

# EC4 Workstation With Screens

## Environmental Product Declaration

An EPD should provide current information and may be updated if conditions change.

The stated validity is therefore subject to the continued registration and publication at [www.environdec.com](http://www.environdec.com)

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# Introduction

This Environmental Product Declaration (EPD) is for the KI (Krueger International, Inc) EC4 Workstation - four person bench with two C series screens. The total bench area is 1600 X 3200mm. This is a cradle to grave EPD based upon production information and data collected by KI from their producers in 2020.

KI has the sole ownership, liability and responsibility of this EPD

This EPD was modelled in SimaPro 9.0.0.24 using data from Ecoinvent version 3.5 and World Steel data for the EU sourced steel.

“EPDs within the same product category but from different programmes may not be comparable.”

## Programme Information

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**Product category rule:** Furniture, except seats and mattresses. Product category classification: UN CPC 3812/3813/3814. Version 2.0. Valid until: 2023-06-17

**PCR reviewed by:** Arper SpA, 2B Srl

**EPD registration number:** S-P-02070

**CPC code:** 3812

**Type of EPD:** Cradle to grave

**EPD geographical scope:** Europe

**Product Codes:** WK2/1632/2/4

**Declared unit:** One item EC4 Workstation - four person Bench with two C series screens in use for 15 years.

**Third Party Verifier:** Chris Foster, EuGeos Limited

**Approved by:** The International EPD® System

Independent third-party verification of the declaration and data, according to ISO 14025:2006:

EPD process certification       EPD verification

**Life Cycle Assessment (LCA) conducted by:** Giraffe Innovation Ltd.

[www.giraffeinnovation.com](http://www.giraffeinnovation.com)



# Company Profile

KI's furniture helps the world's leading organisations create happy, healthy, high performing working and learning environments for their people. Bringing together good design, advanced engineering and sustainable resources, KI's products are durable, flexible and offer excellent value.

Founded in 1941, KI has grown to become one of the world's largest, most respected furniture manufacturing groups. KI's EMEA headquarters in London is supported by an established network of manufacturing facilities and distribution partners across the region. For more information, visit: [www.kieurope.com](http://www.kieurope.com)

## Standards

The EC4 Workstation has been tested to:

- BS EN 527-1:2011 Office furniture. Work tables and desks. Dimension.

## Product Description

This EPD applies to EC4 Workstation - four person Bench 1600 X 3200mm with two particle board C series screens covered in Blazer Lite Foam Backed fabric and weighs approximately 203kg. The product was manufactured for KI in Kirkbymoorside, North Yorkshire and Tiptree, Essex UK.

All of the product's framework is manufactured from cold rolled European sheet steel which is cut to size and formed into the main body parts. These are then powder coated and assembled together.

The work surface is made from melamine faced chipboard (MFB) with ABS edging

The EC4 Workstation bench & desk system is constructed using a simple, easily assembled and very stable modular under structure featuring solid oak legs. The basic construction comprises a set of end legs and powder coated metal frame connected by transverse rails that support the worksurfaces. Longer runs can be achieved adding intermediate legs and additional rails as required. The metal frame is available in two colours as standard.

For distribution each completed unit is placed on a pallet and covered in LDPE film and strapped into place. They are generally supplied to the customer via a warehouse. The average European delivery distance to a customer is 500km using a 18t Euro 5 lorry and the pallets have a typical lifespan of 10 uses<sup>1</sup>.

The product carries a 25 year warranty for the under structure and screen and 5 years for the worktop.

<sup>1</sup> <https://circulareconomy.europa.eu/platform/en/good-practices/reuse-and-recycling-loading-pallets>

Apart from regular cleaning, KI workstations are considered to be maintenance free. The Work tops are easy to maintain, simply use a damp cloth and a mild detergent solution or non-abrasive cleaner to keep the surface clean and hygienic

At the end of life, the products can be reused, recycled or disposed of. This EPD is calculated on the basis that 15% of the items are reused and 84% recycled and 1% landfilled. It is assumed that the product packaging is either recycled, incinerated or landfilled and the percentage of each is dependent upon the different types of material. The recycling rates of the packaging is shown in Table 1<sup>2</sup>.

