

Environmental Product Declaration

EN ISO 14025:2010
PCR 2010:14

Alier

AENOR

Paper for bags

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The holder of this Declaration is responsible for its content, as well as for keeping the supporting documentation that justifies the data and statements included during the period of validity



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PCR 2010:14. Processed paper and paperboard. V 3.1.2

Independent verification of the declaration and data in accordance with EN ISO 14025:2010

☐ Internal

☒ External

Verification body

AENOR

1. General information

1.1. The organisation

ALIER is a company specializing in the production of recycled paper from 100% recovered paper, with a high capacity for recycling paper that is difficult to process, such as moisture-resistant, laminated, bonded, liquid packaging, plastic-coated papers, etc. It has an annual production capacity of 180,000 tonnes of paper, in grammages ranging from 50 g/m² to 450 g/m², using two paper machines with useful widths of 2.52 m and 3.53 m.

The organisation has a Quality Management System and an Environmental Management System that comply with the requirements of UNE-EN ISO 9001:2015 and UNE-EN ISO 14001:2015, respectively. In addition, it holds PEFC and FSC chain-of-custody certificates for forest products.

ALIER holds B Corp certification and certificates as an approved company acting as a recoverer/recycler for ECOEMBES S.A. for paper-cardboard material and beverage/food cartons from selective collection.

ALIER, S.A. currently has an Energy Management System implemented based on UNE-EN ISO 50001:2018.

1.2. Scope of the Declaration

This environmental product declaration describes the environmental information regarding the cradle-to-grave life cycle of Alier's bag paper manufactured at its plant located at Pol. Industrial, s/n, 25124 Roselló, Lleida (Spain).

1.3. Life cycle and compliance.

This EPD has been developed and verified in accordance with EN ISO 14025:2010 and the Product Category Rule.

Table 1-1. Product Category Rule

Title	Processed paper and paperboard product category
Registration/version	PCR 2010:14 version 3.1.2
Issue date	2024-10
Administrator	The International EPD® System

Table 1-2 System boundaries. Information modules considered

Upstream	Procurement of raw materials and power generation.
Core Process	Transport to the plant, manufacture of the product and management of landfill and waste.
Downstream	Product End of Life

This EPD may not be comparable with EPDs developed under other programme operators or in accordance with different reference documents. In particular, it may not be comparable with EPDs that have not been developed and verified in accordance with the same Product Category Rules (PCR).

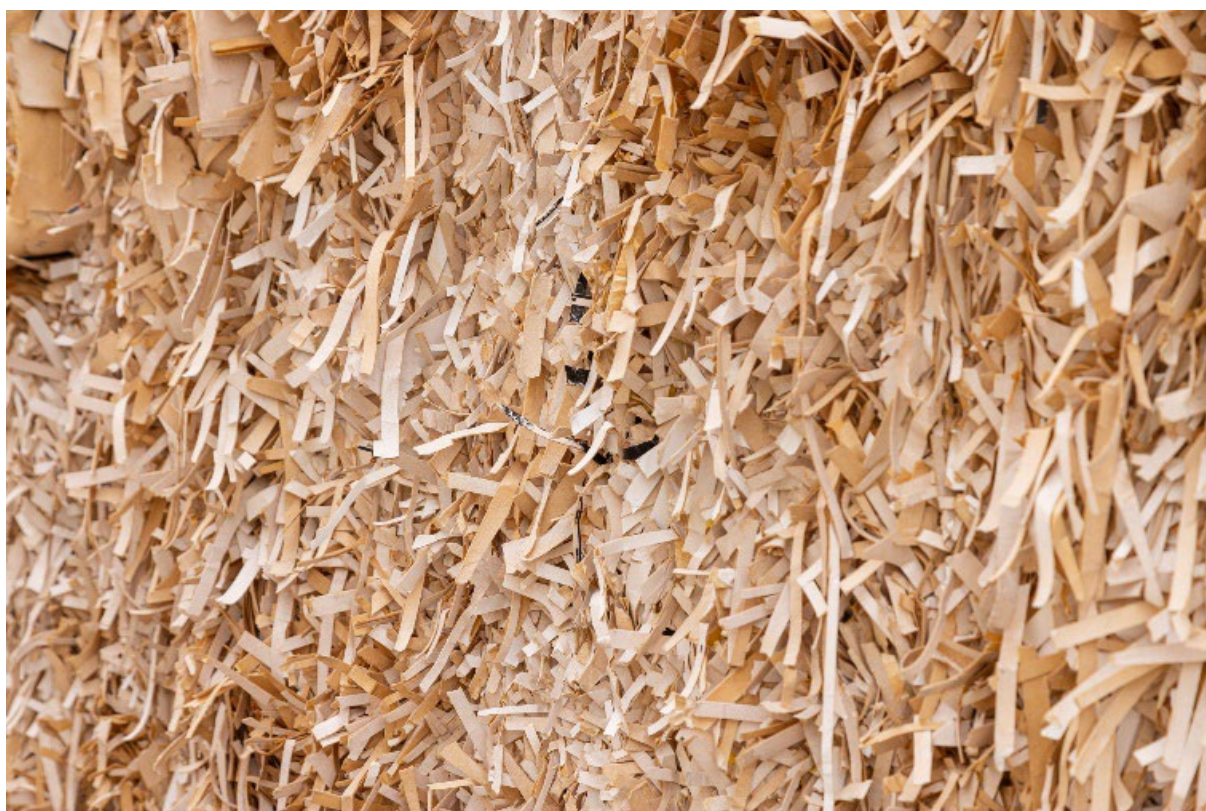
Likewise, EPDs may not be comparable if they are based on different data sources (e.g. different databases), do not include all relevant information modules, or are not based on the same scenarios.

