



ENVIRONMENTAL PRODUCT DECLARATION

RAW A/S confirms that the products

RAW All Year Foam
RAW NBS All Year Foam
RAW PU Foam with Straw
RAW Joint Foam Flex
RAW Elastic Expanding Polyurethane Foam

are compliant with Model EPD:

Declaration number: EPD-FEI-20220108-IBG1-EN

Sample identification: RAW All Year Foam, NBS All Year Foam, PU Foam with Straw,
Joint Foam Flex, Elastic Expanding Polyurethane Foam

Product type: Products based on polyurethane or silane-modified polymer, group 4

The Association of the European Adhesive and Sealant Industry (FEICA) developed model Environmental Product Declarations for different types of sealants and adhesives. These declarations were certified by IBU (Institut Bauen und Umwelt/Institute Building and Environment).

FEICA members and their customers, are authorized to use these model EPD's.

This declaration confirms the compliance of above mentioned product with the specific model EPD.

11.09.2024

A handwritten signature in blue ink, appearing to read "Stuart Kilpatrick", is written over a light blue circular stamp.

Stuart Kilpatrick
Operational Excellence Manager

Authorisation for the use of FEICA Model Environmental Product Declarations (EPDs)

FEICA, the Association of the European Adhesive and Sealant Industry, has published Model EPDs for the products of FEICA members and their customers used in the construction sector. They can be downloaded from the websites of the IBU¹, ECO² or directly from the FEICA³ website.

Unlike product-specific and average declarations, the FEICA Model EPDs are structured according to chemical composition and cover all products within a certain range of formulations and applications. Each FEICA Model EPD represents the worst-case product within its group of representative products, and therefore covers any product with an overall lower environmental impact. In order to determine whether or not a product is covered, FEICA has developed internal guidance for FEICA members.

FEICA hereby confirms that FEICA members and their customers are entitled to use the internal FEICA guidance to determine whether its products are covered by the FEICA Model EPDs. FEICA members and their customers therefore have the right to make reference to the FEICA Model EPDs for its products as long as it has verified compliance. FEICA recommends entitled companies to publish a self-declaration certifying compliance of a specific product with the relevant FEICA Model EPD.

¹ <http://construction-environment.com/hp11212/EPD-Overview.htm>

² <http://www.eco-platform.org/list-of-all-eco-epd.html>

³ <http://www.feica.eu/our-priorities/key-projects/epds.aspx>

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ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	DBC, EFCC, FEICA, IVK
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-FEI-20220108-IBG1-EN
Issue date	1-6-2022
Valid to	31-5-2027

Products based on polyurethane or silane-modified polymer, group 4

DBC - Deutsche Bauchemie e.V.

EFCC - European Federation for Construction Chemicals

FEICA - Association of the European Adhesive and Sealant Industry

IVK - Industrieverband Klebstoffe e.V.

www.ibu-epd.com | <https://epd-online.com>



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Construction Chemicals
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Adhesive and Sealant Industry
IVK - Industrieverband Klebstoffe e.V.

Products based on polyurethane or silane-
modified polymer, group 4

Programme holder

IBU – Institut Bauen und Umwelt e.V.
Hegelplatz 1
10117 Berlin
Germany

Owner of the declaration

DBC, Mainzer Landstr. 55, D-60329
Frankfurt a.M.
EFCC, 172 Boulevard du Triomphe, B-1160
Brussels
FEICA, Rue Belliard 40, B-1040
Brussels IVK, Völklingerstr. 4, D-
40219 Düsseldorf

Declaration number

EPD-FEI-20220108-IBG1-EN

Declared product / declared unit

1 kg product based on polyurethane
or silanemodified polymer; density
0.85 - 1.8 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 verified EPD 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
members of DBC, EFCC, FEICA and IVK
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 secretariats of the four
associations. The members of the
associations are listed on the respective
websites.

Issue date

1-
6-2022

Valid to

31-
5-2027

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.

The EPD was created according to the specifications of *EN 15804+A2*. In the following, the standard will be simplified as *EN 15804*.

Verification

The standard *EN 15804* serves as the
core PCR
Independent verification of the
declaration and data according to *ISO*
14025:2011

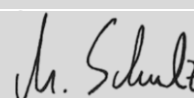
internally
externally



Dipl. Ing. Hans Peters
(chairman of Institut Bauen und Umwelt e.V.)



Dr. Alexander Röder
(Managing Director Institut Bauen und Umwelt e.V.)



Matthias Schulz
(Independent verifier)

2. Product

1. General Information

2.1 Product description/Product

definition This EPD comprises reactive products based on polyurethane (PU) or silane-modified polymer (SMP) with a volatile organic compound (VOC) content >10 % and ≤50 % (VOC definition according to *Decopaint Directive*) and a castor oil-/derivatives content ≤10 %. The one- or two-component reactive PU products are manufactured using polyols and isocyanates. Reactive products based on SMP polymers are usually manufactured as a one-component system from polyols and alkoxy silane in a preliminary stage. The aqueous systems consist of (a) dispersion and are crosslinked by a dispersible isocyanate. The products fulfil manifold, often specific, functions in the construction, furnishing and repair of buildings. The product displaying the highest environmental impacts was used as a representative product for calculating the Life Cycle Assessment results (worst-case approach).

