

ENVIRONMENTAL PRODUCT DECLARATION FOR

**Bioflex®**, **Bioflex® S1**, **Biofloor®**,  
**H40® Eco Flex**, **H40® Revolution®**,  
**Special Eco**, **Super Bio**

Mineral adhesives for ceramic tiles and natural stone



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Geographical scope: Global

CPC Code: Multiple UN CPC Codes - Construction products and CPC 54 construction services

- ✓ Complies with ISO 14025 and EN 15804
- ✓ Independently verified
- ✓ Cradle to Gate scope
- ✓ Products-specific

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### 1. ABOUT THIS EPD

#### What is an EPD?

Environmental Product Declaration (EPD) is label that provide a transparent, multi-faceted overview of the environmental performance of a product during its life cycle.

Our intention in providing this EPD is to present the potential environmental impacts for our products.

They are presented in single EPDs such that they can be combined to calculate the impacts of a more complex building system.

Target audiences of the study are customers and other parties interested in the environmental impacts of our products.

According to EN 15804, EPD of construction products may not be comparable if they do not comply with this standard.

EPDs within the same product category from different programs may not be comparable.

#### Declaration owner and LCA Author

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#### EPD programme and programme operator

The International EPD® System  
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#### CEN standard EN 15804 served as the core PCR

PCR EN 15804 as the core PCR,  
International EPD System PCR 2012:01 "Construction products and construction services",  
v2.2, 2017-05-30

PCR review conducted by The Technical Committee of the International EPD® System

Chair Massimo Marino  
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Independent verification of the Declaration and data, according to ISO 14025

EPD process certification (Internal)  
 EPD verification (External)

#### Third party verifier

SGS Italia S.p.A.  
www.sgsgroup.it  
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Accredited by Accredia

## 2. ABOUT KERAKOLL

### **Kerakoll - The GreenBuilding Company**

From the outset, the pillar of the Kerakoll vision has always been to make the difference through sustainable innovation. This belief led to the launch of Biocalce and Healthy Building in April 2005, i.e. the new take on sustainable building in which the focus is to safeguard health and improve the quality of life.

Kerakoll became The GreenBuilding Company, the leading manufacturer of green solutions for designing, building and living in harmony with the environment and in healthy spaces: the company earned certification for the GreenBuilding Rating from the Société Générale de Surveillance (SGS) and got the EPD Process Certification, meaning that our internal processes to produce EPDs have been quality assured by an external certification body.

### **Mission & Vision**

To represent GreenBuilding, the new low environmental impact approach to building that safeguards the health and wellbeing of people. We think, develop and produce innovative solutions that focus on the environment and on improving both health and quality of life by using building materials that avoid the most common illnesses caused by indoor pollution. Our vision is to interpret GreenBuilding as a new way of building that is kind on the environment, promoting higher quality homes around the world and helping people to live better.

Products, services and specific know-how formed the basis of Kerakoll's rise to become the GreenBuilding Company, the only company to provide a global GreenBuilding solution that aims at designing, building, and living in harmony with the environment and in healthy spaces.

### **Values**

The Kerakoll business culture to create value over time.

Kerakoll is determined to improve its performance in all ways, firm in the belief that to create value over time you have to first create a firm business culture.

Business culture in Kerakoll means being committed to recognizing and reclaiming the value of key experiences and practices of the past, and at the same time being constantly willing to go out on a limb.

Research and innovation only make sense in such a context, where progress goes hand-in-hand with restoration, preservation and reclaiming the heritage of the company's past.

The Kerakoll mission is to meet the needs of its consumers with a constant supply of new and original ideas, remaining ever faithful to a business culture always ready to consider the ideas of all its members.

When it comes to knowledge assets, people are a key resource for Kerakoll along with the values, expectations, hopes, ideas and originality they bring with them.

This belief is the cornerstone of the Kerakoll business ethos, and the five pillars of this approach represent our modus operandi in both life and work.

### **Integrated policy for total quality, wellbeing and protection of the environment**

We pride ourselves on our quality, we are guided by our commitment to society and the health of people, and tireless in our promotion of environmental sustainability.

