

# Environmental Product Declaration

for Ravaber Stone Wool Boards  
in accordance with ISO 14025 and EN 15804

**Programme:** The International EPD® System, [www.environdec.com](http://www.environdec.com)  
EPD Turkey, [www.epdturkey.org](http://www.epdturkey.org)

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**EPD Registration Number: S-P-01673**



THE INTERNATIONAL EPD® SYSTEM



ENVIRONMENTAL PRODUCT DECLARATIONS

## PROGRAMME INFORMATION

<b>Programme</b>	<p>The International EPD® System</p> <p>EPD International AB Box 210 60 SE-100 31 Stockholm Sweden</p> <p>Regional Office: EPD Turkey, Nef 09 B Blok 7/15 Kagithane/Istanbul, Turkey, www.epdturkey.org</p> <p>www.environdec.com info@environdec.com</p>
<b>Product Category Rules (PCR)</b>	<p>Construction Products and Construction Services 2012:01, version 2.3</p> <p>SUB-PCR to PCR 2012:01 Thermal Insulation Products (EN 16783:2017) Versiyon 2.2</p>
<b>PCR Review Was Conducted By</b>	<p>The Technical Committee of the International EPD® System. A full list of members available on www.environdec.com.</p> <p>Contact via: info@environdec.com</p>
<b>Verification</b>	<p>Independent verification of the declaration and data, according to ISO 14025:2006:</p> <p><input type="checkbox"/> EPD process certification <input checked="" type="checkbox"/> EPD verification</p>
<b>Third Party Verifier</b>	<p>Ing. Luca Giacomello, PMP® Corso Gamba 36 C 10144 Torino - Italy</p> <p>Approved by: The International EPD® System Technical Committee, supported by the Secretariat</p>
<b>Data Follow Up</b>	<p>Procedure for follow-up of data during EPD validity involves third party verifier:</p> <p><input type="checkbox"/> Yes <input checked="" type="checkbox"/> No</p>
<b>LCA Study &amp; EPD Design Conducted By</b>	<p>Semtrio Sustainability Consulting AND Plaza No:10-12 Kozyatagi Istanbul/Turkey www.semtrio.com</p>

The EPD owner has the sole ownership, liability, and responsibility for the EPD. EPDs within the same product category but from different programmes may not be comparable. EPDs of construction products may not be comparable if they do not comply with EN 15804.

## COMPANY INFORMATION



RAVABER Kayseri Manufacturing Plant, Turkey

The owner of the EPD - RAVABER - operates in more than 350 locations in 40 countries, being a member of the Belgium-based Ravago Group and a leader in the insulation industry by meeting the mineral rockwool requirement of an area of 20,000,000 sqm annually with its wide product range for thermal insulation, sound insulation and fire safety. RAVABER is located in Kayseri Organized Industrial Zone with its high technology equipment investments in a total area of 80,000 sqm with 56,000 sqm indoor area. RAVABER is the biggest mineral wool manufacturer in the region with an annual production capacity of 120,000 tonnes.

In addition to 25 different types of mineral rockwool products, RAVABER is producing Ceramic Wool and Agro used in soilless agriculture. RAVABER has become the only company in the sector supplying all mineral wool products in the last quarter of 2018 by starting mineral wool production with the new production line of glass wool. Ravaber, the only manufacturer that can produce all mineralwool insulation materials under the same roof, offers a wide range of products with new Ravaber bio according to various application areas. Stone wool products are labelled and sold under Ravaber® Stone Wool and Ravatherm™ brands; and also under Air-Bur Rock brand of BUR2000.

