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Danish market	All modules valid for the Danish market

3<sup>rd</sup> PARTY VERIFIED

**EPD**

VERIFIED ENVIRONMENTAL PRODUCT DECLARATION | ISO 14025 & EN 15804



## 1. General Information

### Troldtekt A/S

#### Programme holder

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

#### Declaration number

EPD-TRO-20220048-ICA2-EN

#### This declaration is based on the product category rules:

Wood cement - Mineral-bonded wooden composites, 01.2019  
(PCR checked and approved by the SVR)

#### Issue date

11-04-2022

#### Valid to

06-04-2027



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



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

### Troldtekt 25 mm Natural Grey based on FUTURECEM - unpainted

#### Owner of the declaration

Troldtekt A/S  
Sletvej 2 A  
8310 Tranbjerg  
Denmark

#### Declared product / declared unit

Acoustic panel "Natural Grey FUTURECEM" - 1 m<sup>2</sup>, 25 mm thickness - unpainted

#### Scope:

This declaration represents the production, supply, mounting, use, dismantling and disposal of 1 m<sup>2</sup> (25 mm thickness) of grey composite cement-bonded wood wool acoustic panel "Natural Grey FUTURECEM", produced by Troldtekt A/S, with a reference service life of 50 years. The production facility is located in Jutland, Denmark. Three scenarios represent its use in indoor conditions in Denmark, Sweden and Germany.

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

The EPD was created according to the specifications of *EN 15804+A1*. In the following, the standard will be simplified as *EN 15804*.

#### Verification

The standard *EN 15804* serves as the core PCR

Independent verification of the declaration and data according to *ISO 14025:2011*

internally  externally



Ms Jane Anderson  
(Independent verifier)

## 2. Product

### 2.1 Product description/Product definition

Troldtekt Natural Grey FUTURECEM acoustic panels are some of the leading and preferred solutions for creating a good indoor sound environment. They are sold in various thicknesses (20-35 mm) and dimensions (width: 600 mm, lengths: 600/1200/2400 mm or width: 625 mm, lengths: 625/1250/2500 mm). The panels can be unpainted or painted in a wide variety of colours.

For the placing on the market of the product in the European Union/European Free Trade Association (EU/EFTA) (with the exception of Switzerland) *Regulation (EU) No. 305/2011* applies. The product needs a declaration of performance taking into consideration *EN 13964:2014, Suspended ceilings. Requirements and test methods*, and the CE-marking.

For the application and use, the respective national provisions apply.

### 2.2 Application

The panels are installed on the ceilings and walls in offices, businesses, schools, institutions, cultural sites, sports centres, swimming pools and private homes.

### 2.3 Technical Data

The table below indicates the technical specifications of the panels in accordance with *EN 13168*, the standard for cement-bonded wood wool and double-layer panels with cement-bonded wood wool, and *EN 13964*, the standard for suspended ceilings.

## Technical specifications of the product covered in this EPD

Name	Value	Unit
Gross density	463	kg/m <sup>3</sup>
Grammage	11.59	kg/m <sup>2</sup>
Thermal conductivity acc. to EN 13168:2012+A1:2015	0.076	W/(mK)
Water vapour diffusion resistance factor acc. to DIN 4108-4	-	-
Sound absorption coefficient (only with reference to the corresponding component design)	-	%
Light reflection (measured by DELTA Light and Optics)	26.3 - 70.8	%
Reaction to fire	B/S1/d0	

Performance data of the product in accordance with the declaration of performance with respect to its essential characteristics according to EN 13168:2012+A1:2015, *Thermal insulation products for buildings. Factory made wood wool (WW) products. Specification*, and EN 13964:2014, *Suspended ceilings. Requirements and test methods*.

### 2.4 Delivery status

The panel is usually distributed in length of 600, 1200 or 2400 mm by 600 mm width or in length of 625, 1250 or 2500 mm by 625 mm width. It comes in three thicknesses: 20, 25 and 35 mm. Additionally, several density ranges are available: Coarse, Fine, Ultra-Fine and Extreme-Fine causing different densities (388-428 kg/m<sup>3</sup>). The panels are normally delivered in packs of 80 units on pallets.