Focus on the environmental sustainability of a home as it relates to the health of its inhabitants: this is the core philosophy that underlies Kerakoll GreenBuilding. The pillars of healthy housing are indoor air quality, advanced environmental and energy standards, and healthy spaces that exist in harmony with nature. Kerakoll's personal approach aims to integrate the many aspects of GreenBuilding into everyday life, in keeping with the growing environmental sensibility of every individual.

We believe that our mission is to make technology more sustainable and to develop an associated model of development: the true aim of any business should be to develop projects of low environment impact but of huge technological innovation.

Kerakoll's commitment in this direction can be seen in everyday things, in business, and in our awareness of consumer needs in order to satisfy current requirements without jeopardizing the wellbeing of future generations. This is not just an economic mission, but also one of corporate social responsibility which guides and unites everyone here at Kerakoll.

That's why at Kerakoll we see business and social responsibility as going hand in hand, which means we make it our business to improve the quality of life of people and the environment they live in.

### **Taking "Made in Italy" excellence around the world**

In its 40 years in the industry, Kerakoll has been so successful that it has gone from being top of the domestic market to a top Italian-based business in Europe, before also becoming a leading European group (and Italian at heart) bound for the international arena. International expansion and an ever more global approach have certainly not eroded the longstanding Kerakoll identity. The company has remained faithful to the values that saw it rise to 1st place in the production of GreenBuilding solutions around the world with more than 1,700 items.

Innovation, respect for the environment, concern for health and living comfort, and a pure wholesome approach are the defining tenets of Kerakoll.

### 3. MANUFACTURING

The manufacturing process starts from raw materials purchased from suppliers and stored in the plant.

Bulk raw materials are stored in specific silos and added mostly automatically in the production mixer, according to the formula of the products. Other raw materials, supplied in bags or big bags, are stored in their warehouse and added automatically or manually in the mixer.

The production is a discontinuous process, in which all the components are mechanically mixed in batches.

The semi-finished product is then packaged in bags, put on wooden pallets, covered by stretched hoods and stored in the Finished Products' warehouse. The quality of final product is controlled before the sale.

This manufacturing process does not involve water and it is almost a close-loop process, involving maximum recirculation of dry waste into production; wherever dust is issued during production, it is directed to a filter system according to the limit values applicable for the workplace. Most of the residual dust collected in the filter system and product incurred during production are returned to the production process wherever possible.



## 4. PRODUCTS

### Description and use of the products

These products are manufactured by Kerakoll S.p.A. in the production plants located in Sassuolo (MO - Italy) and Rubiera (RE - Italy).

Available in 2 colours, grey and white, they are supplied in 25 kg paper bags and only a few of them also in 2 or 5 kg format.

Multi-purpose, flexible, structural, single-component mineral adhesives for high performance bonding of porcelain tiles, ceramic tiles and natural stone, with no vertical slip and long open time.

They develop full substrate and tile back coverage ensuring high resistance to shear stress as well as total safety when tiles of all formats and thicknesses are laid even in the most demanding of applications

Formulated with mineral bentonite, natural NHL lime, locally-sourced minerals and natural polymers.

With very low volatile organic compound emissions, they contain recycled materials thereby reducing the damage to the environment caused by extracting pure raw materials.

They are recyclable as an inert material at the end of their life, avoiding waste disposal costs and environmental impact.

Category: Inorganic mineral products

Class: Laying ceramic tiles and natural stone; mineral adhesives with SAS technology for ceramic tiles and natural stone.



### Products standard

The products are designed, produced and CE marked according to EN 12004:2007+A1:2012 (Adhesives for tiles. Requirements, evaluation of conformity, classification and designation) for interior and exterior bonding of ceramic tiles, porcelain, natural stone and mosaics on floors and walls.

### Physical characteristics

The products are supplied from production in dry form, premixed in respect of all contents but water.

Water is added at the building site in the construction/ installation stage, in a defined amount and technique, in order to get easily workable product of high-performance grouting of ceramic tiles, porcelain tiles, low thickness slabs, marble and natural stone.

