

# ENVIRONMENTAL PRODUCT DECLARATION

In accordance with ISO 14025 and EN 15804+A1 for:

## **NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040**

**Mineral Wool Rolls**

From

**KNAUF**INSULATION



Program:	The International EPD® System <a href="http://www.environdec.com">www.environdec.com</a>
Programme operator:	EPD International AB
EPD registration number:	S-P-01893
Publication date:	2020-12-10
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## Programme-related information and verification

The EPD owner has the sole ownership, liability, and responsibility for the EPD. EPDs of construction products may not be comparable if they do not comply with EN 15804+A1 and if the building context, respectively the product-specific characteristics of performance are not taken into account.

<b>Programme:</b>	The International EPD® System EPD International AB Box 210 60 SE-100 31 Stockholm Sweden <a href="http://www.environdec.com">www.environdec.com</a> <a href="mailto:info@environdec.com">info@environdec.com</a>
<b>EPD registration number:</b>	S-P-01893
<b>Published:</b>	2020-12-10
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<b>EPD owner</b>	Knauf Insulation Sprl Rue de Maestricht 95 4600 Visé Belgium
<b>Product Category Rules:</b>	PCR 2012:01. Construction products and construction services. Version 2.3 Sub-PCR-I Thermal insulation products (EN 16783: 2017)
<b>Product group classification:</b>	UN CPC 37
<b>Reference year for plant data:</b>	2019
<b>Geographical application scope:</b>	Europe

CEN standard EN 15804+A1 serves as the Core Product Category Rules (PCR)
Product category rules (PCR): Construction products and Construction services, 2012:01, version 2.3. Sub-PCR-I Thermal insulation products (EN 16783: 2017)
PCR review was conducted by: The technical Committee of the International EPD® System
Independent third-party verification of the declaration and data, according to ISO 14025:2006: <input checked="" type="checkbox"/> EPD process certification <input type="checkbox"/> EPD verification
Certified by: Bureau Veritas certification Sverige AB SE006629-1
Procedure for follow-up of data during EPD validity involves third party verifier: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No

## General information

### Information about the company

#### Description of the organisation:

Knauf Insulation has more than 40 years of experience in the insulation industry and is one of the most respected names in insulation worldwide. Knauf Insulation is manufacturing products and solutions mainly in glass and rock mineral wool as well as wood wool. We operate more than 37 manufacturing sites globally in 15 countries and employ more than 5,000 people.

The Group Headquarters are based in Visé in Belgium where the biggest glass wool manufacturing plant in Europe is located.



#### Product-related or management system-related certifications:

All Knauf Insulation sites, including the related sites for this EPD, are ISO 9001, ISO 14001, ISO 50001 and ISO 45001 certified under the scope "Design, Development and Production of Insulation Materials and Systems".

#### Name and location of production site:

The use in dedicated building applications of the concerned product is Europe. The data utilized for the production stage life cycle assessment are related to production plants located in Visé (Belgium), Lannemezan (France), Krupka (Czech Republic) and Eskisehir (Turkey).

Rue de Maestricht 95, 4600 Visé, Belgium

501 Voie Napoleon Iii, 65300 Lannemezan, France

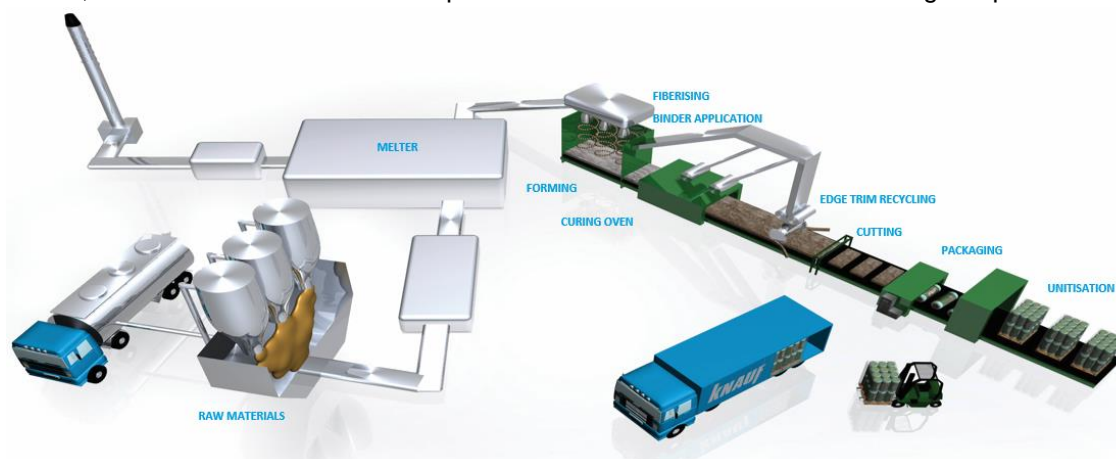
Pod dolní drahou 110, 417 42 Krupka, Czechia

