

Environmental Product Declaration (EPD)



Declaration Code: EPD-TDB-GB-68.0



Tremco CPG Germany GmbH

Building connections

Sealing tapes



Basis:

DIN EN ISO 14025
EN 15804 + A2

Company EPD
Environmental
Product Declaration

Publication date:
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28/04/2031



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Declaration Code: EPD-TDB-GB-68.0

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LCA Practitioner	Improving Sustainability GmbH Bernwardstrasse 26 D-29399 Wahrenholz		
Declaration holder	Tremco CPG Germany GmbH Werner-Haepf-Straße 1 D-92439 Bodenwoehr www.tremcocpg.eu		
Declaration code	EPD-TDB-GB-68.0		
Designation of declared product	Sealing tapes		
Scope	Joint sealing tape for sealing joints and connections in building construction. Multifunctional sealing tape for sealing windows and doors.		
Basis	This EPD was prepared on the basis of EN ISO 14025:2011 and DIN EN 15804:2012+A2:2019. In addition, the "Allgemeiner Leitfaden zur Erstellung von Typ III Umweltproduktdeklarationen" (Guidance on preparing Type III Environmental Product Declarations) applies. The Declaration is based on the PCR documents "PCR Part A" PCR-A-2.0:2025 and "Baukörperanschluss" PCR-BA-3.0:2023.		
Validity	Publication date: 28/04/2026	Last revision: 30/04/2026	Valid until 28/04/2031
	This verified company Environmental Product Declaration applies solely to the specified products and is valid for a period of five years from the date of publication in accordance with DIN EN 15804.		
LCA basis	The LCA was prepared in accordance with DIN EN ISO 14040 and DIN EN ISO 14044. The base data includes both the data collected at the production site of Tremco CPG Germany GmbH and the generic data from the "LCA for Experts 10" database. LCA calculations were carried out for the included "cradle to grave with options" life cycle including all upstream chains (e.g. raw material extraction, etc.).		
Notes	The "Conditions and Guidance on the Use of ift Test Documents" apply. The declaration holder assumes full liability for the underlying data, certificates and verifications. ift Rosenheim GmbH is not liable for manufacturer information, life cycle assessment data, and evidence.		
Assessment committee	Dr. Torsten Mielecke Chairman of Expert Committee ift-EPD and PCR		
External Verification	Prof. Dr.-Ing. Eric Brehm		

1 General product information

Product definition

The EPD relates to the product group building connections and applies to:

**1 m of Sealing tape
made by Tremco CPG Germany GmbH**

The declared unit is obtained as follows:

Product groups and Assessed product	Declared unit	Linear weight (kg/m)
PG1: Single-purpose sealing tapes (joint sealing tapes) TP600 grey*	1 m	0.533 kg/m
PG2: Multifunctional sealing tapes TP360 anthracite*	1 m	0.603 kg/m

Table 1: Product groups

The average unit is declared as follows: Directly used material flows are determined by means of masses (kg) and assigned to the declared unit. All other inputs and outputs in production are allocated in their entirety to the declared unit, as these cannot be directly related to the average size. The reference period is 2024.

The validity of the EPD is limited to the following products.:

PG 1 Single-purpose sealing tapes	PG 2 Multifunctional sealing tapes
TP600 grey	TP360 anthracite
TP001 grey	TP654 anthracite
TP050 anthracite	TP655 anthracite
TP050 grey	TP670 anthracite
TP310 anthracite	-
TP310 grey	-
TP600 anthracite	-
TP601 anthracite	-
TP601 grey	-
TP610 anthracite	-
TP610 grey	-
TP670 anthracite	-
TP670 grey	-

Table 2: scope of validity

*assessed products highlighted

Product description

Product Group 1 (PG1):

Joint sealing tape for driving rain-proof and vapor-permeable sealing of joints and connections in building construction.

Product Group 2 (PG2):

Multifunctional sealing tape for standard-compliant, driving rain-proof, and airtight sealing of windows and doors. The tapes provide a high level of thermal and sound insulation.

For a detailed product description refer to the manufacturer specifications or the product specifications of the respective offer/quotation.

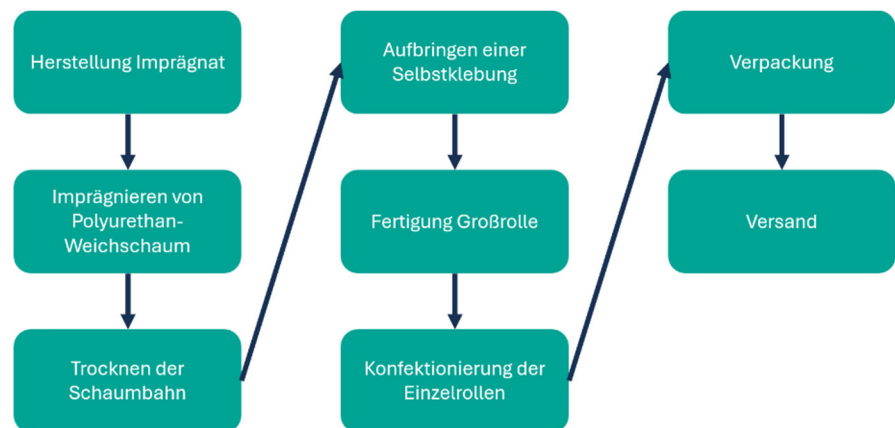
Product manufacture

Table 3: production

Scope

Joint sealing tape for sealing joints and connections in building construction. Multifunctional sealing tape for sealing windows and doors.

Management systems

The following management systems are in place:

- Quality Management System in acc. with DIN EN ISO 9001:2015
- Energy Management System in acc. with DIN EN ISO 50001:2018
- Environmental Management System in acc. with DIN EN ISO 14001:2015
- Occupational Health and Safety Management System in acc. with DIN ISO 45001:2018

Additional information

For additional evidence of fitness for use or certificates of conformity, if applicable, please refer to the CE marking and the documents accompanying the product.

For information on the products' physical and performance characteristics, please refer to the respective product data sheets.

All relevant information about the products, data sheets, and performance characteristics can be found at www.illbruck.com.

