

ENVIRONMENTAL PRODUCT DECLARATION

IN ACCORDANCE WITH ISO 14025 AND ISO 21930:2017

SmartEPD-2023-012-0039-01

Reactamine 760



Date of Issue:
Dec 23, 2023

Expiration:
Dec 23, 2028

Last updated:
Jul 05, 2024

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General Information

Carboline

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Product Name:	Reactamine 760
Functional Unit:	1 m2 of covered and protected flooring surface for a period of 60 years
Declaration Number:	SmartEPD-2023-012-0039-01
Date of Issue:	December 23, 2023
Expiration:	December 23, 2028
Last updated:	July 05, 2024
EPD Scope:	Cradle to grave A1 - A3, A4, A5, B1 - B7, C1 - C4
Market(s) of Applicability:	North America

Reference Standards

Standard(s):	ISO 14025 and ISO 21930:2017
PCR:	PCR for Resinous Floor Coatings v.1e Date of issue: December 17, 2018 Valid until: December 17, 2024
PCR review panel:	 Contact Smart EPD for more information.
General Program Instructions:	 Smart EPD General Program Instructions v.1.0, November 2022

Verification Information

LCA Author/Creator:

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EPD Program Operator:

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📍 585 Grove St., Ste. 145 PMB 966, Herndon, VA 20170, USA

Verification:

Independent critical review of the LCA and data, according to ISO 14044 and ISO 14071 :

External

🌐 Anna Lasso | 🏢 Smart EPD | ✉️ anna.lasso@smartepd.com

Independent external verification of EPD, according to ISO 14025 and reference PCR(s) :

External

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Limitations, Liability, and Ownership

In order to support comparative assertions, this EPD meets all comparability requirements stated in ISO 14025:2006. However, differences in certain assumptions, data quality, and variability between LCA data sets may still exist. As such, caution should be exercised when evaluating EPDs from different manufacturers or programs, as the EPD results may not be entirely comparable. Any EPD comparison must be carried out at the construction works level per ISO 21930:2017 guidelines. The results of this EPD reflect an average performance by the product and its actual impacts may vary on a case-to-case basis.

The EPD owner shall have sole ownership, liability, and responsibility for the EPD.

Organization Information

For over seven decades, Carboline has been at the forefront of delivering cutting-edge product development alongside a wealth of technical expertise and experience, offering unparalleled protective coating solutions on a global scale. As a notable manufacturer of paint and coating products, Carboline is dedicated to showcasing its sustainability leadership while recognizing the business value in transparently reporting the comprehensive environmental impacts of its products, spanning from cradle to grave. For further details on Carboline's product range, visit their website at <https://www.carboline.com/>.

Further information can be found at: <https://www.carboline.com>

Product Description

Carboline's Reactamine 760 is a solvent free, 100% solids, fast curing single coat, aromatic polyurethane hybrid resin to provide protection for metal and concrete substrates. Reactamine 760's environmentally friendly, advanced hybrid technology, plural-component applied coating is used as a lining for water, wastewater, manholes, penstocks, dam gates, pipelines, and other aggressive immersion applications. Provides protection against microbiologically induced corrosion (MIC) and hydrogen sulfide corrosion found in wastewater treatment service.

Further information can be found at: <https://www.carboline.com/products/product-details/Reactamine-760>

Product Information

Functional Unit:

1 m2 of covered and protected flooring surface for a period of 60 years

Mass:

12.665 kg

Reference Service Life: 60 Years

Product Specificity: ☒ Product Average
☒ Product Specific

Averaging:
Averaging was not conducted for this EPD.