For the placing on the market in the European Union/European Free Trade Association (EU/EFTA) with the exception of Switzerland) products falling under 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

Products based on polyurethane or silane-modified polymer, group 4, are used for the following applications:

Module 1: Adhesives for parquet and floor coverings

Parquet adhesives in accordance with *EN ISO 17178* for wooden and parquet floors and flooring adhesives in accordance with *EN ISO 22636* for floor coverings

Module 2: Reactive products for protecting and repairing concrete structures

Products for increasing the durability of concrete and reinforced concrete structures as well as for new concrete and for maintenance and repair work (requirements 2.1), products for structural bonding of strengthening materials to an existing concrete structure (requirements 2.2) and products for concrete injection for filling cracks, voids and interstices in concrete (requirements 2.3)

Module 3: Liquid-applied roof

waterproofing kits Reactive products for waterproofing roof constructions which are applied on site

Module 4: Reactive products for liquid-applied bridge deck waterproofing kits

Products for liquid-applied waterproofing for use on concrete bridge decks

Module 5: Screed material, floor screeds and decorative floors

Products for screed/synthetic resin screed for use in floor constructions

Module 6: Reactive products as an adhesive for tiles

Tile adhesives for internal and external tile installations on walls, floors and ceilings

Module 7: Adhesives and sealants

Reactive products for use as:

- Structural and repair adhesives
- Surface and joint sealants

Applications in accordance with the manufacturer's

technical documentation/declaration of performance

Module 8: Reactive products for watertight covering kits

Products for waterproofing floors and/or walls in wet rooms inside buildings

Module 9: Reactive products for liquid-applied waterproofing

Liquid applied products for waterproofing of buildings

Module 10: Reactive products for waterproofing and/or for pre-treating mineral substrates Applications in accordance with the manufacturer's technical documentation

Module 11: Liquid-applied waterproofing membranes for use beneath ceramic tiling

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 regularly and irregularly shaped spaces between at least two surfaces made of typical building materials with a one-component foam (OCF)

Module 13: Sealants for glazing Two component reactive sealants are to be used as the second barrier of the structural hermetic seal in insulating glass units.

Module 14: Bonded glazing sealants One and two component reactive sealants are used for the bonding of insulating glass units in the window frame.

2.3 Technical Data

The density of the products is between 0,85 and 1,8 g/cm³, other relevant technical data can be found in the manufacturer's technical documentation.

Module 1: Reactive products as adhesive for parquet and floor coverings

The minimum requirements of *EN ISO 17178* and *EN ISO 22636* must be maintained.

Module 2: Reactive products for protecting and repairing concrete structures

2.1 The requirements on essential characteristics for all intended uses in accordance with *EN 1504-2*, Tables 1 and 5 must be maintained. These are: - Permeability to CO₂ (*EN 1062-6*)

- Water vapour permeability (*EN ISO 7783-1/-2*)

- Capillary absorption and permeability to water (*EN 1062-3*)

- Adhesive strength by pull-off test (*EN 1542*)

2.2 Essential characteristics for all intended uses in accordance with *EN 1504-4*, Tables 3.1 and 3.2 (manufacturer's declaration of performance) **2.3** Requirements on essential characteristics for all intended uses in accordance with *EN 1504-5*, Table 3:

- Injectability (*EN 1771*)

- Viscosity (*EN ISO 3219*)

Further essential characteristics in accordance with the manufacturer's technical documentation/declaration of

performance

Module 3: Liquid-applied roof waterproofing kits

The minimum requirements of *EAD 030350-00-0402* Liquid-applied roof waterproofing kits must be maintained. The essential characteristics are to be specified in accordance with the European Technical Assessment (ETA, specification no.).

Module 4: Reactive products for liquid-applied bridge deck waterproofing kits

The minimum requirements of *ETAG 033*

Liquidapplied bridge deck waterproofing kits must be maintained. The essential characteristics are to be specified in accordance with the European Technical Assessment (ETA, specification no.).

Module 5: Screed material, floor screeds and decorative floors

The requirements on essential characteristics according to 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)

- Reaction to fire (EN 13501-1)

Further essential characteristics in accordance with the manufacturer's technical documentation / declaration

of performance

Module 6: Reactive products as an adhesive for tiles

The requirements on essential characteristics according to EN12004, must be maintained. These are:

-Tensile adhesion strength after dry storage (EN 12004-2)

-Tensile adhesion strength after water immersion (EN 12004-2)

-Tensile adhesion strength after heat ageing (EN 12004-2)

-Tensile adhesion strength after freeze/thaw cycles (EN 12004-2)

-Open time: Tensile strength (EN 12004-2)
Further essential characteristics in accordance with the manufacturer's technical documentation

Module 7: Adhesives and sealants

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

Module 8: Reactive products for watertight covering kits

The minimum requirements of EAD 030352-00-0503 Liquid applied watertight covering kits for wet room floors and/or walls must be maintained. The essential characteristics are to be specified in accordance with the European Technical Assessment (ETA, specification no.).

