

INDUSTRIAL FURNACES AND OVENS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 43420

PCR 2022:10
VERSION 1.0.1

VALID UNTIL 2026-12-21

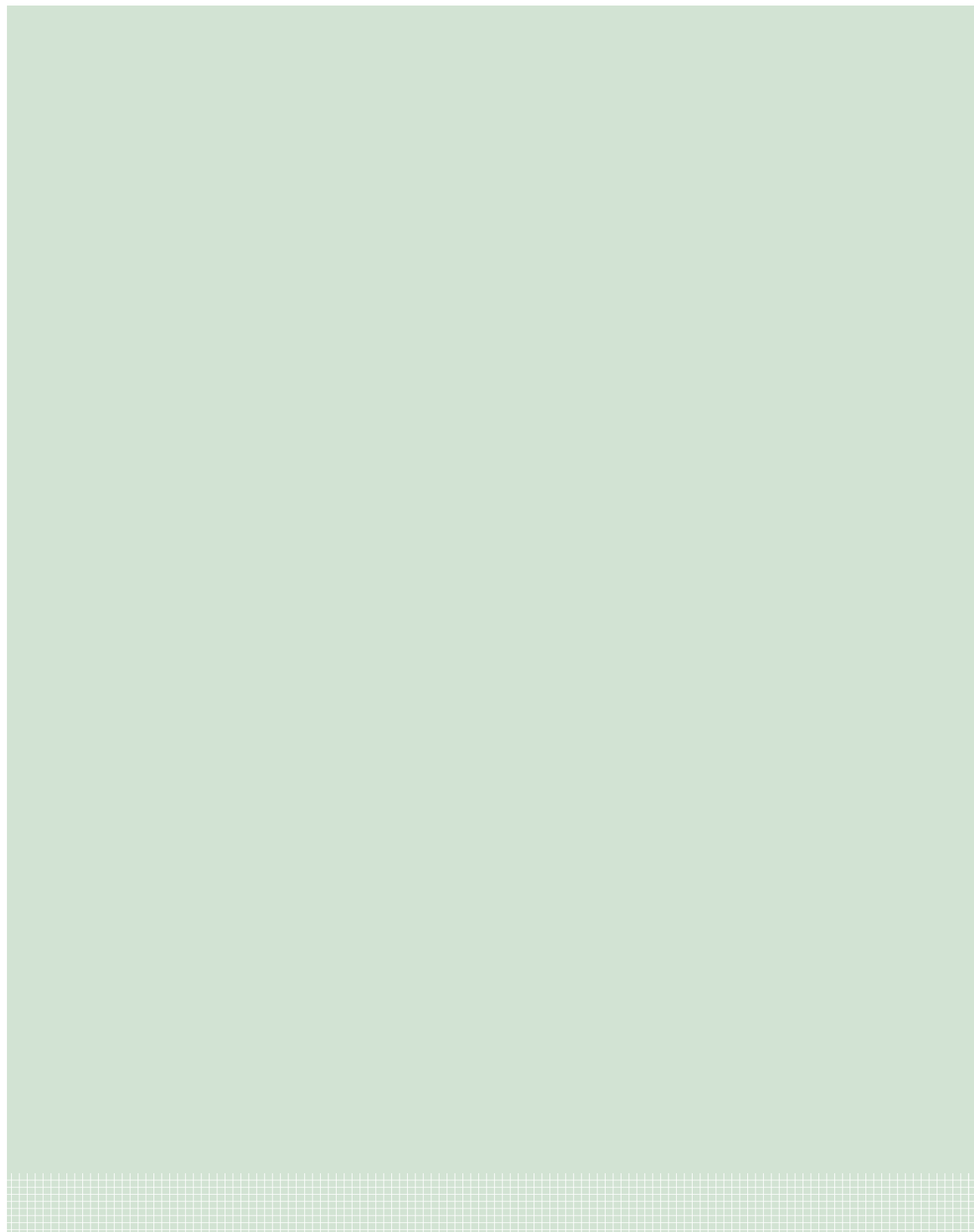


TABLE OF CONTENTS

1	Introduction	3
2	General information	4
2.1	Administrative information	4
2.2	Scope of PCR.....	4
3	PCR review and background information.....	7
3.1	Open consultation	7
3.2	PCR review	7
3.3	Existing PCRs for the product category	7
3.4	Reasoning for development of PCR.....	8
3.5	Underlying studies used for PCR development.....	8
4	Goal and scope, life cycle inventory and life cycle impact assessment	9
4.1	Functional unit	9
4.2	Technical specification, lifespan and reference service life (RSL)	9
4.3	System boundary	9
4.4	System diagram	12
4.5	Cut-off rules.....	12
4.6	Allocation rules	12
4.7	Data quality requirements and selection of data	13
4.8	Environmental performance indicators.....	17
4.9	Including multiple products in the same EPD.....	18
5	Content and format of EPD.....	19
5.1	EPD languages	19
5.2	Units and quantities	19
5.3	Use of images in EPD	20
5.4	EPD reporting format.....	20
6	List of abbreviations.....	27
7	References.....	28
8	Version history of PCR	29

1 INTRODUCTION

This document constitutes Product Category Rules (PCR) developed in the framework of the International EPD® System: a programme for type III environmental declarations¹ according to ISO 14025:2006, ISO 14040:2006, ISO 14044:2006, and product-specific standards such as EN 15804 and ISO 21930 for construction products. Environmental Product Declarations (EPD) are voluntary documents for a company or organisation to present transparent, consistent and verifiable information about the environmental performance of their products (goods or services).

The rules for the overall administration and operation of the programme are the General Programme Instructions (GPI), publicly available at www.environdec.com. A PCR complements the GPI and the normative standards by providing specific rules, requirements and guidelines for developing an EPD for one or more specific product categories (see Figure 1). A PCR should enable different practitioners using the PCR to generate consistent results when assessing products of the same product category.

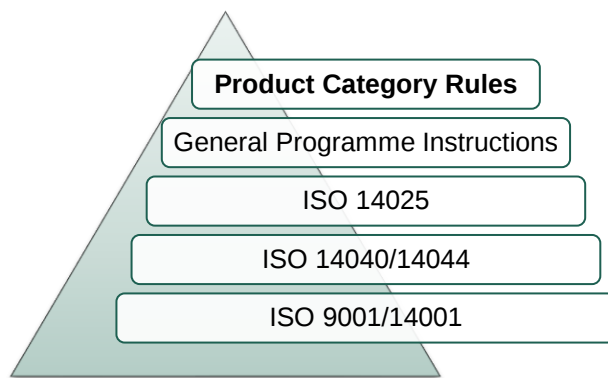


Figure 1 The hierarchy between PCRs, standards and other documents.

Within the present PCR, the following terminology is adopted:

The term “shall” is used to indicate what is obligatory, i.e. a requirement.

The term “should” is used to indicate a recommendation, rather than a requirement. Any deviation from a “should” requirement shall be justified in the PCR development process.

The terms “may” or “can” is used to indicate an option that is permissible.

For definitions of further terms used in the document, see the normative standards.

A PCR is valid for a pre-determined period of time to ensure that it is updated at regular intervals. The latest version of the PCR is available at www.environdec.com. Stakeholder feedback on PCRs is very much encouraged. Any comments on this PCR may be sent directly to the PCR Moderator and/or the Secretariat during its development or during its period of validity.

Any references to this document shall include the PCR registration number, name and version.

The programme operator maintains the copyright of the document to ensure that it is possible to publish, update, and make it available to all organisations to develop and register EPDs. Stakeholders participating in PCR development should be acknowledged in the final document and on the website.

¹ Type III environmental declarations in the International EPD® System are referred to as EPDs, Environmental Product Declarations.