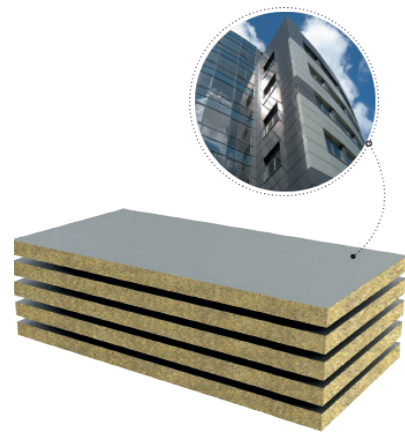


## PRODUCT INFORMATION

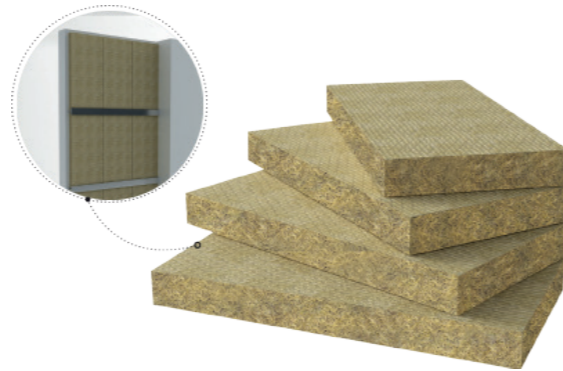
Stone wool is an insulation material which contains %98 natural fibre and obtained by transforming the minerals and inorganic volcanic stones into natural fibre by melting them at 1500-1600 °C. Stone wool performs heat insulation, sound insulation, damp insulation and fire protection in all places like roof of the houses, separating walls, outside walls, ovens, steel doors, vessels, electrical house appliances, entertainment places like cinemas.

**UN CPC code:** 37990, Non-metallic mineral products n.e.c. (including mineral wool, expanded mineral materials, worked mica, articles of mica, non-electrical articles of graphite or other carbon and articles of peat). HS Code: 6806.

**Geographical scope:** Global.



Stone wool boards with aluminium foil or glass tissue coated on one side. It ensures heat, sound and fire insulation in granite, marble, aluminium and glass claddings; and ensures fire insulation at air-conditioning surfaces.



Stone wool board without facing, used in elevator shaft, stairwells, separating walls, neighbour walls. It ensures heat, sound and fire insulation.

## TECHNICAL SPECIFICATIONS

Standard		40		50		70		90		100		110		130		150	
		kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>	kg/m <sup>3</sup>
EN 882	Legend (tolerance)	1200 mm															
EN 882	Width (tolerance)	600 mm															
EN 824	Determination of Squareness Maximum 5 mm	1 mm max.															
EN 825	Determination of Flatness Maximum 6 mm	2 mm max.															
EN 826	Compressive Strength (10% deformation)	-	-	-	-	>15	>25	>35	>45								
EN 1604	Determination of Dimensional Stability	0	0	0	0	0	0	0	0								
EN 1667	Determination of Tensile Strength Vertical to Faces	-	-	-	-	>7.5	>10	>15	>15								
EN 1609	Short Term Water Absorption WP	>1															
EN 12037	Long Term Water Absorption WP	>3															
EN 12086	Water Vapor Diffusion Resistance Coefficient μ	>1															
EN 12667	Declared Thermal Conductivity (max. 0.04 W/(m.K)	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036	0.036
EN 12667	Thermal Resistance (m <sup>2</sup> K/W) R	1.39															
EN 13501-1	Reaction to Fire	A1 Class															
	Melting Point	C 1000															

## LCA INFORMATION

**Functional unit / declared unit:** The functional unit is providing a thermal insulation on 1 sqm of product with a thermal resistance of 1 K.m<sup>2</sup>.W<sup>-1</sup>.

Declared Unit weight for 1 sqm with a thermal resistance of 1 K.m<sup>2</sup>.W<sup>-1</sup>.

Product	Density, kg/m <sup>3</sup>	Thickness, mm	Thermal Conductivity, W/m.K	Weight, kg
Stone Wool Wall Board – no facing	70	35	0.035	2.450
Stone Wool Wall Board – Aluminium Foil facing	120	35	0.035	4.320
Stone Wool Wall Board – Glass Tissue facing	120	35	0.035	4.320

**Reference service life:** N/A

**EPD Type (System Boundary):** Cradle-to-gate

**Data Collection:** Specific data (primary data) was used for the Core Module and was gathered from the RAVABER Manufacturing Plant. The manufacturing data are monitored and recorded in RAVABER data collection system specifically per unit of product. Data represents the period from 1st January 2018 to 31st October 2018. For secondary data Ecoinvent v3.5 datasets was used. LCA was modelled in SimaPro v9.0.0.31.

**Allocation:** No allocation conducted for input materials and energy consumption was collected specifically per functional unit.

**Calculation Methods:** All resource use values are calculated from Cumulative Energy Demand V1.11 in SimaPro outputs; water consumption from inventory. Potential environmental impacts are calculated with the CML-IA baseline V 3.05, in SimaPro software.

