

# ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	Kuraray Europe GmbH
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-KUR-20230072-CC11-EN
Issue date	12/05/2023
Valid to	11/05/2028

## PVB film (Trosifol®) Kuraray Europe GmbH

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ECO PLATFORM

EPD  
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**General Information**

**Kuraray Europe GmbH**

**Programme holder**

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

**Declaration number**

EPD-KUR-20230072-CC11-EN

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

Plate glass for construction and interlayers, 01/09/2022  
 (PCR checked and approved by the SVR)

**Issue date**

12/05/2023

**Valid to**

11/05/2028



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



Dipl.-Ing. Hans Peters  
 (Managing Director Institut Bauen und Umwelt e.V.)

**PVB film (Trosifol®)**

**Owner of the declaration**

Kuraray Europe GmbH  
 Philipp-Reis-Str. 4  
 65795 Hattersheim  
 Germany

**Declared product / declared unit**

Trosifol® PVB.  
 The declared unit is 1 m<sup>2</sup>.

**Scope:**

Trosifol PVB, manufactured in Troisdorf based on Mowital® resin from Frankfurt.  
 The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

The EPD was created according to the specifications of EN 15804+A2. In the following, the standard will be simplified as *EN 15804*.

**Verification**

The standard EN 15804 serves as the core PCR	
Independent verification of the declaration and data according to ISO 14025:2011	
<input type="checkbox"/>	internally
<input checked="" type="checkbox"/>	externally



Dr. Matthew Fishwick,  
 (Independent verifier)

**Product**

**Product description/Product definition**

Kuraray's polyvinyl butyral (PVB) thermoplastic films are tough, resilient safety interlayers used in laminated architectural safety glass. These Trosifol® PVB interlayers offer safety advantages by retaining dangerous shards in case of glass breakage. They are commonly used as safety glass interlayers available worldwide.

This EPD covers all Trosifol® PVB products produced in Troisdorf based on Mowital® resin produced in Frankfurt. Product codes Trosifol® B2XX and Trosifol B8XX.

For the use and application of the product, the respective national provisions at the place of use apply, in Germany, for example, the building codes of the federal states and the corresponding national specifications.

**Application**

Trosifol® PVB film needs to be laminated between two pieces of glass. This sandwich arrangement is called laminated safety glass according to EN ISO 14449. Special Trosifol® PVB grades offer additional decorative, acoustic, UV managing and structural properties.

**Technical Data**

For calculating the light, solar and heat parameters of glazing specifically containing films from the Trosifol® & SentryGlas® product range, please go to:

<https://www.trosifol.com/winslt-tool/>

Sound Control data can be found here:

<https://www.trosifol.com/soundlab-ai/>

The following data are valid for Trosifol® Clear / Trosifol® UltraClear. Other product's data can be found in our laminator brochure:

<https://www.trosifol.com/de/salessupport/downloads/produktbro>

schueren/

**Constructional data**

Name	Value	Unit
Refractive index acc. to DIN EN ISO 489	1.48	-
Thermal conductivity acc. to DIN EN 993-15	0.21	W/mK
Thermal expansion coefficient acc. to ISO 11359-2	0.00017	K <sup>-1</sup>
Specific heat capacity	1.9	kJ/kgK
Surface resistivity acc. to DIN 53482	1E+13	Ω
Tensile strength acc. to ISO 527-3	20	N/mm <sup>2</sup>
Elongation at break acc. to ISO 527-3	250	%
Tg acc. to DMA, 3K/min, 1Hz	32	°C

Performance data of the product with respect to its characteristics in accordance with the relevant technical provision (no CE-marking).

**Base materials/Ancillary materials**

The main constituents of Trosifol® PVB film are (in mass percentages):

- PVB resin ~72 %
- Plasticizer ~27-28 %
- Additives and water <1 %

- 1) This product contains substances listed in *the candidate list* (date: 17.01.2023) exceeding 0.1 percentage by mass: **no**
- 2) This product contains other Carcinogenic, Mutagenic, Reprotoxic (CMR) substances in categories 1A or 1B which are not on the candidate list, exceeding 0.1 percentage by mass: **no**
- 3) Biocide products were added to this construction product or it has been treated with biocide products (this then concerns a treated product as defined by the (EU) Ordinance on Biocide Products No. 528/2012): **no**

**Reference service life**

The reference service life is typically determined by the glass and not by the interlayer.

