

ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	EJOT SE & Co. KG
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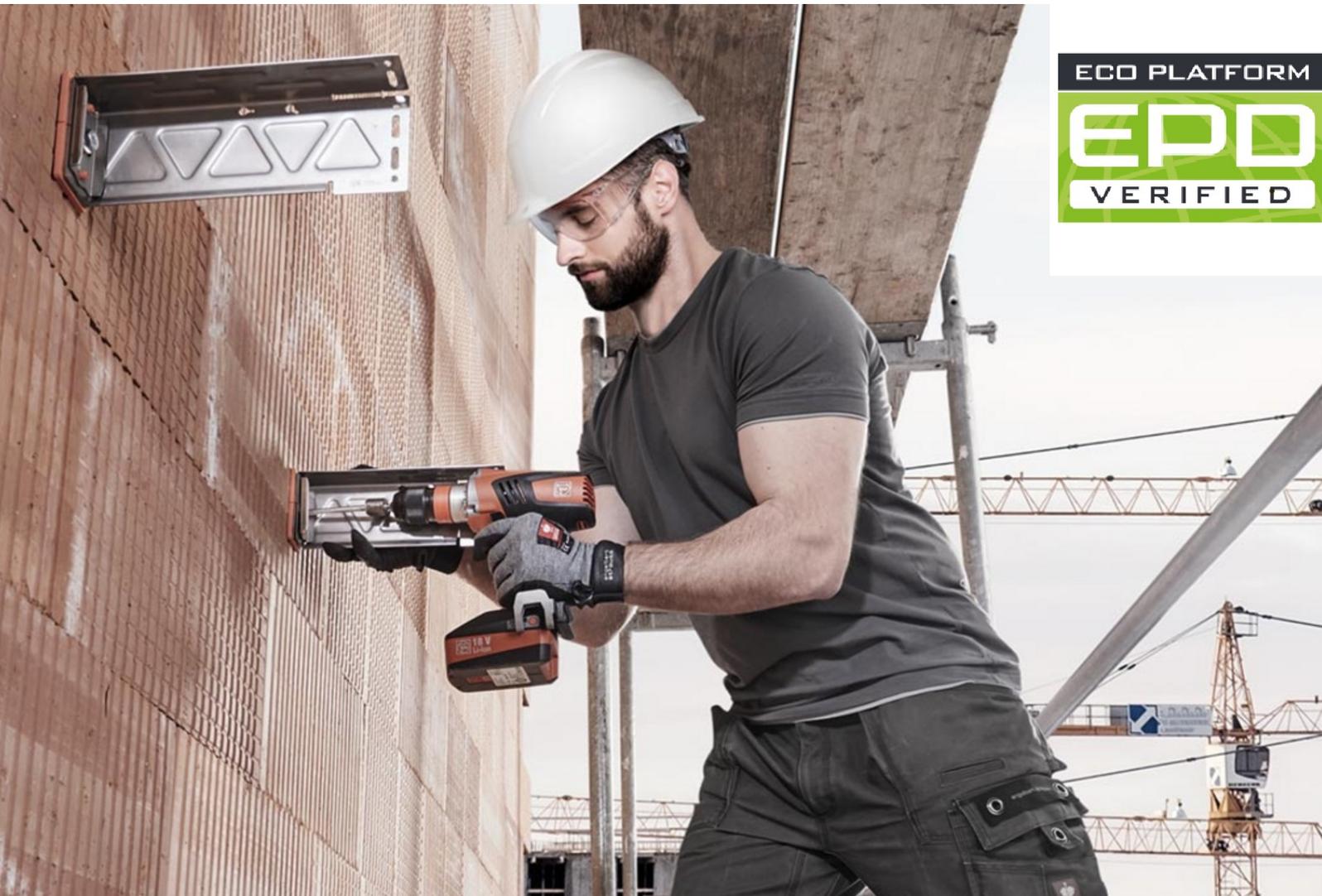
**CROSSFIX
EJOT**

