

Statement of Verification

BREG EN EPD No.: 000418

Issue 02

This is to verify that the
Environmental Product Declaration
provided by:
Gradus Ltd



is in accordance with the requirements of:
EN 15804:2012+A1:2013
and
BRE Global Scheme Document SD207

This declaration is for:
1m² Bodega Loop Pile Tufted Bitumen Backed Carpet Tile

Company Address

Park Green
Macclesfield
Cheshire
SK11 7LZ



GRADUS

Signed for BRE Global Ltd

Emma Baker
Operator

05 October 2023
Date of this Issue

06 June 2022
Date of First Issue

05 June 2027
Expiry Date



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To check the validity of this statement of verification please, visit www.greenbooklive.com/check or contact us.

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Environmental Product Declaration

EPD Number: 000418

General Information

EPD Programme Operator	Applicable Product Category Rules
BRE Global Watford, Herts WD25 9XX United Kingdom	BRE Environmental Profiles 2013 Product Category Rules for Type III environmental product declaration of construction products to EN 15804:2012+A1:2013
Commissioner of LCA study	LCA consultant/Tool
Gradus Ltd Park Green Macclesfield Cheshire SK11 7LZ	Andrew Dutfield/BRE LINA v2.0
Declared Unit	Applicability/Coverage
1m ² (4.5 kg/m ²) Bodega loop pile tufted bitumen backed carpet tile	Product Average.
EPD Type	Background database
Cradle to Gate	ecoinvent v3.2
Demonstration of Verification	
CEN standard EN 15804 serves as the core PCR ^a	
Independent verification of the declaration and data according to EN ISO 14025:2010 <input type="checkbox"/> Internal <input checked="" type="checkbox"/> External	
(Where appropriate ^b)Third party verifier: Nigel Jones	
a: Product category rules b: Optional for business-to-business communication; mandatory for business-to-consumer communication (see EN ISO 14025:2010, 9.4)	
Comparability	
Environmental product declarations from different programmes may not be comparable if not compliant with EN 15804:2012+A1:2013. Comparability is further dependent on the specific product category rules, system boundaries and allocations, and background data sources. See Clause 5.3 of EN 15804:2012+A1:2013 for further guidance	

Information modules covered

Product			Construction		Use stage							End-of-life				Benefits and loads beyond the system boundary
					Related to the building fabric				Related to the building							
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Raw materials supply	Transport	Manufacturing	Transport to site	Construction – Installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction demolition	Transport	Waste processing	Disposal	Reuse, Recovery and/or Recycling potential
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Note: Ticks indicate the Information Modules declared.

Manufacturing site(s)

3 First Avenue
 Poynton Industrial Estate
 Poynton
 Cheshire
 SK12 1YJ

Winsford Industrial Estate
 Winsford
 Cheshire
 CW7 3QB

Construction Product:

Product Description

Bodega combines durability with ease of maintenance and is available in 12 colours. Bodega is ideal for a wide range of environments including commercial, healthcare and education.

The following products are included in this EPD:

Product	Pile weight (g/m ²)	Total product weight (g/m ²)
Bodega bitumen backed tile	678	4,500
Bodega textile backed broadloom	678	1,906

Technical Information

Property	Value, Unit (all products)
Wear Class Classification BS EN 1307	4
Castor Chair BS EN 985 Test A	Pass
Impact Sound Reduction ISO 140-8	27dB (tile)
Static Electricity ISO 6356	<2 kV
Sound Absorption ISO 354	Class E
Flammability BS EN 13501-1	Class Efl-s1