### 2.5 Base materials/Ancillary materials

The composition of the finished product is a mix of wood wool (31.9 %), Portland composite cement (62.2 %), water (4.5 %), as well as water glass (<1 %) and accelerator (<1 %). The composition is at dry basis at the factory gate, as most of the water has evaporated during drying, but water remains bound to the wood fibre and cement paste (hydrated cement).

This product/article/at least one partial article contains substances listed in the candidate list (date: 17.01.2022) exceeding 0.1 percentage by mass: No

This product/article/at least one partial article contains other CMR substances in categories 1A or 1B which are not on the candidate list, exceeding 0.1 percentage by mass: No

Biocide products were added to this construction product or it has been treated with biocide products (this then concerns a treated product as defined by the (EU) Ordinance on Biocide Products No. 528/2012): No

### 2.6 Manufacture

Norway spruce logs from local forests (with a moisture content of about 65-70 %) are received and the bark is removed. The wood is stored for approximately six months until the moisture content in the wood drops to 29 %. The wood is then shredded to produce wool.

The wood wool is mixed together with Portland composite cement, water, and additives. The mixture is cast and cured using a heat press and dried with a biomass-fired oven. The cast panel is milled to remove any material in excess and cut edges. After approximately 4 weeks of curing, the panel can be painted before being stored on a pallet and packaged to be transported to central distribution warehouses.

### 2.7 Environment and health during manufacturing

Troldtekt is following its working environment closely. Both the physical working environment and sickness absence are closely monitored. It is an ongoing process involving both leaders and factory workers.

### 2.8 Product processing/Installation

Installation instructions are available here: <https://www.troldtekt.com/Installation>

### 2.9 Packaging

The product is packaged with polyethylene plastic film and cardboard. The packaging material can be easily sorted and treated in dedicated waste recycling channels. The packaged product is delivered on a returnable wood pallet.

### 2.10 Condition of use

Conditions of use are detailed here: [https://www.troldtekt.com/Installation/Use\\_and\\_maintenance](https://www.troldtekt.com/Installation/Use_and_maintenance)

### 2.11 Environment and health during use

Environmental and ecotoxicity risks from exposure to Troldtekt panel products during use have been assessed and found eligible to the following certification schemes:

- Finnish M1 classification
- Danish Indoor Climate
- Cradle to Cradle

These certificates can be accessed here: <https://www.troldtekt.com/Web-tools/Downloads/Certificates-and-tests>

### 2.12 Reference service life

The technical service life of the panel is superior to 50 years. This EPD refers to the service lifetime indicated by the BBSR table for the material 353.311 of type "Holzbekleidungen: Holz, Holzwerkstoff und Mehrschichtleichtbauplatten".

Because the panel is used in a building, in this EPD its reference service life is limited by the expected service life of the building, which is commonly accepted as 50 years, at least as LCA timeframe.

There is no influence of the ageing of the material on its technical performance.

### 2.13 Extraordinary effects

#### Fire

Information on the fire performance according to EN 13168.

#### Fire protection

Name	Value
Building material class	B

Burning droplets	d0
Smoke gas development	S1

## Water

No information on the product performance under the unforeseeable influence of water is available.

## Mechanical destruction

No information on the product performance under unforeseeable mechanical destruction is available.

## 2.14 Re-use phase

Currently, Troldtekt panels undergo thermal treatment with energy recovery. Composting is also possible.

Additional information on recycling

options: [https://www.troldtekt.com/~media/Files/Info%20sheets/English/Troldtekt\\_Recycling%20instructions%20pdf.pdf](https://www.troldtekt.com/~media/Files/Info%20sheets/English/Troldtekt_Recycling%20instructions%20pdf.pdf)

## 2.15 Disposal

The product may be composted, thermally treated with energy recovery, or landfilled.

*European Waste Code: 10 13 11* (wastes from cement-based composite materials)

Painted panels must be incinerated at end-of-life.

