ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	**Fritz EGGER GmbH & Co. OG**
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-EGG-20140248-IBA2-EN
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Valid to	07.04.2019

EGGER sawn timber planed

EGGER Sägewerk Brilon GmbH

Institut Bauen und Umwelt e.V.

www.bau-umwelt.com / https://epd-online.com

1. General Information

EGGER Sägewerk Brilon GmbH

Programme holder
IBU - Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
Germany

Declaration number
EPD-EGG-20140248-IBA2-EN

This Declaration is based on the Product Category Rules:
Solid wood products, 07.2014
(PCR tested and approved by the SVR)

Issue date
08.04.2018

Valid to
07.04.2019

Prof. Dr.-Ing. Horst J. Bossenmayer
(President of Institut Bauen und Umwelt e.V.)

Dr. Burkhart Lehmann
(Managing Director IBU)

EGGER sawn timber planed

Owner of the Declaration
Fritz EGGER GmbH & Co. OG
Weiberndorf 20
6380 St. Johann in Tirol
Österreich

Declared product / Declared unit
1 m³ EGGER sawn timber planed

Scope:
The results of the Life Cycle Assessment are based on current data from the EGGER sawmill in Brilon. The present environmental product declaration applies to planed EGGER sawn timber from the EGGER sawmill in Brilon, Germany. This document is translated from the German Environmental Product Declaration into English. It is based on the German original version EPD-EGG-20140248-IBA1-DE. The verifier has no influence on the quality of the translation.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.

Verification

The CEN Norm /EN 15804/ serves as the core PCR
Independent verification of the declaration according to /ISO 14025/
☐ internally ☒ externally

Manfred Russ
(Independent verifier appointed by SVR)

2. Product

2.1 Product description

EGGER sawn timber is made from fresh spruce and pine logs (*Picea abies* and *Pinus sylvestris*). The logs are split along the grain to rectangular timber cross sections with at least 12 mm thickness. The drying process and the planing take place subsequently. Different ranges and qualities are differentiated by defined grading criteria. Essentially, there is grading by the strength, visually and by machine, and grading by optical and aesthetic aspects. The dry board raw density is 420 kg/m³ on average for spruce and 480 kg/m³ for pine.
The declared product is a mass-weighted average of the ranges produced.

2.2 Application

EGGER timber is used in construction for both decorative and constructive purposes. Strength-graded timber may be used for load-bearing building elements, e.g., in structural engineering, both as individual element or as lamella in a glued element, such as e.g. glue-laminated timber, plywood, or finger-jointed solid structural timber.

2.3 Technical Data

Structural engineering data

Name	Value	Unit
Wood types by trade names according to EN 1912	spruce and pine	-
Wood moisture according to EN 13183-1	12 - 18	%
Use of wood preservatives (preservatives (the test grade of the wood preservative according to DIN 68800-3 must be specified)	-	-
Compressive strength parallel according to EN 1995	17 - 26	N/mm²
Compressive strength rectangular according to EN 1995	-	N/mm²
Tensile strength parallel according to EN 1995	10 - 24	N/mm²
Tensile strength rectangular according to EN 1995	4	N/mm²
Modulus of elasticity according to EN 1995	8 - 14	N/mm²
Shear strength according to EN	32 - 4	N/mm²

1995		
Shear modulus according to EN 1995	5 - 88	N/mm²
Dimensional deviation according to EN 336	Dimension tolerance 2	mm
Length (min. - max.)	2 - 54	m
Width (min. - max.)	3 - 35	m
Height (min. - max.)	12 - 15	m
Gross density Raw density structural components according to EN 338 and DIN 1052, non-structural elements: according to DIN 68364	310 - 420	kg/m³
Surface quality (possible manifestations must be mentioned)	planed	-
Risk class according to DIN 68800-3	5	-
Thermal conductivity according to EN 12664	13	W/(mK)
Specific heat capacity according to EN 12664	16	kJ/kgK
Calculation value for thermal conductivity	-	W/(mK)
Water vapor diffusion equivalent air layer thickness according to EN ISO 12572	-	m
Water vapour diffusion resistance factor according to EN ISO 12572	-	-

The use of wood preservatives is not declared, given that no wood preservatives are used according to "DIN 68800-3".

