

Knoll Environmental Timeline

Our mission is to manufacture affordable, well-designed office furnishings in the most environmentally responsible way.

- 1978** › Knoll hires full-time environmental engineer and redesigns waste water treatment plant at East Greenville facility, reducing harmful effluents.
 - › Introduces powder coating technology with no heavy metal pigments on Bertioia Chair and other seating.
- 1979** › Initiates Clean Technology approach. Partners with vendors to eliminate contaminants at the source.
- 1982** › Introduces water-saving counter-float system for power washes.
- 1984** › Sets goal to eliminate VOCs from all manufacturing operations.
- 1985** › Initiates use of water-based glues to replace VOC-emitting solvent-based glues in systems production.
- 1986** › Develops resins and processes for converting solvent-based paint spraying to powder coating for all metal products. Reduces material waste by up to 80% and eliminates 99% of metal-coating VOCs
- 1987** › Replaces emission-producing adhesives with non-polluting hot melt glues in seating manufacturing.
- 1988** › Becomes first OEM in Pennsylvania to adopt HVLP (high volume/low pressure) equipment for spraying water-based paints, which is now an industry and EPA standard.
 - › Hires consulting firm to begin testing office furniture emissions.
- 1990** › Submits major products for voluntary emissions testing by Air Quality Science.
- 1992** › Eliminates use of ODM's (ozone depleting materials) from all manufacturing processes worldwide.
- 1993** › Joins Green Lights initiative, replaces large portion of existing lighting in facilities with energy-efficient solutions.
 - › Bulldog chair developed and manufactured for clean technology from start to finish, including returnable and reusable packaging.
- 1994** › Invests \$3.5 million in UV-cured curing systems used in Toronto and East Greenville facilities for clear-coating veneer panels.
 - › Awarded Pennsylvania Governor's Waste Minimization Award.

- 1995**
 - › East Greenville facility 65.5% below Pennsylvania state standards for VOC emissions. Grand Rapids facility so far below EPA standards it doesn't have to report.
 - › Gehry Seating introduced: product offered with an option of maple grown by the Menominee Tribal Enterprise, a sustained yield wood source.
 - › Reclaimed red birch obtained from logs sunk in 19th century Midwest logging operations added to wood veneer options, as available.

- 1996**
 - › Virtually all scrap metals, cardboard and paper in all manufacturing facilities recycled.
 - › Sponsors art contests in Pennsylvania and Michigan to raise environmental awareness among grade school children.
 - › First major OEM to make panel fabrics from 100% producer-colored polyester fibers (completely recyclable, benign pigments, no effluents).

- 1997**
 - › Adds Terratex™ fabrics to textile line, made of 100% recycled PEP from soda bottles.
 - › Knoll featured in study and report on American Green Companies published by the Swedish Office of Science and Technology.
 - › KnollStudio offers sustainable wood and veneers as option on selected products.
 - › Use of returnable packaging expanded to all United States manufacturing facilities.

- 1998**
 - › Knoll the first U.S. OEM to receive ISO14000 Standard for Environmental Management Systems certification.
 - › Knoll the seventh company in the state and first major OEM to win designation as a Michigan Clean Corporate Citizen.
 - › All hardwoods used in Knoll products harvested from North American managed forests.
 - › Established minimums for recycled content in manufacture. Steel: weighted average 25%; Particleboard: 30% (averages 50% today, 100% in Ref, Equity and Dividends).

- 1999**
 - › After four years of development and an investment of \$2 million, Knoll introduces powder-on-wood finishing technology, reducing material waste and further reducing VOC emissions.
 - › EPA publishes case study on Knoll environmental initiatives.

- 2001**
 - › Receives Environmental Excellence Award from North York Chamber of Commerce, Toronto, Canada.