For specific physical properties, we refer to the CE declaration or Declaration of Performance available on demand or to the technical datasheet on [www.kerakoll.com/it](http://www.kerakoll.com/it).

### Content declaration

The main components of the involved products are the following.

#### White products

Component	Weight (%)	CAS Nr.	Classification	Comment (i.e. recycled materials)
Aggregates and fillers	50-75	1317-65-3	-	Calcium carbonate partially recycled
Binders (cement, plaster, lime)	25-50	65997-15-1	H318 H315 H317 H335	Portland cement
		65997-16-2	-	Aluminous cement
Others (additives, etc.)	<2,5	85117-09-5	H315 H318 H335	Lime (Chemical)
		68475-76-3	H318 H315 H317 H335	Flue Dust

#### Grey products

Component	Weight (%)	CAS Nr.	Classification	Comment (i.e. recycled materials)
Aggregates and fillers	50-80	1317-65-3	-	Calcium carbonate partially recycled
		14808-60-7		Quartz
Binders (cement, plaster, lime)	20-50	65997-15-1	H318 H315 H317 H335	Portland cement
		65997-16-2	-	Aluminous cement
Others (additives, etc.)	<2,5	68475-76-3	H318 H315 H317 H335	Flue dust

Products are free from substances of very high concern (SVHC) on the REACH Candidate List published by the European Chemicals Agency in a concentration more than 0,1% (by unit weight) and it does not contain fungicides.

## 5. LCA INFORMATION



### Declared Unit and Reference Service Life

The Declared Unit (DU) is 1 kg of product (dry mortar).

This document describes the environmental impact of 1 kg of powder product (packaging included) for each products involved. According to the system boundary of this EPD, a RSL has not been provided.

### Scope

CEN developed the EN 15804, a core set of rules for the development of EPD applicable to construction products. This standard is developed with a modular structure, described below.

This EPD is of the 'Cradle to Gate' type, including EN 15804 modules from A1 to A3.

Modules not accounted in the LCA since they are not assessed are marked as "MND", Module Not Declared.

Upstream - Core			Downstream												
Product stage			Construction process stage		Use stage							End of life stage			
Raw material supply	Transport of raw materials and pack	Manufacturing	Transport to customer	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction demolition	Transport to waste processing	Waste processing	Disposal
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND

System boundaries and processes included in the LCA (X: Included, MND: Not Declared)

### Product (A1-A3)

- A1-A2: extraction, supply and transport of raw materials and packaging to Kerakoll and manufacturing process energy consumption.
- A3: manufacturing process of product and its packaging and waste management from the same process.

Very low volumes of water are required for laboratory tests and for sanitary facilities.

It covers dosage and mixing of selected and measured raw materials and additives to ensure that the product meets desired properties and packaging material consumption.

The main types of waste are powder waste and packaging materials.

Packaging product materials consist of wooden pallet, cardboard and LDPE used as wrapping material and they include both distribution and consumer packaging, as follows.

Material	Distribution packaging	Consumer packaging
Wooden pallet	x	
Plastic and LDPE film (e.g. for wrapping material)		x
Cardboard and cardboard boxes		x
Printed kraft paper bags coated on the inside with PE film		x

#### Data quality

For the background data the Ecoinvent v.3.3 database is mainly used.

Raw materials and packaging, energy and water consumption and waste data are collected from Kerakoll.

The most relevant considered data are European or specific from supplier.

All dataset are not more than 10 years old (according to EN 15804 § 6.3.7 "Data quality requirements").

#### Period under review

All primary data collected from Kerakoll are representative for the period of 2017-2018.

#### Allocations

There are no co-products in the production of mortars manufactured by Kerakoll. Hence, there is no need for co-product allocation. The Company sources raw materials from different locations across Europe and other parts of the world and by different means of transport. For this reason, transport is allocated according to raw material quantities.

Kerakoll manufactures various products with specifications for different applications in its different manufacturing plants. Raw materials, transport, energy consumption during manufacturing, packaging and waste data are allocated using data from Kerakoll involved plants.