**Cut-off Rules:** Cut-off rule of 1% regarding waste and wastewater treatment was applied. Regarding to material and chemical inputs, no cut-off rule has been applied.

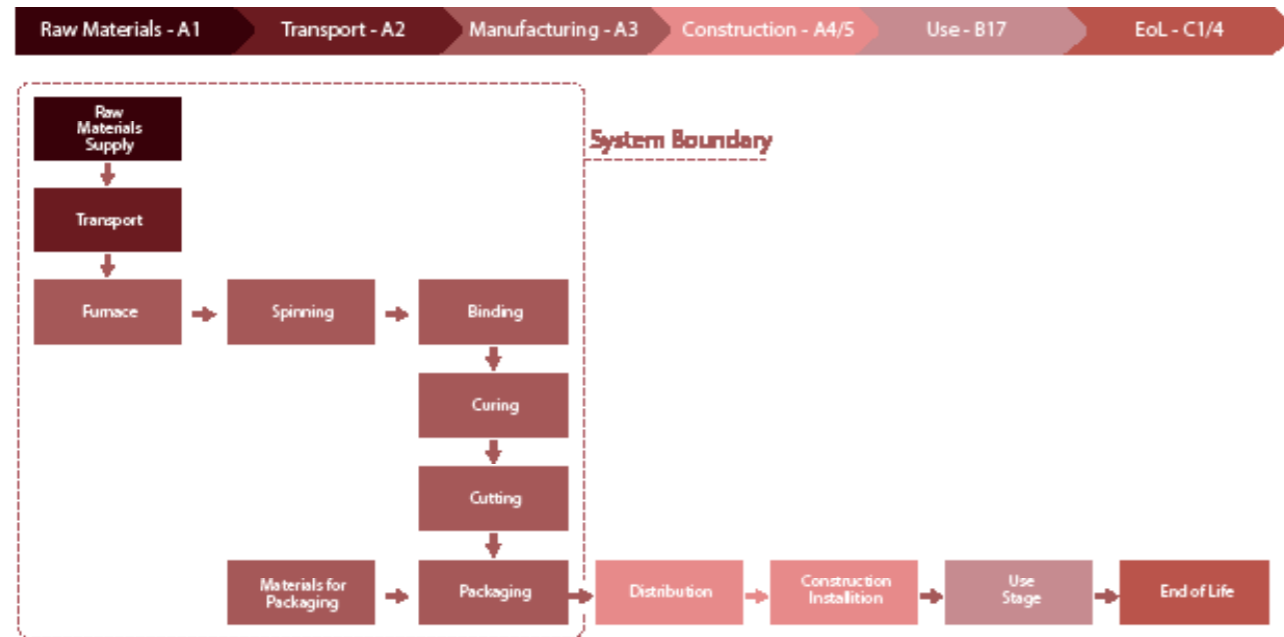
**Excluded lifecycle stages:** Downstream Processes A4/5, B1/7, C1/4 and module D are not evaluated in this LCA study. The EPD is intended to be as cradle to gate (A1 to A3). This EPD only covers the Cradle to Gate stage because other stages are very dependent on particular scenarios.

**Included life cycle stages per EN 15804:**

Product stage			Construction stage		Use stage								End of life stage				Resource recovery stage
Raw materials	Transport	Manufacturing	Transport	Construction installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal		
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D	
X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	

MND: Module not declared.

System Diagram:



Upstream Processes

**A1) Raw material supply:**

- Extraction and processing of raw materials (e.g. mining processes)
- Energy generation in the upstream processes

Glass cullet is used as secondary materials in the production system. All elementary flows at resource extraction have been included.

Core Processes

The scope of the core module is defined by the organizational boundaries and includes all activities which the manufacturing organization is in control of. In this LCA Study the core process includes transportation of raw materials to production plant, impacts generated by fuel burned in the core process, impacts due to the electricity production according the country energy mix.

**A2) Transportation:**

- External transportation to the core processes and internal transport

**A3) Manufacturing:**

- Manufacturing of the glass wool product
- Packaging materials



**CONTENT DECLARATION**

Materials	Percentage, %
Basalt, kg	75-90
Limestone, kg	30-45
Cement, kg	1-10
Formaldehyde, kg	1-8

**Packaging:** PE packaging film is used to cover the end products. Classified as Distribution Packaging: designed for the purposes of transport, handling and/or distribution.