2 GENERAL INFORMATION

2.1 ADMINISTRATIVE INFORMATION

Name:	Industrial furnaces and ovens
Registration number and version:	2022:10, version 1.0.1
Programme:	 The International EPD® System
Programme operator:	EPD International AB, Box 210 60, SE-100 31 Stockholm, Sweden. Website: www.environdec.com E-mail: info@environdec.com
PCR Moderator:	Mariangela Oriolo, Pro Iter Ambiente S.r.l., mariangela.oriolo@proiterambiente.it
PCR Committee:	Pro Iter Ambiente S.r.l., Studio Fieschi & soci S.r.l., Presezzi Extrusion S.p.A.
Date of publication and last revision:	2023-01-23 (version 1.0.1) See a version history of the PCR in Section 8.
Valid until:	2026-12-21
Schedule for renewal:	A PCR is valid for a pre-determined time period to ensure that it is updated at regular intervals. When the PCR is about to expire, the PCR Moderator shall initiate a discussion with the Secretariat how to proceed with updating the PCR and renewing its validity. A PCR may also be updated without prolonging its period of validity, provided significant and well-justified proposals for changes or amendments are presented. See www.environdec.com for the latest version of the PCR. When there has been an update of the PCR, the new version should be used to develop EPDs. The old version may however be used for 90 days after the publication date of the new version, as long as the old version has not expired.
Standards conformance:	General Programme Instructions of the International EPD® System, version 4.0, based on ISO 14025 and ISO 14040/14044
PCR language(s):	At the time of publication, this PCR was available in English. If the PCR is available in several languages, these are available at www.environdec.com . In case of translated versions, the English version takes precedence in case of any discrepancies.

2.2 SCOPE OF PCR

2.2.1 PRODUCT CATEGORY DEFINITION AND DESCRIPTION

This document provides Product Category Rules (PCR) for the assessment of the environmental performance of *industrial furnaces and ovens* and the declaration of this performance by an EPD. The product category corresponds to UN CPC 43420 Industrial furnaces and ovens, except non-electric bakery ovens; other industrial or laboratory induction or dielectric heating equipment.

INDUSTRIAL FURNACES AND OVENS
PRODUCT CATEGORY CLASSIFICATION: UN CPC 43420

This category includes any industrial or laboratory furnaces and ovens and any induction or dielectric heating equipment.

The hierarchical structure is:

- Division 43 – General-purpose machinery
 - Group 434 Ovens and furnace burners and parts thereof
 - Class 4342 Industrial or laboratory furnaces and ovens, except non-electric bakery ovens; other industrial or laboratory induction or dielectric heating equipment
 - Subclass 43420 - Industrial or laboratory furnaces and ovens, except non-electric bakery ovens; other industrial or laboratory induction or dielectric heating equipment.

This PCR excludes:

- Non-electric bakery ovens

The product group and CPC code shall be specified in the EPD.

The specification of the product should be based on one standard configuration with or without accessories. Since industrial furnaces and ovens can be highly customized to different purposes, the EPD shall include specifications of all physical modules², accessories³ and reconfigurations⁴ under declaration.

The contribution to the impact categories that the auxiliary elements generate in adding to those caused by standard configurations, should be reported separately.

The trade name (if relevant), species and the variety (if relevant) of product shall be declared. The production system should be specified, if relevant.

The EPD shall specify the technical performance and other relevant information describing the product. Table 1 reports the minimum information to be provided in the EPD. The information is mandatory any time they are applicable. If similar machines are included in the same EPD, this information shall be specific to each machine independently.

Operational parameters and specific conditions to which this technical information are referred shall be declared. In particular, material temperature at furnace inlet (T_0) and material temperature difference between start and end of heat treatment (ΔT) shall be declared both in the LCA study and in the EPD.

Table 1: Machines description and technical information

INFORMATION	EXAMPLES/EXPLANATIONS	Unit
Commercial name	As stated in the operating manual and sales catalogues	
Type of material worked	e.g. Aluminium 6005	
Input material dimensions	Length (X Axis), width (Y Axis), height (Z Axis) or diameter	mm
Max. heating temperature		°C
Max. skin temperature		°C
Taper		°C/m
Machine Size and dimension	Length (X Axis), width (Y Axis), height (Z Axis)	mm
Weight		kg
Main power supply		Phases/V/Hz

² Physical modules are machine parts that perform a specific function, made of several structural, hardware and/or software components.

³ Accessories are auxiliary elements whose incorporation into a standard configuration does not alter the primary function of the machine.

⁴ Reconfigurations are structural, hardware and/or software components substituted in order to quickly adjust the machine production capacity and functionality.

INFORMATION	EXAMPLES/EXPLANATIONS	Unit
Heating sections		n
Energy consumption		kWh/t
Energy consumption for cooling process (if relevant)		kWh/t
Productivity		t/h
Foreseen production		t/year
Installed Power		kW
Processing material(s) consumption		kg/y
Refrigerating fluid type and consumption	Air, water	kg/y – m³/y
List of physical modules and accessories included	e.g. Physical modules: Mobile pad, hydraulic units, etc. Accessories: billet loading/unloading system, chiller, etc.	

2.2.2 GEOGRAPHICAL SCOPE

This PCR may be used globally.

2.2.3 EPD VALIDITY

An EPD based on this PCR shall be valid for a 5-year period starting from the date of the verification report ("approval date"), or until the EPD has been de-registered from the International EPD® System.

An EPD shall be updated and re-verified during its validity if changes in technology or other circumstances have led to:

- an increase of 10% or more of any of the declared indicators of environmental impact,
- errors in the declared information, or
- significant changes to the declared product information, content declaration, or additional environmental, social or economic information.

If such changes have occurred, but the EPD is not updated, the EPD owner shall contact the Secretariat to de-register the EPD.

3 PCR REVIEW AND BACKGROUND INFORMATION

This PCR was developed in accordance with the PCR development process described in the GPI of the International EPD® System, including open consultation and review.

3.1 OPEN CONSULTATION

3.1.1 VERSION 1.0

This PCR was available for open consultation from 2022-03-31 until 2022-05-30, during which any stakeholder was able to provide comments by contacting the PCR Moderator and/or the Secretariat.

Stakeholders were invited via e-mail or other means to take part in the open consultation and were encouraged to forward the invitation to other relevant stakeholders. No stakeholders provided comments during the open consultation and agreed to be listed as contributors in the PCR and at www.environdec.com.

3.2 PCR REVIEW

3.2.1 VERSION 1.0

PCR review panel:	The Technical Committee of the International EPD® System. A full list of members is available at www.environdec.com . The review panel may be contacted via info@environdec.com . Members of the Technical Committee were requested to state any potential conflict of interest with the PCR Committee, and if there were conflicts of interest they were excused from the review.
Chair of the PCR review:	Paola Borla
Review dates:	2022-07-07 until 2022-11-11

3.3 EXISTING PCRS FOR THE PRODUCT CATEGORY

As part of the development of this PCR, existing PCRs and other internationally standardized methods that could potentially act as PCRs were considered to avoid unnecessary overlaps in scope and to ensure harmonisation with established methods of relevance for the product category. The existence of such documents was checked among the following EPD programmes and international standardisation bodies:

- International EPD® System. www.environdec.com.
- EPD Italy, www.epditaly.it.
- EPD Norge, www.epd-norge.no.
- UL Environment, <https://industries.ul.com/environment/transparency/product-category-rules-pcrs>.
- JEMAI EcoLeaf, <http://www.ecoleaf-jemai.jp/eng/pcr.html>.
- European Commission's Product Environmental Footprint (PEF) system, https://ec.europa.eu/environment/eussd/smqp/ef_pilots.htm#pef.

No existing PCRs with overlapping scope were identified.

Table 2 lists the identified PCRs and other standardized methods. The guidance in these PCRs listed were considered to harmonize reporting on the machinery sector.

Table 2 Existing PCRs and other internationally standardized methods that were considered to avoid overlap in scope and to ensure harmonisation with established methods.

NAME OF PCR/STANDARD	PROGRAMME/ STANDARDISATION BODY	REGISTRATION NUMBER, VERSION NUMBER/DATE OF PUBLICATION	SCOPE
Machine-tools for drilling, boring or milling metal	International EPD System	2012:02, version 3.02, 2019-09-06	Assessment of the environmental performance of machine tools for drilling, boring or milling metal.
Machine-tools for material working by removal of material	International EPD System	2021:10, version 1.0.1, 2022-01-10	Assessment of the environmental performance of machine tools for material working by removal of material

3.4 REASONING FOR DEVELOPMENT OF PCR

This PCR was developed to enable publication of EPDs for this product category based on ISO 14025, ISO 14040/14044. The PCR enables different practitioners to generate consistent results when assessing the environmental impact of products of the same product category, and thereby it supports comparability of products within a product category (assuming identical functional units have been chosen).

