

# Kimball®Office



**Rhonda Scherer**  
**Safety / Environmental Manager**  
**Kimball Office – Jasper**



## **Reducing Environmental Impacts**

During the year 2009 Kimball Office focused on many Significant Environmental Aspects as process improvements activities developed.

Each facility evaluated processes that impacted the environment and worked to reduce or eliminate the impact.

In 2009 Kimball Office achieved 14 goals associated with identified Significant Environmental Aspects (SEAs).

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## Reduce Air Emissions

UV Clear coat application  
Flat line application of clear  
coat

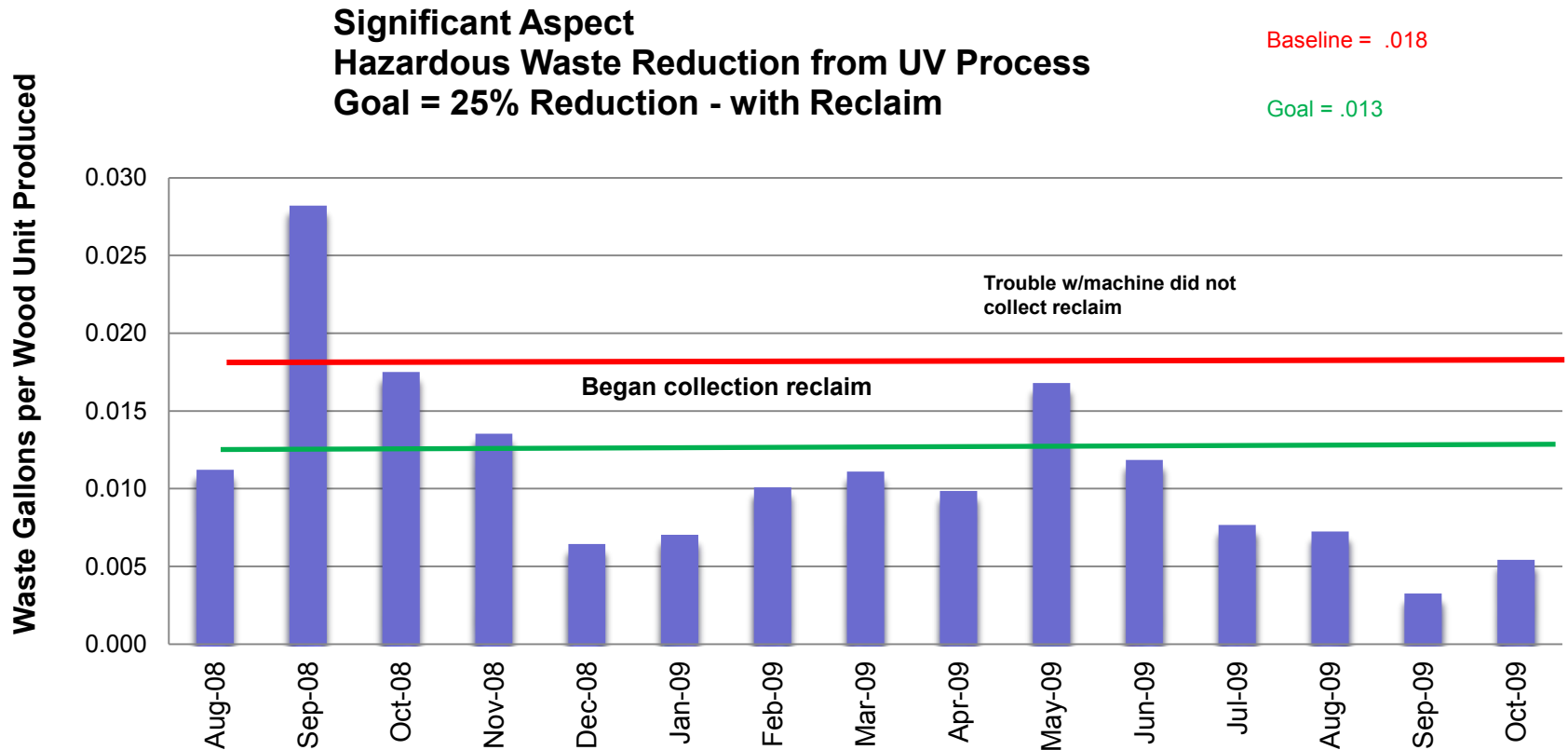


- Reduced VOCs by 35% from clear coat operations and saved approximately \$1175.00 in air permit fees.
- Reduced Formaldehyde from clear coating operations by 79%.  
Reduced from .0008 lbs to .0001 lbs per unit produced.
- Reduced VOCs from High solids paint by 100% - converted metal painting to powder Coat.

