



EARTH FRIENDLY MATERIALS

Herman Miller continually works to minimize the environmental impact of its materials while maximizing product quality. Following are key materials, methods, and policies that are helping the Materials program at Herman Miller do the right things for the earth as well as our customers.

Textiles

Several factors affect the environmental impact of fabrics. Among these are recyclability, recycled content, dyeing processes, and the cut and fit of the fabric to product. To be recyclable, fabric must be composed of a single material. Most of Herman Miller's fabric offering already meet this criterion. Additionally, Herman Miller avoids textiles with additives or backings that might render the fabric nonrecyclable. Knit-to-size fabrics on chairs minimize fabric waste. Some fabrics are solution dyed, a process yielding less waste than other coloring techniques and using less energy.

Systems Textiles

Kira fabric is a proprietary Herman Miller systems fabric that's derived from corn. As a biological nutrient, it can be quickly composted and go back into the soil at the end of its useful life. Kira contains no petroleum content. Its quality and performance are identical to those associated with conventional fabrics. Kira meets Greenguard requirements.

Fabric Name	HMI Part #	Fiber Content (by weight)
Kira	5D00 Series	100% Ingeo™ PLA Fiber

The following vertical surface (panel) fabrics are made from either recycled polyester or wool. Wool is a renewable resource; the wool in our fabrics is processed on energy-efficient looms that produce high-quality fabric with less raw material. Beyond its renewable aspects, wool absorbs significantly more airborne environmental toxins than nylon, polyester, or acrylic. And at the end of its life cycle, wool can be recycled or composted.

Fabric Name	HMI Part #	Fiber Content (by weight)
<i>Proprietary Textiles</i>		
Bento	7000 Series	100% Antimony-free Polyester
Chain	2V00 Series	100% Post-consumer Recycled Polyester
Coil	8500 Series	100% Pre-consumer Recycled Polyester
Cord	5100 Series	52% Antimony-free Polyester 48% Virgin Polyester
Crepe	9200 Series	100% Pre-consumer Recycled Polyester
Crossing	8T00 Series	100% Pre-consumer Recycled Polyester
Flannel	6400 Series	100% Wool
Frost	5700 Series	100% Pre-consumer Recycled Polyester
Glaze	8Z00 Series	100% Pre-consumer Recycled Polyester
Grasscloth	2I00 Series	28% Pre-consumer Recycled Polyester 72% Post-consumer Recycled Polyester
Grosgrain	8400 Series	100% Pre-consumer Recycled Polyester
Horizon	4N00 Series	65% Antimony-free Polyester 35% Virgin Polyester
Luminary	2U00 Series	58% Pre-consumer Recycled Polyester 42% Post-consumer Recycled Polyester
Magnolia	1W00 Series	48% Pre-consumer Recycled Polyester 52% Post-consumer Recycled Polyester
Maia	1Y00 Series	39% Pre-consumer Recycled Polyester 61% Post-consumer Recycled Polyester
Moiré	3A00 Series	45% Pre-consumer Recycled Polyester 55% Post-consumer Recycled Polyester
Penumbra	1Z00 Series	68% Pre-consumer Recycled Polyester 32% Post-consumer Recycled Polyester

Fabric Name	HMI Part #	Fiber Content (by weight)
<i>Proprietary Textiles - continued</i>		
Quilty	6S00 Series	100% Antimony-free Polyester
Railroad	8V00 Series	94% Pre-consumer Recycled Polyester 6% Post-consumer Recycled Polyester
Savannah	8L00 Series	58.5% Pre-consumer Recycled Polyester 17.5% Post-consumer Recycled Polyester 24% Polypropylene
Silkworm	2M00 Series	58% Pre-consumer Recycled Polyester 42% Virgin Polyester
Sironetta	6300 Series	45% Pre-consumer Recycled Polyester 55% Post-consumer Recycled Polyester
Slideshow	2Z00 Series	56% Pre-consumer Recycled Polyester 44% Virgin Polyester
Soba	6700 Series	100% Antimony-free Polyester
Strands	8W00 Series	100% Pre-consumer Recycled Polyester
Tape	4300 Series	48% Pre-consumer Recycled Polyester 52% Polypropylene
Twist	8R00 Series	100% Pre-consumer Recycled Polyester
Udon	6800 Series	100% Antimony-free Polyester
Violetta	1V00 Series	40% Pre-consumer Recycled Polyester 60% Post-consumer Recycled Polyester
<i>Textile Alliance Program (TAP) Textiles</i>		
Chenille Rib	VP00 Series	41% Post-industrial Recycled Polyester 10% Post-consumer Recycled Polyester 49% Virgin Polyester
Constellation	TV00 Series	100% Recycled Polyester
Flip	TS00 Series	78% Post-industrial Recycled Polyester 22% Post-consumer Recycled Polyester
Linea	VL00 Series	100% Recycled Polyester
Messenger	TI00 Series	78% Post-industrial Recycled Polyester 15% Virgin Polyester 7% Nylon
Parallel	TT00 Series	78% Post-industrial Recycled Polyester 22% Post-consumer Recycled Polyester
Quad	V300 Series	79% Post-industrial Recycled Polyester 21% Post-consumer Recycled Polyester
Season	ZP00 Series	100% Post-industrial Recycled Polyester
Stars	T400 Series	100% Recycled Polyester
Twilight	VJ00 Series	68% Recycled Polyester 32% Xorel
Whimsy	VK00 Series	67% Recycled Polyester 33% Polyester
<i>Open Line Textiles</i>		
Bailey	8700 Series	100% Recycled Polyester
FR 701	9400 Series	100% Post-consumer Recycled Polyester
Vertical Surface Blends	4900 Series	100% Post-consumer Recycled Polyester
Vertical Surface Solids	3800 Series	100% Post-consumer Recycled Polyester