3.5 UNDERLYING STUDIES USED FOR PCR DEVELOPMENT

The methodological choices made during the development of this PCR (declared/functional unit, system boundary, allocation methods, impact categories, data quality rules, etc.) were primarily based on the following underlying study:

- Pretato U., Cropanise I., Masino P. (2022) Life cycle assessment of extrusion presses and ovens manufactured by Presezzi Extrusion. (Confidential)

4 GOAL AND SCOPE, LIFE CYCLE INVENTORY AND LIFE CYCLE IMPACT ASSESSMENT

The goal of this section is to provide specific rules, requirements and guidelines for developing an EPD for the product category as defined in Section 2.2.1.

4.1 FUNCTIONAL UNIT

The functional unit is defined as the thermal treatment of a material by means of an industrial furnace/oven during a Reference Service Life (RSL) of 20 years.

Industrial furnaces and ovens for thermal treatment can perform their function according to different operating parameters, therefore the functional unit above shall be completed with the following information:

- The type(s) of the material thermally treated.
- The corresponding operational set-up, and working conditions, of the product (oven set-up, energy consumption, type and amount of auxiliary materials used, type of operation, processing time, daily operating hours and annual operating days, etc.).

Such information may be linked with test campaigns. In addition to such information also sound assumptions on the actual use of the product during its lifespan shall be defined. Such data should be referred to data from final users or, alternatively, to reasonable expected use of the product.

To calculate the environmental performance results per functional unit, two further aspects shall be considered and declared in the EPD:

- The expected lifetime production in the RSL.
- The productivity according to the selected operational set-up.

The reference flow shall be set as the amount of furnace/oven needed to fulfil the functional unit (this may be less or more than one press, depending on the technical/actual lifespan of the press, see Section 4.2).

Results for an alternative functional unit, for example 1 tonne of metal thermally treated, may also be declared as additional environmental information.

4.2 TECHNICAL SPECIFICATION, LIFESPAN AND REFERENCE SERVICE LIFE (RSL)

The reference service life (RSL) of a product category is the reference time to which the performance of all products of a product category shall be related. The RSL is set as 20 years of expected lifetime at nominal operational conditions (daily operating hours and annual operating days).

The technical/actual lifespan of the furnace/oven shall also be declared. This is not necessarily the same as the RSL, meaning that the furnace/oven can be replaced during the RSL (i.e. through revamping, see Section 4.7.3.3) or that less than one furnace/oven is needed to fulfil the functional unit.

4.3 SYSTEM BOUNDARY

The scope of this PCR and EPDs based on it is from cradle-to-grave.

4.3.1 LIFE-CYCLE STAGES

For the purpose of different data quality rules and for the presentation of results, the life cycle of the product is divided into three life cycle stages:

- Upstream processes (from cradle-to-gate)
- Core processes (from gate-to-gate)
- Downstream processes (from gate-to-grave)

In the EPD, the environmental performance associated with each of the three life-cycle stages above shall be reported separately and in aggregated form. The processes included in the scope of the PCR and belonging to each life cycle stage are described in Sections 4.3.1.1–4.3.1.3.

4.3.1.1. Upstream processes

The following unit processes are part of the product system and shall be classified as upstream processes:

- extraction and production of raw materials for all parts of the product,
- recycling processes of secondary materials from other product life cycles,
- production of parts of the product,
- transportation of raw material and commercial products,
- the manufacturing of primary and secondary packaging, if relevant, and
- generation of electricity and production of fuels, steam and other energy carriers used in the upstream processes.

Upstream processes not listed may also be included. All elementary flows at resource extraction shall be included, except for the flows that fall under the general cut-off rule in Section 4.5.

4.3.1.2. Core processes

The following unit processes are part of the product system and shall be classified as core processes:

- external transportation to the core processes (e.g. materials, packaging to the factory),
- external transportation from the core processes (e.g. wastes to the landfills),
- production of auxiliary materials used in the core process,
- manufacturing of the product (e.g. welding, painting, assembly, etc.),
- internal transports within the manufacturing plant,
- testing of the product including the energy and materials used,
- waste treatment of waste generated during manufacturing,
- preparation and packaging of the final product for shipment, and
- generation of electricity and production of fuels, steam and other energy carriers used in core processes (see Section 4.7.3.2).

Core processes not listed may also be included. Manufacturing of a minimum of 99% of the total weight of the declared product including packaging shall be included.

The following processes shall not be included:

- manufacturing of production equipment, buildings and other capital goods,
- business travel of personnel,
- travel to and from work by personnel, and
- research and development activities.

4.3.1.3. Downstream processes

The following unit processes are part of the product system and shall be classified as downstream processes:

- transportation of the product to the user;
- installation of the product at site, including used material and energy, if relevant; potential waste generated from installation is also included;
- production of semi-consumables installed in the product at delivery (e.g. hydraulic fluid, etc.);

- operation of the product including energy and material consumptions and emissions (e.g. coolant, ancillary products etc.). If the treated material generates emissions during the thermal treatment process carried out with the product (i.e., the furnace) under analysis, those emissions are outside the scope of the LCA of the product, unless specific equipment to abate such releases is part of the product;
- ordinary maintenance, replacements of products parts, during the RLS;
- revamping activities including substitution of key parts of the product, which extends the lifespan of the product (if relevant);
- disassembling of the product;
- end-of-life treatment of the used product after use phase and final disassembly; and
- end-of-life processes of packaging waste and any wasted part of the product.
- generation of electricity and production of fuels, steam and other energy carriers used in the downstream processes.

4.3.2 OTHER BOUNDARY SETTING

4.3.2.1. Boundary towards nature

Boundaries to nature are defined as where the flows of material and energy resources leaves nature and enters the technical system (i.e. the product system). Emissions cross the system boundary to nature when they are emitted to air, soil or water.

4.3.2.2. Boundary towards other technical systems

Boundaries towards other technical systems define the flow of materials and components to/from the product system under study and from/to other product systems. If there is an inflow of recycled material to the product system in the production/manufacturing stage, the transport from the scrapyard/collection site to the recycling plant, the recycling process, and the transportation from the recycling plant to the site where the material is being used shall be included. If there is an outflow of material or component to recycling, the transportation of the material to the scrapyard/collection site shall be included. The material or component going to recycling is then an outflow from the product system.

See Section 4.6 for further guidance.

4.3.2.3. Temporal boundary

The temporal boundary defines the time period for which the life cycle inventory data is recorded, e.g. for how long emissions from waste deposits are accounted. As default, the time period over which inputs to and outputs from the product system is accounted for shall be 100 years from the year that the LCA model best represents, considering the representativeness of the inventory data. This year shall, as far as possible, represent the year of the publication of the EPD.

4.3.2.4. Geographical boundary

The geographical boundary defines the geographical coverage of the LCA. This shall reflect the physical reality of the product under study, accounting for the representativeness of technology, input materials and input energy.