Plants

 Carboline - Green Bay, WI
2122 Angie Ave, Green Bay, WI 54302, USA

 Carboline - Lake Charles, LA
2425 Fruge Street, Lake Charles, LA, USA

Product Specifications

Product SKU(s): 885702009BDD

Product Classification Codes: Masterformat - 09 67 00
EC3 - Finishes -> Flooring -> OtherFlooring

Coating Type: Self-leveling or broadcast slurry floor coating

Options: ☒ Industrial

Estimated market service life: 10 years

Estimated technical service life: 15 years

Material Composition

Material/Component Category	Origin	% Mass
Additive	US	40-70
Colorant	US	5-10
Aggregate	US	0-5
Hardener	US	0-5
Resin	US	25-50

Packaging Material	Origin	kg Mass
Steel Drum	US	68.781

Hazardous Materials
Titanium Dioxide (CAS 13463-67-7)
DMTDA (CAS 106264-79-3)
N,N-dialkylaminodiphenylmetha (CAS 5285-60-9)
Diethylmethylbenzenediamine (CAS 68479-98-1)
4,4 MDI (CAS 101-68-8)
Polymeric MDI (CAS 9016-87-9)
2,2, 2,4 MDI (CAS 26447-40-5)

EPD Data Specificity

Primary Data Year:	2022-2023
Manufacturing Specificity:	✗ Industry Average ✓ Manufacturer Average ✓ Facility Specific

Software and LCI Data Sources

LCA Software:	 SimaPro v. 9.5
LCI Foreground Database(s):	 Ecoinvent v. 3.9.1  North America  cut-off
LCI Background Database(s):	 Ecoinvent v. 3.9.1  North America  cut-off

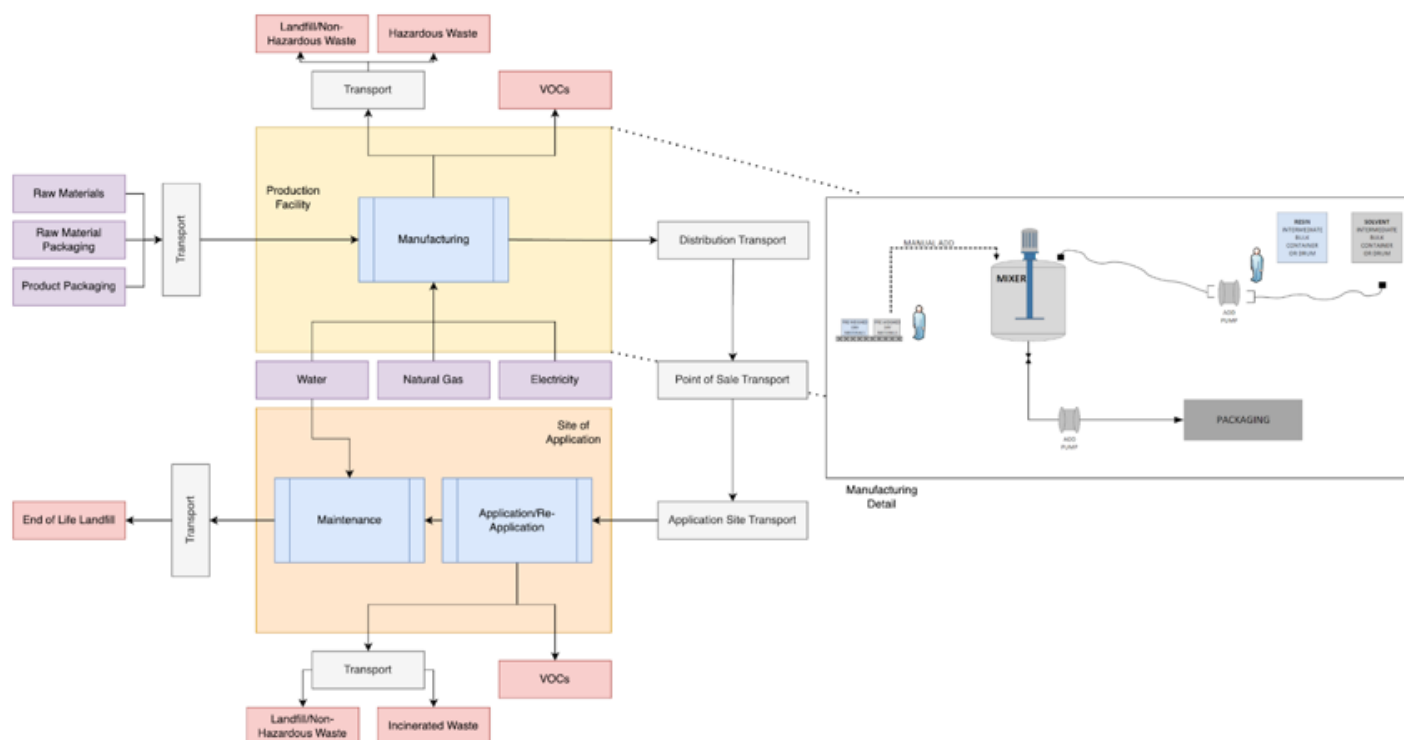
Renewable Electricity

Renewable electricity is used:	No
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System Boundary