Additional information on disposal

options: <https://www.troldtekt.com/environment-and-csr/product-life-cycle/recycling/>

## 2.16 Further information

For additional information on technical specifications, you may consult the Declaration Of

Performance: <https://www.troldtekt.com/Web-tools/Downloads/DoPs>

## 3. LCA: Calculation rules

### 3.1 Declared Unit

The functional unit is 1 m<sup>2</sup> of acoustic panel, in 25 mm thickness, corresponding to 11.59 kg of material with unpainted finish, mounted on the ceiling, with a reference service life of 50 years.

#### Declared unit

Name	Value	Unit
Declared unit	1	m <sup>2</sup>
Gross density	463	kg/m <sup>3</sup>
Grammage	11.59	kg/m <sup>2</sup>
conversion factor [Mass/Declared Unit]	11.59	-
Layer thickness	0.025	m

### 3.2 System boundary

Cradle to grave

### 3.3 Estimates and assumptions

Assumptions are described occasionally throughout the section "LCA: Calculation rules".

### 3.4 Cut-off criteria

The cut-off criterion is applied according to *EN 15804* Section 6.3.5 and *PCR part A* Section 5.6. All inputs and outputs for which data are available are included in the LCA model. Data gaps are filled with conservative assumptions from average data (when available) or with generic data and are documented accordingly.

The following product flows have been omitted according to the 1% cut-off rule:

- Wooden pallet to transport the product
- Capital infrastructure (factory)
- Allocation of burden from wood logging to residual wood fractions

### 3.5 Background data

Two types of data source are used as secondary data:

- Product-specific EPDs for the manufacture and supply of Portland composite cement and water-based paint
- Database *ecoinvent v.3.6 cut-off*

### 3.6 Data quality

#### Statistical representativeness

The statistical representativeness of the product system is very good. The input and output data samples used to build inventories are based on the entirety of the annual production of panels in 2020 and is verified by a third party. Such representativeness is also valid for the production of Portland composite cement (FUTURECEM), whose EPD was published in 2019 and audited in 2021. The EPD for the paint used was published in 2018.

#### Temporal, geographical and technological representativeness

All data strictly related to the cement production is technologically, temporally, and geographically representative. The cement production data is less than 5 years old. The data used to model the foreground inventory of acoustic panels dates from the production year of 2020. As for secondary data, some of the *ecoinvent* datasets are less than 3 years old.

### 3.7 Period under review

The primary data concerned with the manufacture (A1-A3) relates to the production year 2020 and the data are based on the volumes produced on an annual basis.

### 3.8 Allocation

Allocation of production data to the multiple produced types of panels (with the same functional unit) is performed based on the rules provided in *EN 15804*. Sub-processes associated to painting have especially been allocated to the painted panels. Data such as waste generation and packaging have been allocated to the entire production volume of panels in Troldtekt. The only case of co-produced outputs is associated to wood logging. However, the environmental load is evenly distributed over all its co-products, such as logs, energy wood, and bark.

### 3.9 Comparability

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

The used background database is *ecoinvent v.3.6 cut-off*

## 4. LCA: Scenarios and additional technical information

### Manufacture (A1-A3)

#### Data

Primary data is third-party verified and based on the production year 2020, within the facilities of Troldtekt A/S in Jutland (Denmark).

#### End-of-waste state and use of by-products

For all processes supplying a residual material/waste that originates the end-of-life phase of a product to the product system to be used as input, the polluter-pay principle "100:0" is used. Some wooden by-products generated during manufacture in Troldtekt end up as soil improvers externally (reaching end-of-waste state), and thus their biogenic carbon leaves Troldtekt's system boundary.

#### Wind-certified electricity

All the electricity used to produce the panels in Module A3 originates from Danish wind power, for which a certificate ensures the origin. It originates from a 1-3 MW offshore wind turbine, with transformation, transmission and distribution losses and is modelled correspondingly.

#### Carbon balance

**Biogenic:** Absorption of biogenic CO<sub>2</sub> by the purchased wood has been considered in A1. Some of it is released again during production in A3, some ends up sequestered in soil, while the majority of the remaining biogenic CO<sub>2</sub>, 7.15 kg, is retained in the finished product and emitted during end-of-life incineration in C4.

