accoya®



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Environmental Product Declaration (EPD)

OWNER OF DECLARATION:	ACCSYS
ACCOYA WOOD PRODUCTS:	ACCOYA ROUGH SAWN ACCOYA PLANED ACCOYA FINGER JOINT ACCOYA FOR TRICOYA
PROGRAM OPERATOR:	SCS GLOBAL SERVICES 2000 POWELL STREET, STE. 600, EMERYVILLE, CA 94608 +1.510.452.8000 SCSGLOBALSERVICES.COM
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Declaration owner:	Accsys
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Declaration Number:	SCS-EPD-10639
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Program Operator:	SCS Global Services, 2000 Powell Street, Ste. 600, Emeryville, CA 94608 USA
Declaration URL:	www.scsglobalservices.com/certified-green-products-epd
General Program Instructions:	SCS Type III Environmental Declaration Program Operator Manual, v12.0, December 2023
Product(s):	Accoya® Wood
Declared Unit:	One (1) cubic metre of rough sawn wood
Product's Intended Application and Use:	For use in building, windows, doors, decking and cladding
Product Warranty:	50 years above ground and 25 years in ground or fresh water
Market Applicability:	Global
EPD Type:	Product specific
EPD Scope:	Cradle-to-gate with End-of-Life Module D
Year(s) of Reported Manufacturer Primary Data:	2024–2025
LCA Software & Version Number:	OpenLCA v2.5.0
LCI Database & Version Number:	Ecoinvent v3.11, Ecoinvent 3.11 EN 15804 Add-on
LCIA Methodology & Version:	EF 3.1
Reference PCR:	PCR 2019:14. Construction products (EN 15804+A2) v2.0.1. EPD International. Published 06-05-2025. Valid until 04.07.2030
PCR review	PCR review was conducted by: The Technical Committee of the International EPD System. See www.environdec.com for a list of members. Review chairs: Rob Rouwette (chair) Noa Meron (co-chair). The review panel may be contacted via the Secretariat www.environdec.com/contact
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Independent critical review of the LCA and data, according to ISO 14044 and the PCR:	☐ Internal ☒ External
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Independent verification of the declaration and data, according to ISO 14025:	☐ Internal ☒ External
EPD Verifier:	Lindita Bushi Lindita Bushi, Ph.D., Athena Sustainable Materials Institute

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DISCLAIMERS

An EPD should provide current information and may be updated if conditions change. The stated validity is therefore subject to continuing registration and publication.

Conformity
This EPD conforms to ISO 14025:2006, EN 15804.

Ownership
The EPD owner has the sole ownership, liability, and responsibility of the EPD.

Accuracy
Due to PCR constraints, this EPD provides averages of potentially most or inherently limited terms of accuracy.

Comparability
The PCR this EPD was based on was not written to support comparative assertions. EPDs based on different PCRs, or different calculation models, may not be comparable. When attempting to compare EPDs or life cycle impacts of products from different companies, the user should be aware of the uncertainty in the final results, due to and not limited to, the practitioner's assumptions, the source of the data used in the study, and the specifics of the product modeled. In accordance with EN 15804, EPDs are comparable only if they comply with the core PCR, use the same sub-category PCR where applicable, include all relevant information modules and are based on equivalent scenarios with respect to the context of construction works. The owner of the declaration shall be liable for the underlying information and evidence; SCS shall not be liable with respect to manufacturer information, life cycle assessment data, and evidence supplied or made available to SCS.

1. Accsys Technologies

With over 20 years of innovation and expertise, Accoya stands as the global leader for high-performance wood.

Our patented modification process enables wood to withstand harsh exterior elements and accentuates its natural beauty, strength and character.

Acetylation Process



Accsys proprietary acetylation technology

Acetylation is a proven science for modifying wood, permanently transforming the cell structure to create wood that is virtually unaffected by the intake of water. We have perfected our exclusive manufacturing process to produce the best option in performance building materials.

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2. Product

2.1 Product Description



WOOD THAT STAYS TRUE

Accoya remains structurally sound with virtually no movement before, during and after decades after the job is complete.

- High usability of boards that stay straight before and after installation
- So dimensionally stable that even harsh environments will not impact installation
- Three to four times less swelling than traditional wood species
- Minimal movement that keeps projects looking great

WOOD THAT IS GUARANTEED TO LAST

Accoya solves the problem of deterioration in any climate, giving you the confidence that you made the right choice.

- 50-year warranty above ground
- 25-year warranty in ground or fresh water
- Certified for use in termite zones and 22 times more resistant than pine
- 60-year service life (verified by BRE) demonstrating significantly higher durability with real world testing

WOOD TO CHANGE THE WORLD

Accoya has the environmental credentials to enable sustainable construction.

- Peace of mind with the knowledge that all Accoya comes from FSC® (C012330) and other certified sustainable forests
- One of the few building materials certified Cradle to Cradle® at the Gold Level
- Non toxic and 100% recyclable

WOOD WITHOUT COMPROMISE

Accoya is the ultimate workable material trusted by craftsmen to deliver in any project.

- Excellent machinability, easy to work with, no special tools required
- The best of both worlds, improved density and hardness without sacrificing strength
- Leave natural for exquisite grain patterns or create a unique finish of your choice

Sustainability

All of our wood is FSC® certified (CO12330). This ensures that the forests we source from are replenished, responsibly managed and ecosystems are respected, and high human rights standards are upheld.