Module 9: Reactive products for liquid-applied waterproofings

The minimum requirements of the test principles regarding the issuing of general building authority test certificates for liquid-applied products for waterproofing of buildings (PG-FLK) must be maintained. The characteristics for the proof of usability are to be specified in accordance with the test principles for granting general building authority test certificates for liquid applied polymer products for waterproofing buildings

Module 10: Reactive products for waterproofing and/or for pre-treating mineral substrates

Name	Value	Unit
Density acc. to EN ISO 2811-1	700 - 1800	kg/m ³
Shore hardness A acc. to ISO 484	>15	
Shore hardness D acc. to ISO 484	>5	
Viscosity acc. to ISO 3219-2	<100	Pas

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

Module 11: Liquid-applied waterproofing membranes for use beneath ceramic tiling

The minimum requirements on essential characteristics according to EN 14891 - Liquid applied water-impermeable products for use beneath ceramic tiling - Definitions, specifications and test methods- must be maintained. These are:

- Initial tensile adhesion strength

- Tensile adhesion strength after water contact
- Tensile adhesion strength after heat ageing
- Tensile adhesion strength after freeze-thaw cycles
- Waterproofing
- Crack bridging ability

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 *EN 17333-4*, Movement Capability *EN 17333-4*, Curing Pressure *EN 17333-2*, Thermal conductivity *EN 17333-5*, Sound Insulation *EN ISO 717-1*, Post expansion *EN 17333-2*

12.2 Door Installation & Fixation

Shear Strength *EN 17333-4*, Tensile Strength *EN 17333-4*, Compression Strength *EN 17333-4*,

Curing pressure *EN 17333-2*

12.3 General Gap Filling Sagging *EN 17333-3*

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

Module 13: Sealants for glazing

Reactive sealants must comply with *EN 1279-4*
Performance characteristics in accordance with the manufacturer's technical documentation/declaration of performance

Module 14: Bonded glazing sealants

Reactive sealants must comply with *RAL-GZ 716 part 2* and *ift-Guideline VE-08/4*.

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

2.4 Delivery status

Liquid or pasty in containers made of tinplate or plastic packed in separate or combi-containers for the required mixing ratio. Packages containing one kg of product in different types of containers. Sealants in plastic cartridges and foil packs. Typical container sizes contain 10 to 25 kg of material. For major works, vats containing approx. 200 kg or IBCs (intermediate bulk containers) containing 1 tonne or more are also used. The LCA is based on tinplate, plastic and wood packaging.

2.5 Base materials/Ancillary materials

Products based on polyurethane or silane-modified polymer with a VOC content >10 % and ≤50 % and a castor oil/-derivatives content ≤10 % usually comprise a reactive polymer and a crosslinking system. The polymer component contains polyether and/or polyester polyols. Crosslinking takes place after installation on site. In the case of two-component systems, this involves the use of pre-polymers and polymers based on typically methylene diphenyl diisocyanate (MDI), toluene diisocyanate (TDI), hexamethylene diisocyanate (HDI) or isophorone diisocyanate (IPDI). The resin mixing ratio is adjusted according to the stoichiometric requirements. Crosslinking starts directly after the components have been mixed. There are also one-component reactive polymer formulations based on PU or SMP which crosslink in the presence of moisture. They comprise prepolymers based on e.g. MDI, TDI, HDI, IPDI or those with alkoxy-silane groups in the case of SMP formulations. In formulations with aqueous dispersions, dispersible isocyanates are used for crosslinking. The formulations can contain auxiliary materials such as accelerators, catalysts, wetting agents, foam regulators and viscosity regulators for fine-tuning the product features. Typically, the products covered by this EPD contain the following ranges of base materials and auxiliaries:

Polyol component: up to approx. 50 %

Crosslinking component: up to approx. 95 %

SMP component: up to approx. 80 %

Plasticiser: ~ 0-25 %

Additives / Pigments: ~ 0-30 %

Water: ~ 0-60 %

VOC: >10 % and ≤50 % according to the
Decopaint

Directive (mandatory)

Castor oil and derivatives: ≤10 % **(mandatory)**

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).

Note: For companies to declare their products within the scope of this EPD it is not sufficient to simply comply with the product composition shown above. The application of this EPD is only possible for member companies of DBC, EFCC, FEICA, and IVK member associations and only for specific formulations with a total score below the declared maximum score for a product group according to the associated guidance document.

1. substances from the “Candidate List of Substances of Very High Concern for Authorisation” (SVHC)

If this product contains substances listed in the candidate list (latest version) exceeding 0.1 percentage by mass, the relevant information can be found in the safety data sheet of the relevant product covered by this model EPD. **2. CMR substances in categories 1A and 1B**

If this product contains other carcinogenic, mutagenic, reprotoxic (CMR) substances in categories 1A or 1B which are not on the

candidate list, exceeding 0.1 percentage by mass, the relevant information can be found in the safety data sheet of the relevant product covered by this model EPD.