**Fossil:** Absorption of some fossil CO<sub>2</sub>, originating from the calcination of limestone during cement production, happens when the cement is mixed with water in A3. A majority is absorbed during the use phase B1, and all the absorbed fossil CO<sub>2</sub> is finally emitted during end-of-life incineration in C4.

### Distribution to site (A4) and mounting (A5)

To consider the main geographical variants of the life cycle of Troldtekt Natural Grey FUTURECEM panels, three scenarios are developed, where the product is supplied, mounted, used and discarded in Aarhus (Denmark), Hamburg (Germany) and Malmö (Sweden). An additional 50 km from the local warehouse to construction site is assumed.

#### Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	26.8	l/100km
Transport distance to Denmark	160	km
Transport distance to Germany	370	km
Transport distance to Sweden	394	km
Transport distance from warehouse to local construction sites in Denmark/Germany/Sweden	50	km
Capacity utilisation (including empty runs)	85	%
Gross density of products transported	463	kg/m <sup>3</sup>

Capacity utilisation volume factor	1	-
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### Installation into the building (A5)

Name	Value	Unit
Electricity consumption	0.060	kWh
Material loss (plastic film)	0.007	kg
Material loss (cardboard)	0.032	kg

### Use phase (B1)

Before distribution and during the use phase (B1), the carbonation of the cement contained in the panel, during use, is accounted for. Based on laboratory measurement, the panel will absorb up to 140 grams of carbon dioxide per kilogram of cement. Normalized to the reference flow, this corresponds to an uptake of approximately 0.7 kilograms of carbon dioxide by the end of the service lifetime, including the uptake in A3.

### Maintenance (B2)

As the panel does not require any maintenance except for the occasional dusting, no maintenance module (B2) is considered.

Name	Value	Unit
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### Repair, replacement, refurbishment (B3, B4, B5)

As the technical service life of the panel is superior to the assumed service life of the building (50 years), no repair (B3), replacement (B4) or refurbishment (B5) steps are considered.

Name	Value	Unit
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### Replacement (B4) / Refurbishment (B5)

Name	Value	Unit
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Information about reference service life is detailed in 2.12.

### Reference service life

Name	Value	Unit
Reference service life (according to ISO 15686-1, -2, -7 and -8)	50	a
Life Span (according to BBSR)	50	a
Life Span according to the manufacturer	75	a

### Operational energy use (B6) and Operational water use (B7)

Name	Value	Unit
Water consumption	-	m <sup>3</sup>
Electricity consumption	-	kWh
Other energy carriers	-	MJ
Equipment output	-	kW

### End of life (C1-C4)

Name	Value	Unit
Electricity use (for un-mounting)	0.060	kWh

Transport (to material sorting facility)	50	km
Collected as mixed construction waste	11.59	kg
Energy recovery	3.64	kg
Energy recovery efficiency	10	%
Energy recovered	7.42	MJ

The panel is un-mounted at the end of its reference service life and driven to the regional waste incineration plant. Energy is recovered from the wood part of the panel at 10 % efficiency.

### Reuse, recovery and/or recycling potentials (D), relevant scenario information

Name	Value	Unit
Electricity	1.76	MJ
Heat	5.66	MJ

The energy substituted from incineration of the panel's wood component in C4 is considered to be a split of the Danish electricity grid mix (for electricity) and natural gas (for heat).

#### *Details on possible disposal routes*

Aalborg Portland cement factory utilizes dust and offcuts from the Troldtekt factory as a raw material in new cement, i.e. in the technical circle. During incineration in the cement kiln, the wood content in the cement-bonded wood wool panels replaces fossil fuels, while the cement ends up as a raw material in new cement, replacing virgin raw materials and heavy fossil fuels, thereby avoiding a significant amount of CO<sub>2</sub> emissions. This scheme of wood wool waste as a raw material can be scaled for construction site and demolition waste. It will be gradually rolled out to all of Denmark in the period 2021-2023. Once Denmark has documented economic and environmental benefits to be gained by including wood wool waste in the production of new cement rather than going to waste incineration or landfill, dialogue with municipalities and local cement producers in the primary markets of Troldtekt is initiated to facilitate similar schemes regionally or nationally.