75. Yıl Mh. Küçük Org. San, 1. Cd. No:1/G, 26250 Odunpazarı, Turkey

## Information about Glass Mineral Wool production

The Glass Mineral Wool Products for (GMW) are available in the form of slabs, rolls and boards. In general, the density for glass mineral wool ranges from 10 to 85 kg/m<sup>3</sup> and glass mineral wool consists of at least 92.5% inert material. The inert part is made of recycled glass (external cullet, up to 80% of the composition) and mainly sand and dolomite.

The remaining fraction (less than or equal to 7.5%) is made of bio-based binder components. At Knauf Insulation, the binder used for the GMW products is the ECOSE binder whose origin is plant starch.



## Product information

**Product name:** NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040

**Product identification:** The declared insulation products are NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040 unfaced glass mineral wool of 1 m<sup>2</sup> and 100 mm thickness (considered for this EPD). If indicators values for other thicknesses are required, they may be obtained by linear extrapolation of those values.

For the placing on the construction products market in the European Union/ EFTA (with exception of Switzerland), the Regulation/ (EU) No 305/2011/ applies. The concerned products need Declarations of Performance /DoP G4222GPCPR/G4248GPCPR/ G4220GPCPR/ G4232GPCPR taking into consideration the harmonized product standard /EN 13162/ and the /CE-mark/.

**Product description:** The main application for NatuRoll Plus, KI FIT 040, Earthwool 40, and Classic 040 are thermal and acoustic insulation of inclined roofs with regular or irregular frames.

**UN CPC code:**

37990: Non-metallic mineral products (including mineral wool, expanded mineral materials, worked mica, articles of mica, non-electrical articles of graphite or other carbon and articles of peat).

**Geographical scope:**

The product is manufactured in Visé (Belgium), Lannemezan (France), Krupka (Czech Republic) and Eskisehir (Turkey) with related country energy mix for electricity. Regarding the market area, the product is mainly marketed in Europe.

**Energy:**

Electricity mix and gas inputs are taken from related country values taken from reference year 2015.

**Technical Characteristics:**

Parameter	Value
Thermal conductivity/ EN 12667	0.040 W/(mK) at 10°C
Thermal Resistance (ISO 8301)	2.5 m <sup>2</sup> K/W
Water vapor diffusion resistance (EN 12086)	1
Reaction to fire (EN 13501-1)	A1
Declared density range/ EN 1602	11.5 kg/m <sup>3</sup> (+/- 10%)

## LCA information

### Functional unit / declared unit:

The declared unit is one square meter of Glass Mineral Wool unfaced NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040 with a thickness of 100 mm. The declared lambda is 0.040 W/mK at 10°C. The density used for the calculation of this specific LCA is 11.5 kg/m<sup>3</sup>.

**Reference service life:** The RSL or durability of NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040 is as long as the lifetime of the building equipment in which it is used (at least 50 years).

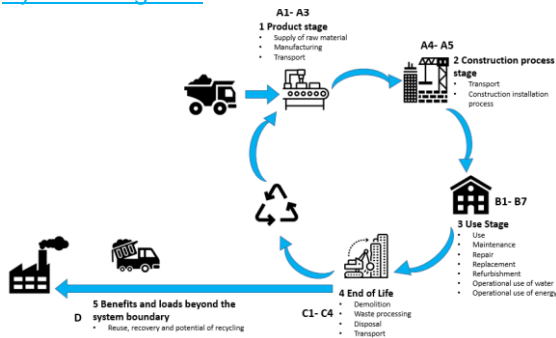
### Time representativeness:

Plants production data for the complete year 2019.

