



## EARTH MATTERS

BETTER COMPANY. BETTER PRODUCT. BETTER WORLD.





## *Statement of Environmental Ethics*

We expect all members to balance the needs of the company with careful, responsible stewardship of the environment. We believe the scope of this stewardship includes—

- human and financial resources
- corporate facilities
- community
- natural environment and natural resources

With an emphasis on personal responsibility, we expect wise and effective use of all resources.

We will maintain documented policies for making decisions with regard to reducing waste, recycling waste and manufacturing by-products, conserving energy, and using recycled or rapidly-renewable materials in our products and processes.

## STEWARDS OF THE ENVIRONMENT

Crystal Cabinet Works, Inc., a family-owned manufacturer of fine, American-made custom cabinetry, strives to surpass other cabinet manufacturers in our stewardship of natural and human resources. A sustainable manufacturer is one that considers impacts on people and the environment— both in terms of products and manufacturing processes. Crystal is committed to truly being a leader in green. Sound environmental practices add inherent value to our products and complement our customers' desire to make purchasing decisions as part of a healthy lifestyle.

Earth Matters is designed to present Crystal's environmental initiatives and achievements to those who may be considering adding our products to their home. The company's goal of balancing high-quality, handcrafted and durable cabinetry with added environmental benefits continues to distinguish Crystal in the custom cabinet marketplace.

## KCMA ENVIRONMENTAL STEWARDSHIP PROGRAM

Crystal was directly involved with the development of the Kitchen Cabinet Manufacturers Association's Environmental Stewardship Program (ESP). All of Crystal's cabinet manufacturing facilities are certified under this KCMA program that is included in the National Green Building Standard.

The ESP is designed as a framework for manufacturers to highlight sound environmental business practices concerning:

product and process resource management, air quality, environmental management policies and systems, and community relations.

Due to Crystal's solid environmental record, no major changes were required in our operations or products in order to achieve certification, which requires a rigorous annual compliance review.



## FSC CHAIN OF CUSTODY CERTIFICATION

The Forest Stewardship Council is an international non-profit organization whose mission is to create a marketplace that promotes well-managed forests by ensuring forestry practices are environmentally responsible, socially equitable, and economically viable.

- Reduced environmental impact of harvest
- No conversion of natural forests
- No use of hazardous pesticides
- No illegal logging
- No logging in protected areas
- Respect for workers' and indigenous peoples' rights

Crystal is certified under the Forest Stewardship Council's (FSC) Standard for Chain of Custody Certification # SGS-COC-005701 (FSC-STD-40-004). This certification enables us to sell FSC-certified and labeled cabinetry in birch, cherry, heartwood, hickory, maple, quarter sawn white oak, red oak, rustic cherry, rustic hickory, and rustic red oak. Other species may be available by special request. All of the aspen used in our dovetailed drawer boxes is FSC certified as well.

By earning FSC chain of custody certification, Crystal continues to show that we are truly a leader in the development of green custom cabinetry. Customers can be assured that when ordering FSC certified cabinetry, the wood is sourced responsibly from well-managed forests.

We are proud of our ability to meet the strictest standards required to comply with FSC certification. Crystal will continue to pursue every effort to demonstrate our commitment to environmental stewardship through operational excellence and relationships with suppliers who share our values.



## *Wood is Good*

Wood products are an environmentally responsible choice for a number of reasons. They are recyclable, store carbon, biodegradable and use less energy to process than metals and plastic. Wood is also a naturally renewable resource, meaning new trees will grow in place of those that have already been harvested. In addition to renewing themselves, new trees are often planted to help the forest thrive.

Now more than ever we can use wood products without the fear of diminishing wood supply or forest prosperity. Many forests are harvested using sustainable forest practices which assure the forests remain healthy. By purchasing wood and wood products supplied by a recognized sustainable forestry program, like FSC, you will be ensuring the health of the environment and your family.



## *Saving Trees*

Our company believes that we need to do our part in the important role of conservation of species whose decline is caused wholly or in part by international trade. Irresponsible management of wood, a limited resource, means that there are some species of this once plentiful material that are now almost extinct. CITES (Convention on International Trade of Endangered Species) has identified and compiled a list of species that Crystal will not use to make cabinets for this reason.

To see a list of endangered species visit our web site: [www.crystalcabinets.com](http://www.crystalcabinets.com). Click on cabinetry, wood and finish, then special wood species.



