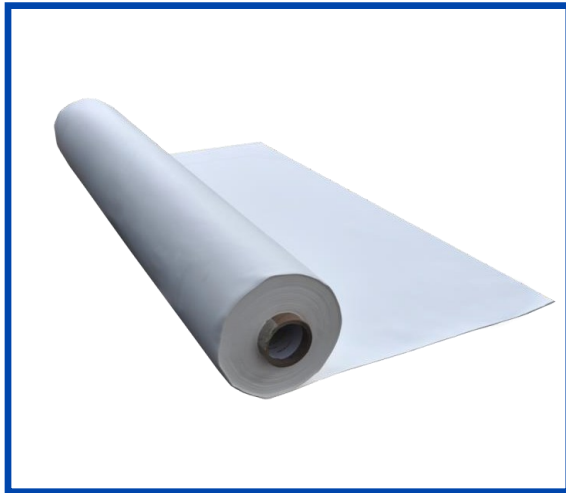


Duro-Last® EV Fleece| Single-Ply PVC Roof Membrane



| | |
|---------------------------|---|
| Company Name | Amrize Building Envelope d/b/a Duro-Last. |
| Product Type | Single-ply PVC roofing |
| Product Name | Duro-Last® EV Fleece 60-mil and 80-mil |
| Manufacturing Site | 525 Morley Drive Saginaw, MI 48601 |
| EPD Scope | Cradle-to-gate |
| Declared Unit | 1 m ² |
| Product Colors | white |

Company Information

Duro-Last (recently acquired by Amrize Building Envelope) began in 1978 with the simple need to find a roofing system that worked. Existing roofing systems presented a common problem — they required ongoing maintenance and continual expense, with no long-term solution in sight. Our Founder, John R. Burt, used his experience in fabricating pool liners to develop a remarkable new roofing membrane. Investigation of the roofing industry proved that the majority of roofing system failures then were not due to the roofing system assembly itself but to workmanship on-site. To solve this problem, we brought our roofing system “in-house,” developing custom prefabrication methods and specialized equipment that allows us to complete nearly all of the difficult roof details and up to 85% of field seams. The result is lower on-site labor costs and better installation quality.

Product Description




The Duro-Last® EV PVC roof membrane is a proprietary thermoplastic formulation that provides a highly reflective, durable, and superior quality product. An 18 x 9 weft-inserted anti-wicking knit scrim laminated between two layers of PVC film gives the membrane its strength and durability. Duro-Last EV contains Elvaloy® KEE (Ketone Ethylene Ester), a polymer manufactured by DuPont™ that provides non-migrating flexibility in roofing membranes. This molecule may replace plasticizers in roofing products, and when mixed with PVC, provides resistance to chemical attack, weather resistance, long-term flexibility, durability, and resistance to microbial growth. This EPD applies to the white Duro-Last EV single-ply membrane in 60-mil and 80-mil nominal thicknesses. The Duro-Last EV membrane was engineered to be used with the complete line of Duro-Last EV precision-fabricated flashings for curbs, stacks, and parapets. Duro-Last EV can be applied by a Duro-Last certified contractor using various methods, including mechanically fastened, Duro-Bond® induction welding, or fully adhered. The fleece offers enhanced adhesion characteristics between the membrane and the substrate. Nearly all Duro-Last EV membrane installations are inspected by Duro-Last’s certified Quality Assurance Technical Representatives