### Database(s) and LCA software used:

The LCA model, the data aggregation and environmental impacts are calculated with the software GaBi 9.2 and its Service Pack 40 databases.

### System diagram:



### Description of system boundaries:

The system boundary of the EPD follows the modularity approach defined by the /EN 15804+A1/.

### The type of EPD is cradle-to-grave.

List and explanation of the modules declared in the EPD.

### The product stage (A1-A3) includes:

- A1 - raw material extraction and processing, processing of secondary material input (e.g. recycling processes),
- A2 - transport to the manufacturer and
- A3 - manufacturing.

This includes provision of all materials, products and energy, packaging processing and its transport, as well as waste processing up to the end-of-waste state or disposal of final residues during the product stage.

The LCA results are given in an aggregated form for the product stage, meaning that the modules A1, A2 and A3 are considered as a unique module A1-A3.

Product Parameters	Value
Declared Density	11.5 kg/m <sup>3</sup>
Glass mineral wool weight (without facing/ coating weight)	1.15 kg
Surface	1 m <sup>2</sup>
Thickness	100 mm
Volume	0.1 m <sup>3</sup>
Packaging Plastic sheet	0.03 kg
Packaging Wooden pallet	0.04 kg

### The construction process stage includes:

- A4 - transport to the construction site and
- A5 - installation into the building.

The transport to the building site (A4) and installation (A5) included in this LCA use the following parameters:

Parameter	Value
Average transport distance	600 km
Type of fuel and vehicle consumption or type of vehicle used for transport.	Truck Euro 6 (28 – 32 t / 22 t) payload.( 33 L for 100 km)
Truck capacity utilization (including 30% of empty returns)	29 % of the weight capacity
Loss of materials in construction site	2%
Packaging Wooden pallet	40% recycled, 60% incinerated
Packaging Plastic sheet	40% recycled, 60% incinerated

The treatment of the packaging waste after the installation of the product (A5) has been considered.

The Use stage (B1-B7) includes:

- B1: Use
- B2: Maintenance
- B3: Repair
- B4: Replacement
- B5: Refurbishment
- B6: Operational Energy Use
- B7: Operational Water Use

Once installation is complete, no actions or technical operations are required during the use stages until the end of life. Therefore, the mineral wool has no impacts (excluding potential energy savings) on this stage.

The end-of-life stage includes:

- C1 - de-construction, demolition,
- C2 - transport to waste processing,
- C3 - waste processing for reuse, recovery and/or recycling and
- C4 - disposal.

This includes provision of all transports, materials, products and related energy and water use. The common manual dismantling impact of insulation is considered as very small and can be neglected in C1.

Although Glass Mineral Wool products from Knauf Insulation are partly recycled at their end-of-life, an established collection system does not yet exist.

Therefore, the assumption chosen in this study, 100% landfill (C4) after the use phase, is the most conservative approach.

Parameter	Value
Disposal type (mineral wool)	100% landfill
Average transport distance waste (C2)	50 km
Type of fuel and vehicle consumption or type of vehicle used for transport.	Truck-trailer, Euro 3, 34 - 40t gross weight / 27t payload capacity/ 40 L for 100 km. (if 100 % utilization).
Truck capacity utilization	70 % of the weight capacity

**Module D** includes reuse, recovery and/or recycling potentials. According to /EN 15804+A1/, any declared benefits and loads from net flows leaving the product system not allocated as co-products and having passed the end-of waste state shall be included in module

D. Benefits considered in module D originate from packaging recycling or incineration.

### Content Declaration

The product does not contain substances on the "Candidate List of Substances of Very High Concern for Authorisation" under the REACH regulation (if above 0.1% of the mass). plant considered.

### Recycled material

The mineral wool waste that is originating from the manufacturing process in the cutting lines is recycled internally and reinjected into the mineral wool production mattress. For the reference year, cullet external waste is considered into this specific LCA for each plant considered. Recycled content for this product was calculated at 73 % in 2019 according to the cullet market availability.

### Additional information:

All raw materials for the manufacturing of the declared product, the required energy, water consumption and the resulting emissions are considered into the LCA. Consecutively, the recipe components with a share even less than 1% are included. All neglected processes contribute less than 5% to the total mass or less than 5% to the total energy consumption. For information, the impact of the Glass Mineral Wool plant construction or machines is not taken into account in the life cycle assessment. Allocation criteria with by-products (mineral wool for ceiling tiles) are based on cost.

