BUILDING TRUST

Declaration of conformity for products with Model EPDs

The Association of the European Adhesive & Sealant Industry (FEICA), of which Sika is a member, has developed so-called Model Environmental Product Declarations (Model EPDs) and had them independently verified by the Institute Construction and Environment (IBU). These IBU verified Model EPDs have been made publicly available by FEICA and IBU. The Model EPDs depict the current production technology in Europe. Based on the product formulations it was checked if our products were covered by the Model EPDs.

This Declaration confirms that the product

Sika Boom®-163 Evolution

produced in Germany is covered by the attached Model EPD «Reactive resins based on polyurethane or silane-modified polymer, containing solvent, solvent content between 10% and 50%" (Declaration number EPD-FEI-20180092-IBG1-EN). This means that the Life Cycle Assessment (LCA) data and the remaining content of the attached Model EPD apply to the above-mentioned product and may thus be used for the evaluation of the sustainability of buildings where the product is applied.

Sika Services AG

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Zurich, January 15th, 2020

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ENVIRONMENTAL PRODUCT DECLARATION

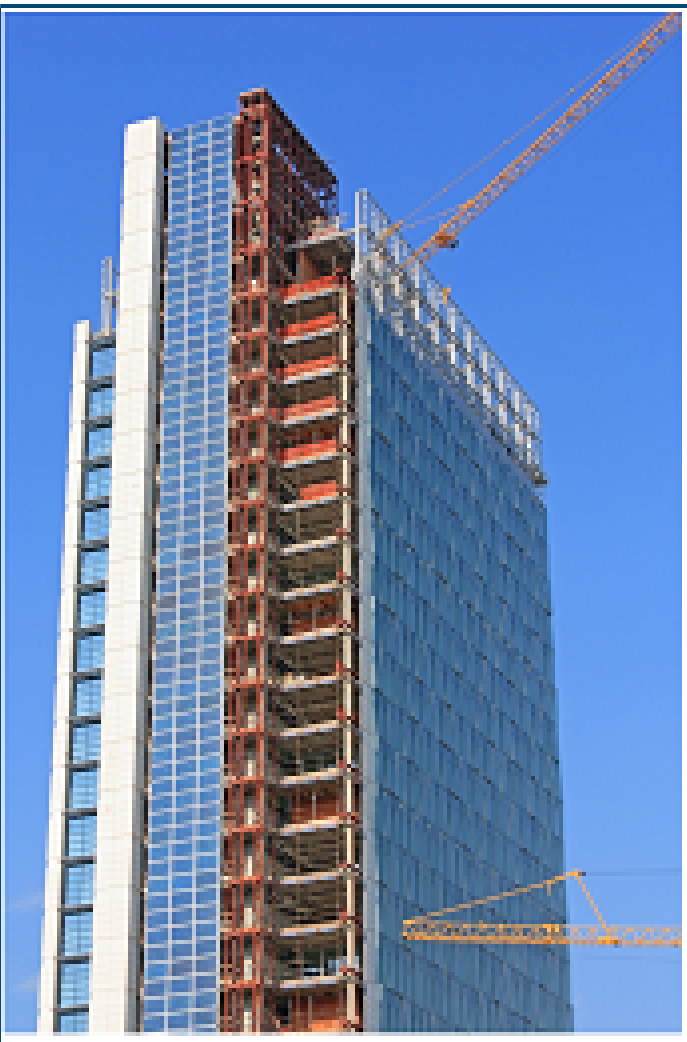
as per /ISO 14025/ and /EN 15804/

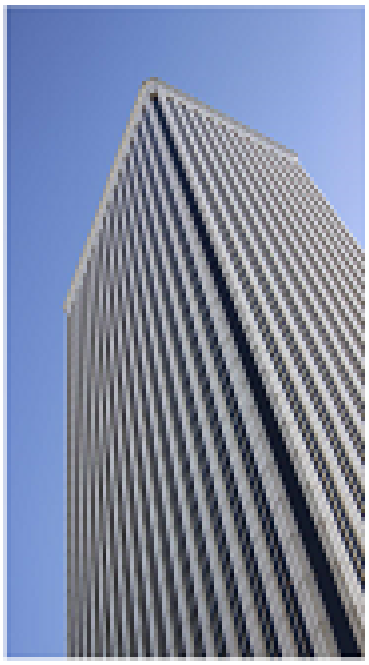
Owner of the Declaration	FEICA - Association of the European Adhesive and Sealant Industry
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-FEI-20180092-IBG1-EN
ECO EPD Ref. No.	ECO-00000344
Issue date	14.08.2018
Valid to	20.02.2022