Seating Textiles

The following seating fabrics are made from recycled polyester or wool. Wool is a renewable resource; the wool in our fabrics is processed on energy-efficient looms that produce high-quality fabric with less raw material. Beyond its renewable aspects, wool absorbs significantly more airborne environmental toxins than nylon, polyester, or acrylic. And at the end of its life cycle, wool can be recycled or composted.

Proprietary Textiles

Bento	7000 Series	100% Antimony-free Polyester
Checkmate	5G00 Series	100% Pre-consumer Recycled Polyester
Coil	8300 Series	100% Pre-consumer Recycled Polyester
Crepe	9200 Series	100% Pre-consumer Recycled Polyester
Crossing	8T00 Series	100% Pre-consumer Recycled Polyester
Moiré	3A00 Series	45% Pre-consumer Recycled Polyester 55% Post-consumer Recycled Polyester
Quilty	6500 Series	100% Antimony-free Polyester
Railroad	8V00 Series	94% Pre-consumer Recycled Polyester 6% Post-consumer Recycled Polyester
Slideshow	2Z00 Series	56% Pre-consumer Recycled Polyester 44% Virgin Polyester
Spools	8Y00 Series	45% Pre-consumer Recycled Polyester 6% Post-consumer Recycled Polyester 49% Virgin Polyester
Square Peg	3B00 Series	100% Pre-consumer Recycled Polyester
Twist	8R00 Series	100% Pre-consumer Recycled Polyester

Textile Alliance Program (TAP) Textiles

Clue	V800 Series	100% Recycled Polyester
Crux	V600 Series	8% Recycled Polyester 92% Virgin Polyester
Divina	TF00 Series	100% Wool
Divina Melange	TG00 Series	100% Wool
Jest	TJ00 Series	100% Recycled Polyester
Messenger	TI00 Series	78% Post-industrial Recycled Polyester 15% Virgin Polyester 7% Nylon
Query	VY00 Series	100% Recycled Polyester
Stars	T400 Series	100% Recycled Polyester
Waterfront	V200 Series	100% Pre-consumer Recycled Polyester
Whimsy	VK00 Series	67% Recycled Polyester 33% Virgin Polyester

Knit-to-Size

The following fabrics are knit-to-size fabrics on chairs which offer another earth-friendly benefit in that they minimize fabric waste. Rather than being cut and sewn, these upholstery fabrics are knit to the desired shape. This streamlined processes also results in energy savings.

Plateau	6J00 Series	100% Virgin Polyester
Trifle	5Y00 Series	100% Virgin Polyester

Finishes and Wood

Herman Miller continually works to minimize the environmental impact of its materials while maximizing product quality. Following are key materials, methods, and policies for finishes that are helping the Materials program at Herman Miller do the right things for the earth as well as our customers.

Water-Based Stains

A switch from solvent- to water-based stains on all standard veneers has yielded greater color consistency and fewer volatile organic compounds (VOCs). This change was in keeping with Herman Miller's commitment to use a complete water-based veneer finishing system.

Sustainable Wood Supplies

Since 1991, Herman Miller has purchased woods coming only from sustainable supplies. To qualify, the wood cannot be harvested faster than it is being replenished. Herman Miller verifies sustainability of its wood supplies by working closely with suppliers.

Powder Coat

Powder-coat finishes have been used on metal parts for some time. Today, powder-coat finishes are also applied on wood work surfaces. Called Formcoat, the powder-coated epoxy is baked onto a medium-density fiberboard substrate for a smooth, seamless, and durable surface. This technique eliminates volatile organic compounds (VOCs), makes product renewal and recycling easier, and allows a more streamlined manufacturing process.

Autodeposition

A state-of-the-art metal finishing system uses autodeposition, a process that uses chemical reactions instead of electrical energy to apply a coating containing no toxic or heavy metals. Autodeposition uses less energy, minimizes solid waste, and yields very low or no VOCs.