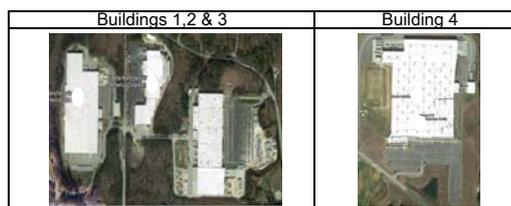


## Kubota Manufacturing of America Corporation

### 1. Outline

<b>Address</b>	2715 Ramsey Road, Gainesville, GA 30501 USA
<b>Number of employees</b>	1,671 (Dec. 2020)
<b>Site area</b>	948,000 m <sup>2</sup>
<b>Establishment day</b>	September, 1, 1988
<b>ISO14001 certification date</b>	20-Sep-2012
<b>Site overview</b>	Development and manufacturing of small-sized tractors, turf equipment and RTVs



### 2. Products

#### Main products



### 3. Environmental policy

**For Earth, For Life**  
Kubota

## Kubota (KMA/KIE) Environmental Policy

Kubota is committed to preserving the environment. Our goal is to reduce our environmental impact by prevention of pollution resulting in clean safe communities, while producing products that meet or exceed our customers' expectations. Kubota is committed to continual improvement by implementing an environmental management system that fulfills our goal.

### 4. Environmental performance data (Jan. 2020 to Dec. 2020)

<b>Used amount of energy</b>	Crude oil equivalent KL	14,459
<b>Used amount of water</b>	thousand m <sup>3</sup>	80

<b>CO<sub>2</sub> emission*</b>	tons CO <sub>2</sub> e	32,679
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\*CO<sub>2</sub> emissions from energy sources.

Air Pollutant measurement results				
Main smoke and soot generation facilities		Boilers		
	Unit	Control content	Control value	Maximum measured
SOx	Total emission control: m <sup>3</sup> N/h	Use of town gas with zero sulfur content	-	-
NOx	Total emission control: m <sup>3</sup> N/h, Concentration control: ppm	-	-	-
Particulate	Concentration control: g/m <sup>3</sup> N	-	-	-

<b>Amount of discharge water</b>	thousand m <sup>3</sup>	79	
<b>Amount of pollutant in discharge water</b>	COD	kg/year	-
	Nitrogen	kg/year	-
	Phosphorus	kg/year	-

Water pollutant measurement results				
		unit	Control value	Maximum measured
Public water areas	pH	-	-	-
	BOD	mg/L	-	-
	COD	mg/L	-	-
	Nitrogen	mg/L	-	-
	Phosphorus	mg/L	-	-
	Hexavalent chromium	mg/L	-	-
	Lead	mg/L	-	-
	COD, total emission control	kg/day	-	-
	Nitrogen, total emission control	kg/day	-	-
	Phosphorus, total emission control	kg/day	-	-
Sewerage lines	pH	-	6.0 - 9.5	6.9, 8.8
	BOD	mg/L	900	435
	COD	mg/L	-	-
	SS	mg/L	900	68

<b>Waste discharge</b>	tons	3,197
<b>Recycling ratio</b>	%	73.5%

## 5.Environmental Topics

### [In an effort to reduce the environmental impact at KMA]

Ⓞ **Waste Reduction:** Effort to reduce Line-X overspray, targeting to reduce 39.1 tons/year of waste. (Photo 1)

Ⓞ **Energy savings:**

- BMS (Building Management System) is in place at Bldg.1 to better control temperature and conserve energy (Photo 8) usage by scheduling holidays, weekends, and after hours (Estimated 675 tons/year of CO2 reduction).
- With improved rooftop insulation, both electricity and natural gas saving from heating and air expects to reduce estimated 152,321 kWh/year of power equivalent to 621 tons of CO2. (Photo 9)
- Retrofitted Bldg. 1, 2 and 4 lighting from fluorescents to LEDs (Photo 2) reducing energy by 3,238,941 kWh and 1,320 tons of CO2. (Photo 14)
- An inverter equipped air compressor was introduced to replace a less energy efficient air compressor in Bldg. 2. The new compressor saves the energy by 479,360 kWh/year equivalent to 195 tons/year of CO2.
- Replaced the air tools for assemblies with DC electric tools that reduced the demand for compressed air saving 21 tons/year of CO2.

Ⓞ **Energy flow maps:** The maps will give a whole picture of how energies are used to run production and its supporting equipment and facilities.(Photo 15) With continuous updating effort, the map will show and prove improvements made by investments or process changes before and after.

### [North American Safety & Environmental Conference]

Conducted remote conferences among KTC, KEA, KCL, KMC and GPM in February and November. The purpose was for promotion of synergy and strengthening collaboration among business sites in the region and improvement of our overall operational efficiency. We created working groups for Safety and Environment individually and decided to have remote conference every two month. (Photo 4)

### [Environmental Achievement Award]

Received "Environmental Excellence Award" for Bldg. 4 Paint Shop Small Parts Line E-coat and Powder coating systems. The Manufacturing Engineering team came up with a unique paint hanger design to eliminate needs for frequent burn-off of paint hangers. The new paint hanger has air pockets that repels e-coat paint to get on hooks and it improves electrostatic bonding to the earth ground. The pocket also creates Faraday's cage effect that keep paint hangers powder-free. This also improve the bonding. As a result, the new paint hanger requires less frequent burn-off to clean hangers and it saves natural gas consumption while improving paint film thickness. (Photo 7)

Ⓞ **Environmental Month Activity** Performed Environmental Month Clean-up activity in June. (Photo 3)

### [Recycling friendly bins and its dumpster]

In order to improve recycling ratio at KMA, a recycling dumpster is introduced in September. This is a trial to verify the effectiveness. (Photo 10 & 11)

### [Stormwater sampling]

Under Industrial Stormwater General Permit (GAR050000), water sampling after a rain event is required quarterly to ensure water quality. (Photo 13)

### [Environmental Audits]

Legal audit in September  
Internal audit by GA Tech in November (Photo 12)  
External audit by BSI in December



Photo 1. Bldg. 4 Line-X process



Photo 2. LED lighting



Photo 3. Environmental Month Clean-up



Photo 4. North American Safety & Environmental Remote Conference



Photo 5. Environmental Month Communication



Photo 6. Environmental Dojo



Photo 7. Excellence



Photo 8. BMS (Building Management System)



Photo 9. Bldg. 2 Roof insulation

## 6.Environmental Communication

### [Environmental Dojo]

Conducted the Environmental Dojo training three times in 2020 to educate supervisors and managers who influence their team members on the shop floors and the offices. The objectives are to teach environmental conservation and compliance as well as engaging Gemba for more being sustainable.

### [Regulatory Training]

Conducted DOT and HAZWOPER training for team members who handle, ship and manage hazardous wastes.

### [Safety & Environmental Training]

Safety Dojo training for all employees including temporary employees. This training includes to teach environmental aspects and impacts caused by the manufacturing and human activities. (Photo 6)

### [Internal Communication]

During the Environmental Month, supervisors conducted briefings to convey the team members the president Kitao's message and promoted the slogan of "Let's work together to reduce plastic waste!". (Photo 5)

Conducted Monthly Environmental Objective Meeting

Conducted Quarterly Environmental Management Review Meeting



Photo 10. Recycling friendly bins



Photo 11. Recycling dumpster at Bldg. 2



Photo 12. Internal environmental audit



Photo 13. Stormwater sampling



Photo 14. Inverter equipped air compressor



Photo 15. Energy Flow Map