4.4 SYSTEM DIAGRAM

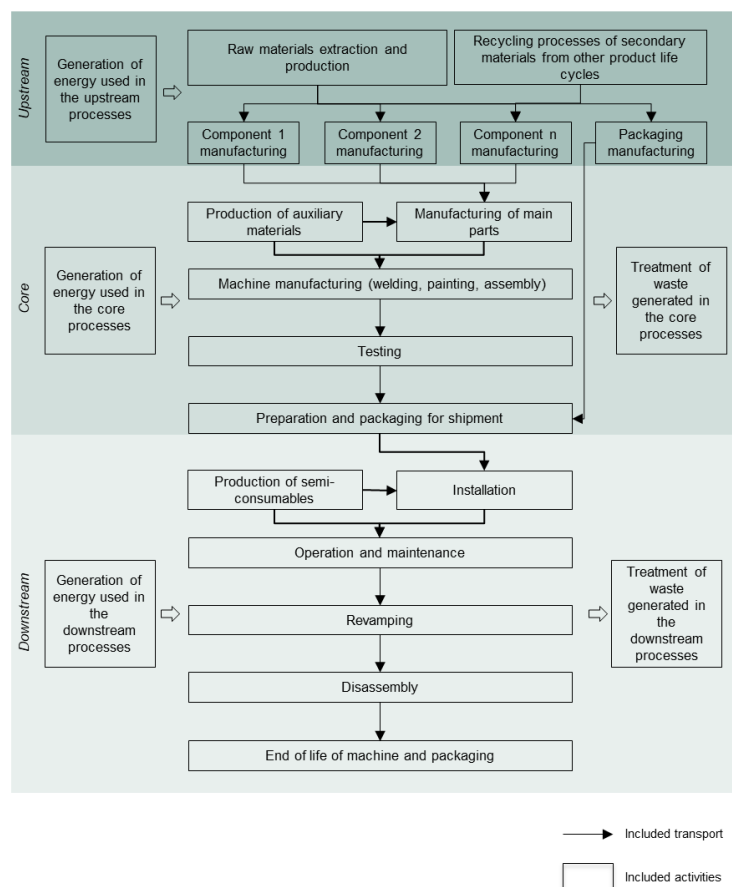


Figure 2 System diagram illustrating the processes that shall be included in the product system, divided into upstream, core and downstream processes. The illustration of processes to include may not be exhaustive.

4.5 CUT-OFF RULES

A cut-off rule of 1% shall be applied. In other words, the included inventory data (not including inventory data of processes that are explicitly outside the system boundary as described in Section 4.3) shall together give rise to at least 99% of the results of any of the environmental impact categories. Also, 99% of the mass of the product content and 99% of the energy use of the product life cycle shall be accounted for. The cut-off of inventory data should, however, be avoided, and all available inventory data shall be used.

The cut-off of inventory data, based on the above cut-off rule, should be an output of a sensitivity analysis, alone or in combination with expert judgment based on experience of similar product systems. Further, the cut-off shall be possible to verify in the verification process, hence the exclusion of inventory data based on the cut-off rule shall be documented in the LCA report, and the EPD developer shall provide the information the verifier considers necessary to verify the cut-off.

4.6 ALLOCATION RULES

Allocation can be divided into allocation of co-products, i.e. allocation of unit processes that generate several products, and allocation of waste, i.e. allocation of unit processes that generate materials that are, for example, landfilled recovered, recycled or reused, and which require further processing to cease being waste and become products (see criteria for end-of-waste state in Section 4.6.2).

The principles for allocation of co-products and allocation of waste are described separately in the following subsections

4.6.1 CO-PRODUCT ALLOCATION

The following hierarchy of allocation methods shall be followed for co-product allocation:

1. Allocation shall be avoided, if possible, by dividing the process to be allocated into sub-processes and collecting the inventory data for each sub-process.
2. If allocation cannot be avoided, the inventory data should be partitioned between the different co-products in a way that reflects the underlying physical relationships between them, i.e. allocation should reflect the way in which the inventory data changes if the quantities of delivered co-products change.
3. If a physical relationship between the inventory data and the delivery of co-products cannot be established, the inventory data should be allocated between the co-products in a way that reflects other relationships between them. For example, inventory data might be allocated between co-products in proportion to their economic values. If economic allocation is used, a sensitivity analysis exploring the influence of the choice of the economic value shall be included in the LCA report.

4.6.2 ALLOCATION OF WASTE TREATMENT PROCESSES

Allocation of waste shall follow the polluter pays principle and its interpretation in EN 15804: "processes of waste processing shall be assigned to the product system that generates the waste until the end-of-waste state is reached." The end-of-waste state is reached when all the following criteria for the end-of-waste state are fulfilled (adapted from EN 15804):

- the recovered material, component or product is commonly used for specific purposes;
- a market or demand, identified e.g. by a positive economic value, exists for such a recovered material, component or product;
- the recovered material, component or product fulfils the technical requirements for the specific purposes and meets the existing legislation and standards applicable to products; and
- the use of the recovered material, product or construction element will not lead to overall adverse environmental or human health impacts.

The above outlined principle means that the generator of the waste shall carry the full environmental impact until the point in the product life cycle in which the end-of-waste criteria are fulfilled. Waste may have a negative economic market value, and then the end-of-waste stage is typically reached after (part of) the waste processing and further refinement, at the point at which the waste no longer has a negative market value. This allocation method is (in most cases) in line with a waste generator's juridical and financial responsibilities. See the GPI for further information and examples.

4.7 DATA QUALITY REQUIREMENTS AND SELECTION OF DATA

Life cycle inventory data are classified into specific data and generic data, where the latter can be selected generic data or proxy data. The data categories are defined as follows:

- specific data (also referred to as "primary data" or "site-specific data"):
 - data gathered from the actual manufacturing plant where product-specific processes are carried out;
 - actual data from other parts of the life cycle traced to the product under study, for example site-specific data on the production of materials or components, or generation of electricity provided by contracted suppliers, and transportation data on distances, means of transportation, load factor, fuel consumption, etc., of contracted transportation providers; and
 - LCI data from databases on transportation and energyware that is combined with actual transportation and energy parameters as listed above.
- generic data (sometimes referred to as "secondary data"), divided into:
 - selected generic data: data (e.g. commercial databases and free databases) that fulfil prescribed data quality requirements for precision, completeness, and representativeness (see below Section 4.7.1),
 - proxy data: data (e.g. commercial databases and free databases) that do not fulfil all of the data quality requirements of "selected generic data".

Specific data shall be used for the core processes. Specific data shall be used for upstream and downstream processes, when available, otherwise generic data may be used. Generic data should be used in cases in which they are representative for the

purpose of the EPD, e.g. for bulk and raw materials on a spot market, if there is a lack of specific data on the final product or if a product consists of many components.

Any data used should preferably represent average values for a specific reference year. However, the way these data are generated could vary, e.g. over time, and in such cases they should have the form of a representative annual average value for a specified reference period. Such deviations should be declared.

4.7.1 RULES FOR USING GENERIC DATA

For generic data to be classified as "selected generic data", the following requirements apply:

- datasets shall be based on attributional LCA modelling (e.g., not be based on marginal data and not include credits from system expansion),
- the reference year shall be as current as possible and should be representative for the validity period of the EPD,
- the 1% cut-off rule (as described in Section A.3.3) shall be met on the level of the product system,
- datasets shall represent average values for a specific reference year; however, how data are generated could vary, e.g. over time, and then they should have the form of a representative annual average value for a specified reference period (such deviations shall be justified and declared in the EPD), and
- the representativeness of the data shall be assessed to be better than $\pm 5\%$, in terms of the environmental impact calculated on the basis of the data, of data that is fully representative for the given temporal, technological and geographical context.

If selected generic data that meets the above data quality requirements are not available, proxy data may be used. The environmental impacts associated with proxy data shall not exceed 10% of the overall environmental impact of the product system.

The EPD may include a data quality declaration to demonstrate the share of specific data, selected generic data and proxy data contributing to the results of the environmental impact indicators.

4.7.2 EXAMPLES OF DATABASES FOR GENERIC DATA

PROCESS	GEOGRAPHICAL SCOPE	DATASET	DATABASE
Electricity demand in the use phase	Global	Electricity, medium voltage {GLO} market group for Cut-off, U	Ecoinvent
Steel and metal components, unspecified composition	Global	Steel, low-alloyed {GLO} market for Cut-off, U	Ecoinvent
Unknown chromium steel manufacturing processes	Global	Metal working, average for chromium steel product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown steel manufacturing processes or single steel item	Global	Metal working, average for steel product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown copper manufacturing processes	Global	Metal working, average for copper product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown metal manufacturing processes	Global	Metal working, average for metal product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown aluminium manufacturing processes	Global	Metal working, average for aluminium product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Programmable Logic Controllers and electronics within laser drives	Global	Printed wiring board, surface mounted, unspecified, Pb containing {GLO} market for Cut-off, U	Ecoinvent
Ethernet cables	Global	Cable, network cable, category 5, without plugs {GLO} market for Cut-off, U	Ecoinvent

PROCESS	GEOGRAPHICAL SCOPE	DATASET	DATABASE
Power cables	Global	Cable, three-conductor cable {GLO} market for Cut-off, U	Ecoinvent
Cables, unspecified type	Global	Cable, unspecified {GLO} market for Cut-off, U	Ecoinvent
Rubber and polymeric items	Global	Depending of the polymer type	Ecoinvent

Table 3 lists examples of databases and datasets to be used for generic data. Please note that a data quality assessment shall be performed also for data listed in the table, and that other data that fulfil the data quality requirements may also be used.