1.4. Differences from previous versions of this EPD.

This EPD corresponds to the second version of the study.

- 2022: Valid until 2028.

- Based on production data for 2021.
- Ecoinvent 3.8 database
- SimaPro version 9.4.0.2.



2. The product

2.1. Identification of the product

Alier's bag paper is a 100% recycled two-layer paper with a cross-sectional and longitudinal weight and moisture profile correction system for the production of bag paper. It is Glued paper on both sides, high mechanical tensile strength in SM (for bags). Bag paper has high machinability and finish quality that provides high definition in paper printing. The high quality of ALIER paper gives the bags the mechanical and structural strength required by customers.

The intended use of the product studied is for the production of shopping and delivery bags.

CPC Code: 32141 – Mixed paper and paperboard, without surface coating or impregnation.

2.2. Product Composition

The product for which this EPD is prepared is 100% recovered paper-board (post-consumer), in accordance with UNE-EN 643:2014 (European list of standard grades of recovered paper and board).

Table 2-1. Composition

Material	% by weight
Post-consumer recovered paper	82,52%
Additives	17,48%

During the life cycle of the product, no hazardous substances listed in the "Candidate List of Substances of Very High Concern (SVHC) for authorisation" are used at a rate greater than 0.1% of the weight of the product.

2.3. Packaging

The primary packaging used in the shipment of the product (distribution packaging) has been included in the study:

Table 2-1. Packaging

Material	kg / declared unit
Cardboard	3,90E+00
Wood	8,60E-01
PVC	3,58E-04
PS	2,86E-03
Anti-slip rubber	2,98E-02
Ink	2,33E-03
PE	7,45E-01
Polyester	2,48E-02
Steel	8,45E-01
Sealing tape	9,93E-04

2.4. Product performance

The technical specifications of the products included in this EPD are shown in the following tables.

Kraft bags



AB Paper Quality													
Technical Characteristics													
UNE / EN / ISO - 536	Grammage	g/m ²	70	75	80	85	90	100	110	120	130	140	
UNE / EN / ISO - 287	Moisture	%	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	± 1.5%
UNE / EN / ISO - 1924 / 2	MD Elongation	%	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	-10%
UNE / EN / ISO - 1924 / 2	CD Elongation	%	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	-10%
UNE / EN / ISO - 1924 / 2	MD Tensile Strength	m	5,500	5,500	6,000	6,000	6,000	6,000	6,000	6,000	6,000	6,000	-10%
UNE / EN / ISO - 1924 / 2	CD Tensile Strength	m	2,300	2,300	2,500	2,500	2,500	2,500	2,500	2,500	2,500	2,500	-10%
UNE / EN / ISO - 1924 / 2	MD Tensile Index	Nm/g	54	54	59	59	59	59	59	59	59	59	-10%
UNE / EN / ISO - 1924 / 2	CD Tensile Index	Nm/g	23	23	25	25	25	25	25	25	25	25	-10%
UNE / EN / ISO - 535	Cobb 60 (Top Side)	g/m ²	30	30	30	30	30	30	30	30	30	30	MAX. 40
UNE / EN / ISO - 535	Cobb 60 (Reverse Side)	g/m ²	30	30	30	30	30	30	30	30	30	30	MAX. 40
UNE / EN / ISO - 2758	Mullen Burst Index	kPa·m ² /g	2.6	2.6	2.6	2.6	2.6	2.6	2.6	2.6	2.6	2.6	MAX. 40
UNE / ISO - 5636-5	Gurley Porosity	s	50	50	55	55	60	65	70	75	80	85	MAX. 40
UNE / EN / ISO - 20187	Relative Humidity	%	50	50	50	50	50	50	50	50	50	50	Indicative
UNE / EN / ISO - 20187	Temperature	°C	23	23	23	23	23	23	23	23	23	23	Indicative

