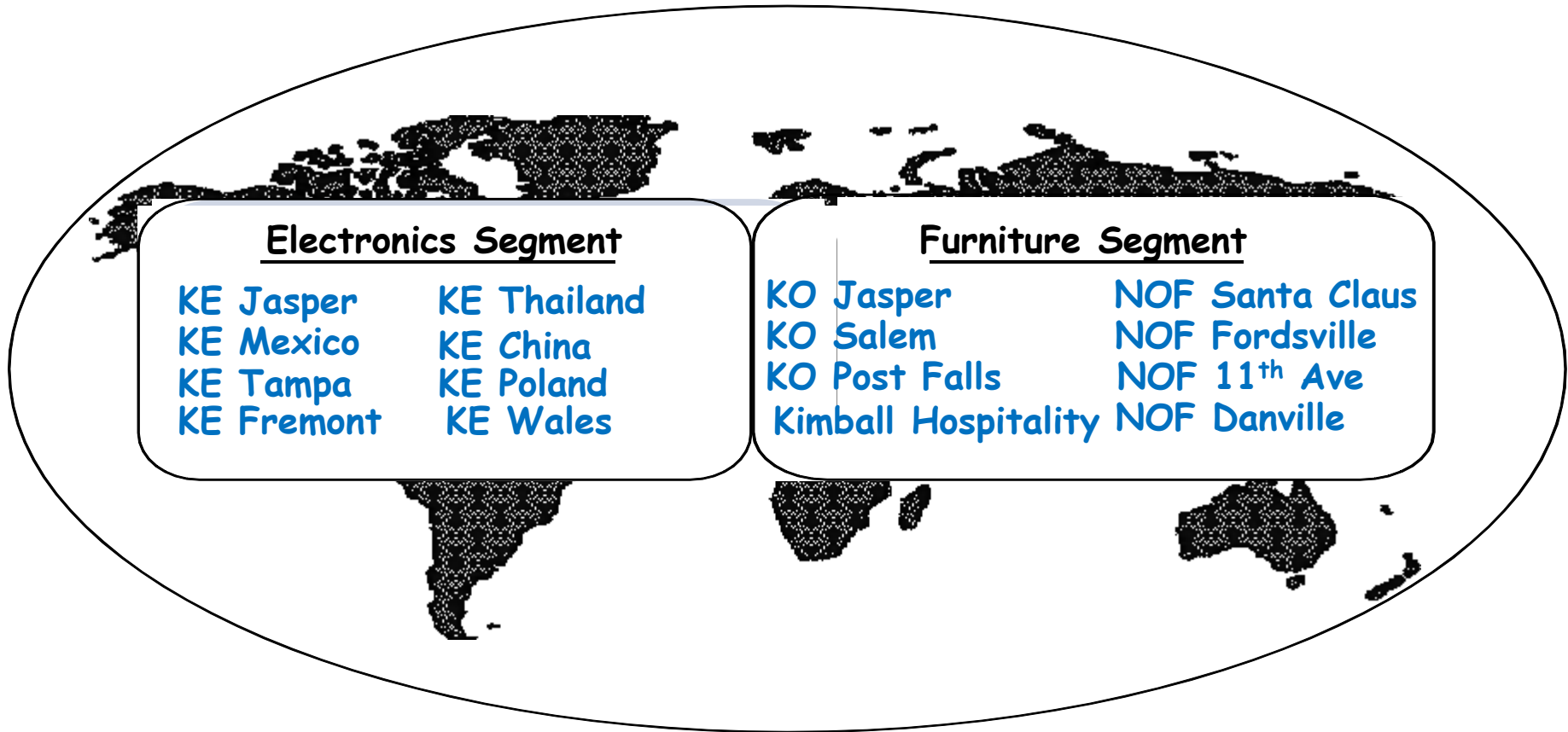


Kimball International , Inc.



Sustainability at Kimball International

- **Sustainable Practices have always been a part of Kimball's Culture. These practices were informal and were not implemented on a consistent basis.**
- **To create a Culture of Sustainability throughout the Kimball Organization a formal Environmental Management System had to be developed.**

Development of 14001 Environmental Management Systems

- **Corporate Directive to develop an Environmental Management System Template**

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- **Decision by Corporate and the Management Teams at Kimball Electronics & Furniture Groups to pattern the EMS Template after the ISO 14001:2004 standard**
- **A team of 16 Environmental Managers was formed & ISO 14001 training conducted by Purdue.**

Development of 14001 Environmental Management Systems (cont)

- **Divided the main team into 2 teams to take on separate Sections of the ISO 14001 standard and create language for the EMS.**

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- **Draft language of these Sections was presented to the entire team, revised and approved.**
- **Once the EMS Template was completed Work Instructions and Environmental Aspects were drafted. These were based on a facility having the most Impacts to the Environment; boiler, dust collection, metal painting, metal cleaning, wood working, and gluing processes.**

Development of 14001 Environmental Management Systems (cont)

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Development of 14001 Environmental Management Systems (cont)

- **Implementation of the EMS Template was conducted at the same facility to surface all issues.**
- **Implementation of the Template was then conducted at 8 additional locations during a 1 year time table.**
- **Third party ISO 14001 registrations were accomplished within 4 months for the 9 locations. Currently there are 14 locations ISO 14001 registered.**
- **The EMS Template has been recognized globally with ISO 14001 registration at Kimball's China, Thailand, Poland, Wales, and Mexico locations.**

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- **Total Annualized Cost Savings realized was just over \$2,000,000**

Sustainability Metrics

Category	Measure	Calendar Year 2008	Calendar Year 2009	% Reduction or (increase)
Air Quality	<u>Tons of VOC Emissions</u>	875 Tons	505 Tons	42%
	<u>Pounds of VOC Emissions per Unit of Production</u>	0.031 Pounds per Unit of Production	0.011 Pounds per Unit of Production	64%
Green House Gases	<u>Metric Tons of GHG</u>	107,538 Metric Tons	84,539 Metric tons	21%
	<u>Pounds of GHG emissions per Unit of Production</u>	4.21 Pounds per Unit of Production	2.03 Pounds per Unit of Production	52%

Sustainability Metrics

Category	Measure	Calendar Year 2008	Calendar Year 2009	% Reduction or (increase)
Water Quality	<u>Gallons of Water Used</u>	53,403,633 Gallons	43,704,539 Gallons	18%
	<u>Gallons of Water Used per Unit of Production</u>	0.949 Gal per Unit of Production	0.477 Gal per Unit of Production	50%
Landfill Diversion	<u>Tons of Solid Waste Disposal Generated</u>	2920 Tons	2094 Tons	28%
	<u>Pounds of Solid Waste Disposal Generated per Unit of Production</u>	0.104 Pounds per Unit of Production	.046 Pounds per Unit of Production	56%
	<u>Solid Waste Recycled as Percentage of Total Solid Waste Generated</u>	83 % recycled	87 % Recycled	4% increase