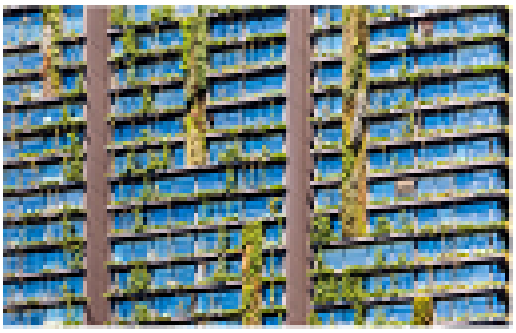
Reactive resins based on polyurethane or silane-modified polymer, containing solvent, solvent content between 10% and 50%

FEICA - Association of the European Adhesive and Sealant Industry

www.ibu-epd.com / https://epd-online.com







1. General Information

FEICA - Association of the European Adhesive and Sealant Industry

Reactive resins based on polyurethane or silane-modified polymer, containing solvent, solvent content between 10% and 50%

Programme holder
IBU - Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
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Owner of the declaration
FEICA - Association of the European Adhesive and Sealant Industry
Avenue E. van Nieuwenhuyse 2
1160 Brussels
Belgium

Declaration number
EPD-FEI-20180092-IBG1-EN

Declared product / declared unit
1 kg reactive resins based on polyurethane or silane-modified polymer, containing solvent, solvent content between 10% and 50%; density: 1 - 1.25 g/cm³

This declaration is based on the product category rules:
Reaction resin products, 07.2014
(PCR checked and approved by the SVR)

Scope:
This validated Declaration entitles the holder to bear the symbol of the Institut Bauen und Umwelt e.V. It exclusively applies for products produced in Europe and for a period of five years from the date of issue. This EPD may be used by FEICA members and their members provided it has been proven that the respective product can be represented by this EPD. For this purpose, a guideline is available at the FEICA secretariat. The members of FEICA are listed on its website.

The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

Issue date
14.08.2018

Valid to
20.02.2022

Verification

The standard /EN 15804/ serves as the core PCR
Independent verification of the declaration and data according to /ISO 14025:2010/
☐ internally ☒ externally

Prof. Dr.-Ing. Horst J. Bossenmayer
(President of Institut Bauen und Umwelt e.V.)

Dipl. Ing. Hans Peters
(Managing Director IBU)

Matthias Schulz
(Independent verifier appointed by SVR)

2. Product

2.1 Product description / Product definition

Reactive resins based on polyurethane or silane-modified polymer - containing solvent

These one- or two-component reactive resins are manufactured using polyols (based on mineral oil or from sustainable raw materials) and isocyanates. Reactive resins based on silane-modified polymer (SMP) are usually manufactured as single components from polyols and alkoxysilane preliminary stages. They may contain solvents for adjusting favourable processing characteristics. They fulfil manifold, often specific, tasks in the construction, furnishing and repair of buildings. Using reactive resins based on polyurethane or SMP, containing solvent, decisively improves the usability of buildings and significantly extends their service lives.

The product displaying the most environmental impacts was applied as a representative product for calculating the Life Cycle Assessment results (worst case-approach).

For the placing on the market in the EU/EFTA (with the exception of Switzerland) products falling under the Regulation (EU) No 305/2011 (/CPR/) need a Declaration of Performance taking into consideration either the relevant harmonised European standard or the European Technical Assessment and the CE marking. For the application and use of the products the respective national provisions apply.