#### Cut-off rules

The consumption of auxiliary materials and waste related to extraordinary activities (A3), having a periodicity exceeding 3 years, are excluded. Quantified contribution from those process: less than 0,5% by mass of products.

## 6. ENVIRONMENTAL INDICATORS

An introduction to each environmental indicator is provided below. All indicators represent the potential to cause environmental impacts; they do not predict if specific environmental thresholds, safety margins or risks will be exceeded. The actual impacts on the environment typically depend upon local, regional and/or global conditions.

### Acidification Potential (AP)

#### - Acid Rain

A measure of emissions that cause acidifying effects to the environment. Acidification potential is a measure of a molecule's capacity to increase the hydrogen ion (H<sup>+</sup>) concentration in the presence of water, thus decreasing the pH value. Potential effects include forest decline and the deterioration of building materials.



### Eutrophication Potential (EP)

#### - Algal Blooms

A measure of nutrient enrichment that may cause an undesirable shift in species composition and elevated biomass production in both terrestrial and aquatic ecosystems. It includes potential impacts of excessively high levels of macronutrients, the most important of which are nitrogen and phosphorus.



### Global Warming Potential (GWP)

#### - Climate Change

A measure of greenhouse gas emissions, such as carbon dioxide and methane. These emissions increase absorption of radiation emitted by the earth, intensifying the natural greenhouse effect.

### Abiotic Depletion Potential (ADP)

#### - Resource Consumption

The consumption of non-renewable resources leads to a decrease in the future availability of the functions supplied by these resources. Depletion of mineral resource elements (ADPE) and non-renewable fossil energy resources (ADPF) are reported separately.



### Ozone Depletion Potential (ODP) - Ozone Hole

A measure of greenhouse gas emissions, such as carbon dioxide and methane. These emissions increase absorption of radiation emitted by the earth, intensifying the natural greenhouse effect.



### Photochemical Ozone Creation Potential (POCP)

#### - Smog

A measure of emissions of precursors that contribute to ground level smog formation (mainly ozone O<sub>3</sub>), produced by the reaction of volatile organic compounds (VOCs) and carbon monoxide in the presence of nitrogen oxides under the influence of UV light. Ground level ozone may be harmful to human and ecosystem health and may also damage crops.



## 7. ENVIRONMENTAL PERFORMANCE

All results are referred to the Declared Unit that is 1 kg of powder product (packaging included).

### Bioflex® Grey

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,79E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,46E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,87E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,92E-4
Ozone layer depletion	kg CFC11 eq	3,94E-8
Abiotic depletion	kg Sb eq	2,20E-6
Abiotic depletion, fossil fuels	MJ	5,08E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	2,91E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	2,91E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,45E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,45E0
Use of net fresh water - FW	m <sup>3</sup>	4,30E-3
Use of secondary material - SM	kg	3,41E-1
Use of renewable secondary fuels - RSF	MJ	1,29E-2
Use of non-renewable secondary fuels - NRSF	MJ	7,39E-5

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,30E-4
Non-hazardous waste disposed - NHWD	kg	1,962E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,69E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	5,96E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	5,99E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,41E-4
Ozone layer depletion	kg CFC11 eq	5,08E-8
Abiotic depletion	kg Sb eq	9,27E-7
Abiotic depletion, fossil fuels	MJ	6,54E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	4,79E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	4,79E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,94E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,94E0
Use of net fresh water - FW	m <sup>3</sup>	7,64E-3
Use of secondary material - SM	kg	6,18E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	0,00E0

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,39E-4
Non-hazardous waste disposed - NHWD	kg	2,10E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,88E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,86E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	5,12E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,93E-4
Ozone layer depletion	kg CFC11 eq	3,83E-8
Abiotic depletion	kg Sb eq	1,58E-6
Abiotic depletion, fossil fuels	MJ	6,96E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	5,15E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	5,15E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,55E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,55E0
Use of net fresh water - FW	m <sup>3</sup>	5,40E-3
Use of secondary material - SM	kg	1,25E-1
Use of renewable secondary fuels - RSF	MJ	1,15E-2
Use of non-renewable secondary fuels - NRSF	MJ	4,28E-5