Responsible sourcing commitment

We continue to support no net deforestation. We specifically source from fast growing pine species that are fast growing and highly carbon efficient. The New Zealand climate, where our timber is majority sourced provides ideal growing conditions and quality standards.

Best in class durability

The acetylation process gives Accoya outstanding durability in any climate, locking in carbon from the atmosphere for longer. This resilience prolongs its useful life, reducing carbon emissions associated with maintenance, repair and replacement.

Responsible manufacturing

Accoya is manufactured to the highest safety, quality and environmental standards and is Cradle to Cradle Certified® Gold, a globally-recognised, multi-attribute standard which credits safe, circular, and responsibly-made products and materials.

We purchase Renewable Energy Certificates (RECs) to cover over 50% of our electricity manufacturing emissions, with a commitment to cover 100% by the end of 2027. These renewable energy credits are included in the EPD figures below. In addition, we offset over 50% of our non-electric manufacturing emissions and 25% of our Cradle to Gate emissions, including transport of raw materials, supporting verified renewable electricity projects worldwide. Offsetting is not reflected in the EPD figures below.



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Accoya Applications



CLADDING

Accoya's exceptional stability means fewer installation issues and a longer-lasting, high-quality finish. With wide boards, versatile surface texturing options through sawing, brushing, and charring, and a broad range of coatings, Accoya offers complete creative flexibility with no compromise on performance.

WINDOWS & DOORS

More durable than hardwood, Accoya comes in fixed-width sections that reduce waste, while the wide choice of coatings unlock endless design possibilities. A superior thermal performance and long service life make Accoya the smart, future-focussed solution for beautiful windows and doors.





DECKING

Resistant to distortion in even the harshest of climates, Accoya's superior durability ensures decking performs year after year. High stability means decking can be laid with smaller gaps and an even surface, making it the most barefoot-friendly option available. Low maintenance, Accoya decking has no need for coatings or frequent repairs.

2.2 Technical

Table 1. Declared unit and reference flows for the product systems under study.

Name	Unit	Accoya Wood
Declared Unit	n/a	1m^3 of product
Mass	kg	515

Accsys's Accoya Wood products belong to the CSI code 06 00 00 for Wood, Plastics and Composites and the UNSPSC code 11121600 for Wood.