DESIGNED BY: CRYSTAL IN-HOUSE DESIGN  
PHOTOGRAPHY: THOEN & ASSOCIATES

GREEN-CORE PLUS CUSTOM INSET  
CABINETS WITH REGENT AND CUSTOM  
REGENT TWO-PANEL DOOR STYLES FIN-  
ISHED IN SIGNATURE UMBER STAIN WITH  
BLACK HIGHLIGHT ON LYPTUS.

## ENVIRONMENTALLY PREFERABLE PRODUCT

The Composite Panel Association's (CPA) Environmentally Preferable Product (EPP) Downstream Program is an easy way for consumers to identify environmentally responsible products. Products carrying the EPP Downstream logo were manufactured by a company that has demonstrated their environmental commitment by purchasing at least 90% CPA EPP certified composite wood products.



### What are CPA EPP certified composite wood products?

Crystal's composite wood panels are certified as meeting the rigorous requirements of the CPA EPP environmental certification program, the most widely-specified environmental certification program for composite wood products in North America:

- It is the only environmental certification program that has achieved ANSI accreditation
- Requires use of 100% recycled or wood fiber
- Requires formaldehyde emissions equal to or lower than CARB Phase I levels
- Requires ongoing participant testing of formaldehyde emissions
- Requires monthly audits to verify recycled content, formaldehyde emissions, and adherence to QC procedures that meet ASTM protocol
- Requires quarterly submission of samples for large chamber testing by accredited third party

So when you specify and purchase EPP Downstream products from Crystal, you can rest assured knowing that those products are manufactured to the highest environmental and quality standards.

## *Natural Resource Stewardship Policy*

We strive to understand and utilize recycled and rapidly-renewable materials and suppliers or strategic partners who practice responsible stewardship. We consider this policy to include the effective use of raw materials and finding ways to recycle and or reuse our by-products. We favor the use of recycled-content materials when feasible. We support any and all organized recycling programs and participate as a matter of corporate philosophy (e.g. paper, cardboard, beverage containers, scrap metal, transport packaging, wood fiber, etc.). We will favor the use of products or suppliers that share this philosophy.



## *Energy Conservation Policy*

We strive to understand and reduce the impact of our processes, policies and product on greenhouse gas emissions by reducing energy consumption. Some of the ways we will do this include: installing energy-conserving lighting and motors; evaluating the use of biomass rather than fossil fuels when feasible; adding hybrid vehicles to our fleet, etc.

We understand energy conservation to include our choice of materials, processes, policies and equipment. We expect value-added, responsible use of resources so we might ensure future sustainability and quality of life.

## ENERGY

Crystal has implemented several energy conservation initiatives over the past few years.

**HYBRID VEHICLES.** Hybrid cars were recently added to Crystal's fleet of company vehicles which has reduced gas consumption and tailpipe emissions from vehicles used by our employees.

**BIOMASS FUEL.** One of Crystal's manufacturing facilities utilizes its own wood waste to heat its facility; fossil fuels are only used as backup fuel. The remaining wood waste is used as a biofuel at another local facility or waste-to-energy plant.

**WASTE-TO-ENERGY.** All of Crystal's refuse is sent to a local waste-to-energy facility, where it is recovered as a fuel source in lieu of fossil fuels.

**ENERGY-EFFICIENT MANUFACTURING.** Converting factory lighting, installing energy-efficient air compressors and motors and motor technology to reduce peak energy demand have all contributed to reducing Crystal's carbon footprint and energy costs.

## RECYCLING

Each year, Crystal's facilities recycle unused paint, used cardboard, mixed paper, plastic transport packaging, and scrap metal to the tune of over 600,000 pounds (that's 300 tons!) per year.

**CLOSE THE LOOP:** The cardboard used in Crystal's packaging system is made from post-consumer recycled materials. The corrugated media has 100% post-consumer recycled content and the lining has an average post-consumer recycled content of 10%. We encourage our customers to close the recycling loop and recycle used cardboard cartons at local recycling facilities.

## SUSTAINABLE MANUFACTURING

Crystal Cabinet Works, Inc. is committed to being a leader in green. This means we must evaluate both product offerings and manufacturing processes in terms of their impact on people and the environment.

Crystal has made impressive gains in certain key environmental indicators—resulting in reductions by over 25% of releases of smog-forming volatile organic compounds, use of federally-reportable chemicals, and generation of solid waste.