No substances included in the Candidate List of Substances of Very High Concern for authorisation under the REACH regulations are included in composition of RAVABER's products, above the threshold for registration with the European Chemicals Agency or above 0.1 % (wt/wt).

**Basalt:** Basalt is a mafic extrusive igneous rock formed from the rapid cooling of magnesium-rich and iron-rich lava exposed at or very near the surface of a terrestrial planet or a moon. More than 90% of all volcanic rock on Earth is basalt.

**Limestone:** Limestone is a carbonate sedimentary rock that is often composed of the skeletal fragments of marine organisms such as coral, foraminifera, and molluscs. Its major materials are the minerals calcite and aragonite, which are different crystal forms of calcium carbonate.

**Cement:** A cement is a binder, a substance used for construction that sets, hardens, and adheres to other materials to bind them together. There are two main forms of cement: Geopolymer cement and Portland Cement.

**Formaldehyde:** Formaldehyde is a naturally occurring organic compound with the formula CH<sub>2</sub>O. It is the simplest of the aldehydes. The common name of this substance comes from its similarity and relation to formic acid.

## ENVIRONMENTAL PERFORMANCE of Stone Wool Board / No Facing

PARAMETERS		UNIT	TOTAL A1 to A3
<b>USE OF RESOURCES</b>			
Primary energy resources – Renewable	Use as energy carrier	MJ, net calorific value	43.7
	Used as raw materials	MJ, net calorific value	0.00
	<b>TOTAL</b>	MJ, net calorific value	43.7
Primary energy resources – Non-renewable	Use as energy carrier	MJ, net calorific value	40.3
	Used as raw materials	MJ, net calorific value	0.00
	<b>TOTAL</b>	MJ, net calorific value	40.3
Secondary material		kg	0.00
Renewable secondary fuels		MJ, net calorific value	0.00
Non-renewable secondary fuels		MJ, net calorific value	0.00
Net use of fresh water		m <sup>3</sup>	0.009
<b>POTENTIAL ENVIRONMENTAL IMPACTS</b>			
Global warming potential (GWP)		kg CO <sub>2</sub> eq.	3.23
Depletion potential of the stratospheric ozone layer (ODP)		kg CFC 11 eq.	1.90E-07
Acidification potential (AP)		kg SO <sub>2</sub> eq.	0.016
Eutrophication potential (EP)		kg PO <sub>4</sub> <sup>3-</sup> eq.	0.001
Formation potential of tropospheric ozone (POCP)		kg C <sub>2</sub> H <sub>4</sub> eq.	0.003
Abiotic depletion potential – Elements		kg Sb eq.	3.17E-06
Abiotic depletion potential – Fossil resources		MJ, net calorific value	36.2
<b>WASTE PRODUCTION AND OUTPUT FLOWS</b>			
Hazardous waste disposed		[kg]	1.43E-04
Non-hazardous waste disposed		[kg]	0.045
Radioactive waste disposed		[kg]	0.00
Components for reuse		[kg]	0.00
Material for recycling		[kg]	0.348
Materials for energy recovery		[kg]	0.00
Exported energy, electricity		[MJ]	0.00