2.3 FLOW DIAGRAM

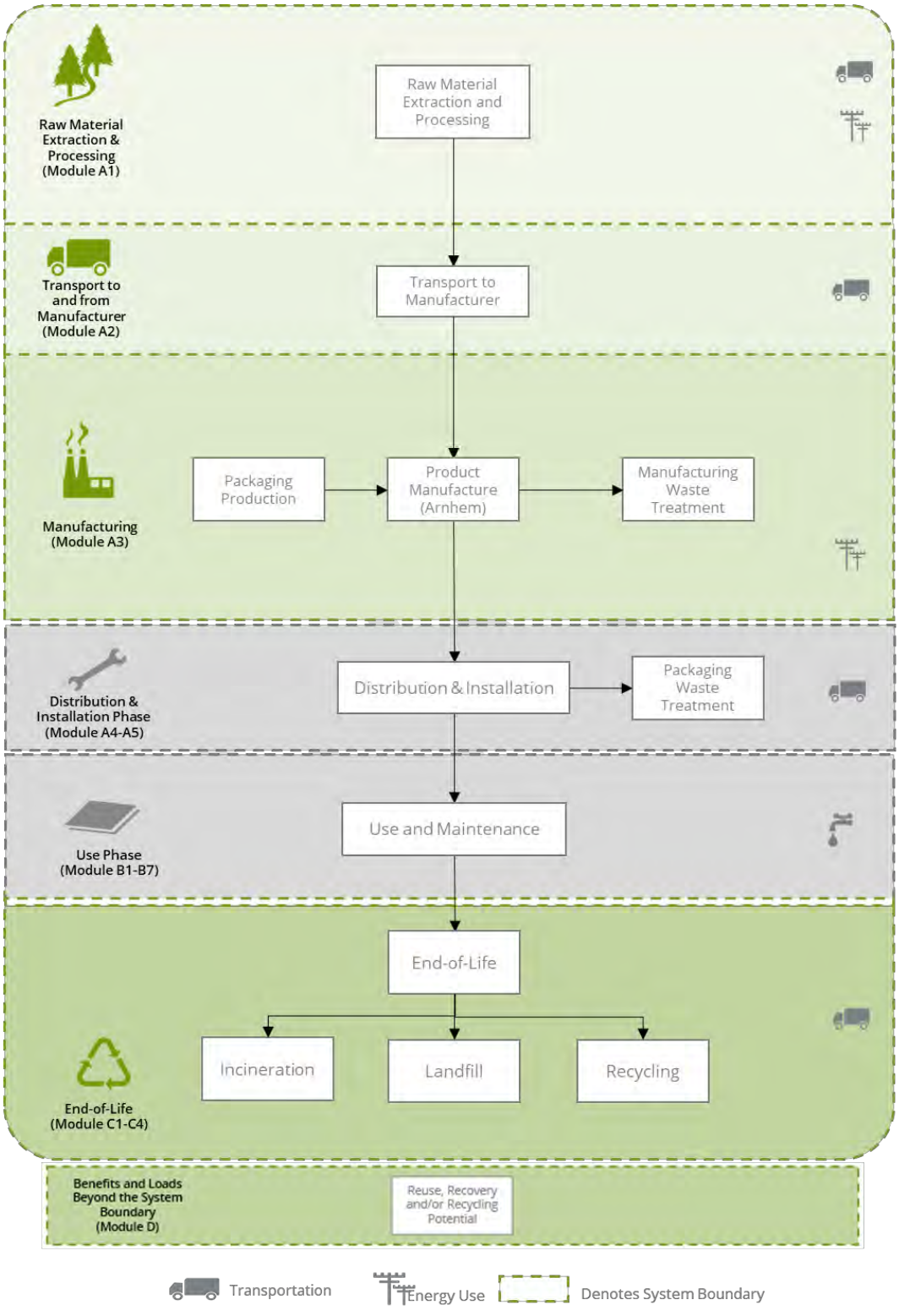


Figure 2. *Flow diagram and system boundaries for the life cycle of the Accoya Wood products produced at Arnhem.*

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2.4 APPLICATION

Accoya Wood products are ideal for outdoor applications such as decking, cladding, and windows.

2.5 DECLARATION OF METHODOLOGICAL FRAMEWORK

The scope of the EPD is cradle-to-gate with end-of-life, including raw material extraction and processing; raw material transportation; product manufacture, and end-of-life

Manufacturing resource use was allocated to the products based on economic value. Impacts from transportation were allocated based on the mass of material and distance transported.

Processes contributing greater than 1% of the total environmental impact indicator for each impact are included in the inventory. No known flows were deliberately excluded from this EPD.

2.6 MATERIAL COMPOSITION

Accoya Wood products are mainly composed of wood, which is treated with acetic anhydride. Wood and acetic anhydride are procured from various sources.

Table 2. *Material component summary for all Accoya Wood products produced at Arnhem*.

Raw Materials	% Mass Final Product
Acetylated Wood	>99%
Acetic acid	<1%
Total:	**100%**

2.7 TRANSPORTATION

Transportation for the LCA model is based on data provided by the manufacturer for transport from the component manufacturer (1st tier supplier) to the production facility. Transportation data for 2nd tier suppliers (material supplier to component manufacturer) are based on data embedded in the representative LCI datasets. Road transport is assumed to be by diesel truck and ocean transport is assumed to by container ship.

2.8 MANUFACTURE

At the Arnhem facility, timber is brought onto the site and undergoes stickering and (sometimes) cutting and pre-drying in preparation for the reaction process. The timber is placed into a reactor with acetic anhydride and undergoes a vacuum-pressure impregnation acetylation process which takes roughly 18 hours and requires heating up to 155 °C. After this, the wood is dried in a kiln before being distributed as Accoya Wood.

2.9 PACKAGING

All Accoya products are packaged using polyethylene strapping. There is no biogenic carbon content in the packaging.

Table 3. *Packaging material summary for all Accoya products per declared unit*.

Packaging Material	Mass (kg)	% Mass	% Post-Consumer Recycled Content	Biogenic Material (kgC)
Polyethylene	7.28×10^{-3}	100%	100%	0.00
Total:	**7.28×10^{-3}**	**100%**	**100%**	**0.00**

2.13 END-OF-LIFE

In the absence of primary data on end-of-life disposal of the Accoya products, an average disposal scenario was designed based on the primary regions in which the products are sold. Regional statistics were sourced from Eurostat. Transportation to the appropriate waste treatment facility was assumed to be 130km for waste bound for incineration and 80km for waste bound for non-incineration waste treatment, in line with the PCR.

Table 4. *End-of-Life summary for the Accoya products.*

End-of-life		Unit	Accoya Arnhem
Assumptions for scenario development			Average disposal scenario based on waste treatment statistics from primary regions products sold into
Collection process	Collected separately	kg	0.00
	Collected with mixed construction waste	kg	515
Recovery	Recycling	kg	283
	Incineration	kg	35.0
Disposal	Product of material for final deposition	kg	197
Removals of biogenic carbon (excluding packaging)		kg CO2	827

2.14 RE-USE. RECOVERY, AND RECYCLING POTENTIAL (Module D)

Module D evaluates the environmental impacts of net flows of recovered materials (recycled or reused) or recovered energy after said material/energy has left the product system. Since the primary raw material inputs to the Accoya product system are 100% virgin wood, and a portion of the finished products are recycled at end-of-life, the results for module D indicate net benefit. Note that this module D calculation only includes the product waste at end-of-life, and no additional internal scrap is considered a secondary material. Equation D.6 (below) from EN 15804 was used to calculate the impact for the substitution of virgin wood with recycled wood in a subsequent product system.

$$e_{module\ D1} = \sum i\ (M_{MRout}|_i - M_{MRin}) \times (E_{MR\ after\ EoW\ out}|_i - E_{VMSub\ out}|_i \times \frac{Q_{R\ out}}{Q_{Sub}}|_i)$$

Based on the disposal scenario designed in the LCA report, 6.8% of Accoya products will be incinerated in Europe. The efficiency for waste-to-energy incineration was found to be 25%, well under the 60% efficiency target set by EN 15804. As such, module D2 is assumed to be zero.

In module D3 and module D4, the product end-of-waste process takes place within the system boundary and exits as exported energy (as heat and/or electricity).

3. Methodological Framework

3.1 DECLARED UNIT

The declared unit used in this study is 1m^3 of acetylated wood. Accoya Wood includes a 50-year warranty for 'above ground' use and 25 year warranty for in ground use. See Table 2.