2.4 Placing on the market / Application rules

Regulation (EU) no. 305/2011 of 9 March 2011 applies to bringing the product into circulation in the EU/EFTA, except Switzerland. The products require a declaration of performance according to EN 14081-1:2005+A1:2011 (Timber structures. Strength graded structural timber with rectangular cross section - Part 1: General requirements") and the CE marking. Relevant national regulations apply to use.
Visual strength-grading takes place pursuant to DIN 4074-1 or the BS 4978. Grading classes are assigned to European strength classes in line with EN 338 pursuant to EN 1912. The machine strength grading is done according to DIN EN 14081 Part 2 to Part 4.
Additional product certifications are based on national requirements or application rules, and are available for EGGER timber for the Australian and North-American market, among others.

2.5 Delivery status

EGGER timber is produced according to customer-specific quality requirements. The following dimensions, surfaces, and edge profiles can be executed:

Dimensions

	Minimum [mm]	Maximum [mm]
Length	1800	5400
Thickness	12	150
Width	30	350

Surface/edge profile

Product	Surface	Edges
Planed timber	dressed	sharp-edged ; planed; chamfered edged

2.6 Base materials / Ancillary materials

EGGER timber contains 100% spruce wood (*Picea abies*) or pine wood (*Pinus sylvestris*). Excipients and additives are not used.

2.7 Manufacture

The logs are delivered at the production site in Brilon and graded by quality. After debarking the logs are graded in the windrow.
In the sawing line, the logs are machined, profiled and separated with boaters into main and sideboards. After separation, the fresh timber is visually graded and packaged. Technical drying in drying chambers to a defined final moisture content takes place subsequently. This is followed by visual or machine strength grading, which precedes the planing.

The production takes place therefore in the following partial steps:
1. Log sorting
2. Debarking
3. Machining, profiling, sawing,
4. Timber
5. Packetization
6. Technical drying
7. Planing
8. Visual/machine strength grading
9. Packetization/packaging

2.8 Environment and health during manufacturing

Due to the manufacturing conditions no measures for health protection are necessary over and above the legislative and other regulations. Values are well below the occupational exposure limit (OEL) in accordance with the Hazardous Substances Ordinance ("GefStoffV") at any point of the plant.
The exhaust air created during production is purified according to the legislative stipulations. There is no impact on water or soil.
All noise levels inside and outside the production plant are far below the applicable requirements within Germany. Sections of the plant where high noise levels are produced have been shielded by suitable construction measures.

2.9 Product processing/Installation

EGGER timber can be sawed, milled, planed and drilled with all common woodworking machines, stationary machines and (electric) manual machines. Wear a respiratory mask if using hand tools without a dust extraction device.
When processing or installing EGGER timber, the usual protective equipment, suitable work clothing, safety goggles, dust mask (for dust) must be used. Observe all liability insurance association regulations for commercial processing operations.

2.10 Packaging

The packages are equipped where desired with solid wood underlays ("EAK 15 01 03"). The strapping is performed with plastic straps ("EAK 15 01 02"). Technically dried assortments are additionally

packaged with a recyclable plastic film ("EAK 15 01 02").

2.11 Condition of use
The material composition corresponds to the composition of the raw materials also during the usage period (see Section 2.6).

2.12 Environment and health during use
When the described products are used properly in accordance with the area of application, there is no risk of water, air or ground contamination according to the current state of knowledge. There are no health hazards or effects to be expected from normal use, i.e. in accordance with the intended uses.

2.13 Reference service life
No reference utilisation duration is specified.

2.14 Extraordinary effects

Fire
Building material class B2 "normally flammable" according to "DIN 4102-4"
Fire class D-s2, d0 according to "DIN EN 14081-1"

Fire protection

Name	Value
Building material class	D
Burning droplets	d0
Smoke gas development	s2

Water
No hazardous water contaminants are washed out. EGGER timber is not resistant to permanent exposure to water (standing water).