2.2 Application

Reactive resins based on polyurethane or SMP, containing solvent, are used for the following applications:

Module 1:
Reactive resins for protecting and repairing concrete structures
Products for **surface protection of concrete**, for increasing the durability of concrete and reinforced concrete structures as well as for new concrete and for maintenance and repair work (requirements 1.1), products for **structural bonding** of strengthening materials to an existing concrete structure (requirements 1.2)
Module 2:
Liquid-applied roof waterproofing kits
Reactive resins for waterproofing roof constructions which are applied on site
Module 3:
Reactive resins for liquid-applied bridge deck waterproofing kits
Products for liquid-applied waterproofing for use on concrete bridge decks
Module 4:
Reactive resins as adhesive for tiles
Tile adhesives for internal and external tile installations on walls, floors and ceilings
Module 5:
Reactive resins for watertight covering kits
Products for waterproofing floors and/or walls in wet rooms inside buildings
Module 6:
Reactive resins for liquid applied waterproofing for buildings
Liquid plastics for waterproofing buildings
Module 7:
Screed material and floor screeds
Products for screed / synthetic resin screed for use in floor constructions
Module 8:
Adhesives and sealants
Performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance
Module 9:
Reactive resins for waterproofing concrete components or masonry and for pre-treating mineral substrates such as screed or concrete floors prior to flooring, parquet and tile work
Applications in accordance with the manufacturer's technical documentation / declaration of performance
Module 10:
Sealing for parquet floors, floor coatings and floor coverings
Reactive resins for the surface protection of wood and parquet floors, floor coatings and floor coverings in interior applications. The products are used for the manufacture and increase of usability and resistance of floors.
Module 11:
Reactive resins for visual design of concrete components
Products for usually coloured design of concrete with simultaneous, unspecific surface protection and improved permanence of concrete and reinforced concrete surfaces. The same applies for other mineral substrates such as plaster, stone and masonry, for example.
Module 12:
One component foam (OCF)
One component foam in a can is a one-component, self-expanding, ready to use polyurethane foam used for various construction applications. It consists of a low viscous semi-fluid in a can that leaves the can as a froth and immediately forms a polyurethane foam.
12.1 Window & External Door Sealing & Insulation:
Installing mechanically fixed external windows and doors with an OCF, as part of a system including sealants and tapes
12.2 Door Installation & Fixation:
Fixing interior doors with an OCF
12.3 General Gap Filling:
Filling of regular and irregular shaped spaces between at least two surfaces made of typical building materials with an One component foam (OCF)

2.3 Technical Data

Module 1:
Reactive resins for protecting and repairing concrete structures
The minimum requirements of /EN 1504/ "Products and systems for the protection and repair of concrete structures – Definitions, requirements, quality control and evaluation of conformity"/ must be maintained. These are:
1.1 **Surface protection** systems for concrete – Requirements on performance characteristics for all intended uses in accordance with /EN 1504-2/, Tables 1 and 5:
- Permeability to CO2 (/EN 1062-6:2002-10/)
- Water vapour permeability (/EN ISO 7783-1/-2:2012-02/)
- Capillary absorption and permeability to water (/EN 1062-3:2008-04/)
- Adhesion strength by pull-off test (/EN 1542:1999-07/)

1.2 Products for **structural** bonding – Performance characteristics for all intended uses in accordance with Tables 3.1 and 3.2 (manufacturer's declaration of performance)
Other performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance
Module 2:
Liquid-applied roof waterproofing kits
The minimum requirements of EAD (on the basis of /ETAG 005:2005-02/) must be maintained.
The performance characteristics must be indicated in accordance with the European Technical Assessment.
Module 3:
Reactive resins for liquid-applied bridge deck waterproofing kits
The minimum requirements of EAD (on the basis of /ETAG 033:2010-09/) must be maintained.
The performance characteristics must be indicated in accordance with the European Technical Assessment.
Module 4:
Reactive resins as adhesives for tiles
The minimum requirements of /EN 12004:2012-09/ "Adhesives for tiles - Requirements, evaluation of conformity, classification and designation" must be maintained. These are:
- Initial shear adhesion strength (/EN 12003:2009-01/)
- Shear adhesive strength after water immersion (/EN 12003:2009-01/)
- Open time: tensile adhesion strength (/EN 1346:2007-11/)

Other performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance
Module 5:
Reactive resins for watertight covering kits
The minimum requirements of EAD (on the basis of /ETAG 022:2007-07/) must be maintained.

