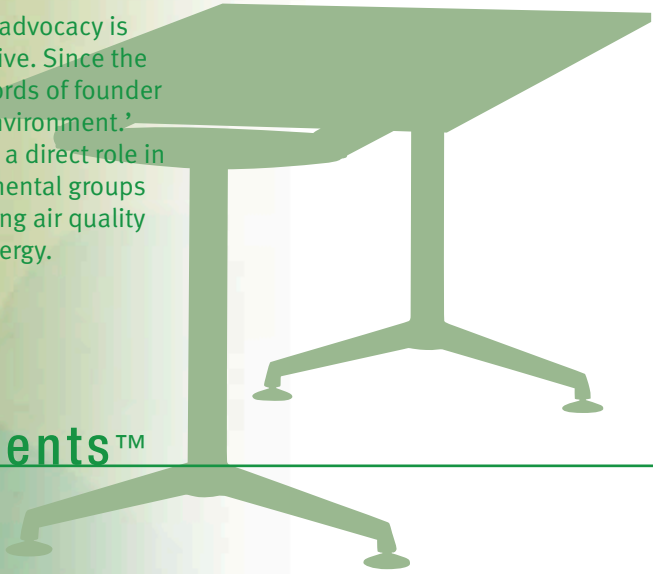


Herman Miller's environmental advocacy is long-standing and comprehensive. Since the 1950s, we have been, in the words of founder D.J. De Pree, 'stewards of the environment.' Today over 400 employees play a direct role in the work of 9 different environmental groups engaged in efforts from improving air quality and reducing waste to green energy.



Environmental Product Summary

AbakEnvironments™

NOTE

Information within this document has been taken from the US version and has not been adapted to UK standards.

Design story:
Efficient, adaptable, globally inspired

A proven success in Europe and Asia, Abak environments respond to the growing worldwide demand for an easily adaptable desk system that works in open environments. Thanks to its simple beam construction and wide variety of desktop designs, Abak is a practical, versatile option for companies large and small.

Abak's clean, crisp styling makes it a natural choice for modern workspaces everywhere, whether in private office, open plan, collaborative, or formal meeting area applications. Environmentally speaking, its standardised product platform and durability make Abak an adaptable and dependable system for the long haul.

Herman Miller's design protocol

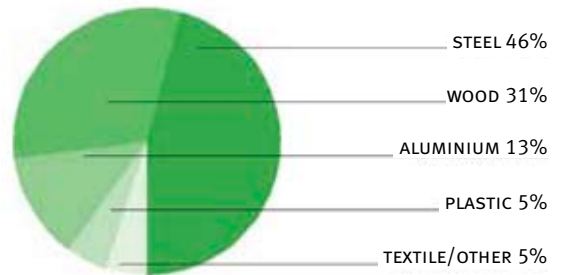
Our commitment to corporate sustainability naturally includes minimising the environmental impact of each of our products. Our Design for the Environment team (DfE) applies environmentally sensitive design standards to both new and existing Herman Miller products, utilizing the McDonough-Braungart Cradle-to-Cradle Protocol.

Cradle-to-Cradle goes beyond regulatory compliance to thoroughly evaluate new product designs in three key areas:

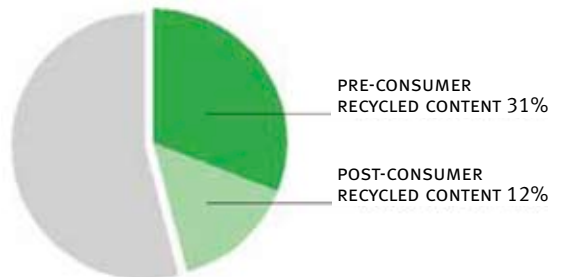
- *Material Chemistry and Safety of Inputs*—What chemicals are in the materials we specify, and are they the safest available?
- *Disassembly*—Can we take products apart at the end of their useful life, to recycle their materials?

Material content

Abak desking components are constructed from steel, wood, aluminum, plastic, and textile.



Abak desking is up to **61 percent recyclable** at the end of its useful life.



Abak is comprised of **43 percent recycled** materials. This figure breaks down to 12 percent post-consumer and 31 percent pre-consumer recycled content.

- Aluminium components and steel components are 100 percent recyclable.
- Most metal components have a powder-coat paint finish that emits negligible volatile organic compounds (VOCs).
- Wood content in work surface substrates is comprised of more than 90-percent reclaimed wood, as certified by Scientific Certification Systems. This wood content is made primarily of sawdust generated by other wood process operations.
- All veneers used are purchased from suppliers practicing sustainable forestry techniques.
 - Approximately 60-80 percent of veneers are derived from domestically grown woods, notably cherry.
 - Sustainably harvested, rapidly renewable bamboo work surface veneer is also available.
 - All veneers are adhered to the substrate with water-based glues to minimise air emissions.
- Plastic components are identified with an ASTM recycling code whenever possible, to aid in returning these materials to the recycling stream.
- Textiles used in Herman Miller products can be made from natural or synthetic fibres. Several textiles are available with 100 percent recycled content.
- Foam and textile materials are part of an open-loop system and can be recycled into everything from automotive components to carpet padding at the end of their current life.
- *Returnable/Recyclable Packaging*—Packaging materials include corrugated cardboard and a polyethylene plastic bag; each is part of a closed-loop recycling system, for repeated recycling.
 - Whenever possible, shipments between Herman Miller and its suppliers include the use of pallets and other returnable packaging to minimise waste.
 - On large orders, disposable packaging can be replaced with reusable shipping blankets.

Manufacturing process

- *Green Energy and Emissions*—Herman Miller is committed to the use of 100 percent renewable energy by the year 2020. The company is similarly committed to achieving a goal of zero air and water emissions from manufacturing by 2020.
- *Waste*—All solid wastes are recycled to the greatest extent possible.

- *Worker Health and Safety*—Herman Miller strives to meet or exceed OSHA standards.
- *ISO*—Abak is manufactured in West Michigan and UK at ISO 14001-certified sites.

HMPS

Herman Miller's commitment to operational excellence lead to an aggressive drive to reinvent its operations and established a fruitful relationship with the Toyota Supplier Support Centre. Through the Herman Miller Production System (HMPS), the company has dramatically reduced manufacturing space and inventories, cut lead times for standard product, and grown sales and profitability. HMPS minimises wasted effort, energy and materials, and plays an important part in Herman Miller's ongoing commitment to a better environment.

Product performance

- Designed for minimal material use, reduced energy requirements, easy reconfiguration, and durability.
- Backed up by Herman Miller's 12-year, 24 hour warranty.

Indoor air quality

Abak Environments is GREENGUARD™ certified as a low-emitting product that meets current indoor air quality standards. GREENGUARD-certified products also meet the emissions requirements of the State of Washington Furniture Systems criteria and the U.S. EPA Procurement Guidelines for Office Furniture.

Corporate environmental policy

For more information on Herman Miller's Corporate Environmental Policy and other environmental efforts, visit the 'Environment' section of www.hmeurope.com

Supplier support

At Herman Miller, we are committed to working closely with our suppliers to reduce our collective impact on the environment. We not only encourage our suppliers to minimise their operations' environmental impacts, but require they assist us in decreasing our facilities' negative environmental effects as well.

CO₂ emissions offset

Herman Miller Ltd. works with Best Foot Forward to calculate, analyse and reduce the CO₂ emissions of the Abak Environments production in the UK plant. Climate Care offsets the remaining CO₂ emissions by funding sustainable energy projects. For more information visit www.climatecare.org