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ECO PLATFORM

EPD
VERIFIED



General Information

EJOT

Programme holder

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

Declaration number

EPD-EJO-20250165-CBA1-EN

This declaration is based on the product category rules:

Thin walled profiles and profiled panels of metal, 01.08.2021
(PCR checked and approved by the SVR)

Issue date

28.05.2025

Valid to

27.05.2030



Dipl.-Ing. Hans Peters
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CROSSFIX

Owner of the declaration

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Declared product / declared unit

This declaration describes a specific substructure system with a console length of 240 mm and a 1-layer aluminium profile (total weight 2.74 kg/m²) for the fastening of 1 m² facade element in the field of rear-ventilated facades.

Further product compositions (80 and 400 mm console length with 1- and 2-layer aluminium profiles as well as 240 mm console length with 2-layer design) can be found in the separate annex to this EPD.

Scope:

The EPD refers to a representative substructure system with a console length of 240 mm and a 1-layer aluminium profile (total weight 2.74 kg/m²) for the fastening of 1 m² facade element in the field of rear-ventilated facades. All remaining products comprised in the EJOT portfolio which are required for the installation of a rear-ventilated facade with an EJOTCROSSFIX® substructure system are presented in the Annex.

The declared products are manufactured at sites in Austria, Germany, Poland and Bosnia and Herzegovina. For further information, see product description.

The data base is the year 2023. The declared results are valid for the average material consumption for 1 m² rear-ventilated facade to be fastened, so the results can be extrapolated with the given formula according to the type of design, total protrusion and material requirement. The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

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

Verification

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



Dr. Jan Werner,
(Independent verifier)

Product

Product description/Product definition

The EJOT CROSSFIX® facade system is an easy-to-install, flexible, low-thermal-bridging substructure system in the area of rear-ventilated facades. With one console length, this system allows for the compensation of wall tolerances of up to 400 mm in order to install an even rear-ventilated facade system.

The system comprises the following components:

- 1) Stainless steel wall console (protrusion 40-400 mm): production in Austria,
- 2) Stainless steel stress plate: production in Austria,
- 3) Thermostop (thermal separator): production in Poland,
- 4) Stainless steel power key: production in Austria,
- 5) EJOT fasteners (depending on the structural requirement): production in Poland,
- 6) Support profiles: production in Bosnia and Herzegovina,
- 7) stainless steel Vario JT: production in Germany and is suitable for substructures with horizontal, vertical as well as one-layer and two-layer design.

The assembly of the kit (preparing the console, profiles, and other components for delivery to the construction site) takes place in Austria. The installation of the kit (anchoring the console, assembling and securing the profiles) always takes place directly at the construction site.

Compared to conventional systems, the use of stainless steel wall consoles can significantly reduce the thermal bridge surcharge in the system. Therefore, the console is a certified passive house component. The placing on the market of the product in the European Union/European Free Trade Association (EU/EFTA) (with the exception of Switzerland) is governed by *Regulation (EU) No 305/2011 (CPR)*. The product requires a declaration of performance considering the *EN 1090-1*. The respective national regulations apply to the use.

Application

The system dealt with in this declaration is mainly used for the implementation of a substructure in the area of rear-ventilated facades on different substructures and design types.

Technical Data

The technical data of the product can be found in the declaration of Performance (DoP):

1. Product description:

Wall console, extrusion profiles, agraffe, profile strips, clips (aluminium, steel and stainless steel), fastening elements

2. Application:

Substructure rear-ventilated façade

3. Year of manufacture:

2023

4. Execution standard:

EN 1090-2; EN 1090-3

5. Geometric tolerances:

acc. to production drawings

6. Fracture strength:

NPD

7. Weldability:

EN AW 6063 T66, EN AW 6060 T66 acc. to *EN 1011-4* and *EN 1999-1-1, 1.4301, 1.4404* acc. to *EN 10088-1*