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3.2 SYSTEM BOUNDARY

Table 5. *System boundary for the Accoya product system*

	Product			Construction Process		Use							End-of-life				Resource Recovery
	A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
	Raw material extraction and processing	Transport to manufacturer	Manufacturing	Transport	Construction - installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction demolition	Transport	Waste processing	Disposal	Reuse, recovery and/or recycling potential
Module Declared	X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	X	X	X	X	X
Geography	Europe			-		-							Europe				Europe
Share of Specific Data	98%			-		-	-	-	-	-	-	-	-	-	-	-	-

X = Module Included | MND = Module Not Declared

The share of primary data is calculated based on GWP-GHG results. It is a simplified indicator for data quality that supports the use of more primary data, to increase the representativeness of and comparability between EPDs. Note that the indicator does not capture all relevant aspects of data quality and is not comparable across product categories

3.3 ALLOCATION

Manufacturing resource use was allocated to the products based on economic value. Impacts from transportation were allocated based on the mass of material and distance transported.

The post-consumer recycled wood used to produce the Accoya for Tricoya product was allocated using the recycled content allocation method (also known as the 100-0 cut off method). Using the recycled content allocation approach, system inputs with recycled content do not receive any burden from the previous life cycle other than reprocessing of the waste material. At end-of-life, materials which are recycled leave the system boundaries with no additional burden.

3.4 CUT-OFF RULES

According to the PCR, processes contributing greater than 1% of the total environmental impact for each indicator are included in the inventory. No data gaps were allowed which were expected to significantly affect the outcome of the indicator results.

3.5 DATA SOURCES

Primary data were provided by Accsys for their manufacturing facility. The principal source of secondary LCI data was the Ecoinvent v3.11 EN15804 Add-on database. Some primary and secondary data were also collected from Accsys' suppliers.

- Raw materials and packaging: Ecoinvent v3.11 EN15804 Add-on database
- Acetic anhydride: LCI and LCIA data from suppliers
- Transport: Ecoinvent v3.11 EN15804 Add-on database
- Manufacturing Inputs: Ecoinvent v3.11 EN15804 Add-on database
- Facility waste treatment: Ecoinvent v3.11 EN15804 Add-on database
- End-of-life waste treatment: Ecoinvent v3.11 EN15804 Add-on database

3.6 DATA QUALITY

The data quality assessment addressed the following parameters: time-related coverage, geographical coverage, technological coverage, precision, completeness, representativeness, consistency, reproducibility, sources of data, and uncertainty.

Table 6. *Data quality assessment.*

Data Quality Parameter	Data Quality Discussion
Time-Related Coverage: Age of data and the minimum length of time over which data is collected	The manufacturer provided primary data on product manufacturing for: ▪ 12-month period from April 1st, 2024 through March 31st, 2025 for the Arnhem facility Representative datasets (secondary data) for upstream and background processes are generally less than 10 years old.
Geographical Coverage: Geographical area from which data for unit processes is collected to satisfy the goal of the study	The data used in the analysis provide the best possible representation available with current data. Electricity use for product manufacture is modeled using representative data modeled for the specific electricity grids represented in this study. Proxy data used in the assessment are representative of global or region-specific operations and are considered sufficiently similar to actual processes.
Technology Coverage: Specific technology or technology mix	For the most part, data are representative of the actual technologies used for processing, transportation, and manufacturing operations. Representative component datasets, specific to the type of material, are used to represent the actual processes, as appropriate.
Precision: Measure of the variability of the data values for each data expressed	Precision of results are not quantified due to a lack of data. Data collected for operations were typically averaged for one year, which is expected to reduce the variability of results.
Completeness: Percentage of flow that is measured or estimated	The LCA model included all known mass and energy flows for production of the products. In some instances, proxy data used to represent upstream and downstream operations may be missing some data which is propagated in the model. No known processes or activities contributing to more than 1% of the total environmental impact for each indicator are excluded.
Representativeness: Qualitative assessment of the degree to which the data set reflects the true population of interest	Data used in the assessment represents typical or average processes as currently reported from multiple data sources and are therefore generally representative of the range of actual processes and technologies for production of these materials. Considerable deviation may exist among actual processes on a site-specific basis; however, such a determination would require detailed data collection throughout the supply chain back to resource extraction.
Consistency: Qualitative assessment of whether the study methodology is applied uniformly to the various components of the analysis	The consistency of the assessment is considered to be high. Data sources of similar quality and age are used; with a bias towards Ecoinvent v3.11 data where available. Different portions of the product life cycle are equally considered.

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Data Quality Parameter	Data Quality Discussion
Reproducibility: Qualitative assessment of the extent to which information about the methodology and data values would allow an independent practitioner to reproduce the results reported in the study	Based on the description of the data and assumptions used, this assessment would be reproducible by other practitioners. All assumptions, models, and data sources are documented.
Sources of the Data: Description of all primary and secondary data sources	Data representing energy use at the facility represent a 12-month average and are considered of high quality due to the length of time over which these data are collected, as compared to a snapshot that may not accurately reflect fluctuations in production. For secondary LCI data, Ecoinvent v3.11 data are used.
Uncertainty of the Information: Uncertainty related to data, models, and assumptions	Uncertainty related to materials in the products and packaging is low. Actual supplier data for upstream operations was available for some suppliers. For other suppliers, the study relied upon the use of existing representative datasets. These datasets contained relatively recent data (<10 years) but lacked geographical representativeness. Uncertainty related to the impact assessment methods used in the study are high. The impact assessment methodology includes impact potentials, which lack characterization of providing and receiving environments or tipping points.