Mechanical destruction
The fracture pattern of EGGER timber has a typical solid wood appearance. The deformation is initially elastic, later plastic. A failure / breakdown is signalled by cracking and splintering of the fibres. There is no impact on the environment.

2.15 Re-use phase
In case of renovation or demolition, EGGER timber can be selectively removed and used for the same application or a different one.
Given the high calorific value of about 16 MJ / kg, energy utilization in approved plants for the generation of process energy and electricity as part of cascading use is reasonable.

2.16 Disposal
Resulting material waste as well as those from demolition activities are to be reused primarily as material. If this is not possible, they must be channelled into energy recovery. Disposal is not permitted. The waste code according to the European Waste Catalogue is "EAK 17 02 01".

2.17 Further information
Additional information on EGGER timber can be found on the Internet at: www.egger.com/schnittholz

3. LCA: Calculation rules

3.1 Declared Unit
The declaration relates to the manufacture of one cubic meter of planed timber. Planed timber has an average density of 489 kg/m³.

Specification of the declared unit

Name	Value	Unit
Declared unit	1	m³
Wood moisture at delivery	15	%
Conversion factor to 1 kg	2	-
Ground reference	489	kg/m³

3.2 System boundary
This is a "from cradle to factory gate, with options" EPD. The life cycle analysis for the products under consideration encompasses the following segments of the life cycle: “Product stage” and “Credits and charges beyond the limits of the product system”. The systems therefore encompass the following stages according to "EN 15804": Product stage (module A1-A3):

- A1 Procurement and processing of raw materials as well as processing of secondary raw materials serving as inputs
- A2 Transportation to the manufacturer
- A3 Production

Once the product has reached the *end-of-waste* status as chipped scrap wood, it is assumed that the product will be transferred to biomass incineration for the production of thermal and electrical energy. The resulting effects and credits are declared in module D. Machinery, facilities and infrastructure required in manufacturing are not taken into account.

3.3 Estimates and assumptions
The EGGER sawmill Brilon GmbH does not record resulting emissions during the drying process. According to the publication of "Rüter & Diederichs 2012" or "Wagner 2009", not insignificant emissions are to be expected, which are accordingly considered in the model. Based on these values, emissions of NMVOC, formaldehyde, acetaldehyde and methanol are to be expected. The amounts given in the publication are scaled from 1 m³ to 1 kg and calculated specifically for the declared products.
The gas used for transport by forklift is estimated by the diesel dataset in the GaBi database.
The environmental inventory of sheet steel (HDG) is used as an approximation for the saw blades, flint blade knives moulding and planing tools.
As there are no EGGER measurements for the drying emissions, these values are estimated based on "Rüter & Diederichs 2012".
The cited estimates represent estimates that are as realistic as possible. Little effect of the assessments on the overall result is to be expected.
It is assumed that the product can be reused for energy recovery with a calorific value of about 16 MJ/kg. Given that the exploitation of timber can be expected to take place in the EU area, the assumption of the substitution of thermal energy and electricity in

accordance with EU-27 Mix corresponds to realistic conditions.

3.4 Cut-off criteria

All data from the operational data collection, i.e., all input materials used for formulation, which used thermal and electrical energy, are taken into account. The shavings and off-cuts produced during the planing process are sold. Since the cashing proceeds with a total of 1.7% provide only a small contribution to the sales of the EGGER sawmill Brilon GmbH, a consideration of this by-product can be left out. The CO2 and primary energy stored in the wood of the by-products were taken into account in the model.
Staples for attaching packaging materials to the product as well as colour ink rollers for the labels are not covered in the LCA model due to their small amount.
Transport costs are included for all basic, auxiliary, and packaging materials.
The sum of the neglected material and energy levels is below 5% according to mass, energy or environmental relevance.

3.5 Background data

All relevant background datasets were taken from the database of the "GaBi 6" software (GABI 6 2013), which is not older than 10 years. The data used have been collected subject to consistent time and methodology constraints.