PROCESS	GEOGRAPHICAL SCOPE	DATASET	DATABASE
Electricity demand in the use phase	Global	Electricity, medium voltage {GLO} market group for Cut-off, U	Ecoinvent
Steel and metal components, unspecified composition	Global	Steel, low-alloyed {GLO} market for Cut-off, U	Ecoinvent
Unknown chromium steel manufacturing processes	Global	Metal working, average for chromium steel product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown steel manufacturing processes or single steel item	Global	Metal working, average for steel product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown copper manufacturing processes	Global	Metal working, average for copper product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown metal manufacturing processes	Global	Metal working, average for metal product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Unknown aluminium manufacturing processes	Global	Metal working, average for aluminium product manufacturing {GLO} market for Cut-off, U	Ecoinvent
Programmable Logic Controllers and electronics within laser drives	Global	Printed wiring board, surface mounted, unspecified, Pb containing {GLO} market for Cut-off, U	Ecoinvent
Ethernet cables	Global	Cable, network cable, category 5, without plugs {GLO} market for Cut-off, U	Ecoinvent
Power cables	Global	Cable, three-conductor cable {GLO} market for Cut-off, U	Ecoinvent
Cables, unspecified type	Global	Cable, unspecified {GLO} market for Cut-off, U	Ecoinvent
Rubber and polymeric items	Global	Depending of the polymer type	Ecoinvent

Table 3 Examples of databases and datasets to use for generic data.

4.7.3 DATA QUALITY REQUIREMENTS AND OTHER MODELLING GUIDANCE PER LIFE-CYCLE STAGE

Below are further data quality requirement per life-cycle stage. Exceptions to the requirements may be accepted, if justified in the EPD; such exceptions are subject to the approval by the verifier on a case-to-case basis.

4.7.3.1 Upstream processes

- Data referring to processes upstream in a supply chain over which the EPD owner has direct management control shall be specific and collected on site.
- Data referring to processes of a supplier of main parts, packaging, or main auxiliaries should be requested from the supplier as specific data, as well as infrastructure, where relevant.

- Data on transport of main parts and components along the supply chain to a distribution point (e.g. a stockroom or warehouse) where the final delivery to the manufacturer can take place, should be specific and based on the actual transportation mode, distance from the supplier, and vehicle load.
- In case specific data is lacking, selected generic data may be used. If this is also lacking, proxy data may be used (see Section 4.7).
- For upstream processes modelled with specific data, generation of electricity used shall be accounted for in this priority:
 1. Specific electricity mix as generated, or purchased from an electricity supplier, demonstrated by a Guarantee of Origin or similar as provided by the electricity supplier.
 2. Residual electricity mix of the electricity supplier on the market.
 3. Residual electricity mix on the market.
 4. Electricity consumption mix on the market.

The residual electricity mix is the mix when all contract-specific electricity that has been sold to other customers has been subtracted from the total consumption mix.

"The market" in the above hierarchy shall be defined as being the (residual or consumption) grid mix of the country where the electricity is used, with exceptions for specified countries for which a sub-national electricity grid mix shall be used: Australia, Brazil, Canada, China, India, and USA. The mix of electricity used in upstream processes shall be documented in the EPD, where relevant.

- Packaging: specific data shall be used for production consumer packaging if the production is under the direct control of the EPD owner or if the environmental impact of the production is more than 10% of the declared results in any of the environmental performance indicators. In other cases, generic data may be used. When consumer packaging shows the organization's logo, the LCA report should report the exerted/non-exerted direct control on the production of consumer packaging by the organization.

4.7.3.2. Core processes

- Transport from the final delivery point of raw materials, chemicals, main parts, and components (see above regarding upstream processes) to the manufacturing plant/place of service provision should be based on the actual transportation mode, distance from the supplier, and vehicle load, if available.
- Goods: Specific data shall be used for the assembly of the product and for the manufacture of main parts as well as for on-site generation of steam, heat, electricity, etc., where relevant.
- For electricity used in the core processes, generation of electricity used shall be accounted for in this priority:
 1. Specific electricity mix as generated, or purchased from an electricity supplier, demonstrated by a Guarantee of Origin or similar as provided by the electricity supplier.
 2. Residual electricity mix of the electricity supplier on the market.
 3. Residual electricity mix on the market.
 4. Electricity consumption mix on the market. This option shall not be used for electricity used in processes over which the manufacturer (EPD owner) has direct control⁵.

The residual electricity mix is the mix when all contract-specific electricity that has been sold to other customers has been subtracted from the total consumption mix.

"The market" in the above hierarchy shall be defined as being the (residual or consumption) grid mix of the country where the electricity is used, with exceptions for specified countries for which a sub-national electricity grid mix shall be used: Australia, Brazil, Canada, China, India, and USA. The mix of electricity used in the core processes shall be documented in the EPD, where relevant.

- Waste treatment processes of manufacturing waste should be based on specific data, if available.

⁵ For electricity markets without trade of Guarantees of Origin (or similar), the residual mix will, however, be identical to the consumption mix.

4.7.3.3. Downstream processes

- Data for the use stage are usually based on scenarios, but specific data should be used when available and relevant. The parameters defining the declared energy consumption shall be specified in both the EPD and the LCA study (i.e. input material size and alloy, etc.).
- Data on the emissions from the use stage should be based on documented tests, verified studies in conjunction with average or typical product use, or recommendations concerning suitable product use. Whenever applicable, test methods shall be internationally recognised.
- The use of electricity in the region/country where the product is used (as specified in the geographical scope of the EPD) shall be accounted for in the following priority:
 1. Residual electricity mix on the market.
 2. Electricity consumption mix on the market.

The residual electricity mix is the mix when all contract-specific electricity that has been sold to other customers has been subtracted from the total production mix.

"The market" in the above hierarchy shall be defined as being the (residual or consumption) grid mix of the country where the electricity is used, with exceptions for specified countries for which a sub-national electricity grid mix shall be used: Australia, Brazil, Canada, China, India, and USA.

The mix of electricity used in the downstream processes shall be documented in the EPD, where relevant.

- The use of other fuels (e.g. gas) shall be specific of the region(s) appropriate to the operation scenario.
- The transport of the product to the customer shall be described in the EPD, where relevant, and be accounted for in this priority:
 1. Actual transportation modes and distances to specific a customer or market, representing the geographical scope of the EPD.
 2. A weighted average of transportation modes and distances, based on transportation to several customers or markets, representing the geographical scope of the EPD.
 3. A default transportation scenario calculated by the means of default data as a fixed long-distance transport: 10 000 km by ship from the production plant to the main destination country, 500 km from the port to the distribution centre by lorry and 1 000 km by lorry to the retailer.
- Scenarios for the end-of-life stage shall be technically and economically practicable and compliant with current regulations in the relevant geographical region based on the geographical scope of the EPD. Key assumptions regarding the end-of-life stage scenario shall be documented in the LCA report.

Refurbishment/revamping

Normal practice, due to the high cost of industrial furnaces/ovens, is the replacement or substitution of the parts of the product which become obsolete, thus extending the lifetime of the product: refurbishment (also known as revamping). If necessary to fulfil the stated technical/actual lifespan of the product (see Section 4.2), refurbishment shall be included in the LCA. For example, refurbishment can include the transportation and waste management of the replaced part, and the production and transportation of the new part with the same or improved features.

If a revamping activity takes place for one or more of the main parts of the product so that the technical lifespan of the product is expected to exceed the fixed 20 years of the RSL, the environmental burdens of the original product manufacturing plus the revamping should be attributed to the RSL (and hence the functional unit) proportionally based on the total technical lifespan achieved. To provide guidelines on how to deal with revamping, the following informative examples are provided:

- Case A – No revamping, lifetime of 20 years: the product enters the end-of-life stage after 20 years and all burdens associated with the original manufacture are assigned 100% to the RSL.
- Case B – No revamping, lifetime of 30 years: 20/30 of the burdens associated with the original manufacture are assigned to the RSL.
- Case C – Revamping occurring before the end of the RSL (e.g. at year 15), thus extending the technical lifespan of the product up to 30 years: the burdens of original manufacture and the revamping are added together, then 20/30 of the total burdens are assigned to the RSL.