3.7 PERIOD UNDER REVIEW

Manufacturer supplied data (primary data) are based on the following:

- 12-month period from April 1st, 2024 through March 31st, 2025 for the Arnhem facility

3.8 COMPARABILITY AND BENCHMARKING

The PCR this EPD was based on was not written to support comparative assertions. EPDs based on different PCRs, or different calculation models, may not be comparable. When attempting to compare EPDs or life cycle impacts of products from different companies, the user should be aware of the uncertainty in the final results, due to and not limited to, the practitioner's assumptions, the source of the data used in the study, and the specifics of the product modeled. Additionally, EPDs of construction products may not be comparable if they do not comply with EN 15804+A2:2019.

Additionally, EPDs within the same product category but published in different EPD programs, may not be comparable. For two EPDs to be comparable, they shall be based on the same PCR (including the same first-digit version number) or be based on fully aligned PCRs or versions of PCRs; cover products with identical functions, technical performances and use (e.g. identical declared/functional units); have identical scope in terms of included life-cycle stages (unless the excluded life-cycle stage is demonstrated to be insignificant); apply identical impact assessment methods (including the same version of characterization factors); and be valid at the time of comparison.

3.9 ESTIMATES AND ASSUMPTIONS

The assessment relied on a number of assumptions related to material composition, processing, and end-of-life. The major assumptions used in the assessment are described below.

- Electricity, fuel, and water use at the manufacturing facility were allocated to the products based on economic allocation.
- The facility under review is located in the Netherlands. Ecoinvent inventory datasets for the country- and region-specific energy grids were used to model resource use and emissions from electricity use at the manufacturing facility.
- The Arnhem facility purchases Renewable Energy Credits (RECs). The LCA model includes the use of these RECs. Further details are provided further in this LCA report.

- A transport distance of 32 km is assumed for any waste generated at the manufacturing facilities, based on the EPA WARM model.
- Transport of the product waste at end-of-life is assumed to be 130 km (for incinerated waste) or 80 km (for non-incinerated waste) by truck based on the PCR.
- The upstream transport distances for the adhesive and waste wood used at the Arnhem facility were unavailable. They were assumed to be 200 km and 500 km, respectively. Both these components represent less than 1% by mass of the final product, and these assumptions were deemed to be reasonable. These assumptions were not limitations of the study.
- No specific data was available regarding product treatment at end-of-life. As such, disposal of product was modeled using regional waste management statistics for the primary markets the product is sold into: Europe.

4. LCA: Results

Results of the Life Cycle Assessment are presented below. It is noted that LCA results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks.

The following environmental impact category indicators are reported using characterization factors based on the EF 3.1 characterization methodology. Results reported in MJ are calculated using lower heating values. All values are rounded to three significant digits.

Table 7. *EF 3.1 LCIA Indicators included in this EPD.*

Impact Category	Abbreviation	Unit
Global warming potential	GWP-total GWP-fossil GWP-biogenic GWP-luluc GWP-GHG	kg CO_2 eq
Ozone depletion potential	ODP	kg CFC-11 eq
Eutrophication potential	EP-freshwater EP-aquatic marine EP-terrestrial	kg P eq kg N eq mol N eq
Acidification potential	AP	mol H^+ eq
Photochemical ozone formation	POCP	kg NMVOC eq
Abiotic Depletion Potential, non-fossil resources*	ADP_E	kg Sb eq
Abiotic Depletion Potential, fossil fuels*	ADP_F	MJ eq
Water Use Deprivation Potential*	WDP	m^3 world eq deprived

**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.*

These impact categories are globally deemed mature enough to be included in Type III environmental declarations. Other categories are being developed and defined and LCA should continue making advances in their development. However, the EPD users shall not use additional measures for comparative purposes. Per the PCR, aggregating results of multiple life cycle stages is not presented, save for the production stage (modules A1-A3). However, as the scope of this EPD is cradle-to-gate with end-of-life, use of the aggregated production stage is discouraged without giving additional consideration to the results of the end-of-life sage (modules C1-C4). The following inventory parameters, specified by the PCR, are also reported.

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Table 8. *Resource use and waste/output indicators included in this EPD.*

Resource Use Indicator	Abbreviation	Unit
Renewable primary resources used as an energy carrier	PERE	MJ, LHV
Renewable primary resources with energy content used as materials	PERM	MJ, LHV
Total use of renewable primary energy resources	PERT	MJ, LHV
Non-renewable primary resources used as an energy carrier	PENRE	MJ, LHV
Non-renewable primary resources with energy content used as material	PENRM	MJ, LHV
Total use of non-renewable primary energy resources	PENRT	MJ, LHV
Secondary materials	SM	kg
Renewable secondary fuels	RSF	MJ, LHV
Non-renewable secondary fuels	NRSF	MJ, LHV
Consumption of freshwater	FW	m^3
Waste/Output Indicator	**Abbreviation**	**Unit**
Hazardous waste disposed	HWD	kg
Non-hazardous waste disposed	NHWD	kg
Intermediate-low level radioactive waste	ILLRWD	kg
High-level radioactive waste	HLRWD	kg
Components for re-use	CRU	kg
Materials for recycling	MFR	kg
Materials for energy recovery	MER	kg
Exported electrical energy	EEE	MJ, LHV
Exported thermal energy	EET	MJ, LHV

All LCA results are stated to three significant figures in agreement with the PCR for this product and therefore the sum of the total values may not exactly equal 100%.