Over the past several years, Crystal has improved the environmental footprint of our operations by retrofitting facility lighting, recovering waste air compressor heat, improving the efficiency of air compressors, installing motion detectors for lighting, using energy saving motor controls, ensuring wood waste is used as a biofuel, and including hybrid vehicles in our fleet. Crystal employs computerized optimization technology and scrap recovery and reuse in order to ensure efficient use of wood materials.

Establishing and maintaining relations with like-minded environmentally-conscious business partners throughout the supply and distribution chain is also vital.





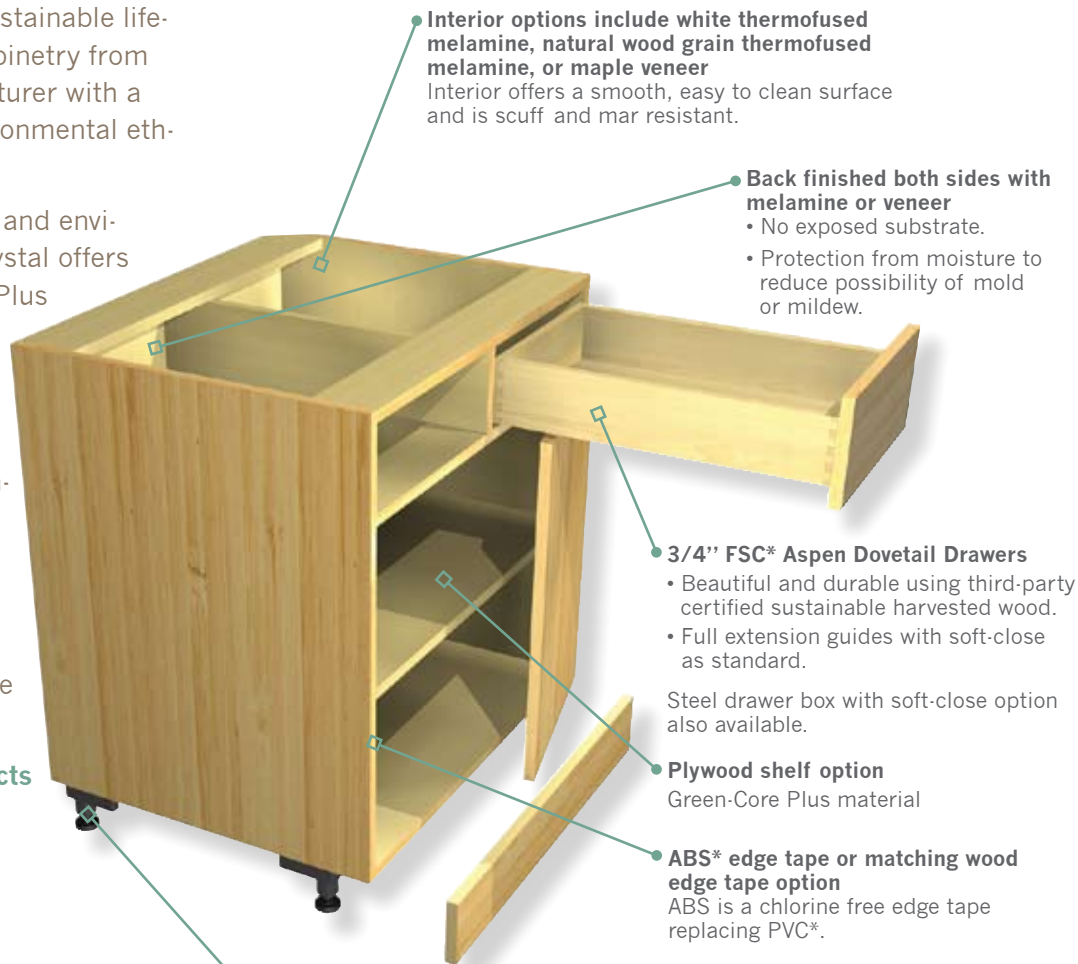
Support your healthy and sustainable lifestyles with green custom cabinetry from Crystal Cabinets, a manufacturer with a legacy of the strongest environmental ethics in the industry.

Balancing durable cabinetry and environmental responsibility, Crystal offers Green-Core and Green-Core Plus with no added urea-formaldehyde, 100% recycled, low-emitting, and rapidly-renewable cabinet components, FSC woods and Green-Guard® certified, Zenith G1™ ultra-low emitting topcoat.