8. Fire behavior:

material classified as A1

9. Fire resistance:

NPD

10. Release of cadmium:

NPD

11. Release of radioactive radiation: NPD

12. Durability:

Aluminium: untreated, or anodized acc. to *ISO 7599*; powder-coated acc. to *EN 12206-1*

Steel: strip-galvanized acc. to *EN 10346* or stainless steel

13. Load-carrying capacity:

NPD

14. Fatigue strength:

NPD

15. Design:

Acc. to *ETA-21/0756, EN 1999-1-1, EN 1993-1-1* and *P-BWU02-178002* see initial sizing or external initial sizing

16. Production:

According to the product specification and *EN 1090-2, EN 1090-3*

17. Execution class:

EXC1, EXC2 and EXC3; EXC4 optionally upon request

18. Installation:

NPD

Constructional data

The constructional data are representative of all substructure systems that are implemented with the CROSSFIX® facade system. The given data are part of the basis for static calculations of the System:

Name	Value	Unit
Thickness of the wall console	1.5	mm
Grammage of the substructure	2.74	kg/m ²
Height of the wall console	≥ 80	mm
Minimum tensile strength of the wall console	≥ 540	N/mm ²
Yield strength of the wall console	≥ 230	N/mm ²
Thickness of support profiles	≥ 1,8	mm
Minimum tensile strength of support profiles	≥ 245	N/mm ²
Yield strength of support profiles	≥ 200	N/mm ²
Thickness of the power key	1,5	mm
Anchor spacing with power key	≥ 250	mm

Performance values of the product corresponding to the declaration of performance in respect of the Essential Characteristics according to *EN 1090-1:2012*, Execution of steel structures and aluminium structures.

Base materials/Ancillary materials

The essential base materials or intermediate products for the production of 1 m² facade substructure are:

- Stainless steel 40- 65 %
- Aluminium 40- 65 %
- Steel 5- 10 %
- PA polyamide 1- 3 %
- Dye < 1 %

Depending on the used substructure design, resulting protrusion and statically related layout, the % shares may change.

The Candidate list can be found on the ECHA website address: echa.europa.eu/de/home.

This product/article/at least one partial article contains substances listed in *the candidate list* (date: 11.04.2025) exceeding 0.1 percentage by mass: no.

This product/article/at least one partial article contains other carcinogenic, mutagenic, reprotoxic (CMR) substances in categories 1A or 1B which are not on the candidate list, exceeding 0.1 percentage by mass: no.

Biocide products were added to this construction product or it

has been treated with biocide products (this then concerns a treated product as defined by the (EU) *Ordinance on Biocide Products No. 528/2012*): no.

Reference service life

The reference values from *BNB* are used to estimate the service life of the products under study. Within *BNB* the service life for the product is >50 years.

Manufacturer information:

The service life of the CROSSFIX® facade system is often

determined by the service life of the building.

Due to the materials and material combinations used, a maintenance-free system is assumed.

The service life of the CROSSFIX® facade system is longer than the service life of the facade panels. If used correctly, a service life of more than 70 years can be assumed.

At the end of the service life of a building, the individual components of the facade can be easily removed and enable a controlled dismantling with virtually sorted separation.

LCA: Calculation rules

Declared Unit

The declared unit is 1 m² CROSSFIX® facade system with a console length of 240 mm and one layer of aluminium profiles with a total weight of 2,74 kg/m². Further product compositions (80 and 400 mm console length with 1- and 2-layer aluminium profiles as well as 240 mm console length with 2-layer design) can be found in the annex to this EPD.

Indication of the declared unit

Name	Value	Unit
Grammage	2.74	kg/m ²
Declared unit	1	m ²
Layer thickness	0,0015	m

The product declared in this EPD is a representative product (in terms of product properties and geographical representativeness) as it has the greatest proportion in terms of sales figures. The results of the other declared products are provided in the annex and vary between -16 % and +68 % (as an example for GWP-total). For detailed results, see annex to this EPD.

