

Chloro fluoro carbons

As you know, a protective filter known as the ozone layer surrounds the earth and acts as a barrier from the sun's harmful rays. Almost every spring since 1982, massive holes in the ozone are detected in the Antarctic. Scientists now agree that Chlorofluorocarbons (CFC's) have been a major contributor to this hole and the further depletion of the ozone layer. In response to this impending crisis, the Canadian government's "Montreal Protocol" established 1996 as the deadline for the elimination of the use of CFC's and was adopted internationally as a target date.

At Global, we were cheering the government's efforts. Why? Because we had already recognized the dangerous environmental impact of CFC's. As a matter of fact, we had eliminated their use from our foam moulding plant in 1993! In doing so, we were one of the first manufacturers of moulded foam in North America to institute ozone-friendly processes.

At Global, we continue to lead the way with new earth-friendly technologies.



RT Technology

RT Technology was started in 1989 as a way for Global to reduce the wood & plastic waste sent to landfill by turning them into new parts for Global Chairs. RT Technology has continually expanded its product line and increased production levels.

The facility currently accepts over 544 metric tons of wood waste and 1224 metric tons of recycled plastic per year. This is waste that would have gone to landfill. This waste is recycled into usable chair products throughout Global. Any scrap generated on site is also reground and used again. This facility is a great example of Global's environmental stewardship.

RT technology facility is environmentally friendly and it makes good business sense.





The Global Group has adopted an environmental logo to represent our on-going environmental achievements and initiatives.

Our logo depicts the Global Total Office corporate logo surrounded by a bird. We designed this image to represent the symbiotic relationship between our company, the global environment and our commitment to keep the environment clean.

qualityvalueservice

THE GLOBAL GROUP

Embracing Global Change

At Global we believe that it is our responsibility to protect the environment for future generations. The growing importance of energy and environmental concerns continues to challenge us in this ever-changing marketplace.

As an industry leader, The Global Group continues to take proactive steps towards reducing the negative impacts on the environment. We are building "healthier" offices; investing in R& D and new technologies; reducing waste and the consumption of energy; and improving the quality of the air we breathe, all which can have a significant impact on our quality of life.

In August 2001, samples of Global chairs were sent to Air Quality Sciences (AQS), an independent test facility in Atlanta Georgia, for testing to stringent off-gassing test protocols in an environmental chamber. The net result of these tests was that on 12 November 2001, AQS listed a total of 114 chair series from Global Upholstery in their GREENGUARD™ Product Guide. (GREENGUARD™ Provides the world's only guide to certified low emitting interior products and building material).

Other significant environmental initiatives include:

- *Eliminated ozone-damaging Freon, CFC's and HCFC's as blowing agents from our molded polyurethane parts*
- *Maximizing the use of powder paint finishes on metal parts at our production facilities*
- *Focusing on the environmental performance throughout the product life cycle, the environmental impact of our product packaging and the use of recycled and recyclable materials in our manufacturing processes*
- *Global's seating line is listed on a U.S.-based web site for environmentally preferred products (www.greenguard.org)*

Protecting the next generations' environment is of paramount concern to Global. Through the guidance of the Global Group Environmental Management Committee, we continue to operate with the environment in mind, making wise business decisions that help protect Mother Earth and its precious natural resources.

Joel Appel

President



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Metal FINISHING



Since 1991, Global has used a powder paint coating process to produce beautiful finishes on chair and panel frames, filing products and storage cabinets. Powder coating provides a high quality finish with excellent chemical and corrosion resistance. It is also environmentally friendly.

How is it environmentally friendly?

- Global's products are powder coated with a durable epoxy polyester hybrid. The powder in its raw form is classified as non-hazardous.
- No solvents are used in the mixing, application or clean up stages of the powder coating process. This keeps the air free from toxins so that it can be recirculated.
- Powder coating is a waste-free process, eliminating the need to vent, filter or recover any solvents – very energy efficient.
- About 98 percent of the excess paint powder is reused eliminating waste.
- Most importantly, powder coating secures healthy working conditions for our employees!