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	4,14E-4
Non-hazardous waste disposed - NHWD	kg	2,49E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,12E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	4,62E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	5,37E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	7,28E-5
Ozone layer depletion	kg CFC11 eq	2,52E-8
Abiotic depletion	kg Sb eq	7,85E-7
Abiotic depletion, fossil fuels	MJ	5,77E+0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	5,20E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	5,20E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,94E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,94E0
Use of net fresh water - FW	m <sup>3</sup>	4,74E-3
Use of secondary material - SM	kg	6,29E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	0,00E0

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	4,26E-4
Non-hazardous waste disposed - NHWD	kg	2,57E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,64E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,04E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,60E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,91E-4
Ozone layer depletion	kg CFC11 eq	3,78E-8
Abiotic depletion	kg Sb eq	6,78E-7
Abiotic depletion, fossil fuels	MJ	4,95E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	2,84E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	2,84E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,05E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,05E0
Use of net fresh water - FW	m <sup>3</sup>	3,64E-3
Use of secondary material - SM	kg	4,59E-1
Use of renewable secondary fuels - RSF	MJ	1,24E-2
Use of non-renewable secondary fuels - NRSF	MJ	6,46E-5

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,93E-4
Non-hazardous waste disposed - NHWD	kg	2,352E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,25E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,61E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,37E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	9,56E-5
Ozone layer depletion	kg CFC11 eq	3,22E-8
Abiotic depletion	kg Sb eq	6,70E-7
Abiotic depletion, fossil fuels	MJ	4,11E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	4,38E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	4,38E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	9,70E-1
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	9,70E-1
Use of net fresh water - FW	m <sup>3</sup>	4,36E-3
Use of secondary material - SM	kg	6,36E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	0,00E0

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,76E-4
Non-hazardous waste disposed - NHWD	kg	2,26E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,64E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,04E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,60E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,91E-4
Ozone layer depletion	kg CFC11 eq	3,78E-8
Abiotic depletion	kg Sb eq	6,78E-7
Abiotic depletion, fossil fuels	MJ	4,95E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	2,84E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	2,84E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,05E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,05E0
Use of net fresh water - FW	m <sup>3</sup>	3,64E-3
Use of secondary material - SM	kg	4,59E-1
Use of renewable secondary fuels - RSF	MJ	1,24E-2
Use of non-renewable secondary fuels - NRSF	MJ	6,46E-5

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,93E-4
Non-hazardous waste disposed - NHWD	kg	2,352E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,25E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,61E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,37E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	9,56E-5
Ozone layer depletion	kg CFC11 eq	3,22E-8
Abiotic depletion	kg Sb eq	6,70E-7
Abiotic depletion, fossil fuels	MJ	4,11E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	4,38E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	4,38E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	9,70E-1
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	9,70E-1
Use of net fresh water - FW	m <sup>3</sup>	4,36E-3
Use of secondary material - SM	kg	6,36E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	0,00E0

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,76E-4
Non-hazardous waste disposed - NHWD	kg	2,26E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,50E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	2,44E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	2,99E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	8,96E-5
Ozone layer depletion	kg CFC11 eq	2,92E-8
Abiotic depletion	kg Sb eq	5,49E-7
Abiotic depletion, fossil fuels	MJ	3,19E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	3,03E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	3,03E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,31E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,31E0
Use of net fresh water - FW	m <sup>3</sup>	3,31E-3
Use of secondary material - SM	kg	3,75E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	9,74E-1

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	6,73E-4
Non-hazardous waste disposed - NHWD	kg	2,31E-3
Radioactive waste disposed - RWD	kg	7,34E-6

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	2,50E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,95E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,49E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,68E-4
Ozone layer depletion	kg CFC11 eq	7,63E-8
Abiotic depletion	kg Sb eq	7,28E-7
Abiotic depletion, fossil fuels	MJ	6,53E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	3,47E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	3,47E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,83E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,83E0
Use of net fresh water - FW	m <sup>3</sup>	3,88E-3
Use of secondary material - SM	kg	7,19E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	2,83E-1

