

All together now

Allsteel®

All the people helping all the planet
so we all profit.

We need to embrace a wider view of how we all affect the
planet and how we can improve it. A broad spectrum of
ideas is needed to make real and lasting improvements to
our environment.

In other words, why just be green?



A young girl with blonde hair, wearing a red dress and a white headband, is smiling and peeking from behind a wall of stacked cardboard boxes. The boxes are arranged in a grid pattern, creating a maze-like structure. The lighting is warm and focused on the girl and the boxes.

What about brown?

When we blanket wrap chairs instead of using corrugated material, we save a stack of boxes 1,325 feet high with every truckload. That's taller than Chicago's John Hancock building. This blanket wrapping has the added benefit of cutting installation time in half.

We also made changes to our packaging that allow us to ship 88% more chairs per truckload, saving 64 tons of corrugate a year. That eliminates 54 semi-trailer trips and 100 tons of CO₂ emissions annually.

Many materials from our suppliers are shipped in reusable totes. Any corrugate shipped into our manufacturing facility from suppliers has recycled content and is recycled. That's 425 tons per year that stays out of landfills and gets turned into new cartons.



What about blue?

Although 70% of our planet is covered in H₂O, only 1% is usable by humans, so saving water is crucial.

We're fortunate to have the 50 square-mile Muscatine Island Aquifer as a clean water source. To help protect it for future generations, we implemented reverse-osmosis systems in the washing processes within several paint lines. Filtering and reusing the water results in an annual water savings of 1.8 million gallons. That's enough drinking water for a city of 9,800 for an entire year.

What about yellow?

After moving into our corporate headquarters (in a reclaimed manufacturing facility) someone had the bright idea to put some “solar sunflowers” out in our backyard. These compact solar panels generate enough clean, renewable energy to power 40 laptop computers every day (or a DVD player long enough to watch *An Inconvenient Truth* 45,000 times in one year).

Speaking of cleaner energy, we purchased green energy credits to offset electricity use at four of our new LEED®-certified Resource Centers and for the production of our new seating and systems furniture lines.



What about clear?

Raise your hand if you're pro-breathing. Yeah, us too.