CHAIR TESTING PROGRAM ANSWERS CUSTOMER CONCERNS

In response to customers' concerns about indoor office air quality, Global recently completed a major testing program of our chairs to ensure that they meet or exceed industry guidelines for indoor air quality.

The chairs that were selected for testing were representative of the entire Global Group seating line.

The test program involved placing chairs in an environmental chamber that passed air over the surface of the product. The air was then evaluated to determine the levels of Volatile Organic Compounds (VOC) and Formaldehyde emitted from the product.

All of the Global Group chairs that were tested exceeded the industry requirements for indoor air quality which means that all of our seating lines can be recognized (advertised) as low emitters of Formaldehyde and VOC 's.

Global Group seating products are now listed on a U.S.-based web site for environmentally preferred products. This site, which contains a link to Global Group's own web site, can be found at www.greenguard.org.

As new chairs are designed and developed, we will ensure that they too can be added to this list.

GLOBAL WOOD GROUP

The Global Wood Group was registered to ISO 14001 by KPMG Quality registrar on November 22, 1999.

The aspects focused on in our program are the 100% diversion of cardboard, wood waste and wood dust from landfill to recycling programs. Global Wood Group has also invested heavily in fire protection and explosion prevention, as this is a major risk in an operation such as ours.

Future programs will focus on reducing or recycling other types of waste and on the efficient use of energy.



WATER-BASED GLUE PROCESS NOW IN USE AT GLOBAL

Three years ago, Global Group initiated a project to find an effective, one-step, solvent-free glue to replace the current solvent-based adhesive used in Global's manufacturing processes.

Through a lot of dedicated work and trial and error, a new process was approved. In January 2002, Global Care became the first Global Group production unit to operate with a water-based glue line.



The process used to bond fabric to foam with water-based glue has superior bonding capabilities, which helps to improve the overall quality of Global products. As well, water-based glue dramatically reduces the chemicals used during the manufacturing process.

Water-based glue is cleaner for the environment, provides better working conditions for employees, and is more cost-effective than a solvent-based system.

Where applicable, the water-based glue process will be systematically implemented at all Global Group production units.



RECYCLING

The Global Wood Recycling and Reclamation program is the cornerstone of Global's environmental initiative as well as a major R&D achievement. Wood and plastic waste by-products from Global manufacturing facilities that were once destined for landfill sites are collected and shredded. Then they are mixed with a synthetic compound and molded into seat and back frames and a variety of other internal components. The resulting products feature exceptional strength, and at significantly lower costs than those manufactured from virgin material. At the same time, the process totally eliminates wood waste.



PACKAGING

We think about protecting the environment even while we're protecting our products!

All companies use shipping cartons and various kinds of packaging to protect their products during transport and storage ... and Global is no exception. At Global, however, we are committed to using only recycled cardboard for our shipping cartons. To be classified as "recycled," according to Environment Canada's Environmental Choice program, a product must contain at least 50% recycled material.

Did we meet the government's guidelines? Once again, we exceeded them! Global's shipping cartons contain at least 80% recycled material.

That's not all... Here are some other ways that Global's packaging programme preserves our environment:

- Global's shipping cartons are made of recycled paper. They too can be recycled.
- Our cartons are imprinted with water-based inks which do not use harmful solvents, or contain heavy metal pigment. These inks are easier to break down for recycling.
- Global will ship products blanket-wrapped, eliminating the need for cartoning altogether, whenever shipping distances are feasible for this transportation method.
- By using different-sized cartons, we are able to reduce the amount of packaging needed. Our packers choose the smallest box possible for each product.
- Global is shipping more and more chairs "knocked down". These chairs require a small amount of assembly but save 50-75% of cartoning space over fully assembled products.

A lot of small initiatives add up to one big environmental benefit!