ENVIRONMENTAL PRODUCT DECLARATION

According to ISO 14025:2006 and ISO 21930:2017



ENVIRONMENTAL PRODUCT DECLARATION VERIFICATION

| EPD Information | | | |
|--|-----------------------------|--|--------------------------------|
| Program Operator | | NSF International | |
| Declaration Holder | | Amrize | |
| Product Duro-Last® EV 50-mil, 60-mil, 80-mil | Date of Issue 12/06/2021 | Valid Until 12/06/2026 | Declaration Number EPD10856 |
| This EPD was independently verified by NSF International in accordance with ISO 14025 and ISO 21930: <input type="checkbox"/> Internal <input checked="" type="checkbox"/> External | |  Tony Favilla afavilla@nsf.org | |
| This life cycle assessment was independently verified by in accordance with ISO 14044 and the reference PCR: | |  Jack Geibig jgeibig@ecoform.com | |
| LCA Information | | | |
| EPD Project report | | A Cradle-to-Gate Life Cycle Assessment of Duro-Last's Single-ply PVC Roofing Membranes, December 2021 | |
| LCA Preparer  | | Lindita Bushi Ph.D., Mr. Jamie Meil and Mr. Grant Finlayson Athena Sustainable Materials Institute 280 Albert Street, Suite 404 Ottawa, Ontario, Canada K1P 5G8 info@athenasmi.org www.athenasmi.org | |
| This EPD project report was critically reviewed in accordance with ISO 14025, ISO 14040/44, and the reference PCR by: | | Jack Geibig jgeibig@ecoform.com | |
| PCR Information | | | |
| Program Operator | | NSF International | |
| Reference PCR | | NSF International, Product Category Rules for Preparing an Environmental Product Declaration for Single Ply Roofing Membranes | |
| Date of Issue | | October 2019 | |
| PCR review was conducted by: | | Thomas P. Gloria, Ph.D. (Chair), Industrial Ecology Consultants Mr. Jack Geibig, EcoForm Mr. Bill Stough, Sustainable Research Group | |

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 Valid Until: 01/04/2027
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Product Specifications

| Physical Property | Test Method | ASTM 4434 Requirement for Type III Sheet | 60-mil Result | 80-mil Result |
|------------------------|-----------------------|---|---------------|---------------|
| Overall Thickness | ASTM D751 | ≥ 0.045 in. | PASS | PASS |
| Thickness Over Scrim | ASTM D7635 | ≥ 0.016 in. | PASS | PASS |
| Breaking Strength | ASTM D751 Grab Method | ≥ 200 lbf./in. | PASS | PASS |
| Elongation | ASTM D751 Grab Method | ≥ 15% | PASS | PASS |
| Seam Strength | ASTM D751 Grab Method | ≥ 317 lbf. (75% of Breaking Strength) | PASS | PASS |
| Tear Strength | ASTM D751 Procedure B | ≥ 45 lbf. | PASS | PASS |
| Low Temp. Bend | ASTM D2136 | Must pass at -40° F. | PASS | PASS |
| Heat Aging | ASTM D3045 | Conditioned for 56 days in oven maintained at 176° F. | PASS | PASS |
| Accelerated Weathering | ASTM G155 | 10,000 hours total test time. Irradiance level of 0.35 W/m ² -340nm. Cycle: 102 minutes light, 18 minutes light + H ₂ O spray, 63±2.5° C black panel, 30±5% RH | PASS | PASS |
| Dimensional Stability | ASTM D1204 | Conditioned for 6 hours in oven maintained at 176° F. Allowable change: ≤ 0.5% | PASS | PASS |
| Water Absorption | ASTM D570 | Immersed in water at 158° F for 168 hours. Allowable change: ≤ 3% | PASS | PASS |
| Static Puncture | ASTM D5602 | ≥ 33 lbf. | PASS | PASS |
| Dynamic Puncture | ASTM 5635 | ≥ 14.7 ft.-lbf. (20 J) | PASS | PASS |

Additional Testing Requirements

Duro-Last EV has met or exceeded all major fire and wind code requirements, and regional approvals as necessary throughout the country. Duro-Last EV has been approved by Factory Mutual as a 1-60, 1-90, 1-165, and 1-915 roofing system. Duro-Last is also listed by Underwriters Laboratories as a Class A, B, & C approved material.

Further testing information and results can be found in the Specs & Technical Info section of the Duro-Last website at duro-last.com.

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Date of Issue: 01/04/2022
Valid Until: 01/04/2027
Declaration#: EPD10856

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Life Cycle Stages

Figure 1 shows the life-cycle stages and information modules that are included within the cradle-to-gate LCA system boundary of this EPD. The boundary is “cradle-to-gate”, including the Production stage (A1 to A3 modules). Construction, Use, and End-of-Life stages - are excluded from the system boundary. The Production stage system boundary is shown in Figure 3. Per ISO 21930, 7.1.7.2.1 [3], the system boundary with nature (natural environment) includes those technical processes that provide the material and energy inputs into the system and the subsequent manufacturing and transport processes up to the factory gate, as well as the processing of any waste arising from those processes.