- Case D – Revamping occurring at the end of the RSL (i.e. after year 20), thus extending the technical life of the product up to 30 years: the burdens of original manufacture and revamping are added together, then 20/30 of the total burdens are assigned to the RSL.

End of life

Scenarios for the end-of-life stage shall be technically and economically practicable and compliant with current regulations in the relevant geographical region based on the geographical scope of the EPD. Key assumptions regarding the end-of-life stage scenario shall be declared in the EPD.

Recommendations for source separation and recycling can be given in the EPD, as well as recommendations for other waste treatment of product parts if relevant. Such recommendation shall be given as additional environmental information, see Section 5.4.6.

4.7.4 DATA QUALITY DECLARATION

EPDs may include a declaration of the quality of data used in the LCA calculations.

4.8 ENVIRONMENTAL PERFORMANCE INDICATORS

The EPD shall declare the default environmental performance indicators and their methods as described at the website (www.environdec.com/indicators), which includes both inventory indicators and indicators of potential environmental impact. The source and version of the impact assessment methods and characterisation factors used shall be reported in the EPD. Alternative regional impact assessment methods and characterisation factors may be calculated and displayed in addition to the default list. If so, the EPD shall contain an explanation of the difference between the different sets of indicators, as they may appear to the reader to display duplicate information.

If the default list of environmental performance indicators and methods at the website is updated, the previous version of the list is valid in parallel to the new version during a transition period of 90 days, as described at the website.

Apart from the required inventory indicators, other inventory data may also be declared in the EPD, if relevant and useful for EPD users. Such data shall not be declared in the main body of the EPD, but in an annex.

4.9 INCLUDING MULTIPLE PRODUCTS IN THE SAME EPD

4.9.1 PRODUCTS FROM THE SAME COMPANY

Similar products from a single or several manufacturing sites covered by the same PCR and manufactured by the same company with the same major steps in the core processes may be grouped and thereby included in the same EPD. For such an EPD, there are three options:

- For each indicator, declare the average results of the included products. This average shall be weighted according to the production volumes of the included products, if relevant. In this option, the average content shall be declared in the content declaration.
- Declare the results of one of the included products – a representative product. The choice of the representative product shall be justified in the EPD, using, where applicable, statistical parameters. For example, the choice may be based on production volumes. In this option, the content of the representative product shall be declared in the content declaration.
- For each indicator, declare the highest result of the included products (i.e., the results of a “worst-case product”, which may be the results of one or several of the included products). In this option, the content declaration shall include the lowest amounts of recycled and biogenic content of the included products and their packaging, respectively, and the information on environmental and hazardous properties of substances shall reflect the highest share and most hazardous such substances contained in the any of the included products.

The first two options are only possible if none of the declared environmental impact indicator results differ by more than 10% between any of the included products. The third option is possible also if variations are larger than 10%.

The option chosen shall be clearly described in the EPD.

4.9.2 SECTOR EPDS

The International EPD® System allows for an industry association to develop an EPD in the form of a Sector EPD. A Sector EPD declares the average product of multiple companies in a clearly defined sector in a clearly defined geographical area. Products covered in a sector EPD shall follow the same PCR and the same functional unit shall be applied.

Any communication of the results from a Sector EPD should contain the information that the results are based on averages obtained from the sector as defined in the EPD. The communication shall not claim that the sector EPD results are representative for a certain manufacturer or its product.

The following information shall also be included a Sector EPD:

- a list of the contributing manufacturers that the Sector EPD covers,
- a description of how the selection of the sites/products has been done and how the average has been determined, and
- a statement that the document covers average values for an entire or partial product category (specifying the percentage of representativeness) and, hence, the declared product is an average that is not available for purchase on the market.

5 CONTENT AND FORMAT OF EPD

EPDs based on this PCR shall contain the information described in this section. Flexibility is allowed in the formatting and layout provided that the EPD still includes the prescribed information. A generic template for EPDs is available at www.environdec.com.

The EPD content shall:

- be in line with the requirements and guidelines in ISO 14020 (Environmental labels and declarations – General principles),
- be verifiable, accurate, relevant and not misleading, and
- not include rating, judgements or direct comparison with other products⁶.

An EPD should be made with a reasonable number of pages for the intended audience and use.

The content of EPDs published in machine-readable format shall correspond with the content of the underlying EPD.

5.1 EPD LANGUAGES

EPDs should be published in English but may also be published in additional languages. If the EPD is not available in English, it shall contain an executive summary in English including the main content of the EPD. This summary is part of the EPD and, thus, also subject to the verification process.

5.2 UNITS AND QUANTITIES

The following requirements apply for units and quantities:

- The International System of Units (SI units) shall be used where available, e.g., kilograms (kg), Joules (J) and metres (m). Reasonable multiples of SI units may be decided in the PCR to improve readability, e.g., grams (g) or megajoules (MJ). The following exceptions apply:
 - Resources used for energy input (primary energy) should be expressed as kilowatt-hours (kWh) or megajoules (MJ), including renewable energy sources, e.g., hydropower, wind power and geothermal power.
 - Water use should be expressed in cubic metres (m³)
 - Temperature should be expressed in degrees Celsius (°C),
 - Time should be expressed in the units most practical, e.g., seconds, minutes, hours, days or years.
 - Results of the environmental performance indicators shall be expressed in the units prescribed by the impact assessment methods, e.g. kg CO₂ equivalents.
- Three significant figures⁷ should be adopted for all results. The number of significant digits shall be appropriate and consistent.
- Scientific notation may be used, e.g. 1.2E+2 for 120, or 1.2E-2 for 0.012.
- The thousand separator and decimal mark in the EPD shall follow one of the following styles (a number with six significant figures shown for illustration):
 - SI style (French version): 1 234,56
 - SI style (English version): 1 234.56

In case of potential confusion or intended use of the EPD in markets where different symbols are used, the EPD shall state what symbols are used for thousand separator and decimal mark.

- Dates and times presented in the EPD should follow the format in ISO 8601. For years, the prescribed format is YYYY-MM-DD, e.g., 2017-03-26 for March 26th, 2017.

⁶ Therefore, results of normalization are not allowed to be reported in the EPD.

⁷ Significant figures are those digits that carry meaning contributing to its precision. For example with two significant digits, the result of 123.45 shall be displayed as 120, and 0.12345 shall be displayed as 0.12. In scientific notation, these two examples would be displayed as 1.2*10² and 1.2*10⁻².

- The result tables shall:
 - Only contain values or the letters “ND” (Not Declared). It is not possible to specify ND for mandatory indicators. ND shall only be used for voluntary parameters that are not quantified because no data is available.⁸
 - Contain no blank cells, hyphens, less than or greater than signs or letters (except “ND”).
 - Use the value “0” only for parameters that have been calculated to be zero.
 - Footnotes shall be used to explain any limitation to the result value.

5.3 USE OF IMAGES IN EPD

Images used in the EPD, especially pictures featured on the cover page, may in themselves be interpreted as an environmental claim. Images such as trees, mountains, wildlife that are not related to the declared product shall therefore be used with caution and in compliance with national legislation and best available practices in the markets in which the EPD is intended to be used.

5.4 EPD REPORTING FORMAT

The reporting format of the EPD shall include the following sections:

- Cover page (see Section 5.4.1)
- Programme information (see Section 5.4.2)
- Product information (see Section 5.4.3)
- Content declaration (see Section 5.4.4)
- Environmental performance (see Section 5.4.5)
- Additional environmental information (see Section 5.4.6)
- Additional social and economic information (see Section 5.4.7)
- References (see Section 5.4.9)

The following sections shall be included, if relevant:

- Differences versus previous versions (see Section 5.4.8)
- Executive summary in English (see Section 5.4.10)

5.4.1 COVER PAGE

The cover page shall include:

- Product name and image
- Name and logotype of EPD owner
- The text “Environmental Product Declaration” and/or “EPD”
- Programme: The International EPD[®] System, www.environdec.com
- Programme operator: EPD International AB
- Logotype of the International EPD[®] System
- EPD registration number as issued by the programme operator⁹
- Date of publication (issue): 20XX-YY-ZZ

⁸ This requirement does not intend to give guidance on what indicators are mandated (“shall”) or voluntary.