Ecokraft bags

AB Paper Quality															
Technical Characteristics															
UNE / EN / ISO - 536	Grammage	g/m ²	60	70	75	80	85	90	100	110	115	120	125	200	
UNE / EN / ISO - 287	Moisture	%	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	± 1.5%
UNE / EN / ISO - 1924 / 2	MD Elongation	%	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	-10%
UNE / EN / ISO - 1924 / 2	CD Elongation	%	5.5	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	-10%
UNE / EN / ISO - 1924 / 2	MD Tensile Strength	m	6,500	8,700	8,700	8,700	8,700	8,700	8,700	8,700	8,700	8,700	8,700	8,700	-10%
UNE / EN / ISO - 1924 / 2	CD Tensile Strength	m	3,000	3,200	3,200	3,200	3,200	3,200	3,200	3,200	3,200	3,200	3,200	3,200	-10%
UNE / EN / ISO - 1924 / 2	MD Tensile Index	Nm/g	64	85	85	85	85	85	85	85	85	85	85	85	-10%
UNE / EN / ISO - 1924 / 2	CD Tensile Index	Nm/g	29	31	31	31	31	31	31	31	31	31	31	31	-10%
UNE / EN / ISO - 535	Cobb 60 (Top Side)	g/m ²	30	30	30	30	30	30	30	30	30	30	30	30	MAX. 40
UNE / EN / ISO - 535	Cobb 60 (Reverse Side)	g/m ²	30	30	30	30	30	30	30	30	30	30	30	30	MAX. 40
UNE / EN / ISO - 2758	Mullen Burst Index	kPa·m ² /g	3.2	3.8	3.8	3.8	3.8	3.8	3.8	3.8	3.8	3.8	3.8	3.6	MAX. 40
UNE / ISO - 5636-5	Gurley Porosity	s	40	50	50	55	55	60	65	70	70	75	80	90	MAX. 40
UNE / EN / ISO - 20187	Relative Humidity	%	50	50	50	50	50	50	50	50	50	50	50	50	Indicative
UNE / EN / ISO - 20187	Temperature	°C	23	23	23	23	23	23	23	23	23	23	23	23	Indicative

Ecokraft sacks

AB Paper Quality									
Technical Characteristics									
UNE / EN / ISO - 536	Grammage	g/m²	70	75	80	85	90	100	
UNE / EN / ISO - 287	Moisture	%	8.0	8.0	8.0	8.0	8.0	8.0	± 1.5%
UNE / EN / ISO - 1924 / 2	MD Elongation	%	2.2	2.2	2.2	2.2	2.2	2.2	-10%
UNE / EN / ISO - 1924 / 2	CD Elongation	%	6.5	6.5	6.5	6.5	6.5	6.5	-10%
UNE / EN / ISO - 1924 / 2	MD Tensile Strength	m	9,000	9,000	8,800	8,800	8,800	8,800	-10%
UNE / EN / ISO - 1924 / 2	CD Tensile Strength	m	4,000	4,000	3,900	3,900	3,700	3,700	-10%
UNE / EN / ISO - 1924 / 2	MD Tensile Index	Nm/g	88	88	86	86	86	86	-10%
UNE / EN / ISO - 1924 / 2	CD Tensile Index	Nm/g	39	39	38	38	36	36	-10%
UNE / EN / ISO - 1924 / 2	MD TEA Index	J/g	1.1	1.1	1.1	1.1	1.1	1.1	-10%
UNE / EN / ISO - 1924 / 2	CD TEA Index	J/g	1.7	1.7	1.7	1.7	1.7	1.7	-10%
UNE / EN / ISO - 535	Cobb 60 (Top Side)	g/m ²	30	30	30	30	30	30	MAX. 40
UNE / EN / ISO - 535	Cobb 60 (Reverse Side)	g/m ²	30	30	30	30	30	30	MAX. 40
UNE / EN / ISO - 2758	Mullen Burst Index	kPa·m ² /g	4.2	4.2	4.2	4.2	4.2	4.2	MAX. 40
UNE / ISO - 5636-5	Gurley Porosity	s	35	40	40	45	45	50	MAX. 40
UNE / EN / ISO - 20187	Relative Humidity	%	50	50	50	50	50	50	Indicative
UNE / EN / ISO - 20187	Temperature	°C	23	23	23	23	23	23	Indicative