Figure 1: Life cycle stages and modules

| Production stage | | | Construction stage | | Use stage | | | | | | | End-of-life stage | | | |
|---|----------------------|---------------|--------------------|--------------|-----------|-------------|--------|-------------|---------------|------------------------|-----------------------|-----------------------------|---|------------------|-------------------|
| Extraction and upstream production | Transport to factory | Manufacturing | Transport to site | Installation | Use | Maintenance | Repair | Replacement | Refurbishment | Operational Energy Use | Operational Water Use | De-Construction/ Demolition | Transport to waste processing or disposal | Waste processing | Disposal of waste |
| A1 | A2 | A3 | A4 | A5 | B1 | B2 | B3 | B4 | B5 | B6 | B7 | C1 | C2 | C3 | C4 |
| X | | | MND | | | | | | | | | | | | |
| X- module is included in system boundary; MND- module is not declared (excluded from system boundary) | | | | | | | | | | | | | | | |

System Boundary

The PVC single-ply membrane is manufactured through an extruding process. Two layers of PVC sheet are laminated together with knit scrim reinforcement between. The polyester scrim is knit onsite at the manufacturing plant. The extruder manufactures master rolls of material which are then cut to length into smaller rolls. Internal off-spec scraps and edge trim cut from rolls during manufacturing are ground and compounded back into other processes; no external scrap is used in the membrane. Any off-spec or surplus scrap is sent to the Duro-Last sister company, Oscoda Plastics®, where it is recycled into resilient flooring and concrete expansion joints.

The purchased electricity used at the facility is primarily used by process equipment like the calender, laminator, extruder, and roll converters. The laminator uses an electrostatic precipitator, a particulate collection device that removes aerosol plasticizers released during manufacturing. There is also a 1,110,000 BTU capacity 2.2.2 induced draft crossflow cooling tower. Natural gas supplied to the plant is used by IR heaters on the extruder and laminators and space conditioning, while propane is used by fork trucks to internally transport products and materials. The calender equipment uses a small amount of water as non-contact cooling water. The water does not come into contact with any chemicals; therefore, there is little to no risk of contamination. VOC emissions from the manufacturing process are calculated based on the amount of product manufactured and stack testing that took place when the equipment was installed. Minimal VOCs are produced during manufacturing which exempts the extruder from requiring any pollution abatement equipment. Figure 2 represents the inputs, outputs, and processes within the system boundary.

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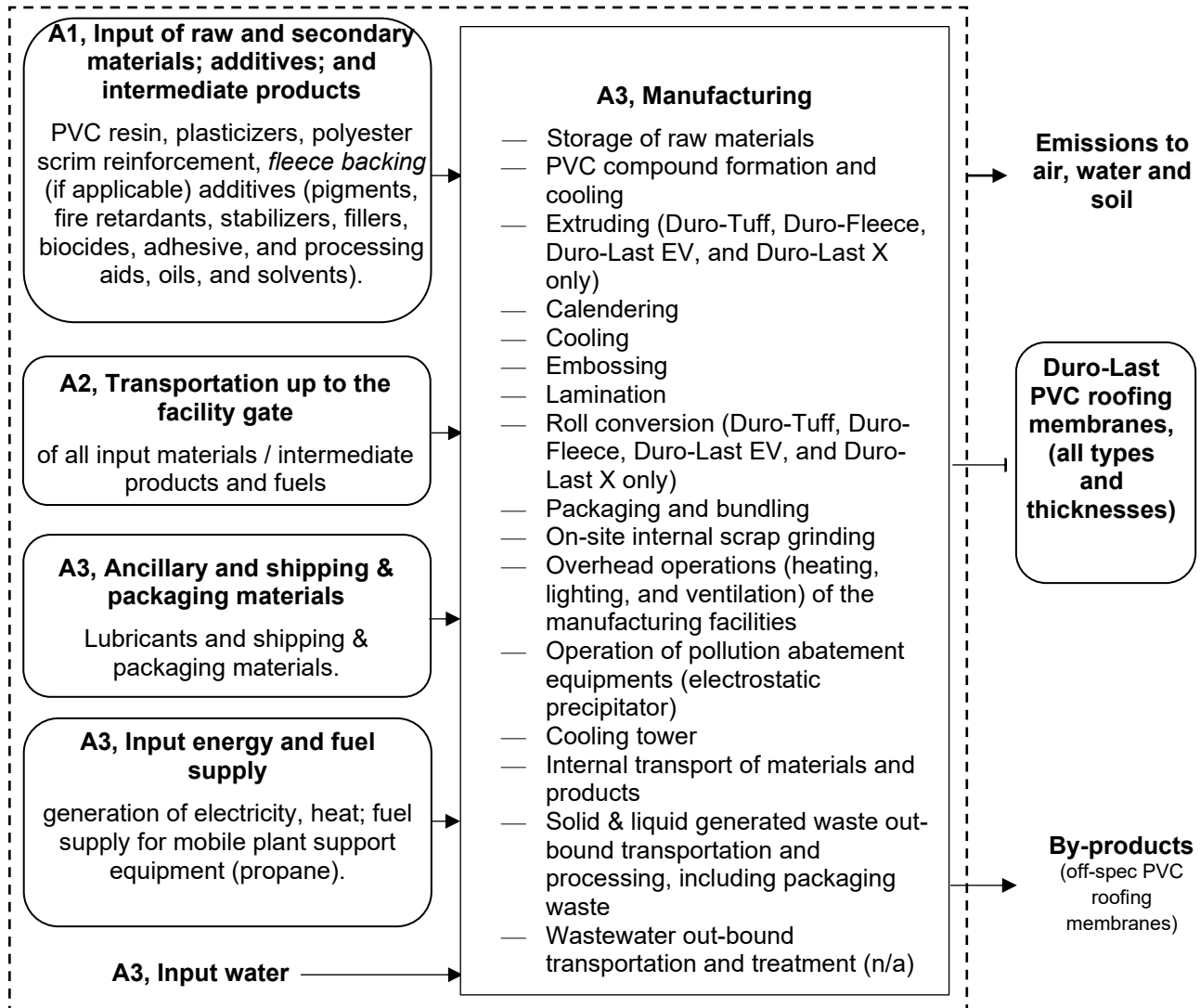
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Valid Until: 01/04/2027
Declaration#: EPD10856