⁹ The EPD shall not include a “registration number” if such is provided by the certification body, as this may be confused with the registration number issued by the programme operator.

- Date of revision: 20XX-YY-ZZ, when applicable
- Date of validity: 20XX-YY-ZZ
- A note that “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”
- A statement of conformity with ISO 14025.
- For EPDs covering multiple products: a statement that the EPD covers multiple products and a list of all products covered by the EPD.
- For Sector EPDs: a statement that the EPD is a Sector EPD.

In the case of EPDs registered through a regional hub (a regional or national programme based on and fully aligned with the International EPD® System through an agreement with the programme operator), “Programme”, “Programme operator”, and “Logotype” shall be expanded to include a reference to the regional programme and the organisation responsible for it.

Where applicable, the cover page shall also include the following information:

- Information about dual registration of EPD in another programme, such as registration number and logotype.
- A statement of conformity with other standards and methodological guides.

5.4.2 PROGRAMME INFORMATION

The programme information section of the EPD shall include:

- Address of programme operator: EPD International AB, Box 210 60, SE-100 31 Stockholm, Sweden, E-mail: info@environdec.com
- The following statement on the requirements for comparability of EPDs, adapted from ISO 14025: “EPDs within the same product category but from different programmes may not be comparable. For two EPDs to be comparable, they must be based on the same PCR (including the same version number) or be based on fully aligned PCRs or versions of PCRs; cover products with identical functions, technical performances and use (e.g. identical declared/functional units); have equivalent system boundaries and descriptions of data; apply equivalent data quality requirements, methods of data collection, and allocation methods; apply identical cut-off rules and impact assessment methods (including the same version of characterisation factors); have equivalent content declarations; and be valid at the time of comparison.”
- A statement that the EPD owner has the sole ownership, liability and responsibility of the EPD
- Information about verification¹⁰ and the PCR in a table with the following format and contents:

Accountabilities for PCR, LCA and independent, third-party verification
Product Category Rules (PCR)
PCR: <name, registration number, version and UN CPC code(s)>
PCR review was conducted by: <name and organisation of the review chair, and information on how to contact the chair through the programme operator>
Life cycle assessment (LCA)
LCA accountability: <name, organization>
Third-party verification
Independent third-party verification of the declaration and data, according to ISO 14025:2006, via:

¹⁰ If the EPD has been verified by an approved individual verifier who has received contractual assistance from a certification body that is not accredited, this certification body shall not be included in this table.

☐ EPD verification by individual verifier Third-party verifier: <name, organisation, and signature of the third-party verifier> Approved by: The International EPD® System
OR
Independent third-party verification of the declaration and data, according to ISO 14025:2006, via: ☐ EPD verification by accredited certification body Third-party verification: <name, organisation> is an approved certification body accountable for the third-party verification The certification body is accredited by: <name of accreditation body & accreditation number, where applicable>
OR
Independent third-party verification of the declaration and data, according to ISO 14025:2006 via: ☐ EPD verification by EPD Process Certification* Internal auditor: <name, organisation> Third-party verification: <name, organisation> is an approved certification body accountable for third-party verification Third-party verifier is accredited by: <name of accreditation body & accreditation number, where applicable> *For EPD Process Certification, an accredited certification body certifies and reviews the management process and verifies EPDs published on a regular basis. For details about third-party verification procedure of the EPDs, see GPI v4, Section 7.5.
Procedure for follow-up of data during EPD validity involves third-party verifier: ☐ Yes ☐ No

5.4.3 PRODUCT INFORMATION

The product information section of the EPD shall include:

- address and contact information of the EPD owner,
- description of the organisation. This may include information on products- or management system-related certifications (e.g. ISO 14024 Type I environmental labels, ISO 9001- and 14001-certificates and EMAS-registrations) and other relevant work the organisation wants to communicate (e.g. SA 8000, supply-chain management and social responsibility),
- name and location of production site,
- product identification by name, and an unambiguous identification of the product by standards, concessions or other means,
- identification of the product according to the UN CPC scheme system. Other relevant codes for product classification may also be included, e.g.
 - Common Procurement Vocabulary (CPV),
 - United Nations Standard Products and Services Code® (UNSPSC),

- Classification of Products by Activity (NACE/CPA),
 - Australian and New Zealand Standard Industrial Classification (ANZSIC), or
 - Global Trade Item Number (GTIN).
- a description of the product,
 - a description of the technical purpose of the product, including its application/intended use,
 - a description of the background system, including the main technological aspects,
 - for EPDs covering multiple products: a description of the selection of products/sites, a list of contributing manufacturers (if Sector EPD), etc. (see Section 4.9),
 - geographical scope of the EPD, i.e., for which geographical location(s) of use and end-of-life the product's performance has been calculated,
 - declared/functional unit,
 - reference service life (RSL) and/or technical/actual lifespan, if relevant,
 - declaration of the year(s) covered by the data used for the LCA calculation and other relevant reference years,
 - reference to the main database(s) for generic data and LCA software used, if relevant,
 - system diagram of the processes included in the LCA, divided into the life cycle stages,
 - description if the EPD system boundary is "cradle-to-gate", "cradle-to-gate with options" or "cradle-to-grave",
 - information on which life-cycle stages are not considered (if any), with a justification of the omission, and
 - references to any relevant websites for more information or explanatory materials.

This section may also include:

- name and contact information of organisation carrying out the underlying LCA study,
- any additional information about the underlying LCA-based information, such as cut-off rules, data quality, allocation methods, and other methodological choices and assumptions,
- a description of the material properties of the product with a declaration of relevant physical or chemical product properties, such as density, etc., and
- if end-of-life treatment is not included, the EPD shall contain a statement that it shall not be used for communicating environmental information to consumers/end users of the product.

5.4.4 CONTENT DECLARATION

The content declaration section shall declare the weight of one unit of product, as delivered to the user, and contain information about the content of the product in the form of a list of materials and chemical substances including information on their environmental and hazardous properties. The gross weight of each material/substance shall be declared, including a minimum of 99% of the materials/substances in one unit of product.

The content declaration does not apply to proprietary materials and substances covered by exclusive legal rights including patent and trademarks. In general, an indication that a product is "free" of a specific hazardous material or substance should be done with caution and only when relevant, following the rules in ISO 14021 on self-declared environmental claims.

Information on the hazardous properties of materials and chemical substances should follow the requirements given in the latest revision of the Globally Harmonized System of Classification and Labelling of Chemicals (GHS),¹¹ issued by the United Nations or national or regional applications of the GHS. As an example, the following regulations should be used for EPDs intended to be used in the European Union:

- Regulation (EC) No 1907/2006 of the European parliament and of the council of 18 December 2006 concerning the Registration, Evaluation, Authorisation, and Restriction of Chemicals (REACH);

¹¹ The GHS document is available at www.unece.org.

- Regulation (EC) No 1272/2008 of the European Parliament and of the Council of 16 December 2008 on classification, labelling, and packaging of substances and mixtures; and
- Directive 2011/65/EU of the European Parliament and of the Council of 8 June 2011 on the restriction of the use of certain hazardous substances in electrical and electronic equipment Text with EEA relevance (for electrical part).

5.4.4.1. Information about recycled materials

When a product is made in whole or in part with recycled materials, the provenience of the materials (pre-consumer or post-consumer) shall be presented in the EPD as part of the content declaration.

To avoid any misunderstanding about which material that may be considered “recycled material”, the guidance given in ISO 14021 shall be considered. In brief, the standard states that:

- only pre-consumer or post-consumer materials (scraps) shall be considered in the accounting of the recycled materials, and
- materials coming from scrap reutilisation (such as rework, regrind, or scrap generated in a process and capable of being reclaimed within the same process that generated it) shall not be considered as recycled content.

In case pre-consumer or post-consumer materials is used within the product, it is necessary to mention the source of information for such data.