System boundary

The EPD covers the LCA results from cradle to gate with options, module C1-C4 and module D (A1-A3 + C + D and additional modules: A4, A5). The following modules are declared:

Module A1-A3 (production stage) include provision of all materials, products and energy (0,501 kg CO₂-eq./kWh), as

well as packaging (PE wrap, cardboard box and wooden pallets). It also covers the waste processing of the production waste up to the end of waste state incl. power consumption (electricity and thermal energy).

Module A4 considers a 100 km truck transport.

Module A5 considers only the treatment and disposal of the packaging as no additional fixing materials are necessary.

Module C1 considers a manual deconstruction (load-free).

Module C2 considers the transport to disposal (50 km).

Module C3 considers the efforts for disposal (recycling of (stainless) steel and aluminium components, thermal recovery of plastic parts) and energy recovery.

Module C4 is not relevant for the product.

Module D considers the loads and benefits beyond the system boundaries.

Geographic Representativeness

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

Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account. The background data are taken from the *Sphera LCA FE* (former GaBi database), CUP 2024.1

LCA: Scenarios and additional technical information

Characteristic product properties of biogenic carbon

The total mass of biogenic carbon in the product is less than 5 % of the total mass. Therefore, the biogenic carbon content is omitted.

The biogenic carbon of the accompanying packaging is declared.

Name	Value	Unit
biogenic carbon in the product	0	kg C
biogenic carbon in the packaging	0,0304	kg C

Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO₂.

The EPD covers the LCA results from cradle to gate with options, modules C1-C4, and module D (A1-A3, C, D and additional modules: A4 and A5). The following technical information is a basis for the declared modules.

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	0.19	l/100km
Transport distance	100	km
Capacity utilisation (including empty runs)	61	%

Assembly (A5)

The installation of the product is done manually.

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

Name	Value	Unit
Output substances following waste treatment on site (PE--Film)	0,023	kg
Output substances following waste treatment on site (Cardboard)	0,016	kg
Output substances following waste treatment on site (wooden pallets)	0,056	kg

Reference Lifetime

The service life of the CROSSFIX® facade system is longer than the service life of the facade panels.

End-of-life (C1-C4)

Name	Value	Unit
Collected as mixed construction waste	2.74	kg
Recycling (stainless steel, steel, aluminium)	2.546	kg
Energy recovery (plastic component)	0.057	kg
Landfilling (collection loss at recycling)	0.137	kg

For all metal components, a recycling scenario is assumed. Potential benefits are assigned. For the calculation of the

quantities, 5 % collection loss is assumed, which are deposited without crediting potential benefits. Furthermore, a loss of 5 % during remelting is included. For included secondary materials (steel and stainless steel), no benefits are given. The aluminium is 100 % modelled as primary aluminium, thus high benefits are assigned in the End of Life (EoL).

The potential benefits for electricity and thermal energy which are assigned during the combustion of the plastic component are offset against European data sets.

LCA: Results

The following tables display the environmentally relevant results according to EN 15804+A2 (EF 3.1) for 1m² of CROSSFIX with a console length of 240mm and one layer of aluminium.

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

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

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 m² CROSSFIX (1layer, 240mm)