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## Hazardous Waste Reduction

Began reclaiming UV waste material from automatic spray operations, saving \$182,000 from decreased Hazardous Waste and material cost.

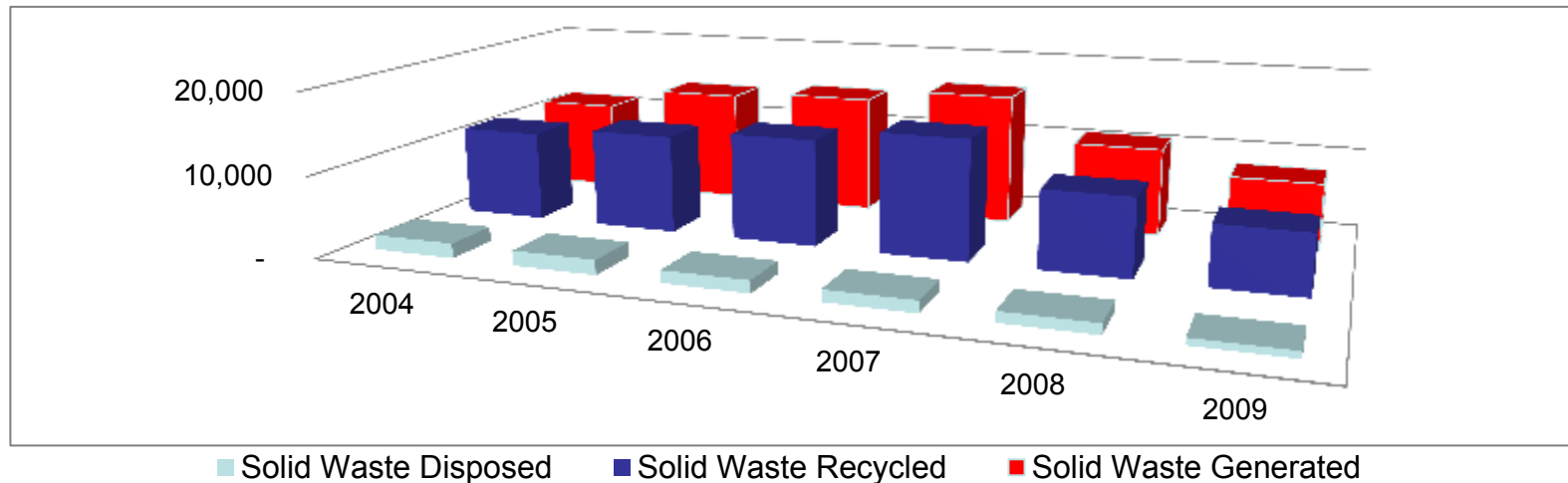


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## Recycling Efforts

|                              | 2004   | 2005   | 2006   | 2007   | 2008   | 2009  |
|------------------------------|--------|--------|--------|--------|--------|-------|
| <b>Solid Waste Disposed</b>  | 1,805  | 1,814  | 1,517  | 1,441  | 1,280  | 816   |
| <b>Solid Waste Recycled</b>  | 11,124 | 12,135 | 13,146 | 14,753 | 9,603  | 7,367 |
| <b>Solid Waste Generated</b> | 11,302 | 13,949 | 14,663 | 16,194 | 10,883 | 8,183 |

**KO WASTE AND RECYCLING SUMMARY (tons)**



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## **Other Achievements in Reducing Environmental Impacts**

- Reduced electrical consumption by up to 10% for an annual cost savings of \$100907.76
- Reduced Hazardous Waste Generation by .5% per unit produced.
- Reduced Hazardous Waste from the UV process by 53% for an annual cost savings of \$20142.20
- Increase material efficiency by 25% with implementation of the UV process for a cost savings of \$171576.24
- Divert waste to the landfill through recycling program. Achieved a 91% recycling rate, for a cost savings of \$69959.85
- Reduce monthly wastewater usage by 10,400 gallons per day for an annual savings of \$2064.00