The performance characteristics must be indicated in accordance with the European Technical Assessment.

Module 6:

Reactive resins for liquid-applied waterproofing for buildings

Module 7:

Screed material and floor screeds

The minimum requirements of /EN 13813/ "Screed material and floor screeds – Screed materials – Properties and requirements" must be maintained. For synthetic resin screeds, these are:

- Bond strength (/EN 13892-8:2003-02/)
- Reaction to fire (/EN 13501-1:2010-01/)

Other performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance

Module 8:

Adhesives and sealants

Performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance

Module 9:

Reactive resins for waterproofing concrete components or masonry and for pre-treating mineral substrates such as screed or concrete floors prior to flooring, parquet and tile work

At least the following requirements must be fulfilled:

Name	Value	Unit
Shore hardness A /ISO 7619-1,2/	15-100	
Shore hardness D /ISO 7619-1,2/	5-95	
Density /EN ISO 2811: 2011-06/	0,7-2,5	kg/dm³
Viscosity /EN ISO 3219: 1994-10/	< 50	Pa s

Other performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance

Module 10:

Sealing for parquet floors, floor coatings and floor coverings

Properties such as chemical resistance, scratch resistance, abrasion resistance /EN ISO 5470:1999-09/, or side-bonding in line with information provided by the manufacturer.

Other performance characteristics in accordance with the manufacturer's technical documentation / declaration of performance

Module 11:

Reactive resins for visual design of concrete components

Physical data on the coating material and/or coating must be indicated in accordance with the respective product standards; these can include, for example:

- Viscosity /EN ISO 3219:1994-10/
- Density /EN ISO 2811:2011-06/
- Pendulum damping /ISO 1522:2007-04/
- Reaction to fire /EN 13501-1:2010-01/
- Tensile strength /EN 13892-8:2003-02/

Other performance characteristics in accordance with the manufacturer's technical documents / declaration of performance

Module 12:

One Component Foams

Physical data of the One Component Foam must be indicated in accordance with the respective product standards; these can include, for example:

12.1 Window & External Door Sealing & Insulation

Tensile Strength /FEICA TM 1018/, Movement Capability /FEICA TM 1013/, Curing Pressure /FEICA TM 1009/, Thermal conductivity /FEICA TM 1020/, Sound Insulation /EN ISO 717-2/

12.2 Door Installation & Fixation

Shear Strength /FEICA TM 1012/, Tensile Strength /FEICA TM 1018/, Compression Strength /FEICA TM 1011/

12.3 General Gap Filling

Sagging /FEICA TM 1006/ Other performance characteristics in accordance with the manufacturer's technical documents / declaration of performance

2.4 Delivery status

Liquid or pasty in containers made of tinplate or plastic appropriately prepared in separate or combi-containers for the practical mixing ratio. One kg of product in individual containers. Sealants in plastic cartridges and poly-tube bags made of foil compound materials. Typical container sizes contain 10 to 25 kg of material. For more extensive applications, vats containing approx. 200 kg or IBCs containing more than 1 tonne are also used.

For the LCA, tinplate (33%) and plastic packaging (66%) was considered.

2.5 Base materials / Ancillary materials

Reactive resins based on polyurethane or SMP and containing solvents can be formulated as single- or dual-component materials. They contain polyether and/or polyester polyols (on mineral oil basis or from sustainable raw materials), homologues, pre-polymers and polymers based on MDI, TDI, HDI or IPDI or those with alkoxy-silane groups and solvents in a concentration of up to 50%, possible segregated by resin and hardening agent component. The components can contain auxiliaries such as fillers, pigments, accelerators, catalysts, wetting agents, foam regulators or inert diluents for fine-tuning the product features (application or marketing restrictions must be adhered to). Crosslinking takes place after installation on site and using the inherent isocyanate or alkoxy-silane group containing component.

The products are largely processed as single-component systems; in the case of dual-component systems, the mixing ratio for resin and crosslinking agent is adjusted according to the stoichiometric requirements. Product crosslinking commences directly after the components are mixed.