3. Biocide products added to the construction product

If this construction product contains biocide products, the active substances, information on the concentration and/or concentration range, the product type together with information on their hazardous properties are listed in the safety data sheet of the respective product.

2.6 Manufacture

The components of the formulation are usually mixed batch-wise and packaged for delivery.

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

Products based on polyurethane or silane-modified polymer, are processed by trowelling/knife-coating or rolling, pouring, spraying or injection.

Precautions for safe handling and storage (e.g. air exchange, exhaust ventilation, personal protective measures, precautions required in the handling of isocyanates, conditions for safe storage) must be observed in accordance with the information on the safety data sheet.

2.9 Packaging

A detailed description of packaging is provided in section 2.4. Empty containers and clean foils can be recycled.

2.10 Condition of use

During the use phase, products based on polyurethane or silane-modified polymer 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 make an essential contribution in retaining their function and long-term value.

2.11 Environment and health during use

Option 1: Products for applications outside indoor areas with permanent stays by people

During use, the reactive products lose their reactive properties and become 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 (see chapter

polyurethane systems do not melt or drip, they do not contribute towards spreading fire.

Water

Cured reactive products based on polyurethane or silane-modified polymer are chemically inert and insoluble in water. They are often used to protect building structures from harmful water ingress or the effects of flooding.

Mechanical destruction

Mechanical destruction of cured reactive products based on polyurethane or silane-modified polymer does not lead to any decomposition products which are harmful to the environment or health.

2.14 Re-use phase

3. LCA: Calculation rules

7). No further influences by emissions on the environment and health are known.

2.12 Reference service life Cured products based on polyurethane or silanemodified polymer fulfil manifold, often specific functions 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, cured products based on polyurethane or silane-modified polymer comply with at least the requirements of *EN 13501-1* standard for fire classes E and Efl. In terms of the volumes applied, they have only a marginal influence on the fire performance characteristics (e.g. smoke gas development) of the building structure in which they have been installed. As crosslinked

According to present knowledge, no environmentally harmful effects are generally anticipated in landfilling, for example, as a result of de-construction and recycling of building materials with adherent crosslinked products. If the crosslinked products can be removed from construction products without large effort, thermal recovery is a practical recycling variant on account of their energy content. Minor adhesion is not taken into consideration during disposal. It does not interfere with the disposal/recycling of the remaining components/building materials.

2.15 Disposal

Residual material which cannot be used or recycled must be combined at a specified ratio and hardened. Hardened product residue is not special waste. Nonhardened product residue is hazardous 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 into consideration the local guidelines. The following waste codes according to the European List of Waste (*2000/532/EC*) can apply:

Hardened product residue:

European Waste Catalogue (EWC) code 080112 (waste paint and varnish with the exception of that mentioned in 08 01 11)

EWC code 080410 (waste adhesives and sealants other than mentioned in 08 04 09)

3.1 Declared Unit

This EPD refers to the declared unit of 1 kg of product based on polyurethane or silanemodified polymer, group 4; applied into the building with a density of 0.85 - 1.8 g/cm³ in accordance with the *IBU PCR* part B for reaction resin products.

The results of the Life Cycle Assessment provided in this declaration have been selected from the product with the highest environmental impact (worst-case scenario).

Depending on the application, a corresponding conversion factor such as the density to convert volumetric use to mass must be taken into consideration.

The Declaration type is according to *EN 15804*: Cradle to gate with options, modules C1–C3, and module D (A1–A3, C, D) and additional modules.

Declared unit

Name	Value	Unit
Declared unit	1	kg
Gross density	0.85 - 1.8	g/cm ³
Conversion factor to 1 kg	-	-

3.2 System boundary

Modules A1, A2 and A3 are taken into consideration in the LCA:

- A1 Production of preliminary products
- A2 Transport to the plant
- A3 Production incl. provision of energy, production of packaging as well as auxiliaries and consumables and waste treatment
- A4 Transport to site
- A5 Installation, product applied into the building during A5 phase operations and packaging disposal. This stage considers VOC emissions during the installation phase. The declared product does not contain substances

2.16 Further information

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

in the formulation that directly emit (as) VOC, but VOCs are generated by a chemical reaction that are occurring during this phase. The end of life for the packaging material considered is described below:

-Incineration, for materials like plastic and wood.

-Landfill, for inert material like metals (where used).

-C1-C2-C3-D

The building deconstruction (demolition process) takes place in the C1 module which considers energy production and consumption in terms of diesel and all the emissions connected with the fuel-burning process to run the machines. After the demolition, the product is transported to the end-of-life processing (C2 module) where all the impacts related to the transport processes are considered. For precautionary principle and as a worst-case scenario, thermal treatment is the only end-of-life scenario considered. This is modelled by the incineration process (module C3) where the product ends its life cycle.

Module D accounts for potential benefits that are beyond the defined system boundaries. Credits are generated during the incineration of wastes and related electricity produced that are occurring in the A5 module.