Material	% Recovery/Recycling rate
Paper and cardboard	79%
Polymers	46.2%
Wood	31.4%

Table 1: Packaging material recovery and recycling rates

The average distance the units and packaging travel for recycling, reuse or disposal is 50Km.

## Materials

The steel used in the KI products is sourced from Europe and has 56% recycled content<sup>3</sup>.

The powder coating process lines use water-based cleaning systems prior to powder painting to clean parts as opposed to solvent-based cleaning systems. Powder coatings are baked onto the metal components using natural gas fired ovens. The powder coatings contain negligible VOC and Hazardous Air pollutant (HAP) contents. Add-on pollution control equipment is not necessary given the very low levels of pollutants.

The MFB contains 75% recycled wood content.

The carton board is assumed to contain 75% recycled content as defined in the Ecoinvent dataset.

A breakdown of the product materials and packaging is given below (Table 2):

Material	% of mass
MFB	45%
Wood	26%
Metal	20%
Carton board & card	5%
Other	2%
Polymers	2%

Table 2: Material by % mass

<sup>2</sup>Defra UK statistics on waste March 2019

<sup>3</sup>World Steel Association LCI report in 2012

# EPD Scope

This is a cradle to grave EPD which is broken down as required into the following processes:

- Upstream processes (cradle to gate) - material and parts production;
- Core processes (gate to gate) - forming of steel sheet, coating, product assembly, packaging and waste treatment of scrap steel;
- Downstream process (gate to gate) distribution, use and end of life waste treatment

The inputs and outputs and travel are captured in each process as shown in Figure 1.

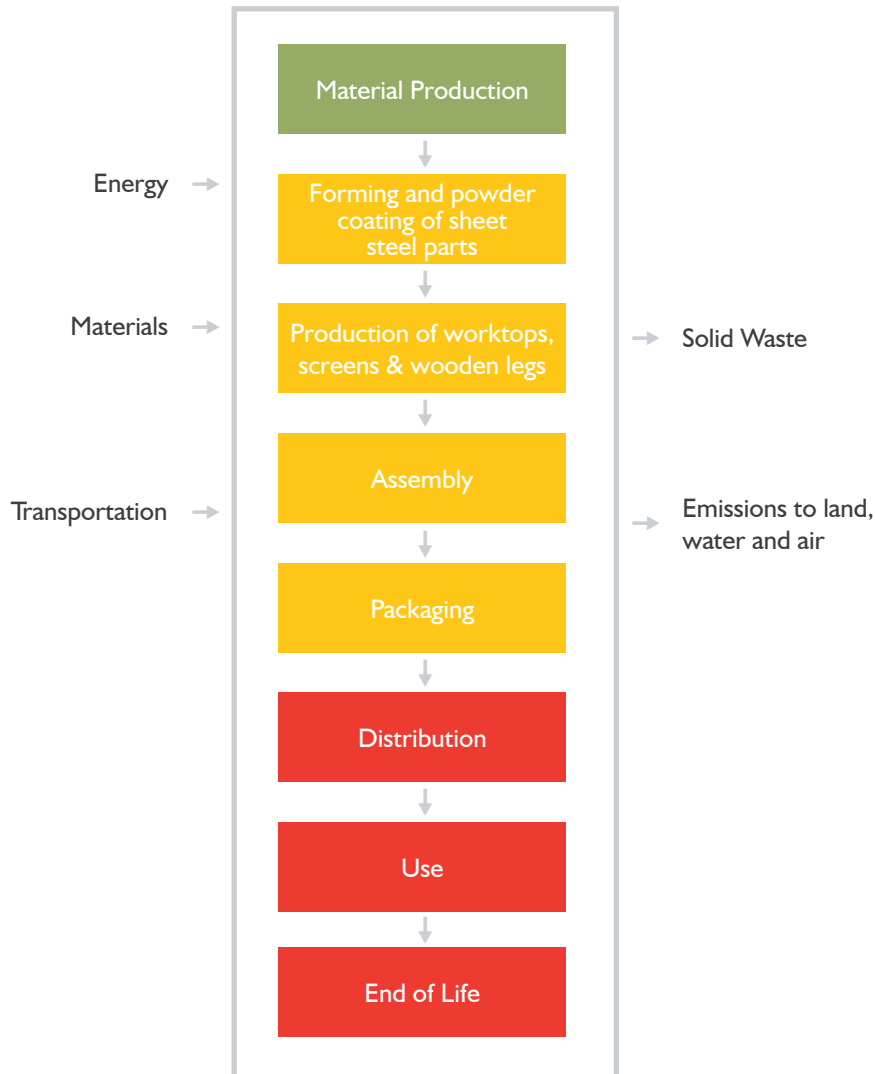


Figure 1: Product life cycle and boundary

## Functional Unit

The functional unit is for a 4 person EC4 bench 1600 X 3200mm with two particle board C series screens covered in Blazer Lite Foam Backed fabric, including use and maintenance for 15 years. The expected lifetime is approx. 25 years.

