3,500 Employees Company-wide
2,123 Wisconsin Employees

WEBSITE
www.phillipsmedisize.com

FOR MORE INFORMATION ABOUT ENVIRONMENTAL INNOVATION EFFORTS, PLEASE CONTACT:

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WISCONSIN BUSINESS FRIEND *of the* ENVIRONMENT AWARDS



Judges

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Program Sponsor

WISCONSIN MANUFACTURERS AND COMMERCE (WMC) is Wisconsin's most successful business advocacy organization. Celebrating over a century of service to state businesses in all sectors, WMC is the Wisconsin manufacturer's association, the state chamber of commerce, and the state safety council. WMC represents the interests of nearly 3,800 member companies from across the state that employ approximately one-quarter of Wisconsin's private sector workforce. WMC is dedicated to making Wisconsin the most competitive state in the nation.