## 5. LCA: Results

Note: Global Warming Potential (GWP) indicator includes CO<sub>2</sub> of both biogenic and fossil origin. Also, GWP results for Troldtekt Natural Grey FUTURECEM (unpainted) for other delivery scenarios in respectively Germany and Sweden, are 2.27E-1 kg CO<sub>2</sub> and 2.40E-1 kg CO<sub>2</sub>.

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

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

### RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A1: 1 m<sup>2</sup> Natural Grey FUTURECEM, 25 mm, unpainted, delivered and used in Denmark

Parameter	Unit	A1-A3	A4	A5	B1	C1	C2	C4	D
GWP	[kg CO <sub>2</sub> -Eq.]	-1.37E+0	1.14E-1	2.41E-1	-5.34E-1	6.50E-4	9.59E-2	7.87E+0	-9.69E-1
ODP	[kg CFC11-Eq.]	1.99E-7	2.08E-8	1.14E-8	0.00E+0	2.81E-10	1.75E-8	6.52E-9	-5.36E-8
AP	[kg SO <sub>2</sub> -Eq.]	1.23E-2	2.30E-4	7.24E-4	0.00E+0	1.59E-6	1.94E-4	5.38E-4	-2.01E-3
EP	[kg (PO <sub>4</sub> ) <sup>3</sup> -Eq.]	5.46E-3	4.73E-5	3.93E-4	0.00E+0	8.86E-7	3.98E-5	2.34E-4	-1.49E-3
POCP	[kg ethene-Eq.]	7.19E-4	1.52E-5	4.25E-5	0.00E+0	8.88E-8	1.28E-5	4.22E-5	-1.16E-4
ADPE	[kg Sb-Eq.]	5.24E-5	3.11E-6	4.92E-6	0.00E+0	1.82E-8	2.61E-6	7.10E-7	-2.60E-6
ADPF	[MJ]	3.59E+1	1.73E+0	2.23E+0	0.00E+0	4.20E-2	1.46E+0	6.50E-1	-1.36E+1

Caption: GWP = Global warming potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential of land and water; EP = Eutrophication potential; POCP = Formation potential of tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources

### RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A1: 1 m<sup>2</sup> Natural Grey FUTURECEM, 25 mm, unpainted, delivered and used in Denmark

Parameter	Unit	A1-A3	A4	A5	B1	C1	C2	C4	D
PERE	[MJ]	6.83E+1	2.44E-2	4.50E-1	0.00E+0	3.91E-2	2.06E-2	8.59E+0	-6.34E+0
PERM	[MJ]	7.47E+1	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PERT	[MJ]	1.43E+2	2.44E-2	4.50E-1	0.00E+0	3.91E-2	2.06E-2	8.59E+0	-6.34E+0
PENRE	[MJ]	3.63E+1	1.73E+0	2.23E+0	0.00E+0	4.20E-2	1.46E+0	6.50E-1	-1.36E+1
PENRM	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PENRT	[MJ]	3.63E+1	1.73E+0	2.23E+0	0.00E+0	4.20E-2	1.46E+0	6.50E-1	-1.36E+1
SM	[kg]	1.35E+0	0.00E+0	2.73E-3	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
RSF	[MJ]	7.89E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
NRSF	[MJ]	8.34E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
FW	[m <sup>3</sup> ]	1.72E-2	2.96E-4	2.20E-3	0.00E+0	1.19E-5	2.49E-4	2.86E-4	-1.86E-3

Caption: PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water

### RESULTS OF THE LCA - WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A1: 1 m<sup>2</sup> Natural Grey FUTURECEM, 25 mm, unpainted, delivered and used in Denmark

Parameter	Unit	A1-A3	A4	A5	B1	C1	C2	C4	D
HWD	[kg]	4.74E-2	1.76E-3	7.11E-2	0.00E+0	5.40E-5	1.48E-3	1.50E-3	-5.92E-2
NHWD	[kg]	1.63E+0	1.21E-1	4.24E-1	0.00E+0	1.12E-3	1.02E-1	6.31E-2	-2.02E+0
RWD	[kg]	7.82E-5	1.19E-5	8.28E-6	0.00E+0	5.78E-7	9.99E-6	5.06E-6	-2.45E-5
CRU	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
MFR	[kg]	4.86E-3	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
MER	[kg]	1.05E-2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
EEE	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	1.76E+0	0.00E+0
EET	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	5.66E+0	0.00E+0