Table 9. *EF 3.1 LCA results for the Accoya Rough Arnhem product.*

Impact Category	Unit	Life Cycle Stage				D
		A1- A3 Total	C2	C3	C4	
GWP-total	kg CO_2 eq	**169**	8.18	4.06	68.9	-449
GWP-biogenic	kg CO_2 eq	**-827**	$1.68x10^{-3}$	$7.72x10^{-4}$	839	0.00
GWP-fossil	kg CO_2 eq	**937**	8.17	4.06	2.40	-449
GWP-luluc	kg CO_2 eq	**0.772**	$2.71x10^{-3}$	$5.90x10^{-4}$	$5.30x10^{-4}$	-0.655
GWP-GHG	kg CO_2 eq	**938**	8.17	4.06	13.3	-450
ODP	kg CFC-11 eq	**$1.48x10^{-5}$**	$1.78x10^{-7}$	$6.44x10^{-8}$	$6.50x10^{-8}$	$-9.25x10^{-6}$
EP-freshwater	kg P eq	**$9.50x10^{-2}$**	$5.60x10^{-4}$	$2.80x10^{-4}$	$1.79x10^{-3}$	-0.178
EP-marine	kg N eq	**1.54**	$8.83x10^{-3}$	$1.54x10^{-2}$	$7.42x10^{-2}$	-0.376
EP-terrestrial	mol N eq	**16.7**	$9.61x10^{-2}$	0.169	$8.69x10^{-2}$	-3.95
AP	mol H^+ eq	**6.02**	$2.62x10^{-2}$	$3.35x10^{-2}$	$1.83x10^{-2}$	-1.31
POCP	kg NMVOC eq	**5.34**	$3.98x10^{-2}$	$5.04x10^{-2}$	$3.23x10^{-2}$	-1.29
ADP_E	kg Sb eq	**$2.13x10^{-3}$**	$2.82x10^{-5}$	$2.87x10^{-6}$	$5.00x10^{-6}$	$-1.47x10^{-3}$
ADP_F	MJ eq	**17,500**	116	53.4	49.4	-6,660
WDP	m^3 world eq	**188**	0.607	0.244	3.35	-112

Table 10. *Resource use indicator results for the Accoya Rough Arnhem product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
PERE	MJ, LHV	**6,900**	1.89	2.67	1.34	0.00
PERM	MJ, LHV	**9,790**	0.00	0.00	0.00	0.00
PERT	MJ, LHV	**16,700**	1.89	2.67	1.34	0.00
PENRE	MJ, LHV	**17,200**	115	52.9	48.9	0.00
PENRM	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
PENRT	MJ, LHV	**17,200**	115	52.9	48.9	0.00
SM	kg	**$7.28x10^{-3}$**	0.00	0.00	0.00	0.00
RSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
NRSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
FW	m^3	**14.4**	$1.45x10^{-2}$	$6.42x10^{-3}$	-0.878	0.00

Table 11. *Waste/Output indicator results for the Accoya Rough Arnhem product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
HWD	kg	**0.00**	0.00	0.00	0.00	0.00
NHWD	kg	**1.31**	0.00	0.00	197	0.00
ILLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
HLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
CRU	kg	**0.00**	0.00	0.00	0.00	0.00
MFR	kg	**0.00**	0.00	0.00	283	0.00
MER	kg	**0.00**	0.00	0.00	0.00	0.00
EEE	MJ, LHV	**0.00**	0.00	0.00	166	0.00
EET	MJ, LHV	**0.00**	0.00	0.00	3,180	0.00

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Table 12. *EF 3.1 LCA results for the Accoya Planed Arnhem product.*

Impact Category	Unit	Life Cycle Stage				D
		A1- A3 Total	C2	C3	C4	
GWP-total	kg CO_2 eq	**191**	8.18	4.06	68.9	-449
GWP-biogenic	kg CO_2 eq	**-827**	$1.68x10^{-3}$	$7.72x10^{-4}$	839	0.00
GWP-fossil	kg CO_2 eq	**965**	8.17	4.06	2.40	-449
GWP-luluc	kg CO_2 eq	**0.868**	$2.71x10^{-3}$	$5.90x10^{-4}$	$5.30x10^{-4}$	-0.655
GWP-GHG	kg CO_2 eq	**966**	8.17	4.06	13.3	-450
ODP	kg CFC-11 eq	**$1.52x10^{-5}$**	$1.78x10^{-7}$	$6.44x10^{-8}$	$6.50x10^{-8}$	$-9.25x10^{-6}$
EP-freshwater	kg P eq	**0.102**	$5.60x10^{-4}$	$2.80x10^{-4}$	$1.79x10^{-3}$	-0.178
EP-marine	kg N eq	**1.60**	$8.83x10^{-3}$	$1.54x10^{-2}$	$7.42x10^{-2}$	-0.376
EP-terrestrial	mol N eq	**17.4**	$9.61x10^{-2}$	0.169	$8.69x10^{-2}$	-3.95
AP	mol H^+ eq	**6.21**	$2.62x10^{-2}$	$3.35x10^{-2}$	$1.83x10^{-2}$	-1.31
POCP	kg NMVOC eq	**5.54**	$3.98x10^{-2}$	$5.04x10^{-2}$	$3.23x10^{-2}$	-1.29
ADP_E	kg Sb eq	**$2.29x10^{-3}$**	$2.82x10^{-5}$	$2.87x10^{-6}$	$5.00x10^{-6}$	$-1.47x10^{-3}$
ADP_F	MJ eq	**17,900**	116	53.4	49.4	-6,660
WDP	m^3 world eq	**193**	0.607	0.244	3.35	-112

