

# Wood Excellence at Knoll

**Since its founding, Knoll has combined the natural warmth and durability of wood with clean, modern design. Over the past eight decades, Knoll has pushed the boundaries of wood furnishings.**

## 1973

Knoll introduced the Stephens Open Office Furniture System, the first system in the industry made of wood.

## 1980

Knoll introduced the Reff System. Knoll's ongoing commitment to enhancements has made Reff the contract industry's largest selling wood system today.

## 1992

Frank Gehry leveraged the inherent strength of ultra-thin, 1/32" maple strips to create the iconic Gehry Collection, virtually free of any metal fasteners.

## 2004

Knoll launched AutoStrada, the industry's first architecturally inspired wood based furniture system addressing requirements from the private office to the open plan—with one aesthetic and one set of planning principles.

## 2007

The Graham Collection was brought to market offering precision planning and broad flexibility in the Private Office with consideration for the principles of sustainable design. Built on the foundation of Knoll design excellence, the Graham Collection has a distinctive linear approach and modern perspective with the unassuming beauty of wood.

## 2009

All wood systems and case good products were consolidated at the Wood Center of Excellence facility in Toronto providing one wood finish palette for most Knoll products.

## 2010

The Reff System was significantly enhanced; Reff Profiles extended the Reff portfolio of workplace solutions to offer a greater degree of scalability, a broader range of aesthetic options and a higher level of personalization to better support today's work styles across a broad spectrum of client needs.

## 2017

Knoll offers new veneer finishing technology with a broad range of options, as well as improved clarity and sustainability.

## Broad Capabilities

### Industry-leading capacity:

- + Operating one of the largest wood working facilities in North America ensures we can handle any order size from a single office to the largest projects:
  - At 500,000 square feet, our wood production facility is the size of 11 football fields.
  - Our “custom-shop,” where shape components are produced, is the size of many of our competitors’ entire facilities.
- + Our lead-times are consistent, and typically 4 to 6 weeks less than traditional wood manufacturers.

### A tradition of custom solutions:

- + Custom product solutions are integral to our production philosophy. Our people, processes and equipment are all designed to support the creation of client specific solutions.
  - Supported by one of the industry’s most experienced engineering teams.
  - We can draw upon a library of more than 600 custom colors and thousands of solutions for specific customer needs, from the private office to the open plan.
  - Extensive options from which to choose.
- + Refr Profiles, AutoStrada, Dividends Horizon and Antenna Workspaces can be used individually or collectively to furnish a complete, aesthetically-integrated workplace, from open plan to private office.
- + A breadth of edge, leg and hardware options provide for personal expression.
- + Clients can choose from an extensive palette of Techwood veneers and domestic and premium natural veneers.

## Enduring Quality

### Fine materials and craftsmanship:

- + A well-trained, experienced workforce understands the nuances of wood:
  - Our associates bring a wealth of experience to the creation of our furniture. The average tenure throughout the plant is 10 years; in the custom shop our associates tenure is over 15 years.
  - A careful veneer lay-up process means that veneer is properly balanced on each component.

- + Knoll selects only the top 5% of architectural grade veneer:
  - AA Architectural Grade natural veneers are hand selected to showcase inherent natural grain characteristics.
  - On-site selection and hand lay-up on every component further ensures grain consistency and color matching.
- + Our products demonstrate a commitment to details:
  - Wood drawer interiors.
  - Dovetail joinery, with an inherently strong locking system.
  - Glue and dowel construction with no visible connection hardware.
  - High quality hardware, solid to the touch and designed to exceed stringent BIFMA standards.
  - Sophisticated manufacturing processes.

### Sophisticated manufacturing processes:

- + High speed core board saws, veneer slicers and stitchers minimize waste while ensuring optimal part sizes.
- + Automated manufacturing technologies ensure repeated consistency in fit and finish whether for one or one thousand offices.
- + Flat board construction processes ensure dimensional accuracy of each component, important for assembly and reconfiguration.