3.3 Estimates and assumptions

For this EPD formulation and production data defined and collected by FEICA were considered. Production waste was assumed to be disposed of by incineration without credits as a worst-case. An average of steel and plastic containers, and wooden pallets was considered in the LCA.

3.4 Cut-off criteria

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

Transport of packaging materials is excluded.

3.5 Background data

Data from the *GaBi* database SP40 (2020) was used as background data.

3.6 Data quality

Representative products were applied for this EPD and the product in the group displaying the highest environmental impact was selected for calculating the LCA results. The background data sets used are less than 4 years old.

Production data and packaging are based on details provided by the manufacturer. The

formulation used for evaluation refers to a specific product. The data quality of the background data is considered to be good.

3.7 Period under review

Representative formulations are valid for 2021.

3.8 Allocation

Mass allocation has been applied when primary data have been used and implemented into the LCA model.

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.

The *GaBi* database SP40 (2020) was used.

4. LCA: Scenarios and additional technical information

Characteristic product properties Information on biogenic Carbon

The packaging material contains biogenic carbon content which is presented below.

waste		
Incineration	0.67	kg

Information on describing the biogenic Carbon Content at factory gate

Name	Value	Unit
Biogenic Carbon Content in product	0	kg C
Biogenic Carbon Content in accompanying packaging	0.016	kg C

Transport to the building site (A4)

Name	Value	Unit
Transport distance	1000	km
Gross weight	34 - 40	t
Payload capacity	27	t

Assembly (A5)

Name	Value	Unit
Other resources for packaging material	0.1	kg
Material loss	0.01	kg

Material loss regards the amount of product not used during the application phase into the building. This amount is 1% of the product, impacts related to the production of this part are charged to the A5 module. This percentage is considered as waste to disposal and impacts of its end of life have been considered in the LCA model and declared in A5.

End of life (C1-C3)

Name	Value	Unit
Collected as mixed construction	0.67	kg

5. LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; ND = MODULE OR INDICATOR NOT DECLARED; MNR = MODULE NOT RELEVANT)

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-constructive 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	ND	ND	MNR	MNR	MNR	ND	ND	X	X	X	ND	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 kg of product based on polyurethane or silane modified polymer, group 4

Core Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	D
GWP-total	[kg CO ₂ -Eq.]	6.36E+0	5.27E-2	1.96E-1	1.87E-4	8.29E-3	1.48E+0	-6.53E-1
GWP-fossil	[kg CO ₂ -Eq.]	6.28E+0	5.22E-2	1.08E-1	1.78E-4	7.93E-3	1.48E+0	-6.51E-1
GWP-biogenic	[kg CO ₂ -Eq.]	7.23E-2	1.52E-4	8.73E-2	8.28E-6	3.63E-4	5.91E-5	-1.53E-3
GWP-luluc	[kg CO ₂ -Eq.]	1.08E-2	4.22E-4	1.12E-4	4.28E-9	1.87E-7	1.40E-5	-4.58E-4
ODP	[kg CFC11-Eq.]	4.06E-9	6.27E-18	4.06E-11	1.90E-20	8.30E-19	1.75E-16	-6.83E-15
AP	[mol H ⁺ -Eq.]	1.16E-2	1.56E-4	1.44E-4	2.41E-6	2.50E-5	8.76E-4	-9.14E-4
EP-freshwater	[kg P-Eq.]	1.09E-5	1.59E-7	1.14E-7	3.85E-11	1.68E-9	2.95E-8	-8.43E-7
EP-marine	[kg N-Eq.]	3.39E-3	6.96E-5	4.22E-5	1.10E-6	1.15E-5	4.23E-4	-2.36E-4
EP-terrestrial	[mol N-Eq.]	3.62E-2	7.80E-4	4.79E-4	1.20E-5	1.27E-4	4.87E-3	-2.53E-3
POCP	[kg NMVOC-Eq.]	1.25E-2	1.38E-4	3.37E-1	3.29E-6	2.27E-5	1.09E-3	-6.78E-4
ADPE	[kg Sb-Eq.]	1.34E-5	3.74E-9	1.35E-7	5.40E-12	2.36E-10	3.11E-9	-1.07E-7
ADPF	[MJ]	1.34E+2	6.94E-1	1.40E+0	2.55E-3	1.11E-1	3.93E-1	-1.10E+1
WDP	[m ³ world-Eq deprived]	8.54E-1	4.66E-4	2.21E-2	3.53E-7	1.54E-5	1.46E-1	-6.78E-2

Caption: GWP = Global warming potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential of land and water; EP = Eutrophication potential; POCP = Formation potential of tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for nonfossil resources; ADPF = Abiotic depletion potential for fossil resources; WDP = Water (user) deprivation potential

RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: 1 kg of product based on polyurethane or silane modified polymer, group 4

Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	D
PERE	[MJ]	8.62E+0	3.90E-2	6.84E-1	8.05E-6	3.51E-4	5.51E-2	-2.42E+0
PERM	[MJ]	5.85E-1	0.00E+0	-5.85E-1	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PERT	[MJ]	9.21E+0	3.90E-2	9.93E-2	8.05E-6	3.51E-4	5.51E-2	-2.42E+0
PENRE	[MJ]	1.09E+2	6.95E-1	1.00E+1	2.56E-3	1.12E-1	1.68E+1	-1.10E+1
PENRM	[MJ]	2.50E+1	0.00E+0	-8.60E+0	0.00E+0	0.00E+0	-1.64E+1	0.00E+0
PENRT	[MJ]	1.34E+2	6.95E-1	1.40E+0	2.56E-3	1.12E-1	3.93E-1	-1.10E+1
SM	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
RSF	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0

NRSF	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
FW	[m³]	2.98E-2	4.52E-5	6.18E-4	1.44E-8	6.30E-7	3.43E-3	-2.81E-3
Caption	PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water							

RESULTS OF THE LCA – WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 kg of product based on polyurethane or silane modified polymer, group 4

Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	D
HWD	[kg]	3.35E-5	3.23E-8	3.35E-7	2.48E-13	1.08E-11	2.24E-10	-4.41E-9
NHWD	[kg]	2.74E-1	1.06E-4	4.85E-2	2.61E-7	1.14E-5	7.42E-3	-5.12E-3
RWD	[kg]	2.27E-3	8.60E-7	2.46E-5	2.74E-9	1.20E-7	1.59E-5	-8.27E-4
CRU	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
MFR	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
MER	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
EEE	[MJ]	0.00E+0	0.00E+0	2.12E-1	0.00E+0	0.00E+0	0.00E+0	0.00E+0
EET	[MJ]	0.00E+0	0.00E+0	3.86E-1	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Caption	HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EEE = Exported thermal energy							

RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional: 1 kg of product based on polyurethane or silane modified polymer, group 4

Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	D
PM	[Disease Incidence]	ND	ND	ND	ND	ND	ND	ND
IRP	[kBq U235Eq.]	ND	ND	ND	ND	ND	ND	ND
ETP-fw	[CTUe]	ND	ND	ND	ND	ND	ND	ND
HTP-c	[CTUh]	ND	ND	ND	ND	ND	ND	ND
HTP-nc	[CTUh]	ND	ND	ND	ND	ND	ND	ND
SQP	[-]	ND	ND	ND	ND	ND	ND	ND
Caption	PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index							

Potential Human exposure efficiency relative to U235, Disclaimer 1 – This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, radon and (from) some construction materials is also not measured by this indicator.

ADP minerals & metals, ADP fossil, WDP, ETF-fw, HTP-c, HTP-nc, SQP, Disclaimer 2 – The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator.

Additional environmental impact indicators (suggested by EN15804, table 4) are not declared in the EPD. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high and as there is limited experience with the indicator (see ILCD classification in EN 15804, table 5). For this reason, results based on these indicators are not considered suitable for a decision-making process and are thus not declared in the EPD.

6. LCA: Interpretation

The majority of 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 the main driver. Another substantial contributor in the production phase, in the category of Abiotic depletion potential for nonfossil resources (ADPminerals& metals), is the steel sheet used as a packaging material. Emissions associated with the manufacturing of products also have some influence on the Formation potential of tropospheric ozone (POCP) in the production phase. In all EPDs, CO₂ is the most important contributor to Global Warming Potential (GWP). For the Acidification Potential (AP), NO_x and SO₂

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) make a low contribution to all impacts.

The installation phase influences mainly the Photochemical ozone formation indicator, due to the emission of VOC during the operations.

7. Requisite evidence

contribute the largest share. In some cases, HCl in water also impacts AP due to the use of TiO₂ as a pigment. The majority of life cycle energy consumption takes place during the production phase (A1-A3). Significant contributions to Primary Energy Demand – Nonrenewable (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 **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 labelling programs for low-emitting products, as far as these

These emissions are not only directly related to the preproducts in the resins, but they are related to the reaction products between pre-products and air components (water and oxygen). The end-of-life phases influence climate change indicators, due to the incineration processes occurring in the C3 module, the process used for modelling the thermal treatment process of the resin.

- (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 *EN 16516*;
- (3) perform testing and apply the limits after 28 days of storage in a ventilated test chamber, under the conditions specified in *EN 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 *EN 16516*.

Examples of such regulations are the *Belgian Royal Decree C-2014/24239*, or the *German AgBB/ABG*. Examples of such voluntary

labelling 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 of 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): Table 1 shown below is an overview of the most relevant regulations and specifications as of October 2021, as regards requirements after 3 days of storage in a ventilated test chamber.