## ENVIRONMENTAL PERFORMANCE Stone Wool Board / AI Facing

PARAMETERS		UNIT	TOTAL A1 to A3
<b>USE OF RESOURCES</b>			
Primary energy resources – Renewable	Use as energy carrier	MJ, net calorific value	45.6
	Used as raw materials	MJ, net calorific value	0.00
	<b>TOTAL</b>	MJ, net calorific value	45.6
Primary energy resources – Non-renewable	Use as energy carrier	MJ, net calorific value	67.2
	Used as raw materials	MJ, net calorific value	0.00
	<b>TOTAL</b>	MJ, net calorific value	67.2
Secondary material		kg	0.00
Renewable secondary fuels		MJ, net calorific value	0.00
Non-renewable secondary fuels		MJ, net calorific value	0.00
Net use of fresh water		m <sup>3</sup>	0.013
<b>POTENTIAL ENVIRONMENTAL IMPACTS</b>			
Global warming potential (GWP)		kg CO <sub>2</sub> eq.	5.56
Depletion potential of the stratospheric ozone layer (ODP)		kg CFC 11 eq.	3.23E-07
Acidification potential (AP)		kg SO <sub>2</sub> eq.	0.027
Eutrophication potential (EP)		kg PO <sub>4</sub> <sup>3-</sup> eq.	0.002
Formation potential of tropospheric ozone (POCP)		kg C <sub>2</sub> H <sub>4</sub> eq.	0.005
Abiotic depletion potential – Elements		kg Sb eq.	4.07E-06
Abiotic depletion potential – Fossil resources		MJ, net calorific value	59.5
<b>WASTE PRODUCTION AND OUTPUT FLOWS</b>			
Hazardous waste disposed		[kg]	1.43E-04
Non-hazardous waste disposed		[kg]	0.045
Radioactive waste disposed		[kg]	0.00
Components for reuse		[kg]	0.00
Material for recycling		[kg]	0.348
Materials for energy recovery		[kg]	0.00
Exported energy, electricity		[MJ]	0.00

## ENVIRONMENTAL PERFORMANCE Stone Wool Board / Glass Tissue Facing

PARAMETERS	UNIT	TOTAL A1 to A3	
<b>USE OF RESOURCES</b>			
Primary energy resources – Renewable	Use as energy carrier	MJ, net calorific value	45.0
	Used as raw materials	MJ, net calorific value	0.00
	<b>TOTAL</b>	MJ, net calorific value	45.0
Primary energy resources – Non-renewable	Use as energy carrier	MJ, net calorific value	66.5
	Used as raw materials	MJ, net calorific value	0.00
	<b>TOTAL</b>	MJ, net calorific value	66.5
Secondary material	kg	0.00	
Renewable secondary fuels	MJ, net calorific value	0.00	
Non-renewable secondary fuels	MJ, net calorific value	0.00	
Net use of fresh water	m <sup>3</sup>	0.016	
<b>POTENTIAL ENVIRONMENTAL IMPACTS</b>			
Global warming potential (GWP)	kg CO <sub>2</sub> eq.	5.48	
Depletion potential of the stratospheric ozone layer (ODP)	kg CFC 11 eq.	3.11E-07	
Acidification potential (AP)	kg SO <sub>2</sub> eq.	0.027	
Eutrophication potential (EP)	kg PO <sub>4</sub> <sup>3-</sup> eq.	0.002	
Formation potential of tropospheric ozone (POCP)	kg C <sub>2</sub> H <sub>4</sub> eq.	0.005	
Abiotic depletion potential – Elements	kg Sb eq.	4.99E-06	
Abiotic depletion potential – Fossil resources	MJ, net calorific value	59.6	
<b>WASTE PRODUCTION AND OUTPUT FLOWS</b>			
Hazardous waste disposed	[kg]	1.43E-04	
Non-hazardous waste disposed	[kg]	0.045	
Radioactive waste disposed	[kg]	0.00	
Components for reuse	[kg]	0.00	
Material for recycling	[kg]	0.348	
Materials for energy recovery	[kg]	0.00	
Exported energy, electricity	[MJ]	0.00	

## CONTACT INFORMATION

### Third party verifier:

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Accredited or approved by: The International EPD® System

### Owner of the Declaration

Ravaber Yapı Ürünleri San. Tic. A.Ş.  
Organize San. Böl. 20. Cad. No: 54  
Kayseri / TURKEY