Caption: HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EEE = Exported thermal energy

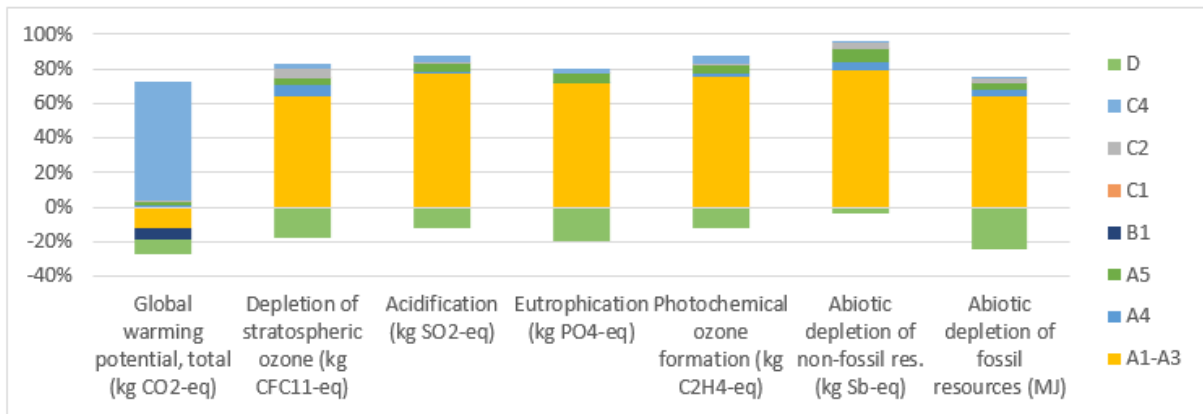
## 6. LCA: Interpretation

The estimated impact results are only relative statements that do not indicate the end points of the impact categories, exceeding threshold values, safety margins or risks.

Two charts are presented: (1) with the standard lifecycle impact categories displaying the share of impacts across all lifecycle stages, and (2) displaying the total carbon balance of the Troldtekt product's lifecycle system.

Impacts from the A1-A3 modules are dominant in the life cycle of the Troldtekt Natural Grey FUTURECEM panel products. This is primarily caused by the acquisition and use of cement and wood in the

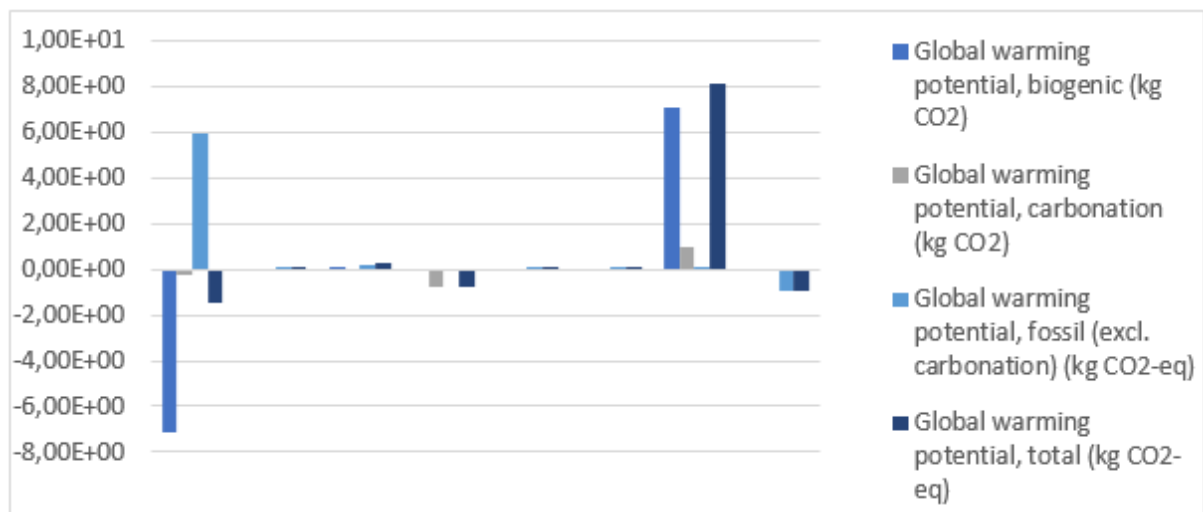
foreground processes. Global Warming Potential net emissions share is much larger in C4 than in A1-A3 (see why in chart (2)), while other impact categories in module D, in general, are avoided in the waste system owing to the incineration of end-of-life panels and substitution of natural gas and Danish electricity mix. C4 also slightly follows emissions of compounds associated to other impact categories. A relatively inefficient transportation of end-of-life panels to waste incineration causes emissions in especially Abiotic depletion of non-fossil resources, Depletion of stratospheric ozone, and Photochemical ozone formation.