2 Materials used

Primary materials	The primary materials used are specified in Section 6.2 Inventory analysis (Inputs).
Declarable substances	<p>The product may contain substances listed on the REACH Candidate List. Information is provided in sections 3 and 15 of the current safety data sheet for the product in question. (Declaration as of February 2026).</p> <p>All relevant safety data sheets are available from Tremco CPG Germany GmbH</p>

3 Construction process stage

Processing recommendations, installation	Observe the instructions for application and use provided by the manufacturer. See www.tremcocpg.eu
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4 Use stage

Emissions to the environment	<p>Emissions may occur into indoor air, water, and soil. VOC emissions are generated. VOC test reports are available for the reference products included in the assessment. All of them meet the EC1plus standard. (As of April 2026)</p> <p>Please contact the manufacturer for the currently valid test certificates.</p>
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Reference service life (RSL)	<p>The RSL information was provided by the manufacturer. The RSL shall be specified under defined reference in-use conditions and shall refer to the declared technical and functional performance of the product within the building. It shall be established in accordance with any specific rules given in European product standards, or, if not available, in accordance with a c-PCR. It shall also take into account ISO 15686-1, -2, -7 and -8. Where European product standards or a c-PCR provide guidance on deriving the RSL, such guidance shall have priority.</p> <p>If it is not possible to determine the service life as the RSL in accordance with ISO 15686, the BBSR table "Nutzungsdauer von Bauteilen zur Lebenszyklusanalyse nach BNB" (service life of building components for life cycle assessment in accordance with the sustainable construction evaluation system) can be used. For further information and explanations refer to www.nachhaltigesbauen.de.</p>
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For this EPD the following applies:

For a "Cradle to gate with options" EPD with the modules C1-C4 and module D (A1-A3 + C + D and one or more additional modules from A4 to B7), the reference service life (RSL) can only be stated if the reference in-use conditions are specified.

The reference service life (RSL) of Sealing tapes made by Tremco CPG Germany GmbH is not specified.

5 End-of-life stage

Possible end-of-life stages

Sealing tapes are shipped to central collection points. There the products are generally shredded and sorted into their original constituents. The end-of-life stage depends on the site where the products are used and is therefore subject to the local regulations. Observe the locally applicable regulatory requirements.

This EPD shows the end-of-life modules according to the market situation.

This EPD presents the end-of-life streams according to market conditions.

100% of plastics are recycled through thermal recovery. Residual fractions are landfilled.

Disposal routes

The LCA includes the average disposal routes.

All life cycle scenarios are detailed in the Annex.

6 Life Cycle Assessment (LCA)

Environmental product declarations are based on life cycle assessments (LCAs) which use material and energy flows for the calculation and subsequent representation of environmental impacts.

Such life cycle assessments were developed for Sealing tapes, serving as the basis. The LCAs are in conformity with the requirements set out in DIN EN 15804 and the international standards DIN EN ISO 14040, DIN EN ISO 14044 and EN ISO 14025 as well as based on ISO 21930.

The LCA is representative of the products presented in the Declaration and the specified reference period.

6.1 Definition of goal and scope

Goal

The goal of the LCA is to demonstrate the environmental impacts of the products. In accordance with DIN EN 15804, the environmental impacts covered by this Environmental Product Declaration are presented for the entire product life cycle in the form of basic information. Apart from these, no other environmental impacts are specified.

Data quality, data availability and geographical and time-related system boundaries

The specific data is derived exclusively from the 2024 fiscal year. This data was collected at the facility in 92439 Bodenwöhr (Germany) and is sourced partly from accounting records and partly from directly recorded measurements. Primary data was collected for energy, water, and packaging consumption, as well as for waste/scrap and emissions.

Generic data is sourced from the ecoinvent 3.12 EN 15804 database of the "Umberto" software. The database was last updated in 2026. Older data also comes from this database and is no more than three years old. No other generic data was used for the calculation.

Generic data is selected as precisely as possible with regard to its geographic reference. If no country-specific data sets are available or if the regional reference cannot be determined, European or globally valid data sets are used.

Data gaps were either replaced with comparable data or conservative assumptions, or truncated in accordance with the 1% rule.

To model the life cycle, the "Umberto" software system for holistic life cycle assessment (version 11.18.1) was used with the "ecoinvent 3.12 EN 15804" database version. The LCA was evaluated using the EF3.1 impact assessment method.

The data quality complies with the requirements of EN 15941:2024-10.

Scope / system boundaries	<p>The system boundaries refer to the supply of raw materials and purchased parts, manufacture/production and end-of-life stage of Sealing tapes.</p> <p>No additional data from pre-suppliers/subcontractors or other sites were taken into consideration.</p>
Cut-off criteria	<p>However, the scope is limited to production-related data. Building components and plant equipment not relevant to product manufacturing were excluded.</p> <p>The transport routes for raw materials and packaging were taken into account 100% based on the mass of the products.</p> <p>In addition to the transport routes for intermediate products, transport routes for waste were also taken into account. The transport of waste generated in A3 was modeled using the following scenario according to the manufacturer:</p> <ul style="list-style-type: none"> • Transport to the collection point using a >32-ton truck (Euro 6), diesel, 15.96-ton average payload, 11.2 km. <p>The criteria for excluding inputs and outputs in accordance with DIN EN 15804 are met. Based on the data analysis, it can be assumed that the neglected processes do not exceed 1% of the mass or primary energy per life cycle stage. In total, 5% of the energy and mass input is accounted for by the neglected processes. Material and energy flows smaller than 1% were also taken into account for the life cycle assessment calculation.</p>
6.2 Inventory analysis	
Goal	All material and energy flows are described below. The processes covered are presented as input and output parameters and refer to the declared unit.
Life cycle stages	The Annex shows the entire life cycle of Sealing tapes. The “Product stage” (A1 - A3), “Construction process stage” (A5), “End-of-life stage” (C1 - C4) and the “Benefits and loads beyond the system boundaries” (D) are considered.
Benefits	<p>The below benefits have been defined in accordance with DIN EN 15804:</p> <ul style="list-style-type: none"> • Benefits (thermal and electrical) from incineration
Allocation of co-products	The manufacture does not give rise to allocations
Allocations for reuse, recycling and recovery	<p>If the products are reused/recycled and recovered during the product stage (rejects) the components are shredded/broken if necessary and then sorted into their single constituents.</p> <p>The system boundaries were set following their disposal, reaching the end-of-waste state.</p>

Allocations beyond life cycle boundaries

The use of recycled materials in the manufacturing process was based on the current market-specific situation. A recycling potential that reflects the economic value of the product after recycling (recyclate) was also taken into account .