### LCA Author & EPD Design

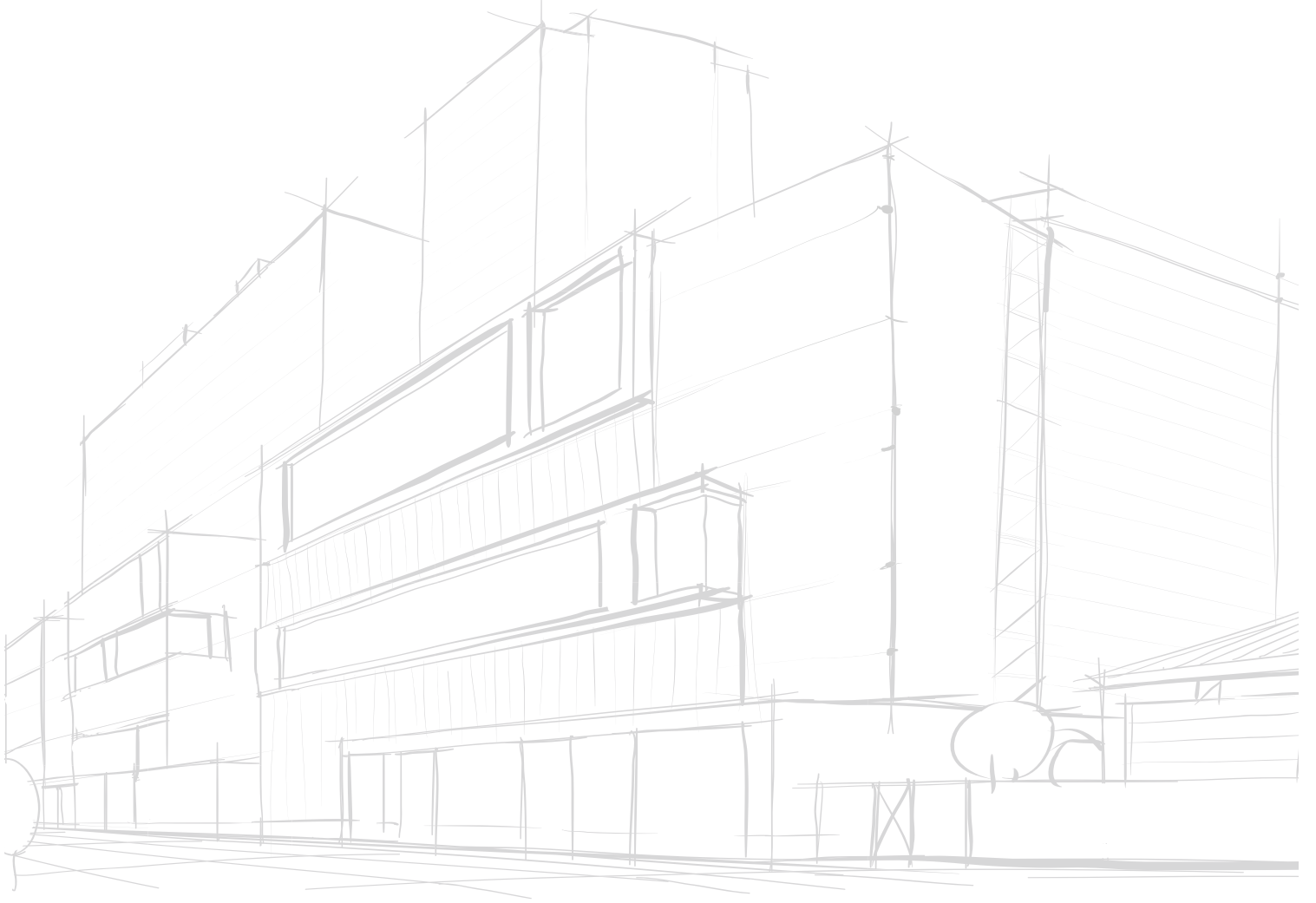
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### References

- Declaration of Performance (DoP) and CE marking / [https://ec.europa.eu/growth/sectors/construction/product-regulation/performance-declaration\\_en](https://ec.europa.eu/growth/sectors/construction/product-regulation/performance-declaration_en)
- Ecoinvent 3.5 / <http://www.ecoinvent.org/>
- Eurima - European Insulation Manufacturers Association / <https://www.eurima.org/about-mineral-wool/production-process.html>
- ISO 14040: 2006 Environmental management -- Life cycle assessment -- Principles and framework
- ISO 14044: 2006 Environmental management -- Life cycle assessment -- Requirements and guidelines
- ISO 14025: 2006 Environmental labels and declarations -- Type III environmental declarations -- Principles and procedures
- Ravaber / <http://www.ravaber.com/en/index.php>
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- The International EPD® System / [www.environdec.com](http://www.environdec.com)
- The International EPD® System / PCR 2012:01 Construction products and construction services (EN 15804:A1) / <https://www.environdec.com/PCR/Detail/?Pcr=%208098>
- The International EPD® System / Sub-PCR-I Thermal insulation products (EN 16783) / <https://www.environdec.com/PCR/Detail/?Pcr=12883>

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