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO ₂ eq	1.62E+01	2.21E-02	1.85E-01	0	1.07E-02	1.32E-01	0	-1.16E+01
GWP-fossil	kg CO ₂ eq	1.63E+01	2.17E-02	7.31E-02	0	1.05E-02	1.32E-01	0	-1.16E+01
GWP-biogenic	kg CO ₂ eq	-1.02E-01	5.19E-05	1.12E-01	0	2.51E-05	1.37E-05	0	-1.01E-02
GWP-luluc	kg CO ₂ eq	1.07E-02	3.65E-04	1.37E-06	0	1.76E-04	1.29E-05	0	-9.09E-03
ODP	kg CFC11 eq	3.78E-11	3.2E-15	1.7E-14	0	1.55E-15	2.15E-14	0	-5.43E-12
AP	mol H ⁺ eq	8.59E-02	3.14E-05	2.85E-05	0	1.52E-05	2.44E-04	0	-6.38E-02
EP-freshwater	kg P eq	1.34E-05	9.27E-08	4.29E-09	0	4.48E-08	9.38E-09	0	-6.44E-06
EP-marine	kg N eq	1.43E-02	1.13E-05	8.27E-06	0	5.44E-06	1.22E-04	0	-1.12E-02
EP-terrestrial	mol N eq	1.57E-01	1.33E-04	1.26E-04	0	6.45E-05	1.35E-03	0	-1.23E-01
POCP	kg NMVOC eq	4.32E-02	3.06E-05	2.29E-05	0	1.48E-05	3.12E-04	0	-3.36E-02
ADPE	kg Sb eq	1.56E-04	1.89E-09	1.79E-10	0	9.14E-10	3.32E-10	0	-8.4E-05
ADPF	MJ	2.06E+02	2.86E-01	3.75E-02	0	1.38E-01	9.06E-02	0	-1.35E+02
WDP	m ³ world eq deprived	5.38E+00	3.36E-04	1.94E-02	0	1.63E-04	1.35E-02	0	-4.91E+00

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

RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: 1 m² CROSSFIX (1layer, 240mm)

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PERE	MJ	9.01E+01	2.46E-02	1.06E+00	0	1.19E-02	1.38E-02	0	-6.64E+01
PERM	MJ	1.05E+00	0	-1.05E+00	0	0	0	0	0
PERT	MJ	9.12E+01	2.46E-02	1.06E-02	0	1.19E-02	1.38E-02	0	-6.64E+01
PENRE	MJ	2.04E+02	2.86E-01	1.08E+00	0	1.38E-01	1.89E+00	0	-1.35E+02
PENRM	MJ	2.84E+00	0	-1.04E+00	0	0	-1.8E+00	0	0
PENRT	MJ	2.06E+02	2.86E-01	3.75E-02	0	1.38E-01	9.06E-02	0	-1.35E+02
SM	kg	7.84E-01	0	0	0	0	0	0	1.67E+00
RSF	MJ	0	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0	0
FW	m ³	1.93E-01	2.75E-05	4.56E-04	0	1.33E-05	3.2E-04	0	-1.86E-01

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

RESULTS OF THE LCA - WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 m² CROSSFIX (1layer, 240mm)

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
HWD	kg	1.77E-07	1.1E-11	2.2E-11	0	5.29E-12	2.69E-11	0	-3.24E-04
NHWD	kg	5.2E+00	4.67E-05	2.79E-03	0	2.26E-05	1.38E-01	0	-3.92E+00
RWD	kg	9.03E-03	5.21E-07	2.03E-06	0	2.52E-07	1.75E-06	0	-4.94E-03
CRU	kg	0	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	2.55E+00	0	0
MER	kg	0	0	0	0	0	0	0	0
EEE	MJ	0	0	3.13E-01	0	0	2.52E-01	0	0

EET	MJ	0	0	5.61E-01	0	0	4.49E-01	0	0
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HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EET = Exported thermal energy

**RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional:
1 m² CROSSFIX (1layer, 240mm)**

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PM	Disease incidence	1.49E-06	3.06E-10	1.77E-10	0	1.48E-10	7.34E-10	0	-1.26E-06
IR	kBq U235 eq	1.08E+00	7.56E-05	3.22E-04	0	3.65E-05	2.52E-04	0	-4.76E-01
ETP-fw	CTUe	6.44E+01	2.12E-01	1.61E-02	0	1.03E-01	3.25E-02	0	-4.83E+01
HTP-c	CTUh	2E-06	4.29E-12	1.61E-12	0	2.07E-12	1.5E-12	0	-5.54E-08
HTP-nc	CTUh	1.35E-07	1.93E-10	5.77E-11	0	9.3E-11	4.1E-11	0	-9.21E-08
SQP	SQP	4.47E+01	1.41E-01	1.19E-02	0	6.8E-02	1.62E-02	0	-7.27E+00