Attesting to its durability, Crystal's green products are backed with a limited lifetime warranty.

**Crystal's GreenQuest products can qualify your project for LEED\* credits. See page 14.**

\* ABS – acrylonitrile butadiene styrene  
 CPA – Composite Panel Association  
 EPP – Environmentally Preferable Product  
 ESP – Environmental Stewardship Program  
 FSC – Forest Stewardship Council  
 KCMA – Kitchen Cabinet Manufacturers Association  
 LEED – Leadership in Energy & Environmental Design  
 PVC – polyvinyl chloride



**Interior options include white thermofused melamine, natural wood grain thermofused melamine, or maple veneer**  
 Interior offers a smooth, easy to clean surface and is scuff and mar resistant.

**Back finished both sides with melamine or veneer**  
 • No exposed substrate.  
 • Protection from moisture to reduce possibility of mold or mildew.

**3/4" FSC\* Aspen Dovetail Drawers**  
 • Beautiful and durable using third-party certified sustainable harvested wood.  
 • Full extension guides with soft-close as standard.

Steel drawer box with soft-close option also available.

**Plywood shelf option**  
 Green-Core Plus material

**ABS\* edge tape or matching wood edge tape option**  
 ABS is a chlorine free edge tape replacing PVC\*.

**Leg Levelers (ABS\* plastic)**  
 Cabinet does not contact floor reducing the chance of mold and mildew from any occurring trapped moisture.

*Cabinet depicted shows a bamboo exterior and natural wood grain melamine interior.*

# WHAT MAKES OUR CABINETS GREEN?

**Low emitting and/or  
Water-based finishes**



Green finish options: GreenGuard® certified, Zenith G1™ ultra-low emitting topcoat, water-based stains and other water-based finishes.



The mark of responsible forestry  
Cert no. SGS-COC-005701  
© 1996 FSC

Harvested from forests that are well-managed to meet the social, economic and ecological needs of present and future generations.



**No added urea-formaldehyde  
plywood & particleboard**

Green-Core plywood and particleboard contains renewable wood fiber with no added urea-formaldehyde resins.

Green-Core plywood is made with a patented soy-based resin and no added urea-formaldehyde.

Green-Core particleboard is 100% recycled with a no added urea-formaldehyde exterior-grade resin.



**ESP Certified**

Crystal meets the requirements of ESP\* 02-09 for Air Quality, Resource Management of Product and Process, Environmental Stewardship and Community Relations and is an approved participant in the KCMA\* Environmental Stewardship Program.



**Composite Panel Association's  
Environmentally Preferable Product  
Downstream Program**

Products made with CPA\*- certified EPP\* composite wood panels are among the greenest you can buy. This seal is your assurance that the products you're getting from Crystal are environmentally responsible.

DESIGNED BY: CRYSTAL IN-HOUSE DESIGN  
PHOTOGRAPHY: THOEN & ASSOCIATES



GREEN-CORE PLUS CUSTOM CABINETRY WITH GENTRY DOOR STYLE FINISHED IN STRAW PAINT. SPRINGFIELD DOOR STYLE FINISHED IN SIGNATURE RAISIN WITH BLACK HIGHLIGHT ON LYPTUS.



BASE DRAWER KNIFE BLOCK DELUXE AND NARROW PULL OUT KNIFE BLOCK MADE WITH MULTIPLE RANDOM HARDWOOD SPECIES FROM RECOVERED WASTE MATERIALS WITH A CLEAR FINISH.

GREENFIELD DOOR STYLE FINISHED IN UMBER FLAT SHEEN ON LYPTUS. QUEST CABINETRY WITH GREEN-CORE BOXWORK.



DESIGNED BY: LYNN LARSEN, CKD, CBD  
PHOTOGRAPHY: PALADINO PHOTOGRAPHY

*Traditional Green*

## GREEN DOOR STYLE OPTIONS

Several of Crystal's door styles are constructed using Green-Core and Green-Core MDF substrates.

You can choose a painted Green-Core MDF door or a sleek, modern wood veneer door over Green-Core MDF substrate. The Manhattan door is available with several horizontal engineered veneers (EV) that are considered green because they are made with under utilized wood species.