3. LCA Information

3.1. Life Cycle Assessment

The Life Cycle Analysis Report for the EPD of Alier S.A.'s bag paper, of March 2026, has been carried out by the company Abaleo S.L.

The LCA study follows the recommendations and requirements of the international standards ISO 14040:2006, ISO 14044:2006 and RCP 2010:14.

The characterization factors are based on EF 3.1.

3.2. Scope of the study.

The scope of this EPD is cradle-to-grave production of the average bag paper manufactured by Alier at its plant in Roselló, Lleida.

The product is manufactured in Spain, although the calculation of the LCA has been carried out for Europe.

3.3. Study limitations.

The following were not included in the LCA

- The production of the aerobic and anaerobic sludge used in the WWTP, which accounts for 0.004% by weight of the total products consumed at the facility; its transport from the supplier to Alier is considered.
- The biogenic CO₂ content of starch.
- All equipment with a service life of more than 3 years.
- The construction of the plant buildings, or other capital goods.
- Staff business travel, or staff commuting to and from work.
- Research and development activities.
- Long-term emissions.

3.4. Declared unit .

The declared unit is one ton (1,000 kg) of product, plus its distribution packaging.

The product has a moisture content of 8.0% and a grammage ranging from 60 g/m² to 200 g/m².

3.5. Reference service life.

Reference Service Life (RSL): not applicable, because the use phase is not included within the system limits established by the RCP.

3.6. Allocation criteria.

In accordance with the criteria of the reference standard, the inputs and outputs of the system have been assigned on a mass basis. This allocation criterion has been applied for all general plant consumption, packaging, transport, waste and discharge.

The quantities of the different materials used and produced in the manufacturing process come from measurements carried out at the plant itself.

It has not been necessary to apply economic allocation criteria.

3.7. Cut-off criteria.

The LCA includes the gross weight/volume of all materials used in the manufacturing process, so that at least 99% of the environmental impacts are obtained.

There has been no exclusion of energy consumption.

3.8. Manufacturing process

The manufacturing process begins with the receipt of recovered paper and board, after which the material is inspected to verify its quality and stored in the designated raw material area.

The paper pulp is produced from recovered paper processed in pulpers. The disintegration process is carried out by adding water to the recovered paper and agitating the mixture. Friction between the pieces of paper separates the fibres, which are then separated from contaminants and other unwanted materials. The resulting pulp subsequently undergoes several purification stages to remove any remaining impurities from the fibres.

The pulp is then fed into the paper machine, where it is deposited onto the forming wire through the headbox slice. On the forming wire, water is first removed by gravity and then by the application of vacuum.

The paper web is subsequently pressed and finally dried using steam.

Depending on the paper grade to be produced, a specific raw material composition is defined. This formulation specifies the quantity of each type of recovered paper to be used, together with the appropriate additives, which are applied either in the pulp (wet-end addition) or on the paper surface (surface application).

3.9. Representativeness, quality and selection of data.

To model the manufacturing process of the product studied, specific production data from the Roselló plant (Lleida, Spain) for 2025 were used. Data obtained from this plant includes raw material, packaging and

energy consumption; transport, discharge and waste generation.

The study was prepared using the Ecoinvent 3.11 database (March 2025) and SimaPro 10.3.0.1 software.

The following criteria were applied when selecting the most representative processes:

- The data must be representative of the technological development actually applied in the manufacturing processes. If no information was available, data representative of an average technology were selected.
- The data must be as geographically close as possible and, where applicable, average regionalised data.
- The data must be as up to date as possible.