	TVOC µg/m ³	Sum of carcinogens. C1A, CA2 µg/m ³	Formaldehyde µg/m ³	Acetaldehyde µg/m ³	Sum of Form- and Acetaldehyde
German AgBB/ABG regulation	10 000	10	-/-	-/-	-/-
Belgian regulation	10 000	10	-/-	-/-	-/-
EMICODE EC1	1 000	10	50	50	50 ppb
EMICODE EC1 <i>PLUS</i>	750	10	50	50	50 ppb

	TVOC µg/m ³	TSVOC µg/m ³	Each carcinogen C1A, CA2 µg/m ³	Formalde- hyde µg/m ³	Acetalde- hyde µg/m ³	LCI	R value	Specials	Sum of non-LCI & non- identified µg/m ³
Belgian regulation	1000	100	1	100	200	Belgian list	1	Toluene 300 µg/m ³	-/-
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	300	German AgBB list	1	-/-	100
EMICODE EC1	100	50	1	(after 3 days)	(after 3 days)	-/-	-/-	-/-	-/-
EMICODE EC1 <i>PLUS</i>	60	40	1	(after 3 days)	(after 3 days)	German AgBB list	1	-/-	40
Finnish M1, sealants	20	-/-	1	10	300	EU LCI list	-/-	Ammonia, odour	-/-
Finnish M1, adhesives	200 µg/m ² h	-/-	5 µg/m ² h	50 µg/m ² h	300	EU LCI list	-/-	Ammonia, odour	-/-

8. References

ETAG 033 Liquid applied bridge deck
waterproofing kits **ISO 48-4**

Table 2 provides an overview of the most relevant regulations and specifications as of October 2021, as regards requirements after 28 days of 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.

ISO 48-4:2018, Rubber, vulcanized or thermoplastic - Determination of hardness- Part 4: Indentation

hardness by durometer method (Shore hardness)

EN ISO 717-1

EN ISO 717-1:2020 Acoustics - Rating of sound insulation in buildings and of building elements - Part 1: Airborne sound insulation

EN 1062-3

EN 1062-3:2008-04, Paints and varnishes - Coating materials and coating systems for exterior masonry and concrete - Part 3: Determination of liquid water permeability

EN 1062-6

EN 1062-6:2002-10, Paints and varnishes - Coating materials and coating systems for exterior masonry and concrete - Part 6: Determination of carbon dioxide permeability

EN 1279-4

EN 1279-4:2002 Glass in building - Insulating glass units - Part 4: Methods of test for the physical attributes of edge seals

EN 1504-2

EN 1504-2:2004-12, Products and systems for the protection and repair of concrete structures - Definitions, requirements, quality control and evaluation of conformity - Part 2: Surface protection

systems for concrete

EN 1504-4

EN 1504-4:2004-11, Products and systems for the protection and repair of concrete structures - Definitions, requirements, quality control and

evaluation of conformity- Part 4: Structural bonding

EN 1504-5

EN 1504-5:2004-12, Products and systems for the protection and repair of concrete structures - Definitions, requirements, quality control and

evaluation of conformity - Part 5: Concrete injection

EN 1542

EN 1542:1999-07, Products and systems for the protection and repair of concrete structures - Test

methods - Measurement of bond strength by pull-off

EN 1771

EN 1771:2004-11, Products and systems for the protection and repair of concrete structures - Test methods - Determination of injectability and splitting test

ISO 2811-1

ISO 2811-1:2016, Paints and varnishes -

Determination of density - Part 1: Pycnometer method

EN ISO 3219

EN ISO 3219:1994-10, Plastics - Polymers/resins in the liquid state or as emulsions or dispersions - Determination of viscosity using a rotational viscometer with defined shear rate

ISO 3219-2

ISO 3219-2:2021, Rheology - Part 2: General

principles of rotational and oscillatory rheometry

EN ISO 7783

EN ISO 7783:2019-02, Paints and varnishes - Determination of water-vapour transmission properties

- Cup method

EN 12004

EN12004:2012, Adhesives for ceramic tiles

EN 12004-1

EN 12004-1:2017, Adhesives for ceramic tiles – Part 1: Requirements, assessment and verification of

constancy of performance, classification and marking

EN 12004-2

EN 12004-2:2017, Adhesives for ceramic tiles - Part 2:

Test methods

EN 13501-1

EN 13501-1:2018, Fire classification of construction products and building elements - Part 1: Classification using data from reaction to fire tests

EN 13813

EN 13813:2002-10, Screed material and floor screeds

- Screed materials - Properties and requirements

EN 13892-8

EN 13892:2003-02, Methods of test for screed

materials - Part 8: Determination of bond strength

ISO 14025

DIN EN ISO 14025:2011-10, Environmental labels and declarations — Type III environmental declarations —

Principles and procedures

EN 14891

EN 14891:2012-04, Liquid applied water impermeable products for use beneath ceramic

tiling - Definitions, specifications and test methods

EN 15804

EN 15804:2019+A2, Sustainability of construction works — Environmental Product Declarations — Core

rules for the product category of construction products

EN 16516

EN 16516:2017

Construction products - Assessment of release of dangerous substances - Determination of emissions

into indoor air

EN ISO 17025

EN ISO 17025:2018-03

General requirements for the competence of testing and calibration laboratories

EN ISO 17178

EN ISO 17178:2020-06, Adhesives - Adhesives for bonding parquet to subfloor - Test methods and minimum requirements

EN 17333-2

EN 17333-2:2020+AC:2020, Characterisation of one

component foam - Part 2: Expansion characteristics

EN 17333-3

EN 17333-3:2020, Characterisation of one component

foam - Part 3: Application

EN 17333-4

EN 17333-4:2020, Characterisation of one component foam - Part 4: Mechanical strength