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Figure 2: Product stage system boundary



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Date of Issue: 01/04/2022
 Valid Until: 01/04/2027
 Declaration#: EPD10856

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Cut-off Rules

The cut-off criteria as per NSF PCR, Section 7.1.6 [6] and ISO 21930, 7.1.8 [3], were followed. All input/output data reported by the Saginaw, MI manufacturing plant were included in the LCI modelling. None of the reported flow data were excluded based on the cut-off criteria. No substances with hazardous and toxic properties that pose a concern for human health and/or the environment were identified in the framework of this EPD. Any plant-specific data gaps for the reference year (e.g., input hydraulic fluids, lubricants, greases, or heated oil) were filled with generic plant data from 2018. Duro-Last confidentially provided Safety Data Sheet (SDSs) for each additive, e.g., plasticizer, fire retardant, stabilizer, fleece backing, etc. As appropriate, any data gaps in the SDS are filled in with proxy and conservative generic LCI datasets.

This EPD excludes the following processes:

- Capital goods and infrastructure flows; and
- Personnel related activity (travel, furniture, office operations and supplies).

Data Quality

The LCA project report provides a detailed description of collected data and the data quality assessment regarding the NSF PCR requirements and ISO 14044. Data quality is assessed based on its representativeness (technology coverage, geographic coverage, time coverage), completeness, consistency, reproducibility, transparency, and uncertainty (Table 1).

Table 1. Data Quality Requirements and Assessments

| Data Quality Requirements | Description |
|---------------------------|--|
| Technology Coverage | Data represents the prevailing technology at the Saginaw, MI facility. Whenever available, North American typical or average industry LCI datasets were utilized for all upstream and core material and processes. <i>Technological representativeness is characterized as "high".</i> |
| Geographic Coverage | The geographic region considered is the U.S. <i>Geographical representativeness is characterized as "high".</i> |
| Time Coverage | Activity data are representative. - Roofing membrane manufacturing process - primary data collected for the reference year 2020 (12 months) - In-bound/ out-bound transportation data- primary data collected for reference year 2020 (12 months) - Polyester scrim reinforcement production- U.S. industry data for the reference year 2010 (12 months) - Fleece backing data- SDS and confidential data provided by Duro-Last (2021) - Generic data: the most appropriate LCI datasets were used as found in the US LCI Database, ecoinvent v.3.5 database for the US and Global, 2018. <i>Temporal representativeness is characterized as "medium" to "high".</i> |
| Completeness | All relevant, specific processes, including inputs (raw materials, energy, and ancillary materials) and outputs (emissions and production volume), were considered and modelled. The relevant background materials and processes were taken from the US LCI Database (adjusted for known data placeholders), ecoinvent v 3.5 LCI database for the US, and modelled in SimaPro software v.9.2, 2021. The completeness of the cradle-to-gate process chain in terms of process steps is rigorously assessed for all membranes and documented in the project report. |