To assess the quality of the primary data used in the LCA, the semi-quantitative data quality assessment criteria proposed by the European Union in its Guide to the Environmental Footprint of Products and Organizations were applied. The following results were obtained:

- Very good integrity. Score 1.
- Good methodological suitability and consistency. Score 2.
- Reasonable temporal representativeness. Score 1.
- Good technological representativeness. Score 2.
- Very good geographical representativeness. Score 1.
- Low data uncertainty. Score 2.

Based on the above data, the Data Quality Rating (DQR) has a value of 1.5, indicating that data quality is excellent.

4. System boundaries, scenarios and additional technical information.

Upstream.

This phase includes the processes of:

- Preparation of the auxiliary products used in the main process.
- Production of pigments, additives and other chemicals used in the main process.
- Production of other raw materials used in the main process.
- Production of packaging used for transport (distribution packaging).
- Production of the electricity and fuel used in the main process.

Core process.

This module includes:

- Transport of raw and auxiliary materials to ALIER.
- The process of making paper for bags.
- The treatment of the waste generated and its transport from the plant to the manager.



Downstream.

Packaging waste is considered to be transported an average distance of 80 km to the nearest waste management point, with 16-32 tonne EURO5 trucks (Erlandsson et al. 2015).

The modelling of the management of the product's packaging has been carried out based on the recycling, landfill and incineration rates determined in Annex C.V2.1 of the European Environmental Footprint:

Table 4-1. End-of-life treatment rates

Recycling rate	Plastics - packaging	29%
	Wood	30%
	Steel - packaging	80%
	Corrugated cardboard - packaging	75%
Landfill ratio on waste Europe		55%
Waste incineration ratio Europe		45%



UPSTREAM

Secondary raw material:

Paper for recycling

Production of raw materials:

Starch, sizing agent, dye

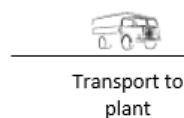
Energy production

Electricity

CORE PROCESS

**Production of auxiliary materials,
fuels, packaging and consumables****Cogeneration plant**

Steam

WWTP**Machinery operation**Materials reception and
sorting

Crushing and cleaning

Refining

Paper machines

Reel

Storage and dispatch

Transport
and waste
managemeProcess
emissions

DOWNSTREAM

Transport and
management of
packaging waste

5. Declaration of LCA and LCI environmental parameters

The estimated impact results are relative and do not indicate the final value of the impact categories, nor do they refer to threshold values, safety margins or risks.

Environmental Impacts

Parameter	Units	Upstream	Core process	Downstream	Total
GWP-total	kg CO ₂ eq	1.16E+02	9.45E+01	1.23E+00	2.11E+02
GWP-fossil	kg CO ₂ eq	1.07E+02	8.59E+01	6.03E-01	1.94E+02
GWP-biogenic	kg CO ₂ eq	-2.79E+03	1.18E+03	1.62E+03	1.11E+01
GWP-luluc	kg CO ₂ eq	7.56E+00	5.77E-02	7.42E-05	7.61E+00
ODP	kg CFC11 eq	3.15E-06	2.66E-05	3.30E-09	2.97E-05
AP	mol H ⁺ eq	1.00E+00	9.21E-01	9.16E-04	1.93E+00
EP-freshwater	kg P eq	5.49E-03	4.24E-03	1.53E-05	9.74E-03
EP-marine	kg N eq	3.75E-01	1.19E-01	9.21E-04	4.95E-01
EP-terrestrial	mol N eq	3.55E+00	3.73E+00	3.80E-03	7.28E+00
POCP	Kg NMVOC eq	7.39E-01	2.68E-01	1.36E-03	1.01E+00
ADP-minerals& metals	kg Sb eq	4.10E-04	6.74E-06	1.12E-08	4.17E-04
ADP-fossil	MJ	1.67E+03	9.54E+02	2.23E+00	2.62E+03
WDP	m ³ depriv.	4.48E+01	5.73E+02	-1.46E-01	6.18E+02

GWP-total: Global Warming Potential – total; GWP-fossil: Global Warming Potential – fossil; GWP-biogenic: Global Warming Potential – biogenic; GWP-luluc: Global Warming Potential – land use and land use change; ODP: Stratospheric Ozone Depletion Potential; AP: Acidification Potential, Accumulated Exceedance; EP-freshwater: Eutrophication Potential, fraction of nutrients reaching the freshwater end compartment; EP-marine: Eutrophication Potential, fraction of nutrients reaching the marine end compartment; EP-terrestrial: Eutrophication Potential, Accumulated Exceedance; POCP: Photochemical Ozone Formation Potential; ADP-minerals&metals: Abiotic Resource Depletion Potential for non-fossil resources (minerals and metals); ADP-fossil: Abiotic Resource Depletion Potential for fossil resources; WDP: Water Deprivation Potential (user), deprivation-weighted water consumption.