The embodied emissions associated to the raw materials (primarily cement) are the main cause of impacts, especially in terms of net Global Warming Potential, with 4.85 kg CO<sub>2</sub>-eq for cement followed by minor impacts from additives. In general, direct emissions from the Troldtekt production site are relatively small. Abiotic depletion of fossil resources appears from the burden of producing cement using fossil raw material such as limestone and to a large extent fossil fuels. In terms of carbon balance, biogenic CO<sub>2</sub> in A1-A3 offsets nearly all the fossil CO<sub>2</sub> emissions in A1-A3. All biogenic CO<sub>2</sub> sequestered in A1-A3 and some fossil CO<sub>2</sub> taken up in A1-A3 and B1

is re-emitted in C4. CO<sub>2</sub>-eq emissions occurring in the remaining modules are negligible.

The amount of wood stored in the product refers to a negative contribution to Global Warming Potential, reducing the share of Global Warming Potential in A1-A3. This is due to the sequestration of biogenic carbon of wood during tree growth. The sequestered carbon does not contribute to global warming as long as it is stored in the biomass.





## Summary

Within the cradle to grave, the following aspects have been identified as major contributors, mainly in the categories Global Warming Potential and Abiotic depletion of fossil resources:

- Emissions from the clinker production from material
- Emissions from the clinker production from fuel
- Substituted emissions from end of life incineration

The clinker (cement) production is the most critical process of the Troldtekt product system, but inaccuracies around the amount used will not invalidate the present conclusions.

Notably, by introducing more up-to-date LCA datasets for the grey cement applied, or introducing cements with less carbon footprint into production could lead to significant reductions of especially the Global Warming Potential indicator.

## 7. Requisite evidence

### 7.1 Testing of substances used

A detailed assessment of substances used was conducted by a DAkkS-accredited laboratory, based on a sample (prepared according to EN 15443), available in the Test Report 2018P216294, using inductively coupled plasma mass spectrometry (EN 16171) and X-ray fluorescence (EN 15309), for the following:

- Heavy metals (cadmium, mercury, etc.)
- and other elements

### 7.2 Leaching

No leaching measurement was conducted according to EN 717-1.

### 7.3 VOC emissions

Testing for VOC emissions has been conducted in accordance with EN ISO 16000-6. Analysis of the air sampled on Tenax was performed at the Danish

Technological Institute under DANAK accreditation 392. Report no. MAIC-2019-1418. Reporting of measured concentrations in toluene equivalents according to EN 16516. This test is the basis for the Finish M1 Material certificate as well as the Danish Indoor Climate labelling certificate.