The system boundary set for the recycled material refers to collection.

Secondary material

The use of secondary material by Tremco CPG Germany GmbH was considered in module A3. Secondary material was not used.

Inputs

The LCA includes the following production-relevant inputs per 1 m of Sealing tape:

Energy

For the input material gas, “thermal energy from natural gas (RER)” and “LPG Europe excluding Switzerland” were assumed. For the electricity mix, the “Europe electricity mix” (residual mix) was assumed (market-based approach).

Electricity mix / gas mix used	Total	Unit
Electricity mix (RER)	8.06 E-01	kg CO ₂ -eq. / kWh
Thermal energy from natural gas (RER)	5.41 E-02	kg CO ₂ -eq. / MJ
LPG	1.09 E-00	kg CO ₂ -eq. / kg

Table 4: Greenhouse gas emissions from the use of electricity/gas in the manufacturing phase

A portion of the process heat is used for space heating. This can, however, not be quantified and a “worst case” figure was taken into account for the product.

Water

The individual production steps result in the following water consumption in liters per meter of sealing tape:

water consumption in liters per meter	
PG 1	PG 2
0.909	0.681

Table 5: water consumption in liters per meter

The consumption of freshwater specified in Section 6.3 originates (among others) from the process chain of the pre-products and the process water used for cooling.

Raw material/pre-products

The chart below shows the share of raw materials/pre-products in %.

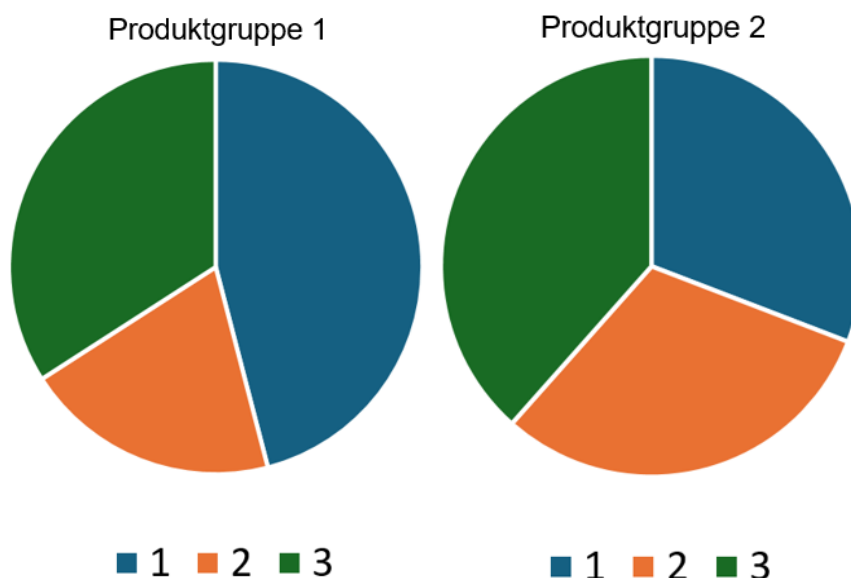


Figure 1: Percentage of individual materials per declared unit

No.	Material	Mass in %	
		PG 1	PG 2
1	Aluminum hydroxide	45.94	30.84
2	Polyurethane flexible foam	19.97	30.71
3	Other ingredients	34.09	38.45

Table 6: Percentage of individual materials per declared unit

Ancillary materials and consumables

No ancillary materials and consumables are used.

Product packaging

The amounts used for product packaging are as follows:

No.	Material	Mass in %	
		PG 1	PG 2
1	Plastic film and protective covers	4.96E-04	8.33E-04
2	Cardboard boxes	6.71E-02	1.47E-01
3	Wooden packaging (Euro pallets)	4.13E-02	6.94E-02

Table 7: Weight in kg of packaging per declared unit

Biogenic carbon content

Only the biogenic carbon content of the associated packaging is specified, as the total mass of substances containing biogenic carbon is less than 5% of the total mass of the product and associated packaging. In accordance with EN 16449, packaging produces the following amounts of biogenic carbon :

No.	Component	Content in kg C per m	
		PG 1	PG 2
1	Associated packaging	3,0E-02	6,4E-02

Note: 1 kg C corresponds to $^{44}/_{12}$ kg CO₂ eq. of biogenic carbon

Table 8: Biogenic carbon content of packaging at gate

GWP-b values resulting from the sequestration and release of biogenic carbon were calculated specifically for each life cycle module and are listed in Note: 1 kg C corresponds to $^{44}/_{12}$ kg CO₂-eqv. of biogenic carbon

Table 10. The overall results table presented in this document, issued by "Umberto", has not been changed.

Binding and release of CO ₂ emissions in kg CO ₂ -eqv. / m ²						
Component		A1-A3	A5	C3	C4	D
PG 1	Packaging	- 0.109	+0.109	0.00	0.00	0.00
PG 2	Packaging	-0.236	+0.236	0.00	0.00	0.00

Note: 1 kg C corresponds to $^{44}/_{12}$ kg CO₂-eqv. of biogenic carbon

Table 9: Binding and release of biogenic CO₂ emissions in kg CO₂-eqv. from product and packaging per life cycle module

Outputs

The LCA includes the following production-relevant outputs per 1 m of Sealing tape:

Waste

Secondary raw materials were included in the benefits. See Section 6.3 Impact assessment.

Waste water

The following amounts of wastewater are generated during production:

Waste water in liters per meter	
PG 1	PG 2
0.232	0.174

Table 10: wastewater generated

6.3 Impact assessment

Goal

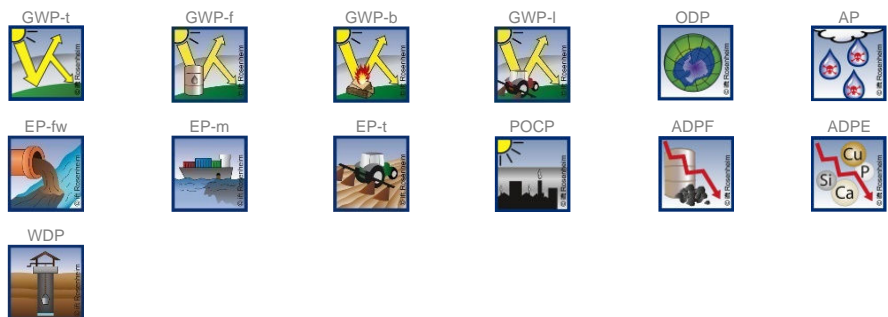
The impact assessment covers both inputs and outputs. The impact categories applied are named below:

Core indicators

The models for impact assessment were applied as described in DIN EN 15804+A2.