**LCA: Calculation rules**

**Declared Unit**

This declaration refers to the declared unit of 1 m<sup>2</sup> of PVB film (Trosifol®). The grammage of the PVB film is 0.775 kg/m<sup>2</sup>.

**Declared unit - PVB film (Trosifol®)**

Name	Value	Unit
Declared unit	1	m <sup>2</sup>
Grammage	0.775	kg/m <sup>2</sup>
Layer thickness	0.00076	m
Density	1.07	g/cm <sup>3</sup>

**System boundary**

The type of EPD is cradle-to-gate with options, modules C1–C4, and module D (A1–A3, C, D and additional module A5). In the following section, a detailed description of the specific system boundaries is given:

**Module A1 to A3:**

The product stage includes the provision of all materials,

products and energy, as well as waste processing up to the end-of-waste state or disposal of final residues during the product stage.

These modules consider the manufacturing of system components/raw materials, the transport to the production site and the production processes of the products under study. The impact of packaging materials is included.

**Module A5:**

Treatment and disposal of packaging material. Credits for potential avoided burdens due to energy substitution of electricity and thermal energy generation are declared in module D and affect only the rate of primary material (no secondary materials).

**Module C1 to C4:**

The end-of-life scenarios are as follows:

- C1 - Deconstruction/demolition: Dismantling is manual (no environmental burden).

- **C2 - Transport to treatment/disposal site:** Average transport distance from the demolition site to waste treatment is assumed as 50 km to the landfill.
- **C3 - Waste processing for reuse, recovery or recycling:** No waste processing (no environmental burden).
- **C4 - Disposal:** PVB film is 100 % landfilled.

**Module D:**

For the thermal and electrical energy generated in Module A5 due to the thermal treatment of packaging and product waste, avoided burdens have been calculated by the inversion of the electricity grid mix and thermal energy from natural gas, using European datasets.

**Geographic Representativeness**

Land or region, in which the declared product system is manufactured, used or handled at the end of the product's lifespan: Europe

**Comparability**

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account. Background datasets: *GaBi ts 10.6* software system and *GaBi Professional 2022.1* LCI database.

**LCA: Scenarios and additional technical information**

**Characteristic product properties biogenic carbon**

Biogenic carbon is only present in the packaging (wooden pallets and cartons).

Assumed water content in wooden pallets (packaging): 18 %.  
Assumed carbon content: dry wood mass consists of 50 % biogenic carbon and paper/cardboard 43 %.

The biogenic carbon content of the packaging is thus:  $0.129 \text{ kg pallet/declared unit} * 0.82 * 0.5 \text{ kg C / kg pallet (abs. dry)} + 0.082 \text{ kg} * 0.43 \text{ kg C/kg cardboard} = 0.08815 \text{ kg C/declared unit}$ .

**Information on describing the biogenic Carbon Content at factory gate**

Name	Value	Unit
Biogenic carbon content in accompanying packaging	0.08815	kg C

The following technical scenario information is required for the declared modules.

**Installation into the building (A5)**

The packaging material treatment and disposal are also considered in module A5.

Name	Value	Unit
Output substances following waste treatment on site [packaging materials per FU]	0.2301	kg

**End of life (C1-C4)**

The end-of-life scenarios are as follows:

C1 - The deconstruction of the PVB film is assumed to be done manually. Therefore, no environmental loads for the dismantling of this product are considered.

C2 - Transport to treatment/disposal site: Average transport distance from the demolition site to waste treatment is assumed as 50 km to landfill.

C4 - Disposal: The PVB film is 100 % landfilled.