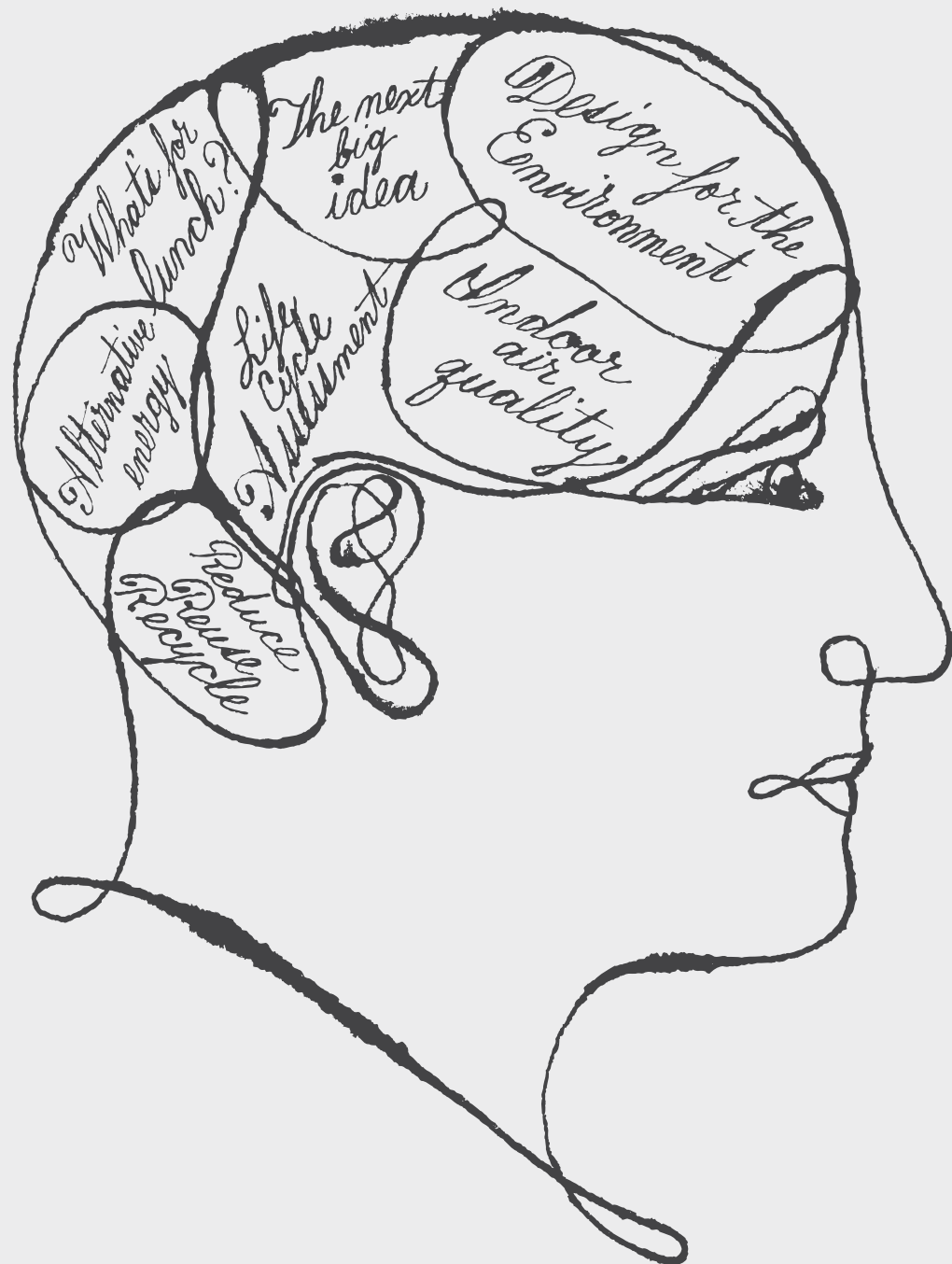
We were the first office furniture manufacturer to complete Scientific Certification Systems (SCS) Indoor Advantage™ indoor air quality certification for all of our systems furniture and seating.

Allsteel was among the first companies to certify its environmental and social responsibility performance claims through the rigorous standards verified by SCS Sustainable Choice.™ And we adhere to the Federal Trade Commission's Guidelines for the Use of Environmental Marketing Claims.