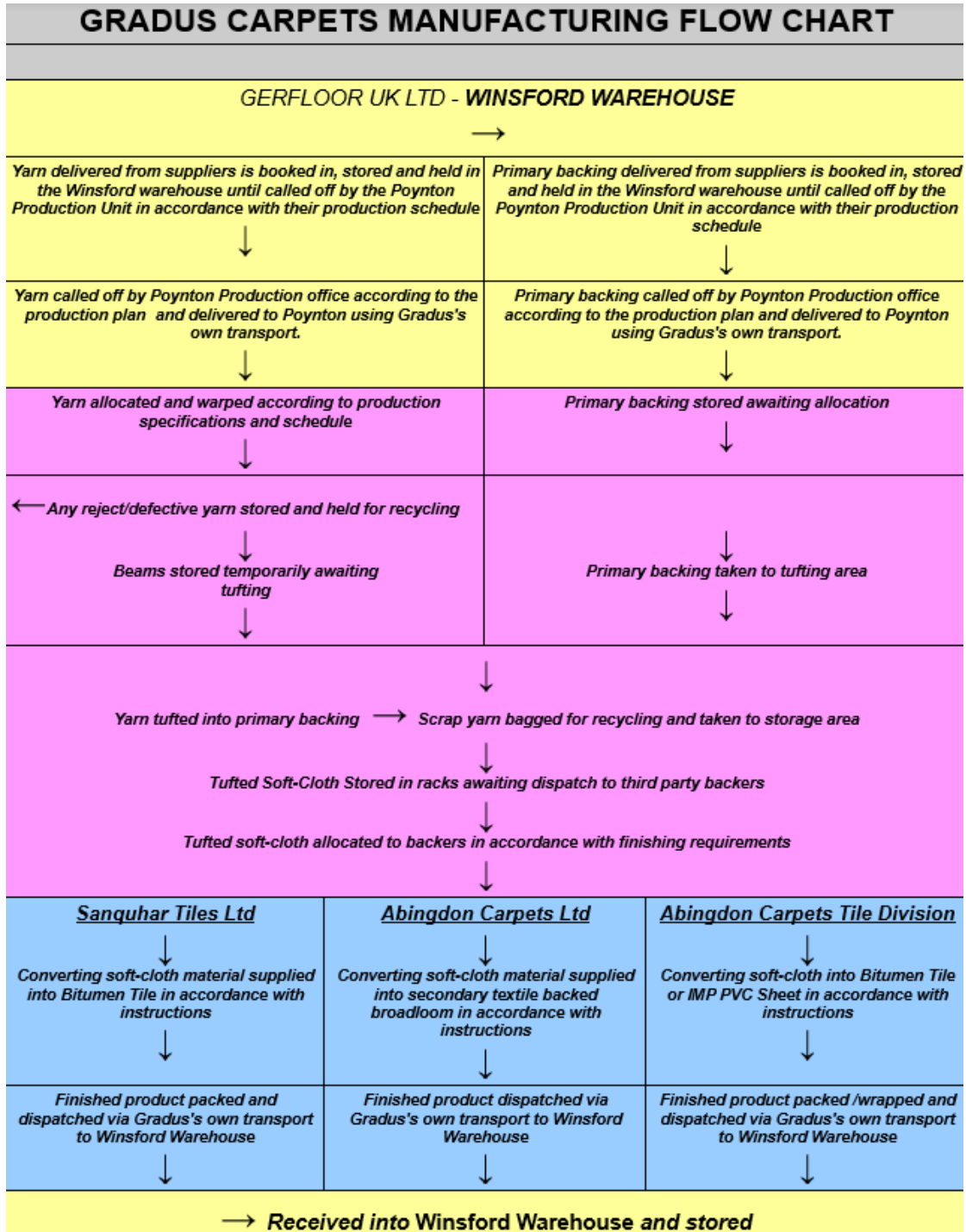
Main Product Contents

Material/Chemical Input	%
Polypropylene yarn	15.1
Primary backing	2.2
Bitumen backing	82.7

Manufacturing Process

Gradus Carpets manufactures a range of contract carpets from Nylon and Polypropylene pile yarns. Their own manufacturing facilities includes warehousing, yarn preparation (warping and beaming), along with a range of tufting machines. They operate from their production unit in Poynton, Cheshire with a shared group warehouse facility in Winsford, Cheshire. Yarn and primary backings are received from their suppliers which is delivered into Winsford, and from which they draw these off according to their production schedule. Yarns and primary backings are allocated and delivered into Poynton in the amounts required and checked and prepared to be converted into soft-cloth product. The required yarns for specific products are warped and held on beams ready for tufting. In accordance with the manufacturing specification and production schedule, the carpet is tufted and the soft-cloth rolls stored on racks until finishing is required. Gradus Carpets works with third party finishers to back their tufted cloth and to convert it into either Bitumen backed tiles, Impervious PVC sheet or Textile secondary backed broadloom carpet.

Process flow diagram



Construction Installation

Carpet tiles should be removed from their boxes and conditioned on site for at least 24 hours before fitting. An arrow on the back of the tile indicates the pile direction. Tiles can be laid with the arrows in the same direction to create a broadloom effect or in a chequer board effect by laying tiles at right angles to each other. Before setting out for the installation, it is essential to ensure that the sub floor is clean, dry, level, smooth and free from contaminants. To obtain a high standard of installation it is necessary to plan your setting out carefully. The correct starting point for setting out is the centre of the area to be tiled. It should be noted however that the final starting point for the installation might be offset from the centre line to ensure the correct size and balance of the side cuts.

Use Information

It is recommended to vacuum daily to remove surface soil using a heavy duty upright vacuum cleaner with a brush or a tub vacuum cleaner with a power head.

To maintain a good visible standard, the carpet will require deep cleaning on a weekly / monthly / as required basis (depending on weather conditions and volume of traffic). Deep cleaning can be carried out using various methods, depending on equipment availability.