Use of resources

Parameter	Units	Upstream	Core process	Downstream	Total
PERE	MJ	3.67E+03	1.23E+04	1.68E+04	3.28E+04
PERM*	MJ	2.89E+04	-1.21E+04	-1.68E+04	0.00E+00
PERT	MJ	3.26E+04	1.51E+02	1.16E-01	3.28E+04
PENRE	MJ	1.64E+03	9.54E+02	3.55E+01	2.63E+03
PENRM*	MJ	3.32E+01	0.00E+00	-3.32E+01	0.00E+00
PENRT	MJ	1.67E+03	9.54E+02	2.23E+00	2.63E+03
SM	kg	1.72E+03	0.00E+00	0.00E+00	1.72E+03
RSF	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00
NRSF	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00
FW	m3	1.30E+00	7.86E+00	-3.89E-03	9.16E+00

PERE: Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM: Use of renewable primary energy used as raw materials; PERT: Total use of renewable primary energy; PENRE: Use of non-renewable primary energy, excluding non-renewable primary energy resources used as raw materials; PENRM: Use of non-renewable primary energy used as raw materials; PENRT: Total use of non-renewable primary energy; SM: Use of secondary materials; RSF: Use of renewable secondary fuels; NRSF: Use of non-renewable secondary fuels; FW: Net use of running water resources.

*The energy used as raw material is declared according to option A of PCR 2019:14.

Waste categories

Parameter	Units	Upstream	Core process	Downstream	Total
HWD	kg	3.02E-02	4.96E-03	1.34E-05	3.52E-02
NHWD	kg	4.37E+00	2.33E+02	1.73E+00	2.39E+02
RWD	kg	2.15E-03	3.33E-03	3.67E-06	5.48E-03

HWD: Hazardous Waste Disposed; NHWD: Non-hazardous waste disposed; RWD: Radioactive waste disposed.

Output flows

Parameter	Units	Upstream	Core process	Downstream	Total
CRU	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00
MFR	kg	0.00E+00	5.59E+02	4.09E+00	5.65E+02
MER	kg	0.00E+00	0.00E+00	0.00E+00	0.00E+00
EEE	MJ	0.00E+00	4.71E+00	2.03E+00	6.74E+00
EET	MJ	0.00E+00	6.35E+01	5.81E+00	6.93E+01

CRU: Components for reuse; MFR: Materials for recycling; MER: Materials for energy recovery; EEE: Electrical energy exported; EET: Thermal energy exported

6. Additional Environmental Information.

6.1. Other indicators.

The manufacture of paper for bags does not generate by-products.

6.2. Indoor air emissions.

The manufacturer declares that the product under study does not generate emissions into indoor air during its useful life.

6.3. Emissions to soil and water.

The manufacturer declares that the product under study does not generate significant emissions to the soil or water during its useful life.

6.4. Biogenic carbon content.

The biogenic carbon content of the product and packaging is declared in the table below.

Table 6-1. Biogenic carbon

Parameter	Kg C biogenic / declared unit
Product	4,40E+02
Packaging	2,09E+00

6.5. Electricity mix.

To represent the production of the electricity consumed in the plant, the GoO certificate issued by the CNMC for the year to which the data correspond has been considered:

- Eolic: 0,07%
- Solar fotovoltaic: 50,25%
- Solar thermoelectric: 49,68%.

Table 6-2. Electricity mix

Mix - GWP - g CO ₂ eq/kWh	
Average Mix	17,024

6.6. Additional environmental information.

The values of the GWP-GHG indicator for 1m² of product according to grammage are detailed below:

Grammage g/m ²	GWP - GHG g CO ₂ eq/m ²
60	12,69
70	14,80
75	15,86
80	16,91
85	17,97
90	19,03
100	21,14

Grammage g/m ²	GWP - GHG g CO ₂ eq/m ²
110	23,26
115	24,32
120	25,37
125	26,43
130	27,49
140	29,60
200	42,29

References

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