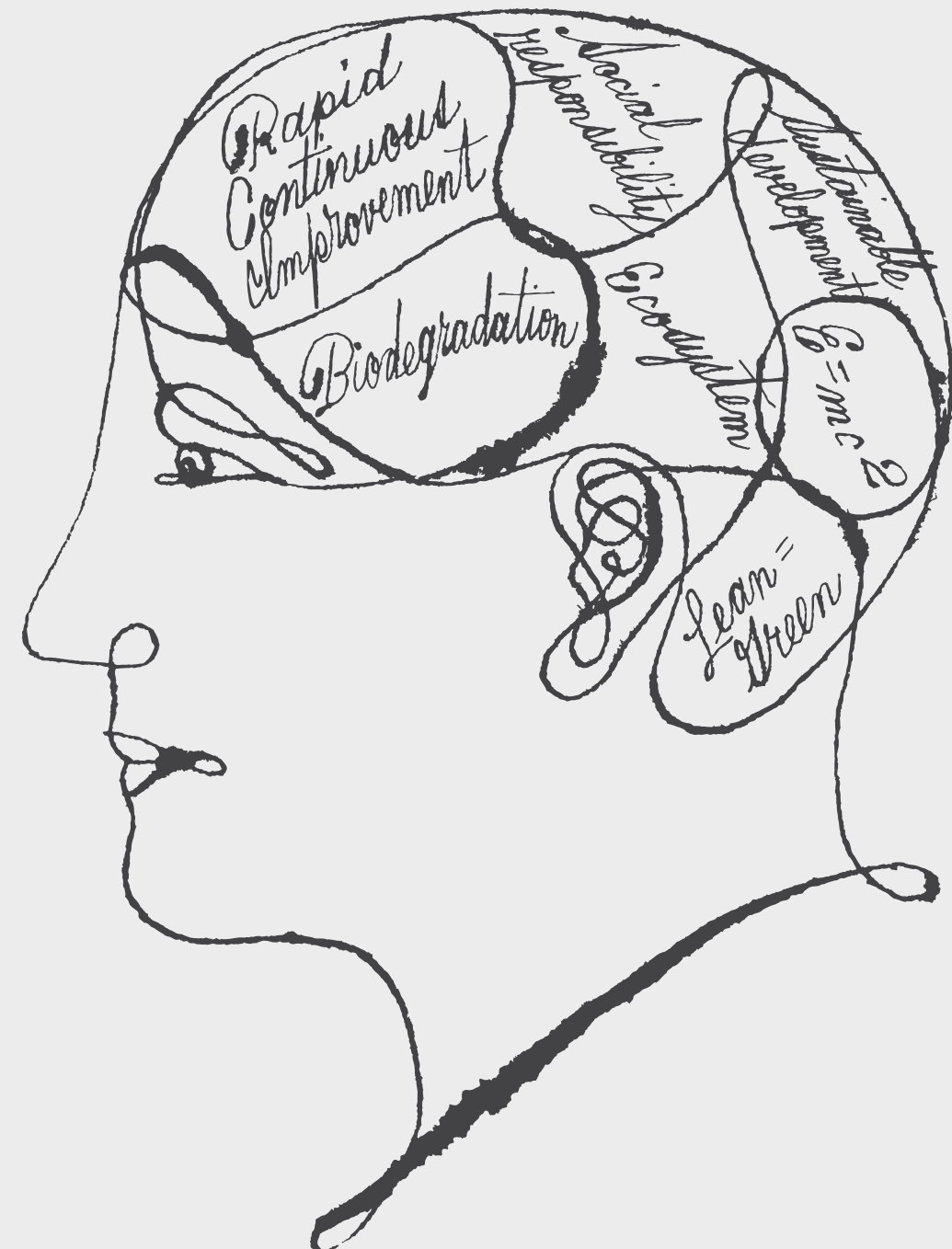
So even our words are clear and credible.

What about gray?

We tap the creative minds of our employees and partners to find new ways to do our work better. We call the process Rapid Continuous Improvement (RCI). It's also known as "Hey, that's a great idea. Let's actually do it." We've also adopted tools like Life Cycle Assessment and Design for the Environment into the design process, which is where the greatest long-term environmental improvement can be made.



The result is products that are totally rethought from start to finish. Our Acuity™ chair is a perfect example. It's made of 46% recycled content, is 90% recyclable, and comes with a "take-back" guarantee at the end of its usable life. All of which earned it a Cradle to Cradle™ Silver Certification by MBDC. That's usin' the old noggin.





What about periwinkle?

A product with low impact to the environment should also reflect its beauty. Using new techniques like biomimicry, new materials, and new technology, our designers and engineers have crafted stylish new lines that take their inspiration from nature.

Many of our fabrics are not only gorgeous and durable, but also Cradle to Cradle Certified^{CM} or woven from 100% recycled polyester. Our Infinite SpectrumTM surfaces can be made in any PANTONE[®] color and are crafted from recyclable PETG resin to create office spaces that not only celebrate nature's beauty, they help preserve it.

The image shows two curved metal handles, likely made of steel, resting on a dark, reflective surface. The handles are positioned diagonally, with one in the foreground and another slightly behind it to the left. The lighting creates soft shadows and highlights the metallic texture of the handles.

What about steel?

What's better than recycling waste?
Creating less waste to start with.

Our engineering teams begin by designing products that use resources wisely. In production we use laser cutting and other state-of-the-art technologies to maximize material use and reduce scrap. This cuts our steel scrap by 1,158 tons a year.