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Date of Issue: 01/04/2022
Valid Until: 01/04/2027
Declaration#: EPD10856

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| Data Quality Requirements | Description |
|---------------------------|--|
| Consistency | To ensure consistency, the input/output LCI modelling of the PVC single-ply roofing membranes used the same LCI modelling structure, which consisted of input raw, secondary (if applicable), ancillary, and packaging materials, intermediate products, energy flows, water resource inputs, product outputs, co-products, by-products, emissions to air, water and soil, and solid and liquid waste disposal. Crosschecks concerning the plausibility of mass and energy flows were continuously conducted. The LCA team conducted mass and energy balances at the facility level and selected process levels to maintain a high level of consistency. |
| Reproducibility | Internal reproducibility is possible since the data and the models are stored and available in the <i>Athena Duro-Last LCI database</i> developed in SimaPro, 2021. A high level of transparency is provided throughout the report as the LCI profile is presented for each of the declared products and primary upstream inputs. The supporting LCA project report summarizes key primary (manufacturer specific) and secondary (generic) LCI data sources. |
| Transparency | Activity and LCI datasets are transparently disclosed in the project report, including data sources. |
| Uncertainty | A <i>sensitivity check</i> was conducted to assess the reliability of the EPD results and conclusions by determining how they are affected by uncertainties in the data or assumptions on the calculation of LCIA and energy indicator results. The sensitivity check includes the results of <i>sensitivity analysis</i> and <i>Monte Carlo uncertainty analysis of background data sets</i> . |

Allocation

Per NSF PCR, Section 7.2 [6], allocation, if required, shall follow the requirements and guidance of ISO 14044:2006, Section 4.3.4 and ISO 21930, Section 7.2.5.

The Saginaw, MI manufacturing facility produces other co-products besides selected membranes, and as such and as per the PCR, allocation based on the mass of membrane products was necessary. "Mass" based, plant-specific formulation for 1m² of PVC roofing membranes were used to calculate the input raw the ancillary materials consumed. "Mass" was used as the physical parameter for allocating flows between the products of interest and other co-products to calculate the input energy flows (electricity, natural gas, propane, etc.), shipping and packaging materials, lubricants, hydraulic fluid, greases, and heating oil, total water consumption, process emissions to air and waste flows. No burden is allocated to the by-product of the declared product system, such as off-spec PVC roofing membranes. In addition, allocation related to transport is based on the mass of transported inputs and outputs.

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Date of Issue: 01/04/2022
Valid Until: 01/04/2027
Declaration#: EPD10856

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Product Material Content & Packaging

Tables 2 and 3 represent the formulation for the three declared products, consisting of polyester scrim reinforcement between a top and bottom layer of PVC film, fleece backing and the packaging materials. The membrane is rolled onto cardboard cores and stored on wood pallets with Styrofoam roll guards. Each pallet typically holds four rolls and is secured with plastic banding.

Table 2: Formulation for 1 m² of 60-mil and 80-mil Duro-Last EV fleece backed membrane

| Raw Material Input | 60-mil | 80-mil |
|---|-------------------------|-------------|
| | % weight of the product | |
| PVC resin | 38% | 41% |
| Plasticizer | 25% | 27% |
| Polyester scrim reinforcement | 17% | 13% |
| Fleece fabric | 10% | 8% |
| Pigment | 3% | 3% |
| Flame retardant | <1% | <1% |
| Others – stabilizer, filler, processing aids, biocide | 6% | 6% |
| Total | 100% | 100% |

Note: Total may not add to 100 due to rounding.

Table 3: Packaging materials for 1m² of 60-mil and 80-mil Duro-Last EV fleece backed membrane

| Packaging Material | Quantity (kg) |
|--------------------|---------------|
| Wooden pallet | 0.10 |
| Cardboard core | 0.04 |
| Total | 0.14 |



Life Cycle Assessment Results

Table 4 presents the “cradle-to-gate” LCA results for 1 m² of Duro-Last EV PVC membrane for each nominal thickness.