Knauf Insulation adopts a "worst case" approach into its EPDs.

Knauf Insulation supports the Ten Principles of the United Nations Global Compact on human rights, labor, environment and anti-corruption.

### More information:

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

### Name and contact information of LCA practitioner:

Yaparak Nayir  
 Knauf Insulation Sprl  
 Rue de Maestricht 95  
 4600 Visé  
 Belgium  
 Contact: yaparak.nayir@knaufinsulation.com

Declared Modules

Life cycle stages as defined in the European standard EN 15978 :2011 and the description of the system boundaries for the reference product LCA (X = included in the LCA, MND = module is not declared)

Product stage			Construction process stage		Use stage								End of life stage				Resource recovery stage
Raw materials	Transport	Manufacturing	Transport	Construction Installation	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	X	X	X	X	X	X	X	X	X	X	X	

## Environmental performance

**Potential environmental impacts:** 1 m<sup>2</sup> of Glass Mineral Wool NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040 with a thickness of 100 mm.

PARAMETERS	UNIT	TOTAL A1-A3**	A4	A5	TOTAL B1-B2-B3-B4-B5-B6-B7	C1	C2	C3	C4	D*
Global warming potential (GWP)	kg CO <sub>2</sub> eq.	1.21E+00	1.09E-01	1.76E-01	0.00E+00	0.00E+00	3.46E-03	0.00E+00	1.85E-02	-8.42E-02
Depletion potential of the stratospheric ozone layer (ODP)	kg CFC 11 eq.	4.82E-14	2.70E-17	4.82E-11	0.00E+00	0.00E+00	8.72E-19	0.00E+00	1.88E-14	-1.03E-15
Acidification potential (AP)	kg SO <sub>2</sub> eq.	9.94E-03	8.97E-05	2.25E-04	0.00E+00	0.00E+00	6.40E-04	0.00E+00	1.10E-04	-9.71E-05
Eutrophication potential (EP)	kg PO <sub>4</sub> <sup>3-</sup> eq.	2.17E-03	1.90E-05	4.83E-05	0.00E+00	0.00E+00	1.66E-04	0.00E+00	1.50E-05	-1.29E-05
Formation potential of tropospheric ozone (POCP)	kg C <sub>2</sub> H <sub>4</sub> eq.	7.18E-04	1.37E-05	1.66E-05	0.00E+00	0.00E+00	3.61E-05	0.00E+00	8.64E-06	-1.06E-05
Abiotic depletion potential – Elements	kg Sb eq.	7.13E-05	9.98E-09	1.46E-06	0.00E+00	0.00E+00	3.23E-10	0.00E+00	6.65E-09	-1.61E-08
Abiotic depletion potential – Fossil resources	MJ, net calorific value	1.97E+01	1.47E+00	4.97E-01	0.00E+00	0.00E+00	4.75E-02	0.00E+00	2.40E-01	-1.63E+00

\*: [Life Cycle D stage covers benefits and loads beyond the system boundary stage (reuse, recovery and recycling potential) therefore, when summing up results, this stage should be considered separately].

\*\* : The indicators results are calculated with a reference product based on annual production volume (following the dedicated market share). The indicators results span between the reference product and the 100% sourced product from each dedicated plant may vary more than 10% (concerning A1- A3).



**Use of resources:** 1 m<sup>2</sup> of Glass Mineral Wool NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040 with a thickness of 100 mm.