#### AgBB overview of results (28 days [ $\mu\text{g}/\text{m}^3$ ])

Name	Value	Unit
TVOC (C6 - C16)	12	$\mu\text{g}/\text{m}^3$
Sum SVOC (C16 - C22)	0 - 5	$\mu\text{g}/\text{m}^3$
VOC without NIK	0 - 5	$\mu\text{g}/\text{m}^3$
Carcinogenic Substances	1	$\mu\text{g}/\text{m}^3$

#### AgBB overview of results (3 days [ $\mu\text{g}/\text{m}^3$ ])

Name	Value	Unit
TVOC (C6 - C16)	-	$\mu\text{g}/\text{m}^3$
Sum SVOC (C16 - C22)	-	$\mu\text{g}/\text{m}^3$
R (dimensionless)	-	-
VOC without NIK	-	$\mu\text{g}/\text{m}^3$
Carcinogenic Substances	-	$\mu\text{g}/\text{m}^3$

## 8. References

### Standards

#### AgBB

AgBB, Ausschuss zur gesundheitlichen Bewertung von Bauprodukten (Committee for Health-related Evaluation of Building Products)

#### BBSR

BBSR, Bundesinstitut für Bau-, Stadt- und Raumforschung (Federal Institute for Research on Building, Urban Affairs and Spatial Development).

BBSR table:

[https://www.nachhaltigesbauen.de/fileadmin/pdf/baustoff\\_gebauedaten/BNB\\_Nutzungsdauern\\_von\\_Bauteilen\\_2017-02-24.pdf](https://www.nachhaltigesbauen.de/fileadmin/pdf/baustoff_gebauedaten/BNB_Nutzungsdauern_von_Bauteilen_2017-02-24.pdf)

#### DIN 4108-4

DIN 4108-4:2017-03, Thermal insulation and energy economy in buildings - Part 4: Hygrothermal design values

#### DIN 52612-2

DIN 52612-2, Testing of thermal insulating materials; determination of thermal conductivity by means of the guarded hot plate apparatus; conversion of the measured values for building applications. 1 June 1984

#### DIN EN ISO 14025

DIN EN ISO 14025:2011, Environmental labels and declarations – Type III environmental declarations – Principles and procedures, German and English versions EN ISO 14025:2011

#### EN 13168

EN 13168:2012+A1:2015, Thermal insulation products for buildings. Factory made wood wool (WW) products. Specification

#### EN 13964

EN 13964:2014, Suspended ceilings. Requirements and test methods

#### EN 15309

EN 15309:2007, Characterization of waste and soil. Determination of elemental composition by X-ray fluorescence

**EN 15443**

EN 15443:2011, Solid recovered fuels. Methods for the preparation of the laboratory sample

**EN 15804**

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

**EN 16171**

EN 16171:2016, Sludge, treated biowaste and soil. Determination of elements using inductively coupled plasma mass spectrometry (ICP-MS)

**EN 16449**

EN 16449:2014, EN 16449:2014, Wood and wood-based products - Calculation of the biogenic carbon content of wood and conversion to carbon dioxide

**EN 16516**

EN 16516:2017+A1:2020, Construction products: Assessment of release of dangerous substances. Determination of emissions into indoor air

**EN 717-1**

EN 717-1:2004, Wood-based Panels – Determination of Formaldehyde Release – Formaldehyde emission by the chamber method

**European Waste Code: 10 13 11**

(wastes from cement-based composite materials)

**ISO 16000-6**

ISO 16000-6:2011, Indoor air - Part 6: Determination of volatile organic compounds in indoor and test chamber air by active sampling on Tenax TA sorbent, thermal desorption and gas chromatography using MS or MS-FID

**Product Category Rule A**

Product Category Rule A, IBU, 2019, Part A, Calculation Rules for the Life Cycle Assessment and Requirements on the Project Report. v.1.8. IBU, 2019.

**Product Category Rule B**

Product Category Rule B, IBU, 2019, Part B, Requirements on the EPD for Wood cement - Mineral-bonded wooden composites. v.1.7. IBU, 2019.

**Regulation (EU) No. 305/2011****Further References****General Programme Instructions, IBU 2021**

General Instructions for the EPD programme of Institut Bauen und Umwelt e.V. Version 2.0, Berlin: Institut Bauen und Umwelt e.V., 2021. [www.ibu-epd.com](http://www.ibu-epd.com)

**Software/database**

OneClick LCA software, Pre-verified EPD tool, Bionova: <https://www.oneclicklca.com/>

Database: Ecoinvent v.3.6. cut-off (2019)  
<https://ecoinvent.org/the-ecoinvent-database/>

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