Crystal's laminate door styles use GreenGuard® certified laminates and have a substrate of 100% recycled and no added urea-formaldehyde Green-Core particleboard. Some foil door offerings are green because they are PVC-free with low-emitting substrate. Stainless steel doors are an appropriate green choice because they have no added urea-formaldehyde substrate and the steel is made with 60% recycled content.

Most of our hardwood doors are available in FSC-certified woods. (See page 3 for list of FSC-certified woods.)

We also offer doors made with 3-ply bamboo that are available in several stain colors. Bamboo is a rapidly-renewable material and is considered a certified specie under the FSC.

In addition to doors featured, we have several other green choices available.



Staten Island 3-Ply Bamboo Door Style, shown with eased edge option, finished in Nutmeg stain



Manhattan Door Style with horizontal engineered veneer carbonized bamboo



Prescott Laminate Door Style with Natural Pear laminate



Stainless Steel Door



Stratus Square MDF Door Style with Chiffon paint



GREEN-CORE PLUS CABINETS FEATURING THE MANHATTAN DOOR STYLE WITH BAMBOO AND CARBONIZED BAMBOO VENEERS.

THE USE OF RECLAIMED MATERIALS, CONCRETE AND RAPIDLY-RENEWABLE BAMBOO CREATES CONTEMPORARY YET TIMELESS CABINETS THAT IS SENSITIVE TO RESOURCE CONSUMPTION AND OUR ENVIRONMENT.

DESIGNED BY: CRYSTAL IN-HOUSE DESIGN  
PHOTOGRAPHY: THOEN & ASSOCIATES



## GREEN BUILDING POINTS

**Crystal's GreenQuest cabinetry was designed to earn eligible points for cabinetry under all LEED systems** and will contribute toward project certification, depending on the green attributes specified.

- Under LEED-2009 (New Construction and Commercial Interiors), Crystal's GreenQuest cabinetry can earn points for recycled content (particleboard, MDF and stainless steel doors), regional materials (if within 500 mile radius), rapid-renewability (bamboo), FSC-certified wood (various species), and low-emitting wood coatings (water-based finishes) and low-emitting composite wood products (Green-Core).
- Under LEED for Homes, Crystal's GreenQuest cabinetry can earn points for recycled content (particleboard and MDF), FSC-certification (various species), and no added urea-formaldehyde resins (Green-Core). (Note: LEED-H does not allow points to be earned for cabinet finishes.)
- National Green Building Standard—This ANSI-accredited green building consensus standard awards points to cabinetry meeting specific criteria.

For details on LEED credits that will earn points using Crystal's green product, and the National Green Building Standard, see our Green Building Points Summary document on our web site: [www.crystalcabinets.com/greenproducts.htm](http://www.crystalcabinets.com/greenproducts.htm)

## ENVIRONMENTAL RESOURCE LINKS

Crystal's Web  
[www.crystalcabinets.com](http://www.crystalcabinets.com)

KCMA Environment Stewardship Program  
[www.greencabinetsource.org](http://www.greencabinetsource.org)

Forest Stewardship Council  
[www.fsc.org](http://www.fsc.org)

Composite Panel Association Environmentally-Preferable Product Program  
[www.pbmdf.com](http://www.pbmdf.com)

LEED Leadership in Energy and Environmental Design  
[www.usgbc.org](http://www.usgbc.org)

GreenGuard®  
[www.greenguard.org](http://www.greenguard.org)

GreenPoint Rated  
[www.builditgreen.org/greenpointrated](http://www.builditgreen.org/greenpointrated)

Lyptus  
[www.lyptus.com](http://www.lyptus.com)

It is our intent to continue pursuing all avenues to 'green' until it truly becomes a way of life. We have a strategic objective to be a leader in green, both in terms of our product offerings and our manufacturing processes. At Crystal, we will continue to build upon our legacy of balancing environmental considerations with durable cabinetry and healthy lifestyle choices for our customers and our communities.

*Thank you for partnering with us.*





## EARTH MATTERS

BETTER COMPANY. BETTER PRODUCT. BETTER WORLD.

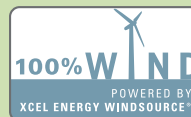
CRYSTAL CABINET WORKS, INC.  
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Princeton, Minnesota 55371

[www.crystalcabinets.com/GreenProducts.htm](http://www.crystalcabinets.com/GreenProducts.htm)



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