5.4.4.2. Information about packaging

As packaging is strongly connected with the product, the producer shall provide information about packaging in the EPD, when applicable. Packaging may be classified as:

- Distribution Packaging: packaging designed to contain one or more articles or packages, or bulk materials, for the purposes of transport, handling and/or distribution (ISO 21067-1:2016, Section 2.2.6).
- Consumer Packaging: packaging constituting, with its content, a sales unit for the final user or consumer at the point of retail (ISO 21067-1:2016, Section 2.2.7).

Consumer packaging is generally the outcome of eco-design processes, or other activities, under direct control of the organisation. Many critical categories with strict legal requirements belong to consumer packaging category like food contact packaging and pharmaceutical packaging.

The weight of the packaging per product, and the type and function of the packaging, shall be reported in the EPD.

A statement of the source of the materials (pre-consumer or post-consumer) shall be presented in the EPD when the packaging is made in whole or in part by recycled materials.

5.4.5 ENVIRONMENTAL PERFORMANCE

Below subsections list the mandatory environmental performance indicators to declare in the EPD. LCA results based on additional indicators may be declared, if they are relevant for the product category, their inclusion is justified in the EPD, appropriate methods are used, and the results are verifiable. If the additional indicators appear to the reader to display duplicate information, the EPD shall contain an explanation of the differences between the declared indicators.

5.4.5.1. Environmental impacts

The EPD shall declare the environmental impact indicators, per functional unit, per life-cycle stage and in aggregated form, using the default impact categories, impact assessments methods and characterisation factors available at www.environdec.com/indicators. The source and version of the impact assessment methods and characterisation factors used shall be reported in the EPD.

Alternative regional life cycle impact assessment methods and characterisation factors may be calculated and displayed in addition to the default list. If so, the EPD shall contain an explanation of the difference between the different sets of indicators, as they may appear to the reader to display duplicate information.

5.4.5.2. Use of resources

The EPD shall declare the indicators for resource use listed at www.environdec.com/indicators per functional unit, per life-cycle stage and in aggregated form.

5.4.5.3. Waste production and output flows

Waste generated along the whole life cycle production chains shall be treated following the technical specifications described in the GPI. The EPD shall declare the indicators for waste production and output flows as listed at www.environdec.com/indicators per functional unit, per life-cycle stage and in aggregated form.

5.4.6 ADDITIONAL ENVIRONMENTAL INFORMATION

An EPD may declare additional environmentally relevant information not derived from the LCA-based calculations, such as:

- the release of dangerous substances into indoor air, soil, and water during the use stage,
- instructions for proper use of the product, e.g. to minimise energy or water consumption or to improve the durability of the product,
- instructions for proper maintenance and service of the product, e.g. to minimise energy or water consumption or to improve the durability of the product,
- information on key parts of the product that determine its durability,
- information on recycling including, e.g. suitable procedures for recycling the entire product or selected parts and the potential environmental benefits gained,
- information on a suitable method of reuse of the product (or parts of the products) and procedures for disposal as waste at the end of its life cycle,
- information regarding disposal of the product, or inherent materials, and any other information considered necessary to minimise the product's end-of-life impacts, and
- a more detailed description of an organisation's overall environmental work, in addition to the information listed under Section 5.4.3, such as:
 - the existence of any type of organised environmental activity, and
 - information on where interested parties may find more details about the organisation's environmental work.

Any additional environmental information declared shall be substantiated and verifiable, and be derived using appropriate methods and be specific, accurate, not misleading, and relevant to the specific product. Quantitative information is preferred over qualitative information.

5.4.7 ADDITIONAL SOCIAL AND ECONOMIC INFORMATION

The EPD may also include other relevant social and economic information as additional and voluntary information. This may be product information or a description of an organisation's overall work on social or economic sustainability, such as activities related to supply chain management or social responsibility.

Any additional social and economic information declared shall be substantiated and verifiable, and be derived using appropriate methods and be specific, accurate, not misleading, and relevant to the specific product. Quantitative information is preferred over qualitative information.

5.4.8 DIFFERENCES VERSUS PREVIOUS VERSIONS

For EPDs that have been updated, the following information shall be included:

- a description of the differences versus previously published versions, and
- a revision date on the cover page.

5.4.9 REFERENCES

A reference section shall be included, including a list of all sources referred to in the EPD, including the GPI (including version number), and PCR (registration number, name, and version) used to develop the EPD.

The source and version of the characterisation models and the factors used shall be reported in the EPD.

5.4.10 EXECUTIVE SUMMARY IN ENGLISH

The executive summary, if included (see Section 5.1), shall contain relevant summarised information related to the programme, product, environmental performance, information related to pre-certified EPDs, and information related to sector EPDs. Besides this, further information may be added such as additional environmental, social or economic information, references as well as differences versus previous EPD versions.

6 LIST OF ABBREVIATIONS

ANZSIC	Australian and New Zealand Standard Industrial Classification
CPC	Central product classification
CPV	Common procurement vocabulary
EPD	Environmental product declaration
GPI	General Programme Instructions
GTIN	Global trade item number
ISO	International Organization for Standardization
LCA	Life cycle assessment
LCI	Life cycle inventory
NACE/CPA	Classification of products by activity
ND	Not declared
PCR	Product category rules
REACH	Restriction of chemicals
RSL	Reference service life
SI	The International System of Units
UN	United Nations
UNSPSC	United Nations standard products and services code

7 REFERENCES

CEN (2013) EN 15804:2012+A1:2013, Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products.

CEN (2019) EN 15804:2012+A2:2019, Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products.

EPD International (2021) General Programme Instructions for the International EPD® System. Version 4.0, dated 2021-03-29.
www.environdec.com.

ISO (2000) ISO 14020:2000, Environmental labels and declarations – General principles.

ISO (2004) ISO 8601:2004 Data elements and interchange formats – Information interchange – Representation of dates and times.

ISO (2006a) ISO 14025:2006, Environmental labels and declarations – Type III environmental declarations – Principles and procedures.

ISO (2006b) ISO 14040:2006, Environmental management – Life cycle assessment – Principles and framework.

ISO (2006c) ISO 14044: 2006, Environmental management – Life cycle assessment – Requirements and guidelines.

ISO (2013) ISO/TS 14067:2013, Greenhouse gases – Carbon footprint of products – Requirements and guidelines for quantification and communication.

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

ISO (2015a) ISO 14001:2015, Environmental management systems – Requirements with guidance for use.

ISO (2015b) ISO 9001:2015, Quality management systems – Requirements.

ISO (2016a) ISO 21067-1:2016, Packaging – Vocabulary – Part 1: General terms.

ISO (2016b) ISO 14021:2016, Environmental labels and declarations - Self-declared environmental claim (Type II environmental labelling).

ISO (2017) ISO 21930:2017, Sustainability in buildings and civil engineering works – Core rules for environmental product declarations of construction products and services.

ISO (2018) ISO 14024:2018, Environmental labels and declaration – Type I environmental labelling – Principles and procedures.

Pretato U., Cropanise I., Masino P. (2022) Life cycle assessment of extrusion presses and ovens manufactured by Presezzi Extrusion.

8 VERSION HISTORY OF PCR

VERSION 1.0, 2022-12-21

Original version of the PCR.

VERSION 1.0.1, 2023-01-23

In this version, the following were changed:

- Changed definition of the reference flow in Section 4.1, so it is consistent with the definition of the functional unit, along with a clarification that results may be declared for an alternative functional unit as additional environmental information.
- Editorial changes.

© EPD INTERNATIONAL AB 2023

YOUR USE OF THIS MATERIAL IS SUBJECT TO THE GENERAL TERMS OF USE PUBLISHED ON BY EPD INTERNATIONAL AB:S HOMEPAGE AT [HTTPS://WWW.ENVIRONDEC.COM/CONTACT/GENERAL-TERMS-OF-USE/](https://www.environdec.com/contact/general-terms-of-use/). IF YOU HAVE NOT REGISTERED AND ACCEPTED EPD INTERNATIONAL AB:S THE GENERAL TERMS OF USE, YOU ARE NOT AUTHORIZED TO EXPLOIT THIS WORK IN ANY MANNER.

COVER IMAGE © N/A