On average, the products covered by this EPD contain the following ranges of base materials and auxiliaries referred to:

Resin component:~ 5-25%
Crosslinking agent component: ~ 20-60%
SMP component: < 60%
Solvents: < 50%
Filler materials: ~ 0-50%
Additives / Pigments: ~ 0-10%

These ranges are average values and the composition of products complying with the EPD can deviate from these concentration levels in individual cases. More detailed information is available in the respective manufacturer's documentation (e.g. product data sheets).

In individual cases, it is possible that substances on the list of materials of particularly high concern for inclusion in Annex XIV of the /REACH/ regulation are contained in concentrations exceeding 0.1%. If this is the case, this information can be found on the respective safety data sheet.

2.6 Manufacture

The product components formulated are usually mixed from the ingredients in batch mode and packaged for delivery, whereby quality and environmental standards in accordance with /ISO 9001:2008-12/ and the provisions outlined in the relevant regulations such as the Industrial Safety Regulation and Federal Pollution Control Act are adhered to.

2.7 Environment and health during manufacturing

As a general rule, no other environmental protection measures other than those specified by law are necessary.

2.8 Product processing/Installation

Reactive resins based on polyurethane or SMP, containing solvents, are processed by trowelling/knife-coating or rolling, pouring or spraying, whereby health and safety measures (ventilation, respiratory equipment, explosion protection) are to be taken and consistently adhered to in accordance with the information on the safety data sheet and conditions on site.
Suitable measures (ventilation, extraction) must ensure that the occupational exposure limits are maintained; explosion protection must be observed. VOC-emissions may occur.

2.9 Packaging

A detailed description of packaging is provided in section 2.5. Empty containers and clean foils can be recycled.

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2.10 Condition of use

During the use phase, reactive resins based on polyurethane or SMP, containing solvents, are crosslinked and essentially comprise an inert three-dimensional network.
They are long-lasting products which protect our buildings in the form of adhesives, coatings or sealants as well as making an essential contribution towards their function and conservation of value.

2.11 Environment and health during use

Option 1
Products for applications outside indoor areas with permanent stays by people
During use, reactive resins based on polyurethane or SMP, containing solvents, lose their reactive capacity and are inert.
No risks are known for water, air and soil if the products are used as designated
Option 2
Products for applications inside indoor areas with permanent stays by people
When used in indoor areas with permanent stays by people, evidence of the emission performance of construction products in contact with indoor air must be submitted according to national requirements. No further influences by emissions on the environment and health are known.

2.12 Reference service life

Reactive resins based on polyurethane or SMP, containing solvents, comply with a variety of, often specific, tasks in the construction or refurbishment of building structures. They decisively improve the usability of building structures and significantly extend their original service lives.
The anticipated reference service life depends on the specific installation situation and the exposure associated with the product. It can be influenced by weathering as well as mechanical or chemical loads.

2.13 Extraordinary effects

Fire
Even without any special fire safety features, reactive resins based on polyurethane or SMP, containing solvents, comply with at least the requirements of /EN 13501-1/ standard for fire classes E and Efl. In terms of the volumes applied, they only have a subordinate influence on the fire performance characteristics (e.g. smoke gas development) of the building structure in which they are installed. As networked polyurethane resins do not melt or drip, the resins do not contribute towards spreading fire.

Water
Reactive resins based on polyurethane or SMP, containing solvents, are chemically inert and insoluble in water. They are often used to protect building structures from harmful water ingress / the effects of flooding.

Mechanical destruction
The mechanical destruction of reactive resins based on polyurethane or SMP containing solvent does not lead to any decomposition products which are harmful for the environment or health.

2.14 Re-use phase

According to present knowledge, no environmentally-hazardous effects in terms of landfilling are to be generally anticipated through dismantling and recycling components to which crosslinked polyurethane products adhere.
If polyurethane systems can be removed from the components at no great effort, thermal recovery is a practical recycling variant on account of its energy content.

2.15 Disposal

Individual components which can no longer be recycled must be combined at a specified ratio and hardened.
Hardened product residue is not special waste.
Non-hardened product residue is special waste.
Empty, dried containers (free of drops and scraped clean) are directed to the recycling process. Residue must be directed to proper waste disposal taking consideration of local guidelines.
The following waste codes according to the European List of Waste (/2000/532/EC/) can apply:
Hardened product residue:
080112 Paint and varnish waste with the exception of those covered by 08 01 11
080410 Adhesive and sealant compound waste with the exception of those covered by 08 04 09

2.16 Further information

More information is available in the manufacturer's product or safety data sheets and is available on the manufacturer's Web sites or on request. Valuable technical information is also available on the associations' Web sites.