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	3,40E-3
Non-hazardous waste disposed - NHWD	kg	5,70E-3
Radioactive waste disposed - RWD	kg	1,48E-5

## Special Eco Grey

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	1,71E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	5,47E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,46E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,30E-4
Ozone layer depletion	kg CFC11 eq	5,22E-8
Abiotic depletion	kg Sb eq	1,08E-6
Abiotic depletion, fossil fuels	MJ	5,78E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	5,68E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	5,68E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	2,56E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	2,56E0
Use of net fresh water - FW	m <sup>3</sup>	9,34E-3
Use of secondary material - SM	kg	9,58E-2
Use of renewable secondary fuels - RSF	MJ	7,60E-3
Use of non-renewable secondary fuels - NRSF	MJ	1,41E-2

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	4,77E-4
Non-hazardous waste disposed - NHWD	kg	2,989E-3
Radioactive waste disposed - RWD	kg	0,00E0

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	9,26E-4
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	3,33E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	3,71E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	5,80E-5
Ozone layer depletion	kg CFC11 eq	2,41E-8
Abiotic depletion	kg Sb eq	5,49E-7
Abiotic depletion, fossil fuels	MJ	3,10E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	2,70E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	2,70E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,68E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,68E0
Use of net fresh water - FW	m <sup>3</sup>	3,65E-3
Use of secondary material - SM	kg	7,36E-1
Use of renewable secondary fuels - RSF	MJ	0,00E0
Use of non-renewable secondary fuels - NRSF	MJ	0,00E0

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	4,46E-4
Non-hazardous waste disposed - NHWD	kg	2,70E-3
Radioactive waste disposed - RWD	kg	0,00E0

## Super Bio Grey

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	3,40E-3
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	9,94E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	4,10E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	1,76E-4
Ozone layer depletion	kg CFC11 eq	3,56E-8
Abiotic depletion	kg Sb eq	7,20E-5
Abiotic depletion, fossil fuels	MJ	4,55E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	1,83E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	1,83E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	4,28E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	4,28E0
Use of net fresh water - FW	m <sup>3</sup>	6,28E-3
Use of secondary material - SM	kg	4,63E-1
Use of renewable secondary fuels - RSF	MJ	6,14E-3
Use of non-renewable secondary fuels - NRSF	MJ	8,09E-3

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	4,49E-4
Non-hazardous waste disposed - NHWD	kg	2,771E-3
Radioactive waste disposed - RWD	kg	0,00E0

## Super Bio White

POTENTIAL ENVIRONMENTAL IMPACT	Unit	A1-A3
Acidification	kg SO <sub>2</sub> eq	9,04E-4
Eutrophication	kg PO <sub>4</sub> <sup>3-</sup> eq	2,85E-4
Global Warming (GWP100a)	kg CO <sub>2</sub> eq	3,16E-1
Photochemical oxidation	kg C <sub>2</sub> H <sub>4</sub> eq	5,43E-5
Ozone layer depletion	kg CFC11 eq	2,13E-8
Abiotic depletion	kg Sb eq	5,03E-7
Abiotic depletion, fossil fuels	MJ	2,90E0

USE OF RESOURCES	Unit	A1-A3
Use of non-renewable primary energy excluding resources used as raw materials - PENRE	MJ	2,53E0
Use of non-renewable primary energy resources used as raw materials - PENRM	MJ	0,00E0
Total use of non-renewable primary energy resources - PENRT	MJ	2,53E0
Use of renewable primary energy excluding resources used as raw materials - PERE	MJ	1,61E0
Use of renewable primary energy resources used as raw materials - PERM	MJ	0,00E0
Total use of renewable primary energy resources - PERT	MJ	1,61E0
Use of net fresh water - FW	m <sup>3</sup>	3,27E-3
Use of secondary material - SM	kg	6,86E-1
Use of renewable secondary fuels - RSF	MJ	9,03E-5
Use of non-renewable secondary fuels - NRSF	MJ	1,67E-4

WASTE PRODUCTION AND OUTPUT FLOWS	Unit	A1-A3
Hazardous waste disposed - HWD	kg	4,50E-4
Non-hazardous waste disposed - NHWD	kg	2,73E-3
Radioactive waste disposed - RWD	kg	0,00E0

## 8. ADDITIONAL ENVIRONMENTAL INFORMATION

### Quality and Environmental management systems

Kerakoll is ISO 9001 certified since 2000 and ISO 14001 since 2012.