Table 13. *Resource use indicator results for the Accoya Planed Arnhem product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
PERE	MJ, LHV	**8,200**	1.89	2.67	1.34	0.00
PERM	MJ, LHV	**9,790**	0.00	0.00	0.00	0.00
PERT	MJ, LHV	**18,000**	1.89	2.67	1.34	0.00
PENRE	MJ, LHV	**17,600**	115	52.9	48.9	0.00
PENRM	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
PENRT	MJ, LHV	**17,600**	115	52.9	48.9	0.00
SM	kg	**$7.28x10^{-3}$**	0.00	0.00	0.00	0.00
RSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
NRSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
FW	m^3	**14.5**	$1.45x10^{-2}$	$6.42x10^{-3}$	-0.878	0.00

Table 14. *Waste/Output indicator results for the Accoya Planed Arnhem product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
HWD	kg	**0.00**	0.00	0.00	0.00	0.00
NHWD	kg	**1.31**	0.00	0.00	197	0.00
ILLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
HLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
CRU	kg	**0.00**	0.00	0.00	0.00	0.00
MFR	kg	**0.00**	0.00	0.00	283	0.00
MER	kg	**0.00**	0.00	0.00	0.00	0.00
EEE	MJ, LHV	**0.00**	0.00	0.00	166	0.00
EET	MJ, LHV	**0.00**	0.00	0.00	3,180	0.00

Table 15. *EF 3.1 LCA results for the Accoya Fingerjointed product.*

Impact Category	Unit	Life Cycle Stage				D
		A1- A3 Total	C2	C3	C4	
GWP-total	kg CO_2 eq	**220**	8.18	4.06	68.9	-449
GWP-biogenic	kg CO_2 eq	**-827**	$1.68x10^{-3}$	$7.72x10^{-4}$	839	0.00
GWP-fossil	kg CO_2 eq	**994**	8.17	4.06	2.40	-449
GWP-luluc	kg CO_2 eq	**0.918**	$2.71x10^{-3}$	$5.90x10^{-4}$	$5.30x10^{-4}$	-0.655
GWP-GHG	kg CO_2 eq	**995**	8.17	4.06	13.3	-450
ODP	kg CFC-11 eq	**$1.58x10^{-5}$**	$1.78x10^{-7}$	$6.44x10^{-8}$	$6.50x10^{-8}$	$-9.25x10^{-6}$
EP-freshwater	kg P eq	**0.112**	$5.60x10^{-4}$	$2.80x10^{-4}$	$1.79x10^{-3}$	-0.178
EP-marine	kg N eq	**1.64**	$8.83x10^{-3}$	$1.54x10^{-2}$	$7.42x10^{-2}$	-0.376
EP-terrestrial	mol N eq	**17.8**	$9.61x10^{-2}$	0.169	$8.69x10^{-2}$	-3.95
AP	mol H^+ eq	**6.35**	$2.62x10^{-2}$	$3.35x10^{-2}$	$1.83x10^{-2}$	-1.31
POCP	kg NMVOC eq	**5.67**	$3.98x10^{-2}$	$5.04x10^{-2}$	$3.23x10^{-2}$	-1.29
ADP_E	kg Sb eq	**$2.52x10^{-3}$**	$2.82x10^{-5}$	$2.87x10^{-6}$	$5.00x10^{-6}$	$-1.47x10^{-3}$
ADP_F	MJ eq	**18,300**	116	53.4	49.4	-6,660
WDP	m^3 world eq	**202**	0.607	0.244	3.35	-112

Table 16. *Resource use indicator results for the Accoya Fingerjointed product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
PERE	MJ, LHV	**8,250**	1.89	2.67	1.34	0.00
PERM	MJ, LHV	**9,790**	0.00	0.00	0.00	0.00
PERT	MJ, LHV	**18,000**	1.89	2.67	1.34	0.00
PENRE	MJ, LHV	**18,000**	115	52.9	48.9	0.00
PENRM	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
PENRT	MJ, LHV	**18,000**	115	52.9	48.9	0.00
SM	kg	**$7.28x10^{-3}$**	0.00	0.00	0.00	0.00
RSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
NRSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
FW	m^3	**14.7**	$1.45x10^{-2}$	$6.42x10^{-3}$	-0.878	0.00

Table 17. *Waste/Output indicator results for the Accoya Fingerjointed product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
HWD	kg	**0.00**	0.00	0.00	0.00	0.00
NHWD	kg	**1.31**	0.00	0.00	197	0.00
ILLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
HLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
CRU	kg	**0.00**	0.00	0.00	0.00	0.00
MFR	kg	**0.00**	0.00	0.00	283	0.00
MER	kg	**0.00**	0.00	0.00	0.00	0.00
EEE	MJ, LHV	**0.00**	0.00	0.00	166	0.00
EET	MJ, LHV	**0.00**	0.00	0.00	3,180	0.00

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Table 18. *EF 3.1 LCA results for the Accoya for Tricoya product.*

