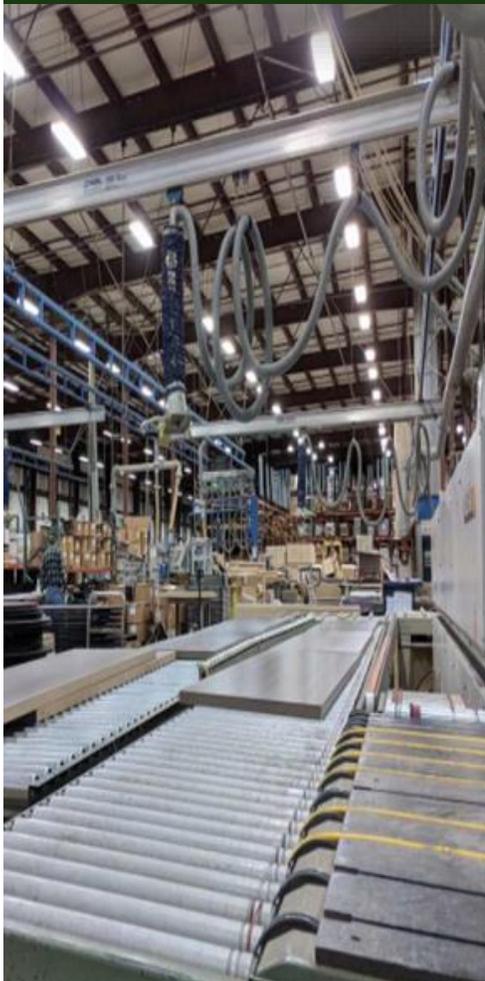


OFFICE FURNITURE MANUFACTURING



SEG's Continuous Energy Improvement Program:

- Program Charter drafted
- Cross Functional Energy Team formed
- 2.5% energy savings goal established
- Energy Awareness program developed
- Integrated Lean Manufacturing Tools Value Stream Mapping & Kaizen Event
- Regression Model reports Savings
- Employee engagement proces defined



Strategic Energy Group works with manufacturing companies to reduce operating costs by adopting a continuous improvement process that focuses on energy efficiency to save an average of 8 %.

This case study features the world's largest office furniture plant which employs more than 900 and has an annual energy spend of \$2.3M. SEG provided support for two years.



Annual Electric Cost:

- 26,186,400 kWh - \$2.3M annual spend



Kaizen Savings:

- Installed a Compressed Air controls system - \$240,000
- Repaired 170 compressed air leaks- \$80,000
- Installed LED lighting- \$150,000
- Replaced CO2 lasers with one fiber optic laser - \$80,000
- Misc. operations & maintenance items - \$52,000



CEI Performance

- Eliminated 6,695,785 kwh
- Reduced Electric Spend by \$602,001
- Exceeded Corporate Savings Goal by 10.4X (26% actual reduction vs 2.5% energy savings goal)