All our products come with Allsteel's Lifetime Warranty, because making products out of durable materials like steel makes sense for the planet. If it doesn't wear out (or ugly out), it'll be used and reused for years and years rather than being thrown away.

Waste not. Pollute not.



So...what about green?

All kinds of green. The kind that respects our planet and keeps factories open and people working. By running a lean and profitable business we can grow our communities and be a leader through charitable giving and our environmental example.

Yes, it is possible to do well and do good at the same time.

What about black and white?

Here's a summary of the environmental efforts we've been undertaking.

No greenwashing. Just real initiatives yielding concrete results.

BULK PACKAGING	<ul style="list-style-type: none">• Bulk packing densely packaged products, reducing shipping “cubes” over 60%, and saving transportation, storage, and installation time.• Protective packaging for overhead storage reduced over 90% and expanded polystyrene foam eliminated completely.• Over 25 major product lines specifically designed to be bulk packed.
CORRUGATED PACKAGING	<ul style="list-style-type: none">• Corrugated packaging from suppliers is baled, delivered to a local recycling center, and converted into paper products.• 462 tons recycled in 2007, reducing 1,372 tons of CO₂ emissions.
BLANKET WRAPPING	<ul style="list-style-type: none">• Reusable blanket wrap eliminates corrugated packaging.• Blanket wrapping allows 400 chairs per truckload compared with 184 boxed chairs. This eliminates more than two tons of corrugated packaging per load and saves 9.5 tons of CO₂ emissions per truckload due to less packaging and fewer trucks on the road.
CARTONING AND SPACE	<ul style="list-style-type: none">• Single-point base attachment on Sum® and Relate® seating allows smaller containers and higher cube utilization for shipping and storage.• One truckload holds 345 chairs compared to 184 chairs packed conventionally, an 88% increase in shipping density.• For Sum, 64-ton reduction in corrugate waste and a reduction of 54 outbound trailer loads annually prevents 100 tons of CO₂ emissions.
TRANSPORT IMPACTS OF SHIPPING	<ul style="list-style-type: none">• Shipping density of outgoing products and consolidation of shipping routes increased through Rapid Continuous Improvement (RCI) initiatives.• Reduced number of annual truckloads required, yielding a 2 million pound reduction of CO₂ emissions from carriers from 2004-06.
WATER CONSERVATION	<ul style="list-style-type: none">• Implemented reverse-osmosis systems in washing processes of several paint lines. This keeps water fresh for a week, meaning there's no need to replenish it daily.• Saves 1.8 million gallons of water annually.
MATERIAL WASTE	<ul style="list-style-type: none">• RCI practices remove waste from manufacturing processes and improve material yield.• State-of-the-art software and technology optimize material use and minimize scrap.• Laser-cutting led to a 1,158-ton annual reduction in steel scrap, also reducing 3,349 tons of CO₂ emissions annually.
PAINT RECLAMATION	<ul style="list-style-type: none">• Reclaimed wet paint and overspray powder is re-blended into new paint.• The interior drawer bodies of Reach® storage units are finished with reclaimed paint.• All reclaimed paint must meet Allsteel quality standards for new paint.
SURFACE MATERIALS	<ul style="list-style-type: none">• Fabrics made of PLA (from renewable corn), 100% recycled polyester, and Eco-Intelligent® polyester that's Cradle to Cradle Certified are part of the standard offering.• Easily recyclable PETG resins are available on panel systems.
FABRIC WASTE	<ul style="list-style-type: none">• Waste fabric is converted into “shoddy” which is used in acoustical automotive interiors, such as trunk liners.• 290 tons of material converted into shoddy in 2007, reducing 861 tons of CO₂ emissions.
RECYCLING WOOD WASTE	<ul style="list-style-type: none">• Wood processing waste is ground and sent to an energy co-generation facility instead of a landfill.• Diverted approximately 6,164 tons of wood waste from landfills in 2007, resulting in a reduction of 18,307 tons of CO₂ emissions.
INDOOR AIR QUALITY	<ul style="list-style-type: none">• First office furniture manufacturer to have all products certified either Indoor Advantage or Indoor Advantage Gold.• Means healthier air in and out of the workplace.