As per the NSF PCR, the US EPA Tool for the Reduction and Assessment of Chemical and Other Environmental Impacts (TRACI), version 2.1, 2012 impact categories are used as they provide a North American context for the mandatory category indicators to be included in this EPD. *These are relative expressions only and do not predict category impact endpoints, the exceeding of thresholds, safety margins or risks [4], [5].* Additional mandatory resource use, waste categories and output flows are also reported per the PCR. *It is also noted that a number of LCA impact categories and inventory items are still emerging and/or under development and can have high levels of uncertainty that preclude international acceptance pending further development. Use caution when interpreting data in these categories: RPRE, RPRM, NRPRE, NRPRM, SM, RSF, NRSF, RE, HWD, NHWD, HLRW, ILLRW, CRU, MR, MER, EE” [6].*

Table 4: LCA results for 1 m² of 60-mil and 80-mil PVC membrane- Product Stage (A1-A3)

| Impact category and inventory indicators | Unit | Duro-Last® EV PVC membrane Production stage (A1 to A3) | |
|---|-----------------------|--|---------|
| | | 60 mils | 80 mils |
| Global warming potential, GWP 100 ¹⁾ | kg CO ₂ eq | 6.8 | 8.7 |
| Ozone depletion potential, ODP ¹⁾ | kg CFC-11 eq | 8.3E-07 | 1.1E-06 |
| Smog formation potential, SFP ¹⁾ | kg O ₃ eq | 0.36 | 0.47 |
| Acidification potential, AP ¹⁾ | kg SO ₂ eq | 0.034 | 0.044 |
| Eutrophication potential, EP ¹⁾ | kg N eq | 0.065 | 0.087 |
| Fossil fuel depletion, FFD ¹⁾ | MJ surplus | 15.6 | 19.7 |
| Abiotic depletion potential, fossil ADPf ²⁾ | MJ LHV | 119.0 | 150.3 |
| Renewable primary resources used as an energy carrier (fuel), RPRE | MJ LHV | 6.6 | 8.8 |
| Renewable primary resources with energy content used as material, RPRM ³⁾ | MJ LHV | - | - |
| Non-renewable primary resources used as an energy carrier (fuel), NRPRE | MJ LHV | 90.5 | 113.3 |
| Non-renewable primary resources with energy content used as material, NRPRM ³⁾ | MJ LHV | 43.6 | 56.1 |
| Secondary materials, SM ³⁾ | kg | 0 | 0 |
| Renewable secondary fuels, RSF ³⁾ | MJ LHV | - | - |
| Non-renewable secondary fuels, NRSF ³⁾ | MJ LHV | - | - |
| Recovered energy, RE ³⁾ | MJ LHV | - | - |
| Consumption of freshwater, FW ³⁾ | m ³ | 1.4E-03 | 2.2E-03 |
| Hazardous waste disposed, HWD ³⁾ | kg | 5.2E-03 | 7.9E-03 |
| Non-hazardous waste disposed, NHWD ³⁾ | kg | 1.5E-02 | 2.2E-02 |
| High-level radioactive waste, conditioned, to the final repository, HLRW ^{3) 4)} | m ³ | 7.4E-09 | 9.4E-09 |

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| Impact category and inventory indicators | Unit | Duro-Last® EV PVC membrane Production stage (A1 to A3) | |
|--|----------------|--|---------|
| | | 60 mils | 80 mils |
| Intermediate- and low-level radioactive waste, conditioned, to the final repository, ILLRW ³⁾⁴⁾ | m ³ | 1.1E-07 | 1.4E-07 |
| Components for re-use, CRU ³⁾ | kg | - | - |
| Materials for recycling, MR ³⁾ | kg | 0.056 | 0.067 |
| Materials for energy recovery, MER ³⁾ | kg | - | - |
| Recovered energy exported from the product system, EE ³⁾ | MJ LHV | - | - |

Notes:

- ¹⁾ Calculated as per U.S EPA TRACI 2.1, v1.05, SimaPro v 9.2 [10]. GWP 100, excludes biogenic CO₂ removals and emissions associated with biobased products, including bio-based packaging. There is no biogenic content in the declared products. CO₂ emissions from calcination and carbonation are not applicable to the declared products; 100-year time horizon GWP factors are provided by the IPCC 2013 Fifth Assessment Report (AR5), TRACI 2.1, v1.05 [10]. FFD is required in LEED V4.1 MR Credit: Building Product Disclosure and Optimization – Environmental Product Declarations [12].
- ²⁾ Calculated as per CML-IA Baseline V3.05, SimaPro v 9.2. ADP_f is also required in LEED V4.1 MR Credit: Building Product Disclosure and Optimization – Environmental Product Declarations [12].
- ³⁾ Calculated as per ACLCA ISO 21930 Guidance [11], respective sections 6.2 to 10.8.
- ⁴⁾ It should be noted that the foreground system (Duro-Last roofing membrane manufacturing process) does not generate any HLRW or ILLRW. High, intermediate or low-level radioactive waste is generated by electricity production (spent fuel from reactors, routine facility maintenance and operations)" (ISO 21930:2017, clause 7.2.14).
- ⁵⁾ "N/A for this product system. "Not all LCA datasets for upstream materials include these impact categories, and thus results may be incomplete. Use caution when interpreting data in these categories" [6].

Interpretation

The above represents a cradle-to-gate life cycle assessment for 1 m² of Duro-Last EV fleece backed single-ply scrim reinforcement PVC roofing membrane in the nominal thicknesses of 60-mil and 80-mil. Across all the declared membranes, Module A1 *Extraction and upstream material input production* contributes the largest share of the LCIA category and energy indicator results – accounting for between 75% (smog) and 95% (eutrophication) of the potential environmental burdens. Module A2 *Transportation* contributed around 18% of the smog-related emissions, but was otherwise, a minor contributor (<10%) to the overall impact of membrane manufacture. Module A3 *Manufacturing* contributed 18% to non-renewable primary energy and is the second-largest contributor (<14%) to the overall potential environmental impacts of the membrane manufacture. Primary energy consumption is predominately fossil fuels at 96%. The industry standard scrim reinforcement is 9 x 9 threads per square inch, whereas Duro-Last reinforces its membrane with a high-strength weft-inserted polyester scrim with an 18 x 9 pattern. The high-density yarn helps improve the membrane's durability, strength, and longevity but may also increase the carbon footprint.

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Date of Issue: 01/04/2022
Valid Until: 01/04/2027
Declaration#: EPD10856

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Additional Environmental Information

- The Duro-Last EV membrane is NSF 347 Sustainability Assessment for Single-Ply Roofing Conformant certified.
- The white Duro-Last EV membrane complies with efficiency programs requiring the use of a highly reflective roof like California Title 24, U.S. Green Building Council's (USBGC) Leadership in Energy and Environmental Design (LEED) rating system, the International Green Construction Code (IgCC), IECC, and Green Building Institute's Green Globes. It is also an ENERGY STAR® qualified product.
- The membrane is up to 100% recyclable. Post-industrial scrap from the manufacturing process is recycled into the new membrane, walk-way pads, concrete expansion joints and resilient flooring.
- Duro-Last EV white reflective roofs, when designed and installed properly, can help increase energy efficiency, especially the building's peak energy demand.
- Cool Roof Rating Council Product ID: 0610-0011.
 - Solar Reflective Index (initial value): 108.

Declaration Type

This "Cradle-to-gate" EPD applies to the Duro-Last EV PVC roofing membrane (all colours) 50, 60, and 80 mils nominal thicknesses. Production activities covered include the *extraction and upstream production, transport to factory, manufacturing* (modules A1 to A3). The declaration is intended for Business-to-Business (B-to-B) communication.

The two declared thicknesses (50 and 60 mils), Duro-Last EV PVC roofing membrane falls under the description:

- *A product-specific EPD from a manufacturer's plant.*

EPD Comparability Limitation Statement

- *Only EPDs prepared from cradle-to-grave life cycle results and based on the same function, RSL, quantified by the same functional unit, and meeting all the conditions for comparability listed in ISO 14025:2006 and ISO 21930:2017 can be used to make comparison between products.*
- *Declarations based on the NSF Product category rules are not comparative assertions; that is, no claim of environmental superiority may be inferred or implied.*

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Date of Issue: 01/04/2022
Valid Until: 01/04/2027
Declaration#: EPD10856

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