3. LCA: Calculation rules

3.1 Declared Unit

This EPD refers to the declared unit of 1 kg reactive resin based on polyurethane or SMP, containing solvent, solvent content between 10% and 50% of density 1 - 1.25 g/cm³ in the mixing ratio required for processing both components in accordance with the /PCR Part B/ for Reactive resin products.
Consumption per unit area of the products to be applied extensively can range between only a few hundred grams and more than 1 kg per square metre. In the case of products, which are injected, the application volume depends on the component to be injected.
The results of the Life Cycle Assessment provided in this declaration have been calculated from the product with the highest environmental impact (worst-case scenario).

Declared unit

Name	Value	Unit
Declared unit	1	kg
Conversion factor to 1 kg	1	-

3.2 System boundary

Modules A1-A3, A4, A5 and D are taken into consideration in the LCA:

- A1 Production of preliminary products
- A2 Transport to plant
- A3 Production incl. provision of energy, production of packaging as well as auxiliaries and consumables, waste treatment)
- A4 Transport to site
- A5 Installation (disposal of packaging & installation losses and emissions during installation)
- D Credits from incineration of packaging materials & installation losses and recycling the metal container

The Declaration is therefore from "cradle to gate - with options".

3.3 Estimates and assumptions

Where no specific GaBi processes were available, the individual recipe ingredients of formulation were estimated on the basis of information provided by the manufacturer or literary sources.

3.4 Cut-off criteria

All raw materials submitted for the formulations and production data were taken into consideration.
The manufacture of machinery, plants and other infrastructure required for production of the products under review was not taken into consideration in the LCA.
Transport of packaging materials is also excluded.

3.5 Background data

Data from the GaBi 6 database was used as background data. Where no background data was available, it was complemented by manufacturer information and literary research.

3.6 Data quality

Representative products were applied for this EPD and the product in a group displaying the highest environmental impact was selected for calculating the LCA results. The datasets are no more than 5 years old.
Production data and packaging are based on details provided by the manufacturer. The formulation used for evaluation refers to a specific product.

3.7 Period under review

Representative formulations were accepted by FEICA Ltd and collected in 2011.

3.8 Allocation

No allocations were applied for production. A multi-input allocation with a credit for electricity and thermal energy was used for incineration of production residues and packaging materials. The credits achieved through packaging disposal are declared in Module D.

3.9 Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to /EN 15804/ and the building context, respectively the product-specific characteristics of performance, are taken into account.

. In this case, 1 kg reactive resin was selected as the declared unit. Depending on the application, a corresponding conversion factor such as the specific unit area must be taken into consideration.

4. LCA: Scenarios and additional technical information

The following technical information forms the basis for the declared modules or can be used for developing specific scenarios in the context of a building evaluation if modules are not declared (MND).

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	0.0016	l/100km
Transport distance	1000	km
Capacity utilisation (including empty runs)	85	%
Gross density of products transported	1000 - 1250	kg/m³
Capacity utilisation volume factor	1	-

Installation into the building (A5)

Name	Value	Unit
Material loss	0.01	kg

5. LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE NOT DECLARED)

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	**A2**	**A3**	**A4**	**A5**	**B1**	**B2**	**B3**	**B4**	**B5**	**B6**	**B7**	**C1**	**C2**	**C3**	**C4**	**D**
X	X	X	X	X	MND	MND	MNR	MNR	MNR	MND	MND	MND	MND	MND	MND	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 kg Reactive resins based on polyurethane, containing solvent, solvent content between 10% and 50%