Name	Value	Unit
Collected as mixed construction waste [PVB film per FU]	0.775	kg
Landfilling [PVB film per FU]	0.775	kg

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

For the thermal and electrical energy generated in Module A5 due to the thermal treatment of packaging, avoided burdens have been calculated by the inversion of the electricity grid mix and thermal energy from natural gas, using European datasets.

**LCA: Results**

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

Product stage			Construction process stage		Use stage							End of life stage				Benefits and loads beyond the system boundaries
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	X	MND	MND	MNR	MNR	MNR	MND	MND	X	X	X	X	X

**RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 m<sup>2</sup> PVB film (Trosifol®)**

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
GWP-total	kg CO <sub>2</sub> eq	3.26E+00	3.77E-01	0	2.37E-03	0	5.49E-02	-1.19E-01
GWP-fossil	kg CO <sub>2</sub> eq	3.55E+00	5.77E-02	0	2.37E-03	0	5.49E-02	-1.18E-01
GWP-biogenic	kg CO <sub>2</sub> eq	-2.95E-01	3.2E-01	0	0	0	0	-6.05E-04
GWP-luluc	kg CO <sub>2</sub> eq	5.4E-04	5.85E-06	0	9.09E-06	0	2.67E-05	-1.3E-05
ODP	kg CFC11 eq	1.91E-09	5.63E-14	0	4.84E-16	0	7.38E-14	-7.99E-13
AP	mol H <sup>+</sup> eq	4.67E-03	7.13E-05	0	7.48E-06	0	1.63E-04	-1.56E-04
EP-freshwater	kg P eq	2.99E-05	1.62E-08	0	4.71E-09	0	1.03E-05	-1.63E-07
EP-marine	kg N eq	1.47E-03	2.45E-05	0	3.5E-06	0	3.6E-05	-4.22E-05
EP-terrestrial	mol N eq	1.64E-02	3.28E-04	0	3.9E-05	0	3.95E-04	-4.52E-04
POCP	kg NMVOC eq	5.78E-03	6.56E-05	0	6.82E-06	0	1.16E-04	-1.18E-04
ADPE	kg Sb eq	1.61E-06	1.45E-09	0	2.36E-10	0	3.81E-09	-1.78E-08
ADPF	MJ	7.95E+01	1.39E-01	0	3.13E-02	0	7.79E-01	-2.01E+00
WDP	m <sup>3</sup> world eq deprived	-7.12E-01	3.87E-02	0	1.01E-05	0	-5.42E-04	-1.26E-02

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

**RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: 1 m<sup>2</sup> PVB film (Trosifol®)**

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
PERE	MJ	1.03E+01	3.42E+00	0	2.06E-03	0	6.41E-02	-5.52E-01
PERM	MJ	3.39E+00	-3.39E+00	0	0	0	0	0
PERT	MJ	1.37E+01	3.22E-02	0	2.06E-03	0	6.41E-02	-5.52E-01
PENRE	MJ	5.47E+01	6.94E-01	0	3.13E-02	0	2.5E+01	-2.01E+00
PENRM	MJ	2.48E+01	-5.55E-01	0	0	0	-2.43E+01	0
PENRT	MJ	7.96E+01	1.39E-01	0	3.13E-02	0	7.8E-01	-2.01E+00
SM	kg	0	0	0	0	0	0	0
RSF	MJ	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0
FW	m <sup>3</sup>	1.64E-02	9.16E-04	0	1.6E-06	0	1.01E-05	-5.31E-04

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

**RESULTS OF THE LCA - WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 m<sup>2</sup> PVB film (Trosifol®)**

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
HWD	kg	8.63E-08	1.17E-11	0	1.37E-13	0	1.2E-10	-2.73E-10
NHWD	kg	3.89E-02	2.29E-02	0	5.1E-06	0	7.72E-01	-1.02E-03
RWD	kg	7.58E-04	6.07E-06	0	3.94E-08	0	9.58E-06	-1.58E-04
CRU	kg	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	0	0
MER	kg	0	0	0	0	0	0	0
EEE	MJ	0	5.32E-01	0	0	0	0	0
EET	MJ	0	9.58E-01	0	0	0	0	0