### VOC emissions

Volatile Organic Compounds (VOC) tests and evidence have been carried out on the product (all colors), according to ISO 16000 parts 3, 6, 9 and 11 and CN/TS 16516. The involved products meet the requirements for the emission class Emission EC1R Plus, as “very low VOC emission”, released by GEV (Gemeinschaft Emissionskontrollierte Verlegewerkstoffe, Klebstoffe und Bauprodukte e.V.). They have been evaluated in emission chambers, in order to detect their VOC emissions after 3 and 28 days storage in the ventilated chambers, according to GEV test method.

Product name	Recycled content (pre-consumer)	Recyclable (end-of-life product recyclability)	Reduced use of resources
Bioflex®	White ≈ 60% Grey ≈ 20-30%	yes	yes
Bioflex® S1	White ≈ 65% Grey ≈ 10%		
Biofloor®	White ≈ 60-65% Grey ≈ 40-45%		
H40® Eco Flex	White ≈ 60-65% Grey ≈ 40-45%		
H40® Revolution®	White ≈ 65-70% Grey ≈ 35-40%		
Special Eco	White ≈ 70-75% Grey ≈ 5%		
Super Bio	White ≈ 65-70% Grey ≈ 40-45%		

As stated in the validation of self-declared environmental claim (N° 16.12795) issued by SGS Italia S.p.A., according to ISO 14021:2016.

## 9. DIFFERENCES VERSUS PREVIOUS VERSION OF THE EPD

Inclusion of the product BIOFLOOR® added to those involved in the previous version of the EPD.

## 10. REFERENCES

Ecoinvent - Ecoinvent Centre, [www.ecoinvent.org](http://www.ecoinvent.org)

EMICODE GEV - Gemeinschaft Emissionskontrollierte Verlegewerkstoffe, Klebstoffe und Bauprodukte e. V. (pub.). [www.emicode.de](http://www.emicode.de)

EN 12004:2007+A1:2012 - Adhesives for tiles - Requirements, evaluation of conformity, classification and designation

EN 15804:2012+A1:2013 - Sustainability of construction works - Environmental Product Declarations - Core rules for the product category of construction products

EN ISO 16000-9:2008-04 - Indoor air - Part 9: Determination of the emission of volatile organic compounds from building products and furnishings - Emission test chamber method

EPD Study Report AdhesivesITA, 2019-04-12

GPI - General Programme Instructions, The International EPD® System, Version 3.0

ISO 9001:2015 - Quality management systems - Requirements

ISO 14001:2015 - Environmental management systems - Requirements with guidance for use

ISO 14021:2016 - Environmental labels and declarations - Self-declared environmental claims (Type II environmental labelling)

ISO 14025:2009 - Environmental labels and declarations - Type III environmental declarations - Principles and procedures

ISO 14040/44:2006 - Environmental management - Life cycle assessment - Principles and framework (ISO 14040:2006) and Requirements and guidelines (ISO 14044:2006)

ISO 16000-3:2013-01 - Indoor air - Part 3: Determination of formaldehyde and other carbonyl compounds by sampling using a pump

ISO 16000-6:2012-11 - Indoor air - Part 6: Determination of volatile organic compounds indoors and in test chambers by sampling on TENAX TA®, thermal desorption and gas chromatography using MS or FID

PCR for Construction Products and CPC 54 Construction Services, The International EPD System, 2012:01 Version 2.2, 2017-05-30

SimaPro - SimaPro LCA Software, Pré Consultants, the Netherlands, [www.pre-sustainability.com](http://www.pre-sustainability.com)

The International EPD® System - The International EPD® System is a programme for type III environmental declarations, maintaining a system to verify and register EPD®s as well as keeping a library of EPD®s and PCRs in accordance with ISO 14025 [www.environdec.com](http://www.environdec.com)

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