Parameter	Unit	A1-A3	A4	A5	D
Global warming potential	[kg CO_2-Eq.]	5.37E+0	5.04E-2	1.29E-1	-1.16E-1
Depletion potential of the stratospheric ozone layer	[kg CFC11-Eq.]	4.17E-9	2.07E-13	4.67E-13	-1.77E-11
Acidification potential of land and water	[kg SO_2-Eq.]	1.18E-2	1.29E-4	1.66E-5	-3.88E-4
Eutrophication potential	[kg $(PO_4)^{3-}$-Eq.]	1.34E-3	3.19E-5	3.09E-6	-3.02E-5
Formation potential of tropospheric ozone photochemical oxidants	[kg ethene-Eq.]	2.32E-3	-3.50E-5	1.80E-1	-4.80E-5
Abiotic depletion potential for non-fossil resources	[kg Sb-Eq.]	2.43E-5	1.98E-9	1.28E-9	-6.05E-9
Abiotic depletion potential for fossil resources	[MJ]	1.13E+2	6.94E-1	2.40E-2	-1.33E+0

RESULTS OF THE LCA - RESOURCE USE: 1 kg Reactive resins based on polyurethane, containing solvent, solvent content between 10% and 50%

Parameter	Unit	A1-A3	A4	A5	D
Renewable primary energy as energy carrier	[MJ]	5.16E+0	IND	IND	IND
Renewable primary energy resources as material utilization	[MJ]	0.00E+0	IND	IND	IND
Total use of renewable primary energy resources	[MJ]	5.16E+0	3.89E-2	2.70E-3	-7.42E-2
Non-renewable primary energy as energy carrier	[MJ]	9.45E+1	IND	IND	IND
Non-renewable primary energy as material utilization	[MJ]	2.45E+1	IND	IND	IND
Total use of non-renewable primary energy resources	[MJ]	1.19E+2	6.97E-1	2.85E-2	-1.47E+0
Use of secondary material	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of renewable secondary fuels	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of non-renewable secondary fuels	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of net fresh water	[m^3]	2.60E-2	6.82E-5	3.16E-4	-2.28E-4

RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES:
1 kg Reactive resins based on polyurethane, containing solvent, solvent content between 10% and 50%

Parameter	Unit	A1-A3	A4	A5	D
Hazardous waste disposed	[kg]	1.47E-5	3.31E-7	8.35E-9	-1.79E-7
Non-hazardous waste disposed	[kg]	1.92E-1	9.92E-5	1.42E-3	7.65E-4
Radioactive waste disposed	[kg]	2.23E-3	9.52E-7	1.78E-6	-5.38E-5
Components for re-use	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Materials for recycling	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Materials for energy recovery	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Exported electrical energy	[MJ]	0.00E+0	0.00E+0	1.83E-1	0.00E+0
Exported thermal energy	[MJ]	0.00E+0	0.00E+0	4.25E-1	0.00E+0

6. LCA: Interpretation

All impacts are associated with the production phase (A1-A3). The most significant contribution to the production phase impacts is the upstream production of raw materials as main driver. Another substantial contributor in the production phase, in the category of Abiotic Depletion Potential Elements (**ADPE**), is the steel sheet used as packaging material. Emissions associated with the manufacturing of products also have some influence on Photochemical Ozone Creation Potential (**POCP**) in the production phase. In all EPDs, CO_2 is the most important contributor to Global Warming Potential (**GWP**). For the Acidification Potential (**AP**), NO_x and SO_2 contribute to the largest share. In some cases, HCl in water also impacts AP due to the use of TiO_2.

The majority of life cycle energy consumption takes place during the production phase (A1-A3). Significant contributions to Primary Energy Demand – Non-renewable (**PENRT**) come from the energy resources used in the production of raw materials. The largest contributor to Primary Energy Demand – Renewable (**PERT**) impacts comes from the consumption of renewable energy resources required for the generation and supply of electricity. It should be noted that Primary Energy Demand – Renewable (**PERT**) generally represents a small percentage of the production phase primary energy demand with the bulk of the demand coming from non-renewable energy resources.

Transportation to the construction site (A4) and the installation process (A5) contribute to a negligible extent to all impacts. Scrap burdens and energy credit reported in module D are not important (contribution <2.5% for most results).

7. Requisite evidence

VOC
Special tests and evidence have not been carried out or provided within the framework of drawing up this Model EPD. Some member states require special documentation on VOC emissions into indoor air for specific areas of application. This documentation, as well as documentation for voluntary VOC labelling, has to be provided separately and is specific for product in question.