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

**RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional:  
1 m<sup>2</sup> PVB film (Trosifol®)**

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
PM	Disease incidence	6.26E-08	5.26E-10	0	4.26E-11	0	1.56E-09	-1.29E-09
IR	kBq U235 eq	7.89E-02	9.02E-04	0	4E-06	0	1.41E-03	-2.68E-02
ETP-fw	CTUe	6.53E+01	8.63E-02	0	2.4E-02	0	7.63E-01	-4.41E-01
HTP-c	CTUh	9.32E-09	4.13E-12	0	4.81E-13	0	3.42E-11	-2.03E-11
HTP-nc	CTUh	4.94E-08	2.79E-10	0	2.77E-11	0	2.87E-09	-7.8E-10
SQP	SQP	4.91E+01	3.71E-02	0	9.38E-03	0	5.61E-02	-3.59E-01

PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index

Disclaimer 1 – for the indicator "Potential Human exposure efficiency relative to U235". This impact category deals mainly with the eventual impact of low-dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, radon and from some construction materials is also not measured by this indicator.

Disclaimer 2 – for the indicators 'abiotic depletion potential for non-fossil resources', 'abiotic depletion potential for fossil resources', 'water (user) deprivation potential, deprivation-weighted water consumption', 'potential comparative toxic unit for ecosystems', 'potential comparative toxic unit for humans – cancerogenic', 'Potential comparative toxic unit for humans - not cancerogenic', 'potential soil quality index'. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high as there is limited experience with the indicator.

## References

### Standards

#### DIN 53482

DIN 53482:1967-01, Testing of Insulating Materials; Determination of Electrical Resistances Values.

#### DIN EN ISO 489

DIN EN ISO 489:1999-08, Plastics - Determination of the refractive index (ISO 489:1999).

#### DIN EN 993-15

DIN EN 993-15:2005-07, Methods of test for dense shaped refractory products - Part 15: Determination of thermal conductivity by the hot-wire (parallel) method.

#### DIN EN ISO 527-3

DIN EN ISO 527-3:2019-02, Plastics - Determination of tensile properties - Part 3: Test conditions for films and sheets (ISO 527-3:2018).

#### EN 15804

EN15804:2012+A1:2013, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products.

#### EN 15804

EN 15804:2012+A2:2019+AC:2021, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products.

#### EN ISO 14449

EN 14449:2005/AC:2005, Glass in building - Laminated glass and laminated safety glass - Evaluation of conformity/Product standard.

#### ISO 11359-2

ISO 11359-2:2021-11, Plastics - Thermomechanical analysis (TMA) - Part 2: Determination of coefficient of linear thermal expansion and glass transition temperature.

#### ISO 14025

EN ISO 14025:2011, Environmental labels and declarations — Type III environmental declarations — Principles and procedures.

### Further References

#### Candidate list

Candidate List of substances of very high concern for Authorisation, published on ECHA website, latest version 17.01.2023 (<https://echa.europa.eu/candidatelist-table>)

#### GaBi

GaBi Software System and Database for Life Cycle Engineering, 1992-2021, Sphera Solutions GmbH, Leinfelden-Echterdingen, with acknowledgement of LBP University of Stuttgart, program version GaBi 10; database version 2022.1.

#### GaBi documentation

GaBi dataset documentation for the software system and databases, LBP, University of Stuttgart and Sphera Solutions GmbH, Leinfelden-Echterdingen, 2021. ([http://www.gabi-software.com/support/gabi/gabi\[1\]database-2021-lci-documentation/](http://www.gabi-software.com/support/gabi/gabi[1]database-2021-lci-documentation/))

#### IBU 2021

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

#### Ordinance on Biocide Products No. 528/2012

Regulation (EU) No 528/2012 of the European Parliament and of the Council of 22 May 2012 concerning the making available on the market and use of biocidal products

#### PCR Part A

PCR Part A: Calculation rules for the Life Cycle Assessment and Requirements on the Background Report according to EN





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