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

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

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

References

Standards

DIN 18516-1

DIN 18516-1: 2024-10, Cladding for external walls, ventilated at rear - Part 1: Requirements, principles of testing

EN 755-1

DIN EN 755-1:2016-10; Aluminium and aluminium alloys - Extruded rod/bar, tube and profiles - Part 1: Technical conditions for inspection and delivery

EN 1011-4

DIN EN 1011-4:2001-02; Welding - Recommendations for welding of metallic materials - Part 4: Arc welding of aluminium and aluminium alloys

EN 1090-1

DIN EN 1090-1:2012-02, Execution of steel structures and aluminium structures - Part 1: Requirements for conformity assessment of structural components

EN 1090-2

DIN EN 1090-2:2024-09, Execution of steel structures and aluminium structures - Part 2: Technical requirements for steel structures

EN 1090-3

DIN EN 1090-3:2019-07, Execution of steel structures and aluminium structures - Part 3: Technical requirements for aluminium structures

EN 1993-1-1

DIN EN 1993-1-1:2010-12; Eurocode 3: Design of steel structures - Part 1-1: General rules and rules for buildings

EN 1999-1-1

DIN EN 1999-1-1:2024-11; Eurocode 9: Design of aluminium structures - Part 1-1: General rules

EN 10088-1

DIN EN 10088-1:2024-04; Stainless steels - Part 1: List of stainless steels

EN 10346

DIN EN 10346:2015-10; Continuously hot-dip coated steel flat products for cold forming - Technical delivery conditions

EN 12206-1

DIN EN 12206-1:2021-07; Paints and varnishes - Coating of aluminium and aluminium alloys for architectural purposes - Part 1: Coatings prepared from thermosetting coating powder

EN 15804

EN 15804:2012-04+A2:2019/, Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction products

ISO 7599

ISO 7599: 2018-01; Anodizing of aluminium and its alloys - Method for specifying decorative and protective anodic oxidation coatings on aluminium

ISO 14025

DIN EN ISO 14025:2011-10, Environmental labels and declarations - Type III environmental declarations - Principles and procedures

other sources

BNB

BBSR table (german): 'Nutzungsdauern von Bauteilen zur Lebenszyklusanalyse nach BNB', Bundesinstitut für Bau-, Stadt- und Raumforschung, Referat II Nachhaltiges Bauen; online available under <https://www.nachhaltigesbauen.de/austausch/nutzungsdauern-von-bauteilen/>

IBU PCR part A

Product Category Rules for Building-Related Products and Services - Part A: Calculation Rules for the Life Cycle Assessment and Requirements on the Project Report according to EN 15804+A2:2019, Version 1.4, Institut Bauen und Umwelt e.V., 2024

IBU PCR part B

PCR Guidance Text for Building-Related Products and Services - Part B: Requirements on the EPD for Thin walled profiles and profiled panels of metal, 01.08.2021 (v11)

Ordinance on Biocide Products No 528/2012

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

P-BWU02-178002

P-BWU02-178002:2017-03; Connections of wall holders made of aluminum or stainless steel on substructures made of aluminum support profiles for external wall cladding, ventilated at rear according to DIN 18516-1

Sphera LCA FE (fka GaBi ts)

Sphera LCA for Experts, LCA FE, software -system and databases, Managed LCA content MLC (fka GaBi database), University of Stuttgart and Sphera Solutions GmbH, 2023, CUP Version: 2024.1, MLC data set documentation under <https://lcadatabase.sphera.com/> (Sep 2024)

The Candidate list

echa.europa.eu/de/home



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