# Data Source and Data Quality

The analysis conforms to ISO 14044 series standard which acknowledges the life cycle assessment requirements of key phases beginning with goal and scope definition, inventory, analysis, impact assessment, and interpretation. Each of these phases, along with their associated databases and models, can have associated uncertainties. It is important to acknowledge these uncertainties in decisions regarding design development and improvement, strategic planning, public policy making, or product marketing.

The key sources of data used for the LCA were as follows:

- Primary data was supplied by KI and their manufacturing contractors, and
- Ecoinvent v3.5 database (2018), standard data sets on energy, environmental impacts of moulding processes, material production, waste disposal and recycling.
- Data on materials and material sourcing, production energy use, waste, logistic, use etc was collected from KI based upon 2019 and 2020 production.

## Exclusions and Cut-Off Criteria

When building a life cycle inventory, it is typical to exclude items considered to have a negligible contribution to results. To do this in a robust manner there must be confidence that the exclusion is fair and reasonable. Therefore, cut-off criteria are defined, which allow items to be neglected if they meet the criteria. In this study exclusions could be made if they were expected to be within the below criteria:

- Mass: if a flow is anticipated to be less than 1% of the mass of the product it may be neglected;
- Energy: if a flow is anticipated to be less than 1% of the cumulative energy it may be neglected; and
- Environmental significance: if a flow is anticipated to be less than 1% of the key impact categories it may be excluded

If an item meets one of the criteria but is expected to be significant to one of the other criteria it may not be neglected. For example, if a chemical is small in mass but is expected to have a notable contribution to the environmental results then it may not be excluded.

Life cycle stages that have been omitted from the scope of the study include the following:

- Human energy inputs to processes;
- Infrastructure and capital goods; and
- Transport of employees to and from their normal place of work

## Allocation

Ecoinvent default allocation was applied to all processes, except for secondary material use, where cut off allocation is applied.

## Assumptions and Estimates

The following assumptions were made:

- Indicative transport modes including lorry and ship type used for the transportation of the materials;
- Production losses through all the processes and these have been based upon supplied data;
- Primary energy used as materials was calculated based upon the gross calorific values of materials;.
- Primary energy used as fuel was calculated by deducting the energy used as materials from the primary energy demand; and
- Secondary materials used including the recycled steel, carton board recycled content and the used pallets.

# Environmental Results

The results of the environmental analysis in accordance with the Product Category Rules (PCR) are shown in the following tables:

Parameter		Unit	Upstream	Core	Downstream	Total
Global Warming Potential (GWP)	Fossil kg CO <sub>2</sub> eq.	kg CO <sub>2</sub> eq.	2.16E+02	4.45E+01	3.00E+01	2.90E+02
	Biogenic kg CO <sub>2</sub> eq.	kg CO <sub>2</sub> eq.	7.91E+01	7.90E+00	1.29E+02	2.16E+02
	Land use and land transformation	kg CO <sub>2</sub> eq.	8.35E-01	3.26E-02	8.00E-03	8.76E-01
	<b>TOTAL</b>	<b>kg CO<sub>2</sub> eq.</b>	<b>2.96E+02</b>	<b>5.24E+01</b>	<b>1.59E+02</b>	<b>5.07E+02</b>
Acidification potential (AP)		kg SO <sub>2</sub> eq.	1.71E+00	1.08E-01	1.13E-01	1.93E+00
Eutrophication potential (EP)		kg PO <sub>4</sub> <sup>3</sup> eq.	4.38E-01	2.83E-02	3.96E-01	8.62E-01
Formation potential of tropospheric ozone (POCP)		kg NMVOC eq.	1.05E+00	9.72E-02	1.41E-01	1.29E+00
Abiotic depletion potential – Elements (ADPE)		kg Sb eq.	4.41E-03	4.41E-05	6.78E-05	4.53E-03
Abiotic depletion potential – Fossil fuels (ADPF)		MJ, net calorific value	2.82E+03	6.47E+02	3.83E+02	3.845E+03
Water scarcity potential		m <sup>3</sup> eq.	1.88E+02	5.05E+00	2.46E+00	1.96E+02