3.6 Data quality

For the products under review, the data were collected directly at the production site for the 2012 business year based on a questionnaire prepared by PE International, the consulting company. The input and output data were provided by EGGER and reviewed for plausibility. It can therefore be assumed that the data are highly representative.

3.7 Period under review

All primary data from the 2012 EGGER operational data collection were taken into account, i.e., starting materials used in the composition, the energy needs, and all direct production waste were included in the assessment. Actual transport distances and transport means (truck, tractor, train) were applied for inputs and outputs.

3.8 Allocation

The total production of Fritz EGGER GmbH & Co. OG in the Brilon sawmill includes not only the considered products but also other products. The values of thermal and electrical energy as well as auxiliary materials are based accordingly during data collection on the products to be declared. This allocation is made for all process steps by volume (excluding the grading process, which is based on mass allocation).
Chips, sawdust, off-cuts, bark and pine pulpwood result from the production of EGGER timber fresh. Since these by-products resulting from the production process can be sold with a market value and the production process can not be divided into more processes, a co-product allocation is applied.
A price allocation is carried out in order to assign the environmental effects to the product produced. The inherent properties of wood (storage of CO2 and primary energy content) follow a mass allocation to reflect the physical conditions in accordance with the actual conditions.
The net flows are computed by subtracting from the total product mass (timber planed 489 kg/m³) the mass that could theoretically be used in A1-A3 as waste wood for energy supply.
In the case of dried timber, this results in a total of 79 kg atro (absolute dry) waste wood during the production phase. This mass may theoretically be recycled in module A1-A3 at the end of the board service life. Thus, only the net flow of 398 kg/m³ (planed) and 388 kg/m³ with assumed equilibrium moisture content of 12% achieves module D.
Specific information about allocations in the background records can be obtained from the documentation of the GaBi databases (http://www.gabi-software.com/databases/).

3.9 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.

4. LCA: Scenarios and additional technical information

The *end of life* cycle assumes the thermal use of timber as secondary fuel, given that wood-based materials reach the end of the waste status after removal from the building.
The dismantled timber leaves the product system in module C3, with +779 kg CO2 eq and -7.86E + 3 MJ renewable primary energy as stored in the wood being exported from the product system (see "EN 16485"), which must be taken into account at a full consideration of the life cycle in accordance with needs.
The thermal use is modelled on a 100% processing rate of planed timber. This scenario represents an assumption. When using the data set in the context of the building, it is necessary to assume a realistic processing rate.
At *end of life*, the timber is burned in a biomass power plant which corresponds to the EU average. Therefore, emission factors, current decoupling, and efficiency are adapted to the EU average.

Reuse, recuperation and recycling potential (D), relevant scenarios

Name	Value	Unit
Moisture during thermal reuse	12	%
Net flow in module D (moisture 12%)	388	kg
Thermal value wood (moisture 12%)	16	MJ/kg

5. LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE NOT DECLARED)

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	MND	MND	MND	MNR	MNR	MNR	MND	MND	MND	MND	MND	MND	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 m³ sawn timber planed

Parameter	Unit	A1-A3	D
Global warming potential	[kg CO_2-Eq.]	-7.55E+2	-5.87E-2
Depletion potential of the stratospheric ozone layer	[kg CFC11-Eq.]	4.54E-10	-1.64E-7
Acidification potential of land and water	[kg SO_2-Eq.]	2.53E-1	-2.52E-1
Eutrophication potential	[kg $(PO_4)^{3-}$-Eq.]	5.12E-2	-1.81E-3
Formation potential of tropospheric ozone photochemical oxidants	[kg ethene-Eq.]	8.24E-2	3.03E-2
Abiotic depletion potential for non-fossil resources	[kg Sb-Eq.]	1.39E-5	-3.75E-5
Abiotic depletion potential for fossil resources	[MJ]	3.21E+2	-5.02E+3