PARAMETER		UNIT	TOTAL A1-A3**	A4	A5	TOTAL B1-B2-B3- B4-B5-B6- B7	C1	C2	C3	C4	D*
Primary energy resources – Renewable	Use as energy carrier	MJ, net calorific value	3.07E+00	8.50E-02	9.66E-02	0.00E+00	0.00E+00	2.75E-03	0.00E+00	2.90E-02	-2.47E-01
	Used as raw materials	MJ, net calorific value	2.22E+00	0.00E+00	3.04E-02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	TOTAL	MJ, net calorific value	5.29E+00	8.50E-02	1.27E-01	0.00E+00	0.00E+00	2.75E-03	0.00E+00	2.90E-02	-2.47E-01
Primary energy resources – Non-renewable	Use as energy carrier	MJ, net calorific value	2.25E+01	1.48E+00	5.95E-01	0.00E+00	0.00E+00	4.78E-02	0.00E+00	2.48E-01	-1.81E+00
	Used as raw materials	MJ, net calorific value	1.22E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	TOTAL	MJ, net calorific value	2.37E+01	1.48E+00	5.95E-01	0.00E+00	0.00E+00	4.78E-02	0.00E+00	2.48E-01	-1.81E+00
Secondary material	kg	8.25E-01	0.00E+00	1.68E-02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Renewable secondary fuels	MJ, net calorific value	9.21E-23	0.00E+00	1.88E-24	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Non-renewable secondary fuels	MJ, net calorific value	1.08E-21	0.00E+00	2.21E-23	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Net use of fresh water	m <sup>3</sup>	6.52E-03	9.91E-05	4.85E-04	0.00E+00	0.00E+00	3.21E-06	0.00E+00	4.73E-05	-3.14E-04	

\*: [Life Cycle D stage covers benefits and loads beyond the system boundary stage (reuse, recovery and recycling potential) therefore, when summing up results, this stage should be considered separately].

\*\* : The indicators results are calculated with a reference product based on annual production volume (following the dedicated market share). The indicators results span between the reference product and the 100% sourced product from each dedicated plant may vary more than 10% (concerning A1- A3).

**Waste production and output flows:** 1 m<sup>2</sup> of Glass Mineral Wool NatuRoll Plus, KI FIT 040, Earthwool 40, Classic 040 with a thickness of 100 mm.

**Waste production**

PARAMETER	UNIT	TOTAL A1-A3**	A4	A5	TOTAL B1-B2-B3-B4-B5-B6-B7	C1	C2	C3	C4	D*
Hazardous waste disposed	kg	2.54E-08	6.83E-08	2.24E-09	0.00E+00	0.00E+00	2.21E-09	0.00E+00	3.93E-09	-6.46E-10
Non-hazardous waste disposed	kg	5.70E-02	2.34E-04	2.57E-02	0.00E+00	0.00E+00	7.57E-06	0.00E+00	1.15E+00	-6.27E-04
Radioactive waste disposed	kg	1.58E-03	2.72E-06	3.84E-05	0.00E+00	0.00E+00	8.80E-08	0.00E+00	3.39E-06	-7.30E-05

\*: [Life Cycle D stage covers benefits and loads beyond the system boundary stage (reuse, recovery and recycling potential) therefore, when summing up results, this stage should be considered separately].

\*\* : The indicators results are calculated with a reference product based on annual production volume (following the dedicated market share). The indicators results span between the reference product and the 100% sourced product from each dedicated plant may vary more than 10% (concerning A1- A3).

### Output flows

PARAMETER	UNIT	TOTAL A1-A3**	A4	A5	TOTAL B1-B2-B3-B4-B5-B6-B7	C1	C2	C3	C4	D*
Components for reuse	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Material for recycling	kg	0.00E+00	0.00E+00	1.16E-02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Materials for energy recovery	kg	0.00E+00	0.00E+00	6.50E-02	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy, electricity	MJ	0.00E+00	0.00E+00	2.16E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
Exported energy, thermal	MJ	0.00E+00	0.00E+00	5.25E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

\*: [Life Cycle D stage covers benefits and loads beyond the system boundary stage (reuse, recovery and recycling potential) therefore, when summing up results, this stage should be considered separately].

\*\* : The indicators results are calculated with a reference product based on annual production volume (following the dedicated market share). The indicators results span between the reference product and the 100% sourced product from each dedicated plant may vary more than 10% (concerning A1- A3).

## LCA interpretation

### ENVIRONMENTAL IMPACTS

All impact categories except the ADPE and the ODP are dominated by the manufacturing. This is mainly due to the consumption of energy (electricity and natural gas) during the production of glass mineral wool.

**The Global Warming Potential (GWP)** is clearly dominated by the production, mostly due to energy consumption (electricity and natural gas). The high cullet content is helping to reduce the energy use in the melting furnace.

**The Ozone layer Depletion Potential (ODP)** seems highly influenced by the installation step, mostly due to plastics packaging incineration scenario resulting in emissions of halogenated compounds.

