



## EARTH FRIENDLY MATERIALS

Herman Miller continually works to minimize the environmental impact of its fabrics, materials, and finishes while maximizing product quality. Following are key materials, methods, and policies that are helping the Color/Materials/Finishes (CMF) 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 by a domestic supplier 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>		
Crackle	5R00 Series	59% Post-industrial Recycled Polyester 41% Post-consumer Recycled Polyester
Crepe	9200 Series	100% Post-industrial Recycled Polyester
Flannel	6400 Series	100% Wool
Grasscloth	2I00 Series	28% Post-industrial Recycled Polyester 72% Post-consumer Recycled Polyester
Heathered Flannel	8J00 Series	100% Wool
Leaf	5W00 Series	80% Wool 20% Nylon
Luminary	2U00 Series	58% Post-industrial Recycled Polyester 42% Post-consumer Recycled Polyester
Magnolia	1W00 Series	48% Post-industrial Recycled Polyester 52% Post-consumer Recycled Polyester
Maia	1Y00 Series	39% Post-industrial Recycled Polyester 61% Post-consumer Recycled Polyester
Mezzotint	4V00 Series	53% Post-industrial Recycled Polyester 47% Post-consumer Recycled Polyester
Moiré	3A00 Series	45% Post-industrial Recycled Polyester 55% Post-consumer Recycled Polyester
Penumbra	1Z00 Series	68% Post-industrial Recycled Polyester 32% Post-consumer Recycled Polyester
Prairie	6E00 Series	100% Post-consumer Recycled Polyester

<b>Fabric Name</b>	<b>HMI Part #</b>	<b>Fiber Content (by weight)</b>
<i>Proprietary Textiles - continued</i>		
Rapunzel	6000 Series	100% Wool
Silkworm	2M00 Series	58% Post-industrial Recycled Polyester 42% Virgin Polyester
Sironetta	6300 Series	45% Post-industrial Recycled Polyester 55% Post-consumer Recycled Polyester
Slideshow	2Z00 Series	56% Post-industrial Recycled Polyester 44% Virgin Polyester
Thatch	5Q00 Series	59% Post-industrial Recycled Polyester 41% Post-consumer Recycled Polyester
Violetta	1V00 Series	40% Post-industrial Recycled Polyester 60% Post-consumer Recycled Polyester
<i>Textile Alliance Program (TAP) Textiles</i>		
Constellation	TV00 Series	100% Recycled Polyester
Flip	TS00 Series	88% Post-industrial Recycled Polyester 12% Post-consumer Recycled Polyester
Frequency	ZR00 Series	100% Post-industrial Recycled Polyester
Messenger	TI00 Series	78% Post-industrial Recycled Polyester 15% Virgin Polyester 7% Nylon
Parallel	TT00 Series	88% Post-industrial Recycled Polyester 12% Virgin Polyester
Quad	V300 Series	100% Recycled Polyester
Season	ZP00 Series	100% Post-industrial Recycled Polyester
Stars	T400 Series	100% Recycled Polyester
<i>Open Line Textiles</i>		
Bailey	8700 Series	100% Recycled Polyester
FR 701	9400 Series	100% Post-consumer Recycled Polyester
Heather	8700 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 by a domestic supplier 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***

Crepe	9200 Series	100% Post-industrial Recycled Polyester
Hopsak 2™	8D00 Series	100% Post-industrial Recycled Polyester
Leaf	5W00 Series	80% Wool 20% Nylon
Moiré	3A00 Series	45% Post-industrial Recycled Polyester 55% Post-consumer Recycled Polyester
Rapunzel	6000 Series	100% Wool
Square Peg	3B00 Series	100% Post-industrial Recycled Polyester
Slideshow	2Z00 Series	56% Post-industrial Recycled Polyester 44% Virgin Polyester

#### ***Textile Alliance Program (TAP) Textiles***

Divina	TF00 Series	100% Wool
Divina Melange	TG00 Series	100% Wool
Messenger	TI00 Series	78% Post-industrial Recycled Polyester 15% Virgin Polyester 7% Nylon
Stars	T400 Series	100% Recycled Polyester
Waterfront	V200 Series	100% Post-industrial Recycled Polyester

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. Additionally, some fabrics are solution dyed, a process yielding less waste than other coloring techniques. Streamlined processes like these also result in energy savings.

#### ***Perspectives® Collection***

Labyrinth	5U00 Series	100% Virgin Polyester
Plateau	6J00 Series	100% Virgin Polyester
Trifle	5Y00 Series	100% Virgin Polyester

## **Materials and Finishes**

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

### **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.

### **Water-Based Stains**

A switch from solvent- to water-based stains on all standard veneers has yielded greater color consistency and fewer VOCs. This change is in keeping with Herman Miller's goal to be the first furniture manufacturer using a complete water-based veneer finishing system.

### **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.

### **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, including staff members' review of logging sites to inspect harvesting practices.

To reorder, contact your Herman Miller sales office or dealer.  
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