Evidence pertaining to VOC emissions shall show
- either an attestation of compliance with,
- or documentation of test data that are required in,

any of the existing regulations or in any of the existing voluntary labeling programs for low-emitting products, as far as these
(1) include limits for the parameters TVOC, TSVOC, carcinogens, formaldehyde, acetaldehyde, LCI limits for individual substances (including but not limited to the European list of harmonized LCIs), and the R value;
(2) base their test methods on /CEN/TS 16516/ (or /EN 16516/, after the on-going revision of /CEN/TS 16516/);
(3) perform testing and apply the limits after 28 days storage in a ventilated test chamber, under the conditions specified in /CEN/TS 16516/; some regulations and programs also have limits after 3 days, on top of the 28 days limits;
(4) express the test results as air concentrations in the European Reference Room, as specified in /CEN/TS 16516/.

Examples of such regulations are the /Belgian Royal Decree C-2014/24239/, or the German /AgBB/. Examples of such voluntary labeling programs are /EMICODE/, /Blue Angel/ or /Indoor Air Comfort/.

Relevant test results shall be produced either by an /ISO 17025/ accredited commercial test lab, or by a qualified internal test lab of the manufacturer.
Examples for the applied limits after 28 days storage in a ventilated test chamber are:
- TVOC: 1000 µg/m³
- TSVOC: 100 µg/m³
- Each carcinogen: 1 µg/m³
- Formaldehyde: 100 µg/m³
- LCI: different per substance involved
- R value: 1 (meaning that, in total, 100% of the combined LCI values must not be exceeded).

Informative Annexes (2 tables):
The table shown below is an overview of the most relevant regulations and specifications as of April 2015, as regards requirements after 3 days storage in a ventilated test chamber.

	TVOC [µg/m³]	Sum of carcinogens. C1A,CA2 [µg/m³]	Formal-dehyde [µg/m³]	Acet-aldehyde [µg/m³]	Sum of Form- and Acet-aldehyde
German DIBt/AgBB regulation	10 000	10	-/-	-/-	-/-
draft Lithuanian regulation	10 000	10	-/-	-/-	-/-
EMICODE EC1	1 000	10	50	50	50 ppb
EMICODE EC1 *PLUS*	750	10	50	50	50 ppb

The table above provides an overview of the most relevant regulations and specifications as of April 2015, as regards requirements after 28 days storage in a ventilated test chamber. Some details may be missing in the table due to lack of space. Values given represent maximum values/limits.

	TVOC [µg/m³]	TSVOC [µg/m³]	Each carcinogen C1A,CA2 [µg/m³]	Formaldehyde [µg/m³]	Acetaldehyde [µg/m³]	LCI	R value	Specials	Sum non-LCI & non-identified [µg/m³]
Belgian regulation	1000	100	1	100	200	Belgian list	1	Toluene 300 µg/m³	-/-
French regulations class A+	1000	-/-	-/-	10	200	-/-	-/-	List of 8 VOCs, 4 CMR	-/-
French regulations class A	1500	-/-	-/-	60	300	-/-	-/-	List of 8 VOCs, 4 CMR	-/-
French regulations class B	2000	-/-	-/-	120	400	-/-	-/-	List of 8 VOCs, 4 CMR	-/-
French regulations class C	>2000	-/-	-/-	>120	>400	-/-	-/-	List of 8 VOCs, 4 CMR	-/-
German DIBt/AgBB regulation	1000	100	1	100	1200	German AgBB list	1	-/-	100
draft Lithuanian regulation	1000	100	1	product type specific	-/-	Lithua-nian list	1	-/-	-/-
EMICODE EC1	100	50	1	(after 3 days)	(after 3 days)	-/-	-/-	-/-	-/-
EMICODE EC1 *PLUS*	60	40	1	(after 3 days)	(after 3 days)	German AgBB list	1	-/-	40
Finnish M1, sealants	20	-/-	1	10	-/-	-/-	-/-	Ammonia, odour	-/-
Finnish M1, adhesives	200 µg/m²h	-/-	5 µg/m²h	50 µg/m²h	-/-	-/-	-/-	Ammonia, odour	-/-

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