All together now

What will it take to widen our view, so we can make a real and lasting difference?

All the People – This isn't just about us at Allsteel. It's about all of us. Customers. Competitors. Suppliers. Neighbors. Whether composting lawn clippings or reducing 150 tons of landfill debris a month, we all must make a difference.

Helping All the Planet – Our actions have global ramifications. Despite our different cultures and countries, we are united in our humanity and the place we all call home.

So We All Profit – These challenges lead to the development of new ideas, new materials, new technology, and new jobs. Improving the environment keeps people working and makes our company, communities, and economies stronger.



What color is our future?

While we're proud of our progress, we're not content to sit back on our recycled laurels. We intend to keep getting better and hope others will join us in our efforts.

Here are a few of the goals we're setting for ourselves:

- Design and develop all new products using Design for the Environment principles with Life Cycle Assessments.
- Achieve 100% diversion of waste from fabrication and assembly processes while reducing landfill disposal by 50% every year.
- Reduce our facilities' energy usage annually by 10% and develop renewable energy options to replace or offset at least 20% of our energy usage.
- Expand our employees' involvement in projects that strengthen our communities.
- Keep adding to this list.

SOURCES:

Brown Spread: Current Relate/Sum carton is 39.75" tall. 400 blanket-wrapped chairs per truckload. Calculation: $39.75" \times 400 \text{ chairs} = 15,900"$. $15,900" \div 12" = 1,325'$. The John Hancock Center at 875 N. Michigan Ave. in Chicago is a 1,127-foot tall skyscraper designed by structural engineer Fazlur Khan of Skidmore, Owings and Merrill.

Blue Spread: Land covers 29.22% of the earth's surface, or about 57.5 million square miles (149 x 106 square kilometers). Water covers the other 70.78% of the earth's surface, or about 139.4 million square miles (361 x 106 square kilometers) [<http://www.enotes.com/science-fact-finder/earth/how-much-earths-surface-land-how-much-water>]. Over 99% of all water (oceans, seas, ice, most saline water, and atmospheric water) is not available for human use. [<http://ga.water.usgs.gov/edu/earthwherewater.html>]. One approach to water intake is the "8 x 8 rule" – drink eight 8 oz. glasses of water or fluid per day (about 1.9 liters) [<http://www.mayoclinic.com/health/water/NU00283>]. Calculation: 8 glasses of water x 8 oz. = 64 oz. or .5 gallons/day. The water saved annually with Allsteel's reverse-osmosis systems is 1.8 million gallons. $1,800,000 \text{ gallons} \div .5 \text{ gallons} = 3,600,000$. The annual water needs for an individual is 182.5 gallons (.5 gallons x 365 days). $1,800,000 \text{ gallons} \div 182.5 \text{ gallons} = 9,863$. This equates to drinking water needs of 3.6 million people for one day or 9,800 people for one year.

Yellow Spread: Allsteel's two solar sunflowers produce approximately 3,000 kWh annually. The average DVD player uses .04 kW/hour. [<http://www.otpco.com/SaveEnergyMoney/applianceEnergyUsage.asp>]. Calculation: The solar sunflowers produce enough energy for 75,000 hours of viewing time ($3,000 \div .04$). *An Inconvenient Truth* is 100 minutes long. The movie can be viewed 45,000 times in one year ($75,000 \text{ hours} \times 60 \text{ minutes} = 4,500,000 \text{ minutes} \div 100 \text{ minutes} = 45,000$).

All CO₂ calculations made using EPA methods.



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Allsteel supports green initiatives in the contract furniture industry as a member of the U.S. Green Building Council. All Allsteel products are SCS Indoor Advantage or Indoor Advantage Gold certified.