**The Acidification Potential (AP)** is also dominated by the production due to the processes emissions and the electricity consumption. Most of impact is by emissions of sulphur dioxide, ammonia and nitrogen oxides.

**The Eutrophication Potential (EP)** is significantly influenced by the manufacturing due to emissions from curing oven, furnace and other unit processes. The glucose for the binder production also has an impact because of crops fertilizers use.

**The Photochemical Ozone Creation Potential (POCP)** is dominated by the production due to emissions in the curing oven and in other unit processes but also energy consumption.

**The Abiotic Depletion Potential Element (ADPe)** is dominated by the raw materials production.

**The Abiotic Depletion Potential Fossil (ADPf)** is dominated by natural gas use and the electricity consumption for the production. The packaging and the binder have also a non-negligible impact. The installation stage has a “positive” contribution due to the energy recovery from incineration of a percentage of plastic packaging and the avoidance production of new plastic production thanks to a percentage of recycling plastic packaging.

### RESOURCES USE

**Total Use of Non-Renewable Primary Energy Resources (PENRT)** is dominated by the manufacturing of glass mineral wool products (especially due to the energy consumption) and with the little influence of raw materials, binder and packaging.

**Total Use of Renewable Primary Energy Resources (PERT)** is dominated by the binder (bio-based), the production, (electricity mix) and the packaging (wooden pallets).

For the **Use of Secondary Material (SM)**, there is a lot of external cullet used into the batch process (recycled glass from windows and bottles) up to 80% depending on plants.

## References

### **International EPD® System**

General Programme Instructions of the International EPD® System. Version 2.5.  
Product Category Rules PCR 2012:01. Construction products and construction services. Version 2.3  
Sub-PCR-I Thermal insulation products (EN 16783: 2017).

### **ISO 14025**

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

### **EN 16783: 2017**

Thermal insulation products - Product category rules (PCR) for factory made and in-situ formed products for preparing environmental product declarations

### **EN 15804**

EN 15804:2012-04+A1 2013: Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products

### **GaBi 9.2**

GaBi 9.2: Software and database for life cycle engineering. LBP, University of Stuttgart and PE INTERNATIONAL AG, 2019.

### **EN 1602**

EN1602: 2013 Thermal insulation products for building applications – Determination of the apparent density

### **EN 12667**

EN 12667: 2001 Thermal performance of building materials and products - Determination of thermal resistance by means of guarded hot plate and heat flow meter methods - Products of high and medium thermal resistance

### **EN 13162**

EN 13162:2012 Thermal insulation products for buildings - Factory made mineral wool (MW) products - Specification

### **EN 13501-1**

EN 13501-1: 2009 Fire classification of construction products and building elements - Part 1: Classification using test data from reaction to fire tests.

### **DIN 4102 / T17**

DIN 4102 / T17: 1990 Fire behaviour of building materials and elements; determination of melting point of mineral fibre insulating materials; concepts, requirements and testing.

### **EN 12086**

EN 12086: 2013 Thermal insulating products for building applications –determination of water vapour transmission properties.

**ISO 8301:1991**

Thermal insulation — Determination of steady-state thermal resistance and related properties — Heat flow meter apparatus.

**EN 29053**

EN 29053: 1993 Acoustics; materials for acoustical applications; determination of airflow resistance

**ISO 10456**

ISO 10456: 2007 Building materials and products — Hygrothermal properties — Tabulated design values and procedures for determining declared and design thermal values

**EN 1609:2013**

Thermal insulating products for building applications. Determination of short-term water absorption by partial immersion

## Contact information:

EPD owner:	 <p>Knauf Insulation Rue de Maestricht 95 4600 Visé Belgium <a href="http://www.knaufinsulation.com">www.knaufinsulation.com</a> Contact: <a href="mailto:sustainability@knaufinsulation.com">sustainability@knaufinsulation.com</a></p>
LCA support:	 <p>Université de Liège – Laboratory of Chemical Engineering PEPs - Products, Environment and Processes Allée du 6 août 15, Bat B6 4000 Liège Belgium</p>  <p>Thinkstep Hauptstraße 111-113 70771 Leinfelden-Echterdingen Germany</p>
Programme operator:	 <p>EPD International AB <a href="mailto:info@environdec.com">info@environdec.com</a></p>