In all cases, deep cleaning must follow brushing and vacuuming. Attention must be given to stains by using a pre-treatment of carpet spot and stain remover and chewing gum remover if required.

A) Preferred method: The use of a conventional jet extraction machine, using a conventional floor tool, scrubbing the carpet and continuing to extract as much water as possible. This method leaves the carpet as dry as possible.

B) Deep Soiled Matting: As with all other maintenance methods, always prepare the carpet by vacuum cleaning prior to treatment. The cleaning professional may consider a combination of a rotary scrubbing machine fitted with a carpet brush and extraction equipment to get improved results.

End of Life

Although Gradus does not operate a collection and disposal policy for the End-of-Life of its product range, its various sheet and tile products can be easily disposed of through three main disposal routes, namely Landfill, Municipal Waste Incineration (MWI) and recycling in the cement industry.

In each of these scenarios, the product may be disposed of either intact or by partial separation for which the product is separated down into its main input materials with some or all of them recycled.

Life Cycle Assessment Calculation Rules

Declared / Functional unit description

1m² (4.5 kg/m²) Bodega loop pile tufted bitumen backed carpet tile

System boundary

This is a cradle-to-gate LCA, reporting all production life cycle stages of modules A1 to A3 in accordance with EN 15804:2012+A1:2013.

Data sources, quality and allocation

The Bodega carpet declared unit is 1 m² of product with a weight of 4.5 kg/m². The bitumen backing has been chosen to represent both product groups as a worst-case scenario due to its higher total product weight. The carpet manufacturing data supplied relates to the Poynton and Winsford sites and covers the working period 1st January to 31st December 2020. Poynton is the main manufacturing site and Winsford is the storage warehouse. The Poynton site manufactures other products in addition to Bodega. Allocations have been made

according to the following table, and according to the provisions of the BRE PCR PN514 and EN 15804 standard:

Raw materials	Production by mass x % of product formulation
Packaging	% of total production by m ²
Energy, water, waste	% of total production by m ²

Energy and water usage at Winsford have also been additionally allocated at 41% of total usage based on the area taken up by Gerflor products within the facility.

Bitumen and textile backings are applied by various other manufacturers. Generic datasets have been created based on data supplied by TFI for the Green Guide in 2007 to represent the impervious PVC application process used for this study. Allocations have been made on a per m² basis according to the provisions of the BRE PCR PN514 and EN 15804 standard. Average transport distances of soft cloth from Poynton to the backing plants and of backed carpet from the backing plants to Winsford have been included. Average quantities and transport distances of packing materials have also been calculated for the finished products from data previously supplied by the backing plants.

Secondary data have been drawn from the BRE LINA database v2.0.87 and the background LCI datasets are based on ecoinvent v3.2 (2015).

Quality Level	Geographical representativeness	Technical representativeness	Time representativeness
Very Good	Data from area under study	Data from processes and products under study. Same state of technology applied as defined in goal and scope (i.e. identical technology)	n/a
Fair	n/a	n/a	Less than 10 years of difference between the reference year according to the documentation, and the time period for which data are representative

The quality level of geographical and technical representativeness is Very Good. The quality level of time representativeness is Fair as the background LCI datasets are based on ecoinvent v3.2 which was compiled in 2015, and so there is less than 10 years between the reference year according to the documentation, and the time period for which data are representative.

Cut-off criteria

All raw materials and energy input to the manufacturing process have been included, except for direct emissions to air, water and soil, which are not measured. The inventory process in this LCA includes all data related to raw material, packaging material, ancillary and consumable items. Process energy, water use, water discharge and waste are included.

LCA Results

(MND = module not declared; MNR = module not relevant; INA = indicator not assessed; AGG = aggregated)

Parameters describing environmental impacts			GWP	ODP	AP	EP	POCP	ADPE	ADPF
			kg CO ₂ equiv.	kg CFC 11 equiv.	kg SO ₂ equiv.	kg (PO ₄) ³⁻ equiv.	kg C ₂ H ₄ equiv.	kg Sb equiv.	MJ, net calorific value.
Product stage	Raw material supply	A1	5.83E+00	7.45E-07	3.19E-02	1.01E-02	4.26E-03	2.47E-05	1.59E+02
	Transport	A2	4.30E-01	7.79E-08	2.42E-03	4.59E-04	2.99E-04	1.00E-06	6.44E+00
	Manufacturing	A3	8.73E-02	2.27E-08	1.37E-03	7.52E-04	3.42E-04	9.31E-07	5.23E+00
	Total (of product stage)	A1-3	6.35E+00	8.46E-07	3.57E-02	1.13E-02	4.90E-03	2.67E-05	1.71E+02