The impact categories presented in the EPD as core indicators are as follows:

- Climate change – total (GWP-t)
- Climate change – fossil (GWP-f)
- Climate change – biogenic (GWP-b)
- Climate change - land use and land use change (GWP-l)
- Ozone depletion (ODP)
- Acidification (AP)
- Eutrophication aquatic freshwater (EP-fw)
- Eutrophication aquatic marine (EP-m)
- Eutrophication terrestrial (EP-t)
- Photochemical ozone creation (POCP)
- Depletion of abiotic resources - fossil fuels (ADPF)
- Depletion of abiotic resources - minerals and metals (ADPE)
- Water use (WDP)

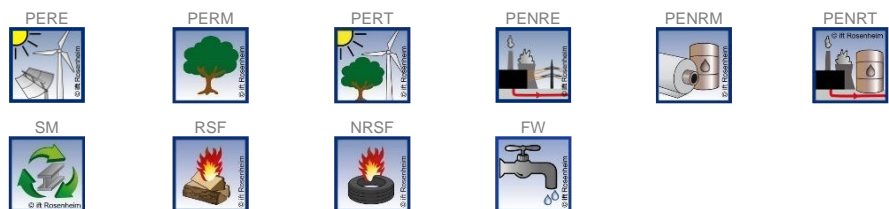


Use of resources

The models for impact assessment were applied as described in DIN EN 15804-A2.

The following parameters for the use of resources are shown in the EPD:

- Renewable primary energy as energy source (PERE)
- Renewable primary energy for material use (PERM)
- Total use of renewable primary energy (PERT)
- Non-renewable primary energy as energy resource (PENRE)
- Non-renewable primary energy for material use (PENRM)
- Total use of non-renewable primary energy (PENRT)
- Use of secondary materials (SM)
- Use of renewable secondary fuels (RSF)
- Use of non-renewable secondary fuels (NRSF)
- Net use of freshwater resources (FW)



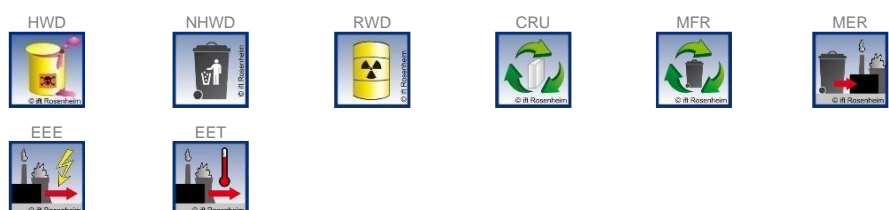
Waste

The waste generate during the production of 1 m of Sealing tape is evaluated and shown separately for the fractions trade wastes, special wastes and radioactive wastes. Since waste handling is modelled within the system boundaries, the amounts shown refer to the deposited wastes. A portion of the waste indicated is generated during the manufacture of the pre-products.

The models for impact assessment were applied as described in DIN EN 15804-A2.

The waste categories and indicators for output material flows presented in the EPD are as follows:

- Hazardous waste disposed (HWD)
- Non-hazardous waste disposed (NHWD)
- Radioactive waste disposed (RWD)
- Components for reuse (CRU)
- Materials for recycling (MFR)
- Materials for energy recovery (MER)
- Exported electrical energy (EEE)
- Exported thermal energy (EET)



Additional environmental impact indicators

The models for impact assessment were applied as described in DIN EN 15804-A2.

The additional impact categories presented in the EPD are as follows:

- Particulate matter emissions (PM)
- Ionising radiation, human health (IRP)
- Ecotoxicity – freshwater (ETP-fw)
- Human toxicity - cancer effect (HTP-c)
- Human toxicity - non-cancer effect (HTP-nc)
- Land use related impacts / soil quality (SQP)





Results per 1 m of Single-purpose sealing tape (PG 1)

Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Core indicators															
GWP-t	kg CO ₂ eq.	2.38	ND	0.11	ND	ND	ND	ND	ND	ND	0.00	2.74E-02	1.23	2.58E-04	-0.43
GWP-f	kg CO ₂ eq.	2.37	ND	3.99E-03	ND	ND	ND	ND	ND	ND	0.00	2.74E-02	1.23	2.57E-04	-0.43
GWP-b	kg CO ₂ eq.	1.85E-03	ND	0.10	ND	ND	ND	ND	ND	ND	0.00	1.31E-05	8.75E-04	1.26E-06	-6.72E-03
GWP-l	kg CO ₂ eq.	5.11E-03	ND	8.66E-07	ND	ND	ND	ND	ND	ND	0.00	9.27E-06	7.78E-05	6.00E-08	-5.85E-04
ODP	kg CFC-11 eq.	1.63E-07	ND	2.99E-11	ND	ND	ND	ND	ND	ND	0.00	6.35E-10	7.91E-10	9.43E-12	-1.33E-08
AP	mol H ⁺ eq.	1.45E-02	ND	2.24E-05	ND	ND	ND	ND	ND	ND	0.00	5.98E-05	3.93E-04	2.89E-06	-1.18E-03
EP-fw	kg P eq.	7.33E-04	ND	7.43E-07	ND	ND	ND	ND	ND	ND	0.00	1.96E-06	2.72E-05	4.47E-07	-1.98E-04
EP-m	kg N eq.	2.16E-03	ND	1.29E-05	ND	ND	ND	ND	ND	ND	0.00	1.60E-05	1.78E-04	7.34E-07	-2.53E-04
EP-t	mol N eq.	1.92E-02	ND	1.08E-04	ND	ND	ND	ND	ND	ND	0.00	1.72E-04	1.52E-03	7.88E-06	-2.29E-03
POCP	kg NMVOC eq.	7.93E-03	ND	2.71E-05	ND	ND	ND	ND	ND	ND	0.00	1.04E-04	3.90E-04	2.88E-06	-8.40E-04
ADPF*2	MJ	35.13	ND	1.95E-02	ND	ND	ND	ND	ND	ND	0.00	0.40	0.75	6.09E-03	-8.09
ADPE*2	kg Sb eq.	1.50E-05	ND	5.96E-09	ND	ND	ND	ND	ND	ND	0.00	8.87E-08	1.38E-07	4.52E-10	-3.37E-07
WDP*2	m ³ world eq. deprived	0.88	ND	3.28E-03	ND	ND	ND	ND	ND	ND	0.00	2.20E-03	9.35E-02	2.90E-04	-0.12
Use of resources															
PERE	MJ	1.26	ND	1.09	ND	ND	ND	ND	ND	ND	0.00	6.73E-03	0.13	1.20E-04	-1.05
PERM	MJ	1.09	ND	-1.09	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
PERT	MJ	2.35	ND	5.60E-04	ND	ND	ND	ND	ND	ND	0.00	6.73E-03	0.13	1.20E-04	-1.05
PENRE	MJ	16.15	ND	4.13E-02	ND	ND	ND	ND	ND	ND	0.00	0.40	18.79	6.09E-03	-8.09
PENRM	MJ	19.01	ND	-2.18E-02	ND	ND	ND	ND	ND	ND	0.00	0.00	-18.03	0.00	0.00
PENRT	MJ	35.15	ND	1.95E-02	ND	ND	ND	ND	ND	ND	0.00	0.40	0.75	6.09E-03	-8.09
SM	kg	8.16E-02	ND	2.58E-05	ND	ND	ND	ND	ND	ND	0.00	1.71E-04	2.68E-04	1.96E-06	-8.84E-04
RSF	MJ	0.00	ND	0.00	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
NRSF	MJ	0.00	ND	0.00	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
FW	m ³	2.18E-02	ND	3.73E-05	ND	ND	ND	ND	ND	ND	0.00	5.02E-05	1.67E-03	-7.34E-05	-2.81E-03
Waste categories															
HWD	kg	0.73	ND	2.90E-03	ND	ND	ND	ND	ND	ND	0.00	2.25E-03	2.30E-02	2.72E-05	-2.08E-02
NHWD	kg	11.05	ND	8.27E-02	ND	ND	ND	ND	ND	ND	0.00	3.97E-02	0.68	8.66E-02	-1.00
RWD	kg	3.23E-05	ND	6.07E-09	ND	ND	ND	ND	ND	ND	0.00	1.17E-07	3.60E-06	1.91E-09	-2.97E-05
Output material flows															
CRU	kg	0.00	ND	0.00	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
MFR	kg	1.07E-02	ND	8.51E-07	ND	ND	ND	ND	ND	ND	0.00	1.14E-05	7.52E-05	1.98E-07	-5.27E-04
MER	kg	3.48E-06	ND	2.39E-09	ND	ND	ND	ND	ND	ND	0.00	1.35E-08	3.73E-08	1.21E-10	-7.52E-08
EEE	MJ	0.35	ND	0.13	ND	ND	ND	ND	ND	ND	0.00	7.91E-05	1.99	2.80E-06	-5.17E-04
EET	MJ	0.80	ND	0.25	ND	ND	ND	ND	ND	ND	0.00	2.49E-04	3.88	5.71E-06	-3.65E-04

Key:

GWP-t – climate change - total **GWP-f** – climate change - fossil **GWP-b** – climate change - biogenic **GWP-l** – climate change - land use and land use change **ODP** – ozone depletion
AP - acidification **EP-fw** - eutrophication - aquatic freshwater **EP-m** - eutrophication - aquatic marine **EP-t** - eutrophication - terrestrial **POCP** - photochemical ozone formation **ADPF*2** - depletion of abiotic resources – fossil fuels **ADPE*2** - depletion of abiotic resources – minerals and metals **WDP*2** – water use **PERE** - use of renewable primary energy **PERM** - use of renewable primary energy resources used as raw materials **PERT** - total use of renewable primary energy **PENRE** - use of non-renewable primary energy **PENRM** - use of non-renewable primary energy resources 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 freshwater **HWD** - hazardous waste disposed **NHWD** - non-hazardous waste disposed **RWD** - radioactive waste disposed **CRU** - components for reuse **MFR** - materials for recycling **MER** - materials for energy recovery **EEE** - exported electrical energy **EET** - exported thermal energy
ND – Not declared



Results per 1 m of Single-purpose sealing tape (PG 1)

Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Additional environmental impact indicators															
PM	Disease incidence	1.03E-07	ND	1.87E-10	ND	ND	ND	ND	ND	ND	0.00	2.29E-09	1.86E-09	4.42E-11	-4.31E-09
IRP*1	kBq U235 eq.	0.13	ND	2.45E-05	ND	ND	ND	ND	ND	ND	0.00	4.83E-04	1.43E-02	8.06E-06	-0.12
ETP-fw*2	CTUe	28.16	ND	3.89E-02	ND	ND	ND	ND	ND	ND	0.00	5.83E-02	2.44	3.84E-03	-0.64
HTP-c*2	CTUh	1.69E-09	ND	7.94E-12	ND	ND	ND	ND	ND	ND	0.00	4.24E-12	1.07E-10	1.02E-13	-5.91E-11
HTP-nc*2	CTUh	3.60E-08	ND	3.29E-10	ND	ND	ND	ND	ND	ND	0.00	2.40E-10	3.79E-09	6.56E-12	-1.63E-09
SQP*2	Dimensionless.	9.91	ND	8.41E-03	ND	ND	ND	ND	ND	ND	0.00	0.32	0.14	1.52E-02	-0.71

Key:

PM – particulate matter emissions **IRP*1** – ionising radiation – human health **ETP-fw*2** - ecotoxicity – aquatic freshwater **HTP-c*2** - human toxicity potential – cancer effect **HTP-nc*2** - human toxicity potential – non-cancer effect **SQP*2** – land use related impacts / soil quality
ND – Not declared

Disclaimers

*1 This impact category deals mainly with the eventual impact of low-dose ionising radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionising radiation from the soil, from radon and from some building materials is also not measured by this indicator

*2 The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator



Results per 1 m of Multifunctional sealing tape (PG 2)

Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Core indicators															
GWP-t	kg CO ₂ eq.	2.81	ND	0.23	ND	ND	ND	ND	ND	ND	0.00	3.10E-02	1.39	2.92E-04	-0.52
GWP-f	kg CO ₂ eq.	2.83	ND	8.12E-03	ND	ND	ND	ND	ND	ND	0.00	3.10E-02	1.39	2.91E-04	-0.51
GWP-b	kg CO ₂ eq.	-2.70E-02	ND	0.23	ND	ND	ND	ND	ND	ND	0.00	1.48E-05	9.90E-04	1.42E-06	-8.01E-03
GWP-l	kg CO ₂ eq.	9.36E-03	ND	1.88E-06	ND	ND	ND	ND	ND	ND	0.00	1.05E-05	8.80E-05	6.78E-08	-6.98E-04
ODP	kg CFC-11 eq.	8.76E-08	ND	6.50E-11	ND	ND	ND	ND	ND	ND	0.00	7.19E-10	8.95E-10	1.07E-11	-1.58E-08
AP	mol H ⁺ eq.	1.65E-02	ND	4.87E-05	ND	ND	ND	ND	ND	ND	0.00	6.76E-05	4.45E-04	3.27E-06	-1.41E-03
EP-fw	kg P eq.	9.28E-04	ND	1.61E-06	ND	ND	ND	ND	ND	ND	0.00	2.22E-06	3.08E-05	5.05E-07	-2.36E-04
EP-m	kg N eq.	2.85E-03	ND	2.81E-05	ND	ND	ND	ND	ND	ND	0.00	1.81E-05	2.01E-04	8.31E-07	-3.02E-04
EP-t	mol N eq.	2.43E-02	ND	2.34E-04	ND	ND	ND	ND	ND	ND	0.00	1.95E-04	1.71E-03	8.92E-06	-2.73E-03
POCP	kg NMVOC eq.	1.06E-02	ND	5.88E-05	ND	ND	ND	ND	ND	ND	0.00	1.18E-04	4.41E-04	3.26E-06	-1.00E-03
ADPF*2	MJ	46.81	ND	4.25E-02	ND	ND	ND	ND	ND	ND	0.00	0.45	0.85	6.89E-03	-9.65
ADPE*2	kg Sb eq.	2.39E-05	ND	1.30E-08	ND	ND	ND	ND	ND	ND	0.00	1.00E-07	1.56E-07	5.11E-10	-4.02E-07
WDP*2	m ³ world eq. deprived	1.10	ND	7.08E-03	ND	ND	ND	ND	ND	ND	0.00	2.48E-03	0.11	3.29E-04	-0.14
Use of resources															
PERE	MJ	1.51	ND	2.35	ND	ND	ND	ND	ND	ND	0.00	7.61E-03	0.15	1.36E-04	-1.25
PERM	MJ	2.35	ND	-2.35	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
PERT	MJ	3.86	ND	1.22E-03	ND	ND	ND	ND	ND	ND	0.00	7.61E-03	0.15	1.36E-04	-1.25
PENRE	MJ	24.56	ND	7.90E-02	ND	ND	ND	ND	ND	ND	0.00	0.45	22.00	6.89E-03	-9.65
PENRM	MJ	22.30	ND	-3.66E-02	ND	ND	ND	ND	ND	ND	0.00	0.00	-21.15	0.00	0.00
PENRT	MJ	46.86	ND	4.25E-02	ND	ND	ND	ND	ND	ND	0.00	0.45	0.85	6.89E-03	-9.65
SM	kg	0.16	ND	5.57E-05	ND	ND	ND	ND	ND	ND	0.00	1.93E-04	3.04E-04	2.22E-06	-1.05E-03
RSF	MJ	0.00	ND	0.00	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
NRSF	MJ	0.00	ND	0.00	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
FW	m ³	2.73E-02	ND	8.08E-05	ND	ND	ND	ND	ND	ND	0.00	5.68E-05	1.89E-03	-8.30E-05	-3.36E-03
Waste categories															
HWD	kg	0.90	ND	6.32E-03	ND	ND	ND	ND	ND	ND	0.00	2.55E-03	2.61E-02	3.08E-05	-2.48E-02
NHWD	kg	13.27	ND	0.18	ND	ND	ND	ND	ND	ND	0.00	4.50E-02	0.77	9.80E-02	-1.20
RWD	kg	5.03E-05	ND	1.32E-08	ND	ND	ND	ND	ND	ND	0.00	1.32E-07	4.08E-06	2.16E-09	-3.54E-05
Output material flows															
CRU	kg	0.00	ND	0.00	ND	ND	ND	ND	ND	ND	0.00	0.00	0.00	0.00	0.00
MFR	kg	2.12E-02	ND	1.85E-06	ND	ND	ND	ND	ND	ND	0.00	1.29E-05	8.51E-05	2.24E-07	-6.28E-04
MER	kg	5.07E-06	ND	5.19E-09	ND	ND	ND	ND	ND	ND	0.00	1.53E-08	4.22E-08	1.37E-10	-8.97E-08
EEE	MJ	0.29	ND	0.27	ND	ND	ND	ND	ND	ND	0.00	8.95E-05	2.25	3.17E-06	-6.16E-04
EET	MJ	0.65	ND	0.55	ND	ND	ND	ND	ND	ND	0.00	2.82E-04	4.39	6.47E-06	-4.36E-04

Key:

GWP-t – climate change - total **GWP-f** – climate change - fossil **GWP-b** – climate change - biogenic **GWP-l** – climate change - land use and land use change **ODP** – ozone depletion
AP - acidification **EP-fw** - eutrophication - aquatic freshwater **EP-m** - eutrophication - aquatic marine **EP-t** - eutrophication - terrestrial **POCP** - photochemical ozone formation **ADPF*2** - depletion of abiotic resources – fossil fuels **ADPE*2** - depletion of abiotic resources – minerals and metals **WDP*2** – water use **PERE** - use of renewable primary energy **PERM** - use of renewable primary energy resources used as raw materials **PERT** - total use of renewable primary energy **PENRE** - use of non-renewable primary energy **PENRM** - use of non-renewable primary energy resources 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 freshwater **HWD** - hazardous waste disposed **NHWD** - non-hazardous waste disposed **RWD** - radioactive waste disposed **CRU** - components for reuse **MFR** - materials for recycling **MER** - materials for energy recovery **EEE** - exported electrical energy **EET** - exported thermal energy
ND – Not declared



Results per 1 m of Multifunctional sealing tape (PG 2)

Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Additional environmental impact indicators															
PM	Disease incidence	1.19E-07	ND	4.04E-10	ND	ND	ND	ND	ND	ND	0.00	2.59E-09	2.11E-09	5.00E-11	-5.14E-09
IRP*1	kBq U235 eq.	0.20	ND	5.32E-05	ND	ND	ND	ND	ND	ND	0.00	5.46E-04	1.62E-02	9.12E-06	-0.14
ETP-fw*2	CTUe	44.46	ND	8.38E-02	ND	ND	ND	ND	ND	ND	0.00	6.60E-02	2.76	4.35E-03	-0.76
HTP-c*2	CTUh	2.49E-09	ND	1.73E-11	ND	ND	ND	ND	ND	ND	0.00	4.80E-12	1.21E-10	1.16E-13	-7.06E-11
HTP-nc*2	CTUh	4.68E-08	ND	7.15E-10	ND	ND	ND	ND	ND	ND	0.00	2.71E-10	4.29E-09	7.42E-12	-1.94E-09
SQP*2	Dimensionless.	15.52	ND	1.83E-02	ND	ND	ND	ND	ND	ND	0.00	0.36	0.16	1.71E-02	-0.84

Key:

PM – particulate matter emissions **IRP*1** – ionising radiation – human health **ETP-fw*2** - ecotoxicity – aquatic freshwater **HTP-c*2** - human toxicity potential – cancer effect **HTP-nc*2** - human toxicity potential – non-cancer effect **SQP*2** – land use related impacts / soil quality
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Disclaimers

*1 This impact category deals mainly with the eventual impact of low-dose ionising radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionising radiation from the soil, from radon and from some building materials is also not measured by this indicator

*2 The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator

6.4 Interpretation, LCA presentation and critical review

Evaluation

- The environmental impacts of
- Single-function sealing tapes
 - Multi-function sealing tapes

vary significantly. The differences lie in the quantities of the respective precursors and raw materials used. In particular, the aluminum hydroxide and polyurethane flexible foam used vary across the different formulations of the product groups, leading to expectations of significant variations in the results.

In the manufacturing phase, the environmental impacts of the two product groups arise primarily from the use of the raw materials and their upstream supply chains. Overall, raw materials account for approximately 80% of the environmental impacts on average.

In Scenario C4, only marginal costs are expected for physical pretreatment and landfill operation. In the case of landfilling, it is not possible to attribute impacts to individual raw materials, as the landfilled portion is set at a flat rate of 5% from Module C1.

In the thermal recycling of sealing tapes, approximately 14% of the environmental impacts arising during production can be credited to both product groups in Scenario D.

The breakdown of the key environmental impacts is shown in the diagram below.

The values obtained from the LCA calculation are suitable for the certification of buildings.

Charts

The following charts illustrate the nine key environmental indicators.

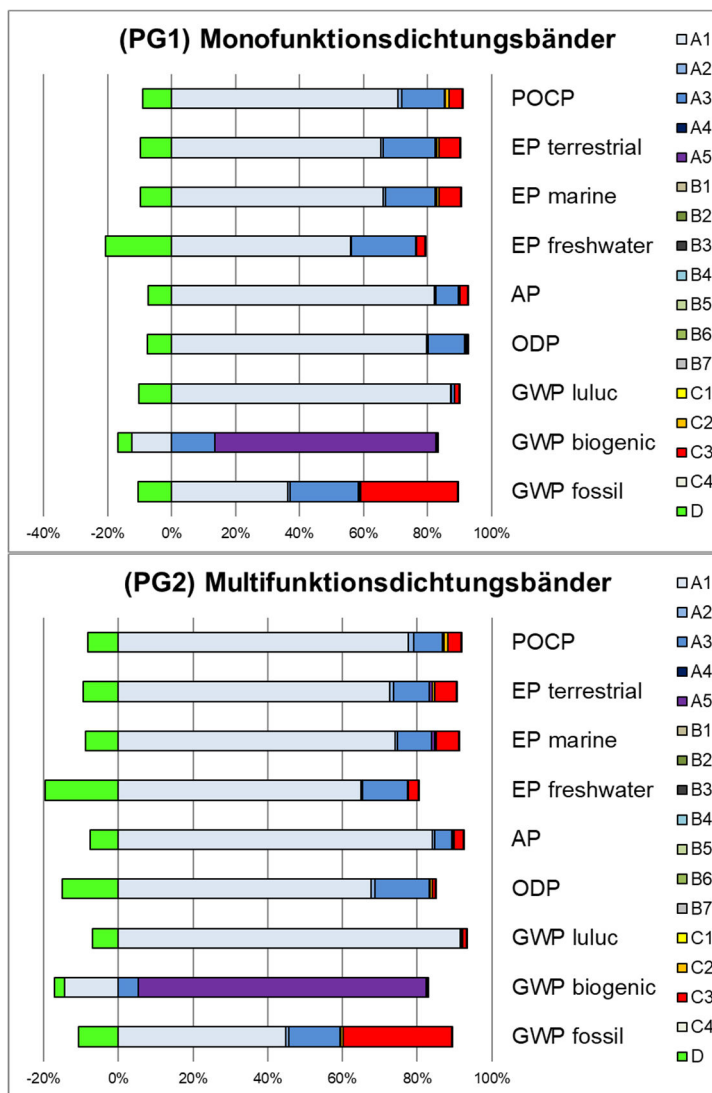


Figure 2: Percentage of the modules in selected environmental impact categories

Report

The LCA report underlying this EPD was developed according to the requirements of DIN EN ISO 14040 and DIN EN ISO 14044 as well as DIN EN 15804 and DIN EN ISO 14025. It is not addressed to third parties for reasons of confidentiality. It is deposited with the ift Rosenheim. The results and conclusions reported to the target group are complete, correct, without bias and transparent. The results of the study are not designed to be used for comparative statements intended for publication.

Critical review

The critical review of the LCA and the report took place in the course of verification of the EPD and was carried out by Prof. Dr.-Ing. Eric Brehm, an external verifier.

7 General information regarding the EPD

Comparability

This EPD was prepared in accordance with DIN EN 15804 and is therefore only comparable to those EPDs that also comply with the requirements set out in DIN EN 15804.

Any comparison must refer to the building context and the same boundary conditions of the various life cycle stages.

For comparing EPDs of construction products, the rules set out in DIN EN 15804 (Clause 5.3) apply.