Table 3: Environmental impacts

Parameter		Unit	Upstream	Core	Downstream	Total
Primary energy resources - Renewable	Use as energy carrier (PERE)	MJ, net calorific value	1.68E+03	9.78E+01	4.68E+00	1.78E+03
	Use as raw material (PERM)	MJ, net calorific value	2.09E+03	0.00E+00	0.00E+00	2.09E+03
	<b>Total (PERT)</b>	<b>MJ, net calorific value</b>	<b>3.77E+03</b>	<b>9.78E+01</b>	<b>4.68E+00</b>	<b>3.87E+03</b>
Primary energy resources - Non-renewable	Use as energy carrier (PENRE)	MJ, net calorific value	2.27E+03	8.86E+02	1.86E+03	3.57E+03
	Use as raw material (PENRM)	MJ, net calorific value	1.53E+03	0.00E+00	0.00E+00	1.53E+03
	<b>Total (PENRT)</b>	<b>MJ, net calorific value</b>	<b>3.79E+03</b>	<b>8.86E+02</b>	<b>4.15E+02</b>	<b>5.09E+03</b>
Secondary material (SM)		kg	1.11E+02	0.00E+00	0.00E+00	1.11E+02
Renewable secondary fuels (RSF)		MJ, net calorific value	0.00E+00	9.57E+01	0.00E+00	9.57E+01
Non-renewable secondary fuels (NRSF)		MJ, net calorific value	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Net use of fresh water (FW)		m <sup>3</sup>	5.00E+00	1.29E-01	8.50E-02	5.22E+00

Table 4: Use of resources

Parameter	Unit	Upstream	Core	Downstream	Total
Hazardous waste disposed (HWD)	kg	9.95E-03	7.74E-04	1.94E-04	1.09E-02
Non-hazardous waste disposed (NHWD)	kg	4.14E+01	3.31E+01	3.31E+01	1.08E+02
Radioactive waste disposed (RWD)	kg	2.24E-02	5.17E-03	2.25E-03	2.98E-02

Table 5: Waste production

Parameter	Unit	Upstream	Core	Downstream	Total
Components for reuse (CRU)	kg	0.00E+00	5.98E+00	2.72E+01	3.32E+01
Material for recycling (MFR)	kg	1.95E+01	2.54E+00	1.85E+02	2.07E+02
Materials for energy recovery (MER)	kg	0.00E+00	5.98E+00	2.04E+01	2.64E+01
Exported energy, electricity (EEE)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy, thermal (EET)	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00

Table 6: Output flows

Parameter	Unit	Upstream	Core	Downstream	Total
Human toxicity, cancer impacts cases	Cases	4.56E-05	9.61E-07	1.28E-06	4.79E-05
Human toxicity, non-cancer impacts cases	Cases	6.56E-05	4.84E-06	9.85E-06	8.03E-05
Fresh water ecotoxicity	PAF.m3.day	1.53E+06	1.06E+05	7.28E+05	2.36E+06
Land use	Species.yr	7.77E-07	3.62E-08	1.09E-04	8.24E-07

Table 7: Other environmental impacts



# References

Product category rule: Furniture, except seats and mattresses. Product category classification: UN CPC 3812/3813/3814. Version 2.0. Valid until: 2023-06-17.

General Programme Instructions For The International EPD® System Version 3.01. 2019-09-18.

Ecoinvent v3.5 database (2018).

ISO 14025:2006, Environmental labels and declarations – Type III Environmental declarations – Principles and procedures

ISO/TS 14027 Environmental labels and declarations -- Development of product category rules

ISO 14040 Environmental management – Life cycle assessment – Principles and framework

ISO 14044 Environmental management – Life cycle assessment – Requirements and guidelines

ISO 14046:2014, Environmental management – Water footprint – Principles, requirements and guidelines

ISO 19011 Guidelines for Auditing Management Systems

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