- 2002**
- › Knoll becomes a founding sponsor of Green Design Education Initiative. GDEI provides information and education on green/sustainable design to the profession.
 - › Receives IDEX/Neocon Canada Sustainable Design Gold Award for Life chair.
 - › Knoll REFF included in Hewlett Foundation project-only the fifth in the nation to receive a USGBC Gold level LEED (Leadership in Energy and Environmental Design) 2.0 certification.
 - › ISO 14001 certification awarded for all Knoll manufacturing facilities worldwide.
 - › LEED® Gold certification in Existing Building Pilot Program awarded to Knoll Lubin manufacturing facility in East Greenville, PA.
 - › GREENGUARD™ certification achieved for all Knoll North America systems, seating, KnollStudio seating and KnollTextiles.
 - › Knoll Environment launched as link on the website for info on Knoll environmental action.
 - › Knoll U.S. manufacturing facilities more than 90% HAP and VOC free.
 - › Knoll FSC-certified Reff furniture chosen by NRDC for its LEED® Platinum Santa Monica Regional Office.
- 2003**
- › Receives Chain of Custody certification for FSC–certified wood products.
 - › All KnollTextiles GREENGUARD™ certified.
 - › All Knoll systems, office seating and Knoll Studio seating GREENGUARD™ certified.
 - › Knoll's San Francisco showroom currently under renovation as pilot project for LEED® Commercial Interiors certification.
 - › Knoll Lubin facility in East Greenville accepted into pilot program for LEED® Existing Building certification.
- 2005**
- › ISO 14001 audit approval for all Knoll manufacturing facilities worldwide under revised 2004 standard.
 - › LEED® Silver certification awarded to the Knoll San Francisco showroom in the Commercial Interiors Pilot Program.
 - › Core office in LEED® Gold Lubin manufacturing facility upgraded, following LEED® criteria for Commercial Interiors.
 - › Knoll East Greenville facility designated an OSHA VPP Star site in recognition of exceptional health and safety programs for employees.
 - › Knoll participates in development of the MTS Sustainable Textile Standard, which sets the international benchmark for sustainable textiles.
 - › More than 90% of wood used to make composite board products contained an average of 93% post-industrial material.

- 2006**
- › Environmental data bases for Knoll systems and seating completed; help clients plan sustainable projects and achieve LEED® credits.
 - › Knoll participates in Clinton Global Initiative Annual Meeting, joins Chicago Climate Exchange (CCX®) and successfully meets Phase I (2003-2006) requirements.
 - › Knoll establishes an Energy Management Program.
 - › Knoll partners with non-profit International Design Center for the Environment (IDCE) to begin development of an affordable, universal computer-based Life Cycle Analysis (LCA) tool to support sustainability in product design and manufacture.
 - › Knoll partners with Market Transformation to Sustainability (MTS) and BIFMA to establish sustainability standards for the Contract Furniture Industry.
- 2007**
- › In its commitment to the Chicago Climate Exchange (CCX), Knoll exceeds required reductions in CO2 emissions.
 - › Knoll initiates projects designed to achieve energy efficiencies in lighting, power wash processes and HVAC in all facilities, projecting CO2 reductions of 500-600 tons by the end of the year.
 - › Knoll converts 45% of lighting in its manufacturing space to high efficiency fluorescent lighting.
 - › Knoll achieves GREENGUARD® indoor air quality certification for KnollStudio Conference Tables. All KnollStudio products are now GREENGUARD-certified.
 - › Knoll creates a new Energy Manager position to develop a systematic plan for implementing ongoing energy reductions throughout all company facilities and operations.
- 2008**
- › In its commitment to the Chicago Climate Exchange (CCX), Knoll exceeds required reductions in CO2 emissions.
 - › Life and Chadwick chairs receive SMaRT Gold Certification.
 - › Knoll partners with The Rainforest Alliance to audit and administer its FSC chain-of-custody certifications and leverage the Company's power with suppliers to increase the long-term supply of FSC-certified wood.
- 2009**
- › Generation by Knoll® introduced: a lightweight, high-performance chair that is the first in the industry to be rated SMaRT Sustainable Platinum.
 - › Clinton Global Initiative Commitment continues with capital investments of more than \$2,000,000, increasing CO2 reductions beyond the 10% goal to 10.41% over the baseline.
 - › Knoll East Greenville facility a beta testing site for the Intu! Wireless Control System, a technology innovation that utilizes lighting fixtures as a vector for energy saving command and control.
 - › Leadership in Clean Technology advanced with Plaforization, an innovative process for the pre-treatment of metal parts that utilizes a non-VOC, non-evaporating liquid polymer, eliminating toxic sludge and saving one million gallons of water per year.
 - › 15th anniversary of The Knoll 8: the principles at the heart of the Environmental Management Program that continues to move the Company toward a sustainable future.
 - › Knoll establishes FSC® certified wood as the standard for general office open plan systems, casegoods and tables.