### Commitment to the life of the product:

- + All products are tested to exceed ANSI/BIFMA/CGSB performance standards.
  - Enhanced Knoll test standards for hardware, connectivity, load carrying capacity and finish durability assure long term service.
- + Our product design philosophies support forward and backward compatibility.
  - Purchases made today will be compatible with add-on and reconfiguration requirements in future.

## Environmental Commitment

**At Knoll's woodworking facility in Canada, sustainability is incorporated into everything we do:**

### Careful material selection:

- + In 2007, we introduced the Sustainable Wood Policy, an ambitious multi-year plan for wood sourcing:
  - Designed to protect the rain forest, since deforestation is one of the largest contributors to global warming.
  - Ensures that wood and food fiber is obtained from environmentally responsible sources.
  - States that Knoll will not obtain wood from sources known to violate civil rights, harvest from unmanaged forests, genetically modify forests or participate in illegal harvesting practices.
- + More than 90% of the wood used to make composite board products contains an average of 93% postindustrial wood.
- + In the 1970s, we pioneered the use of engineered veneers in the open plan and private office.
  - 100% natural wood blended from fast growing African Obeche (Oh-bee-chee) and poplar trees and processed into high quality Techwood.
- + Fabrics can be specified with 100% recycled content.

### Deployment of green technologies:

- + All glues and stains are water based, with virtually no VOC emissions.
- + Our water-based 'flat-line' finishing and UV curing processes have significantly less environmental impact than the more widely used spraying method (spraying wastes approximately 50% material and curing dispenses solvents into the air).
- + Wood waste seldom goes to a landfill:
  - Recycled for animal bedding
  - Used for energy—approximately 70% of our Toronto facility's heating and heat required for our finishing process comes from burning waste wood.
- + Ongoing energy efficiency programs:
  - Implementation of high efficiency lighting throughout plant.
  - Introduction of highly efficient motors for equipment.

### Third party certifications:

- + The Toronto facility is ISO 14001 certified.
- + All Knoll Office wood products are GREENGUARD® certified.
- + Reff Profiles, Antenna Workspaces, Dividends Horizon and AutoStrada are BIFMA level™ 3 certified.
- + Knoll manufacturing sites are chain of custody certified to handle and process FSC® (Forest Stewardship Council) certified wood - (FSC® C028824).
  - FSC®-certified (FSC® C028824) wood is standard on all Knoll office systems, casegoods and tables, with the exception of certain KnollStudio products.
  - Knoll was the first company in our industry to use FSC®-certified wood.
  - FSC certification provides chain of custody that wood bearing the FSC mark comes from forests that protect environmental, social and economic values.
- + Knoll has partnered with the Rainforest Alliance to consult on our wood programs:
  - The Rainforest Alliance's mission is to conserve biodiversity and ensure sustainable livelihoods.
- + Knoll wood furnishings can help clients achieve LEED credits for interiors, new and existing building construction projects as well as Living Building Challenge and WELL Building certifications.
- + Many of our customers have achieved their certification goals using Knoll furnishings:
  - FSC-certified Reff workstations and conference tables were chosen by the National Resources Defense Council for its LEED Platinum regional office building in Santa Monica.
  - Bank of America selected AutoStrada for its LEED Gold interiors at its New York City headquarters.
  - The USGBC (United States Green Building Council) chose Graham private office for its LEED Platinum headquarters in Washington, DC.

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## Additional Reference Materials

### From the Literature Distribution Center

- + Reff Profiles Brochure
- + AutoStrada Brochure
- + The Graham Collection Brochure
- + Knoll Private Office Brochure

### On knoll.com+

- + Knoll and Sustainable Design:
  - Reff LEED Credits
  - AutoStrada LEED Credits
- + Knoll and Environmental Sustainability:
  - Reff Profiles
  - AutoStrada
  - Key Focus Areas
- + Knoll Environment
  - The Key 8
  - Our Journey
- + Knoll Sustainable Wood Policy
- + Knoll Approved Wood Species for FSC Certification