EN 17333-5

EN 17333-5:2020, Characterisation of one component

foam - Part 5: Insulation

EN ISO 22636

EN ISO 22636:2020, Adhesives - Adhesives for floor coverings - Requirements for mechanical and electrical

performance

EAD 030350-00-0402

EAD 030350-00-0402:2018-08, Liquid Applied Roof

Waterproofing Kits

EAD 030352-00-0503

EAD 030352-00-0503:2019-01, Liquid applied

watertight covering kits for wet room floors and/or walls

2000/532/EC

Commission decision dated 3 May 2000 replacing decision 94/3/EC on a waste directory in accordance with Article 1 a) of Council Directive 75/442/EEC on waste and Council decision 94/904/EC on a directory of hazardous waste in terms of Article 1, paragraph 4

of Directive 91/689/EEC on hazardous waste

Belgian Royal Decree C-2014/24239

Belgisch Staatsblad 8 MEI 2014, p. 60603. — Koninklijk besluit tot vaststelling van de drempelniveaus voor de emissies naar het binnenmilieu van bouwproducten voor bepaalde geogde gebouwen

Blue Angel

Environmental label organised by the federal government of Germany www.blauer-engel.de

CPR

CPR Regulation (EU) No 305/2011 of the European Parliament and of the Council of 9 March 2011 laying down harmonised conditions for the marketing of

construction products and repealing Council Directive

89/106/EEC

Decopaint Directive

Directive 2004/42/CE of the European Parliament and the council of 21 April 2004 on the limitation of emissions of volatile organic compounds due to the use of organic solvents in certain paints and varnishes and vehicle refinishing products and amending

Directive 1999/13/EC

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PCR Part A

Product Category Rules for Building-Related Products and Services, Part A: Calculation Rules for the Life Cycle Assessment and Requirements on the Project

report, Version 1.1, Institut Bauen und Umwelt e.V.,

2021-01

PCR Part B

Product Category Rules for Construction Products, Part B: Reaction resin products, Institut Bauen und

Umwelt e.V., 2019-01

RAL-GZ 716

RAL-GZ 716:2019-04 part 2, Kunststoff-

Fensterprofilsysteme - Gütesicherung

REACH

Directive (EG) No. 1907/2006 of the European

Parliament and of the Council dated 18

December 2006 on the registration, evaluation, approval and restriction of chemical substances (REACH), for establishing a European Agency for chemical substances, for amending Directive 1999/45/EC and for annulment of Directive (EEC) No. 793/93 of the Council, Directive (EC) No. 1488/94 of the

Commission, Guideline 76/769/EEC of the Council and Guidelines 91/155/EEC, 93/67/EEC, 93/105/EC and 2000/21/EC of the Commission.



Publisher

Institut Bauen und Umwelt e.V.
Hegelplatz 1
10117 Berlin
Germany

Tel +49 (0)30 3087748-0 +49
Fax (0)30 3087748- 29
Mail info@ibu-epd.com
Web www.ibu-epd.com



Programme holder

Institut Bauen und Umwelt e.V.
Hegelplatz 1
10117 Berlin
Germany

Tel +49 (0)30 - 3087748- 0 +49
Fax (0)30 - 3087748 - 29
Mail info@ibu-epd.com
Web www.ibu-epd.com



Author of the Life Cycle Assessment

Sphera Solutions GmbH
Hauptstraße 111- 113
70771 Leinfelden-Echterdingen
Germany

Tel
Fax +49 711 341817-0 +49
Mail 711 341817-25
Web info@sphera.com
www.sphera.com

Owner of the Declaration

FEICA - Association of the
European Adhesive and Sealant
Industry
Avenue E. van Nieuwenhuyse 2
B-1160 Brussels
Belgium

+32 (0)267 673 20 +32
(0)267 673 99
Tel info@feica.eu
Fax www.feica.eu



Industrieverband Klebstoffe e.V
Völklinger Straße 4
40219 Düsseldorf
Germany

+49 (0)211 67931-10 +49
(0)211 67931-33
Tel info@klebstoffe.com
Fax www.klebstoffe.com



EFCC - European Federation for
Construction Chemicals
Boulevard du Triomphe 172
1160 Brussels
Belgium

+32289720-39 +32289720-
37 info@efcc.be
Tel www.efcc.eu



Deutsche Bauchemie e.V.
Mainzer Landstr. 55
60329 Frankfurt
Germany

+49 (0)69 2556-1318 +49 (0)69
2556-1319 info@deutsche-
bauchemie.de www.deutsche-bauchemie.de

Tel
Fax
Mail
Web



FEICA

The Association of the European Adhesive & Sealant Industry
Avenue E. van Nieuwenhuyse, 4 • B-1160 Brussels • Belgium

Phone: +32 (0)2 676 73 20 • Fax: +32 (0)2 676 73 99 • E-mail: info@feica.eu
VAT: BE 0884 334 548 • IBAN: BE75 3630 1746 0451 • BIC/Swift: BBRUBEBB