The reference products included in the assessment were identified using the worst-case approach and were deemed representative of the product group. The results for individual products within the product group differ from those of the reference products. The identification of the product groups and the resulting variants are documented in the background report.

Communication

The communications format of this EPD meets the requirements of EN 15942:2012 and is therefore the basis for B2B communication. Only the nomenclature has been changed according to DIN EN 15804.

Verification

Verification of the Environmental Product Declaration is documented in accordance with the ift "Richtlinie zur Erstellung von Typ III Umweltproduktdeklarationen" (Guidance on preparing Type III Environmental Product Declarations) in accordance with the requirements set out in DIN EN ISO 14025.

The Declaration is based on the PCR documents "PCR Part A" PCR-A-2.0:2025 and "Baukörperanschluss" PCR-BA-3.0:2023

The European standard EN 15804 serves as the core PCR ^{a)}
Independent external verification of the Declaration and statement according to EN ISO 14025:2010
Independent third party verifier: ^{b)} Prof. Dr.-Ing. Eric Brehm
^{a)} Product category rules ^{b)} Optional for business-to-business communication Mandatory for business-to-consumer communication (see EN ISO 14025:2010, 9.4)

Revisions of this document

No.	Date	Note:	Practitioner	Verifier
1	27/04/2026	External verification	Hannemann	Brehm
2	30/04/2026	Correction Declaration code	Hannemann	--

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9 Annex

Description of life cycle scenarios for Sealing tapes

Product stage			Con-struction process stage		Use stage*							End-of-life stage				Benefits and loads from beyond the system boundaries
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Raw material supply	Transport	Manufacture	Transport	Construction/installation process	Use	Maintenance	Repair	Replacement	Modification/refurbishment	Operational energy use	Operational water use	Deconstruction/demolition	Transport	Waste processing	Disposal	Reuse Recovery Recycling potential
✓	✓	✓	—	✓	—	—	—	—	—	—	—	✓	✓	✓	✓	✓

* For the declared B modules, the calculation of the results is based on the specified RSL related to one year.

Table 11: Overview of applied life cycle stages

Calculation of the scenarios was based on a defined RSL (see Section 4 Use stage).

The scenarios were based on information provided by the manufacturer. The scenarios were furthermore based on the research project “EPDs for transparent building components. (1)

Note: The standard scenarios selected are presented in bold type. They were also used for calculating the indicators in the summary table.

- ✓ Included in the LCA
- Not included in the LCA

Product group: building connections

A5 Construction/installation process

No.	Scenario	Description
A5.1	Manual	According to the manufacturer the products are installed without using additional lifting and auxiliary devices
<p>In case of deviating consumption during installation/assembly of the products which forms part of the site management, they are covered at the construction works level.</p> <p>Ancillary materials, consumables, use of energy and water, use of other resources, material losses, direct emissions as well as waste materials during installation are negligible.</p> <p>It is assumed that the packaging material in the module "construction / installation" is sent to waste handling. Waste is only thermally recycled or disposed of in line with the conservative approach.</p> <p>Transport to the recycling plants is not taken into account.</p> <p>Since only one scenario is used, the results are shown in the relevant summary table.</p>		

C1 Deconstruction, demolition

No.	Scenario	Description
C1	Deconstruction	Assumption: 5% of the product remains on the construction site as construction debris and is sent to a landfill.
<p>No relevant inputs or outputs apply to the scenario selected. The energy consumed for deconstruction is negligible. Any arising consumption is marginal.</p> <p>Since only one scenario is used, the results are shown in the relevant summary table.</p> <p>In case of deviating consumption, the removal of the products forms part of the site management and is covered at the construction works level.</p>		

C2 Transport

No.	Scenario	Description
C2	Transport	<p>7.5–16-ton truck (Euro 6), diesel, with an average load of 3.29 tons, traveling 50 km from the construction site to the collection point and returning empty.</p> <p>>32-ton truck (Euro 6), diesel, with an average load of 15.96 tons, 150 km from the collection point to the recycling plant and back empty.</p>
<p>Since only one scenario is used, the results are shown in the relevant summary table.</p>		

C3 Waste management

No.	Scenario	Description	
C3	Current market situation	Plastics: 100% thermal recycling in municipal waste incineration plants (conservative estimate)	
<p>Electricity consumption of incineration plant 0.5 MJ/kg.</p> <p>As the products are placed on the European market, the disposal scenario is based on average European datasets.</p> <p>The table below describes the disposal processes and their percentage by mass/weight. The calculation is based on the above mentioned proportions in percent related to the declared unit of the product system.</p>			
C3 Disposal	Unit	PG1	PG2
Collection process, collected separately	kg	0.51	0.57
Collection process, collected as mixed construction waste	kg	0.03	0.03
Recovery system, for reuse	kg	0.00	0.00
Recovery system, for recycling	kg	0.00	0.00
Recovery system, for energy recovery	kg	0.51	0.57
Disposal	kg	0.03	0.03
<p>Since only one scenario is used, the results are shown in the summary table.</p>			

C4 Disposal

No.	Scenario	Description
C4	Disposal	The non-recordable amounts and losses within the re-use/recycling chain (C1 and C3) are modelled as “disposed” (RER).
<p>The consumption in scenario C4 results from physical pre-treatment, waste recycling and management of the disposal site. The benefits obtained here from the substitution of primary material production are allocated to module D, e.g. electricity and heat from waste incineration.</p> <p>Since only one scenario is used, the results are shown in the summary table.</p>		

D Benefits and loads from beyond the system boundaries

No.	Scenario	Description ¹
D	Recycling potential	<p>Credits from waste-to-energy plants:</p> <ul style="list-style-type: none"> • Electricity replaces electricity in the energy mix (RER); • thermal energy replaces thermal energy from natural gas (RER).

¹ Value correction factor 70.2% according to metal specific data set, 60% according to standard data set for other materials.

The values in module “D” result from recycling of the packaging material in module A5 and from deconstruction at the end of service life.

Since only one scenario is used, the results are shown in the summary table.

Imprint



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Notes

This EPD is mainly based on the work and findings of the Institut für Fenstertechnik e.V., Rosenheim (ift Rosenheim) and specifically on the "ift-Richtlinie NA-01/5 Allgemeiner Leitfadens zur Erstellung von Typ III Umweltproduktdeklarationen". (Guideline NA-01/5 - Guidance on preparing Type III Environmental Product Declarations)

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