GWP = Global Warming Potential;
 ODP = Ozone Depletion Potential;
 AP = Acidification Potential for Soil and Water;
 EP = Eutrophication Potential;

POCP = Formation potential of tropospheric Ozone;
 ADPE = Abiotic Depletion Potential – Elements;
 ADPF = Abiotic Depletion Potential – Fossil Fuels;

Parameters describing resource use, primary energy			PERE	PERM	PERT	PENRE	PENRM	PENRT
			MJ	MJ	MJ	MJ	MJ	MJ
Product stage	Raw material supply	A1	5.20E+00	2.08E-04	5.20E+00	1.30E+02	3.27E+01	1.63E+02
	Transport	A2	9.48E-02	3.00E-07	9.48E-02	6.42E+00	0.00E+00	6.42E+00
	Manufacturing	A3	3.28E+00	1.34E-06	3.28E+00	5.94E+00	0.00E+00	5.94E+00
	Total (of product stage)	A1-3	8.58E+00	2.09E-04	8.57E+00	1.42E+02	3.27E+01	1.75E+02

PERE = Use of renewable primary energy excluding renewable primary energy 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 resource

Parameters describing resource use, secondary materials and fuels, use of water

			SM	RSF	NRSF	FW
			kg	MJ net calorific value	MJ net calorific value	m ³
Product stage	Raw material supply	A1	0.00E+00	0.00E+00	0.00E+00	9.03E-02
	Transport	A2	0.00E+00	0.00E+00	0.00E+00	1.42E-03
	Manufacturing	A3	0.00E+00	0.00E+00	0.00E+00	2.45E-03
	Total (of product stage)	A1-3	0.00E+00	0.00E+00	0.00E+00	9.42E-02

SM = Use of secondary material;
RSF = Use of renewable secondary fuels;

NRSF = Use of non-renewable secondary fuels;
FW = Net use of fresh water

Other environmental information describing waste categories

			HWD	NHWD	RWD
			kg	kg	kg
Product stage	Raw material supply	A1	7.84E-02	4.64E-01	4.78E-04
	Transport	A2	2.70E-03	2.64E-01	4.44E-05
	Manufacturing	A3	3.02E-03	2.35E-02	1.98E-05
	Total (of product stage)	A1-3	8.42E-02	7.52E-01	5.43E-04

HWD = Hazardous waste disposed;
NHWD = Non-hazardous waste disposed;
RWD = Radioactive waste disposed

Other environmental information describing output flows – at end of life

			CRU	MFR	MER	EE
			kg	kg	kg	MJ per energy carrier
Product stage	Raw material supply	A1	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	Transport	A2	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	Manufacturing	A3	0.00E+00	3.56E-02	0.00E+00	0.00E+00
	Total (of product stage)	A1-3	0.00E+00	3.56E-02	0.00E+00	0.00E+00

CRU = Components for reuse;
MFR = Materials for recycling

MER = Materials for energy recovery;
EE = Exported Energy

Interpretation

Analysis of the results shows that the following raw materials have the highest and second highest impacts for the selected indicators:

Indicator	Highest impact	2nd highest impact
GWP	Polypropylene yarn (61.9%)	Bitumen backing (26.8%)
ODP	Bitumen backing (75.3%)	Polypropylene yarn (14.1%)
AP	Polypropylene yarn (63.9%)	Bitumen backing (25.2%)
EP	Polypropylene yarn (55.6%)	Bitumen backing (30.1%)
POCP	Polypropylene yarn (54.3%)	Bitumen backing (30.4%)
ADPE	Bitumen backing (62.5%)	Polypropylene yarn (18.0%)
ADPF	Polypropylene yarn (49.6%)	Bitumen backing (40.4%)

References

BSI. Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products. BS EN 15804:2012+A1:2013. London, BSI, 2013.

BSI. Environmental labels and declarations – Type III Environmental declarations – Principles and procedures. BS EN ISO 14025:2010 (exactly identical to ISO 14025:2006). London, BSI, 2010.

BSI. Environmental management – Life cycle assessment – Principles and framework. BS EN ISO 14040:2006. London, BSI, 2006.

BSI. Environmental management – Life cycle assessment – requirements and guidelines. BS EN ISO 14044:2006. London, BSI, 2006.

Life cycle inventory analysis (LCI) for textile floor coverings; Part II, LCA for carpet tiles; From cradle to factory gate, Deutsches Teppich-Forschungsinstitut (Textile Flooring Institute - TFI), Aachen, 2007.

Dutfield A, Mundy J and Anderson J; The Environmental Impact of Materials Series: Floor Finishes (incorporating the Green Guide ratings for floor finishes), Watford, 2011.

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