RESULTS OF THE LCA - RESOURCE USE: 1 m³ sawn timber planed

Parameter	Unit	A1-A3	D
Renewable primary energy as energy carrier	[MJ]	1.45E+3	IND
Renewable primary energy resources as material utilization	[MJ]	7.86E+3	IND
Total use of renewable primary energy resources	[MJ]	9.31E+3	-7.79E+2
Non-renewable primary energy as energy carrier	[MJ]	3.32E+2	IND
Non-renewable primary energy as material utilization	[MJ]	0.00E+0	IND
Total use of non-renewable primary energy resources	[MJ]	3.32E+2	-6.56E+3
Use of secondary material	[kg]	0.00E+0	0.00E+0
Use of renewable secondary fuels	[MJ]	1.74E+3	7.86E+3
Use of non-renewable secondary fuels	[MJ]	0.00E+0	0.00E+0
Use of net fresh water	[m³]	9.48E-2	-1.50E+0

RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES: 1 m³ sawn timber planed

Parameter	Unit	A1-A3	D
Hazardous waste disposed	[kg]	1.02E-2	-5.65E-1
Non-hazardous waste disposed	[kg]	2.12E+0	4.29E+0
Radioactive waste disposed	[kg]	4.49E-3	-5.88E-1
Components for re-use	[kg]	0.00E+0	IND
Materials for recycling	[kg]	0.00E+0	IND
Materials for energy recovery	[kg]	IND	IND
Exported electrical energy	[MJ]	IND	IND
Exported thermal energy	[MJ]	IND	IND

6. LCA: Interpretation

A comparison of the previously published EPD / EPD timber 2011-2013 / and this Declaration is influenced by several aspects. The distribution and allocation of the areas covered by the Declaration from January 2013 and by the new declaration according to "EN 15804" is not directly comparable.
The sum results of modules A1-A3 of the current study are different from the sum of January 2013. This is due to

- Declaration of global warming potential exclusive biogenic CO2 in the previous EPD
- Specific modelling of the company's own biomass power plant by PE International (use of a generic data set in the previous EPD)
- Updated foreground data
- Updated data in the background data database ("GaBi 4.3" vs. "GaBi 6.3")
- Adaptation to EN 15804 compatibilit

The sawing process is analogous to the production of fresh timber. As with timber fresh, the dominance of the upstream chain of the log wood supply and the transport can also be identified as an important driver in the categories acidification (AP), eutrophication (EP), ozone depletion (ODP), summer smog (POCP), use of abiotic, fossil resources (ADPF) and of the non-renewable primary energy demand.
Unlike fresh timber, there is also a significant contribution of the energy supply to the categories acidification (AP), eutrophication (EP), global warming

potential (GWP) and the need for renewable primary energy.
The results of planed timber differed from dried timber concerning the additional demand for electricity during the planing process and the difference in the composition of the ranges considered for the averaging (variance of the density of different woods).
Electric and thermal energy are supplied by the plant's own combined heat and energy power systems, which use to a great extent biomass, therefore, a high level of renewable energy consumption occurs.

The category summer smog (POCP) is almost exclusively dominated by the emissions resulting from the drying process. As there are no EGGER measurements for the drying emissions, these values are estimated based on "Rüter & Diederichs 2012".
The use of abiotic, elemental resources is also due to the steel parts used for production.
The packaging process contributes to a very small degree to the generated effects.

7. Requisite evidence

7.1 Formaldehyde
Not relevant, no use of formaldehyde adhesives.

7.2 MDI
Not relevant, no use of MDI-based adhesives.

7.3 Toxicity of the fire gases
Not relevant.

7.4 VOC emissions
Unspecified as optional with shortened validity of EPD.

8. References

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EN 13183-1
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EN 14081-1
Timber structures - Strength graded structural timber with rectangular cross section - Part 1: General requirements; German version EN 14081-1:2005+A1:2011

EN 15686
Buildings and constructed assets -- Service-life planning; ISO 15686:2011-05

EN 1912
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EN 1995
Design of timber structures

EN 336
Structural timber - Sizes, permitted deviations; German version EN 336:2013

EN 338
Structural timber - Strength classes; German version EN 338:2009

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EN 15804
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