Impact Category	Unit	Life Cycle Stage				D
		A1- A3 Total	C2	C3	C4	
GWP-total	kg CO_2 eq	**111**	8.18	4.06	68.9	358
GWP-biogenic	kg CO_2 eq	**-827**	$1.68x10^{-3}$	$7.72x10^{-4}$	839	0.00
GWP-fossil	kg CO_2 eq	**853**	8.17	4.06	2.40	-39.9
GWP-luluc	kg CO_2 eq	**0.718**	$2.71x10^{-3}$	$5.90x10^{-4}$	$5.30x10^{-4}$	-0.475
GWP-GHG	kg CO_2 eq	**853**	8.17	4.06	13.3	-40.5
ODP	kg CFC-11 eq	**$1.22x10^{-5}$**	$1.78x10^{-7}$	$6.44x10^{-8}$	$6.50x10^{-8}$	$-7.16x10^{-7}$
EP-freshwater	kg P eq	**$8.16x10^{-2}$**	$5.60x10^{-4}$	$2.80x10^{-4}$	$1.79x10^{-3}$	$-1.39x10^{-2}$
EP-marine	kg N eq	**1.46**	$8.83x10^{-3}$	$1.54x10^{-2}$	$7.42x10^{-2}$	-0.103
EP-terrestrial	mol N eq	**15.9**	$9.61x10^{-2}$	0.169	$8.69x10^{-2}$	-1.13
AP	mol H^+ eq	**5.72**	$2.62x10^{-2}$	$3.35x10^{-2}$	$1.83x10^{-2}$	-0.283
POCP	kg NMVOC eq	**5.05**	$3.98x10^{-2}$	$5.04x10^{-2}$	$3.23x10^{-2}$	-0.440
ADP_E	kg Sb eq	**$1.92x10^{-3}$**	$2.82x10^{-5}$	$2.87x10^{-6}$	$5.00x10^{-6}$	$-1.49x10^{-4}$
ADP_F	MJ eq	**16,000**	116	53.4	49.4	-647
WDP	m^3 world eq	**160**	0.607	0.244	3.35	-17.9

Table 19. *Resource use indicator results for the Accoya for Tricoya product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
PERE	MJ, LHV	**11,800**	1.89	2.67	1.34	0.00
PERM	MJ, LHV	**4,030**	0.00	0.00	0.00	0.00
PERT	MJ, LHV	**15,800**	1.89	2.67	1.34	0.00
PENRE	MJ, LHV	**15,800**	115	52.9	48.9	0.00
PENRM	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
PENRT	MJ, LHV	**15,800**	115	52.9	48.9	0.00
SM	kg	**$7.28x10^{-3}$**	0.00	0.00	0.00	0.00
RSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
NRSF	MJ, LHV	**0.00**	0.00	0.00	0.00	0.00
FW	m^3	**13.8**	$1.45x10^{-2}$	$6.42x10^{-3}$	-0.878	0.00

Table 20. *Waste/Output indicator results for the Accoya for Tricoya product.*

Impact Category	Unit	A1- A3 Total	C2	C3	C4	D
HWD	kg	**0.00**	0.00	0.00	0.00	0.00
NHWD	kg	**0.300**	0.00	0.00	197	0.00
ILLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
HLRWD	kg	**0.00**	0.00	0.00	0.00	0.00
CRU	kg	**0.00**	0.00	0.00	0.00	0.00
MFR	kg	**0.00**	0.00	0.00	283	0.00
MER	kg	**0.00**	0.00	0.00	0.00	0.00
EEE	MJ, LHV	**0.00**	0.00	0.00	166	0.00
EET	MJ, LHV	**0.00**	0.00	0.00	3,180	0.00

5. LCA: Interpretation

Contribution analysis of the LCIA results reveals that the primary driver of impacts for the Accoya Arnhem products is module A1 (raw material extraction and processing) for most impact categories. For eutrophication (marine), eutrophication (terrestrial), acidification potential and photochemical ozone creation potential, Module A2 (transport) is responsible for the largest impact. Module A3 contributes less to the total impacts for the products produced at Arnhem versus the products produced at Kingsport, mainly due to the use of renewable electricity (via Renewable Energy Certificates). This is further explored in the sensitivity analysis section. Digging deeper, for products produced at Arnhem, the manufacturing impact for GWP-total is driven by the use of heat and electricity at the facility. For module A1, the GWP-total impact is driven by the upstream production of acetic anhydride for all products. For the AP, POCP, EP-marine, and EP-terrestrial impact categories, the impacts for Module A2 are driven by the shipping of the raw materials to the facility.

6. Additional Environmental Information

6.1 ENVIRONMENTAL ACTIVITIES AND CERTIFICATIONS

6.2 FURTHER INFORMATION

Further information on the product can be found on the manufacturer's website at https://www.accysplc.com/.

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7. References

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Abbreviations

Table 21. *List of Abbreviations used in this EPD*

Abbreviation	Meaning	Abbreviation	Meaning
CSI	Construction Specifications Institute	LCI	Life Cycle Inventory
EPA	Environmental Protection Agency	LCIA	Life Cycle Impact Assessment
EPD	Environmental Product Declaration	PCR	Product Category Rule
GHG	Greenhouse Gas	RER	Europe
GLO	Global	RoW	Rest of World
LCA	Life Cycle Assessment	UNSPSC	United Nations Standard Products and Services Code

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