Production	A1	Raw material supply	✓
	A2	Transport	✓
	A3	Manufacturing	✓
Construction	A4	Transport to site	✓
	A5	Assembly / Install	✓
Use	B1	Use	✓
	B2	Maintenance	✓
	B3	Repair	✓
	B4	Replacement	✓
	B5	Refurbishment	✓
	B6	Operational Energy Use	✓
	B7	Operational Water Use	✓
End of Life	C1	Deconstruction	✓
	C2	Transport	✓
	C3	Waste Processing	✓
	C4	Disposal	✓
Benefits & Loads Beyond System Boundary	D	Recycling, Reuse Recovery Potential	ND

Product Flow Diagram



Life Cycle Module Descriptions

The manufacturing of this product involves the direct procurement of raw materials from suppliers in module A1. These materials are then transported in module A2 to Carboline's manufacturing facilities in Green Bay, WI, or Lake Charles, LA, where they are stored and mixed to produce the coatings in module A3. Packaging waste associated the raw materials is recycled and/or send to landfill in Module A3. The coating is distributed and sold across North America in module A4. The product is applied to substrates to create a protective flooring surface in module A5.

Use of the product consists of daily maintenance cleaning with a mop and a cleaning solution such as Hillyard SM-1® Industrial Cleaner Degreaser in module B2. Necessary recoats (re-applications) of the product to achieve service life are modeled in module B4 per the PCR.

The steel drum packaging is discarded to landfill and a 2% coating loss rate during application is assumed per the PCR (for both initial application and any recoats). End of life impacts include transport to disposal and final waste processing in modules C2 and C3, respectively, and landfilling of the substrate with applied coating in module C4, per the PCR.

LCA Discussion

The model includes over 95% of the total material mass, energy, and environmental relevance throughout the product lifetime. Cut-off rules do not apply for hazardous or toxic materials, and the materials were included in the study. Product packaging was allocated by mass. Manufacturing inputs requiring allocation were electricity and natural gas as the production of multiple Carboline products is measured using a single meter for each. The allocation of each was based on the percentage of production for the Reactamine 760 divided by the total site production output.

Note on waste metrics: Significant data limitations currently exist within the LCI data used to generate waste metrics for Life Cycle Assessments and Environmental Product Declarations. The waste metrics were calculated in a way conformant with the requirements of ISO 21930:2017, but these values represent rough estimates and

are for informational purposes only. As such, no decisions regarding actual cradle-grave waste performance between products should be derived from these reported values.

Results

Environmental Impact Assessment Results

TRACI 2.1, IPCC AR5 GWP 100
per 1 m2 of covered and protected flooring surface for a period of 60 years.
LCIA results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks.

Industrial - Market Service Life

Impact Cate- gory	Method	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
ODP	TRACI 2.1	kg CFC 11 eq	5.34e-7	2.81e-8	1.44e-8	5.77e-7	1.64e-8	1.26e-10	0	1.10e-8	0	2.96e-6	0	0	0	0	1.26e-9	6.18e-9	5.10e-9
AP	TRACI 2.1	kg SO2 eq	4.18e-2	1.16e-2	2.43e-3	5.58e-2	5.29e-3	4.97e-5	0	7.16e-4	0	3.06e-1	0	0	0	0	4.07e-4	5.93e-4	2.10e-3
EP	TRACI 2.1	kg N eq	5.24e-1	1.82e-3	3.52e-3	5.29e-1	1.01e-3	1.64e-3	0	5.39e-4	0	2.66e+0	0	0	0	0	7.75e-5	3.83e-4	8.29e-2
POCP	TRACI 2.1	kg O3 eq	5.75e-1	3.02e-1	3.50e-2	9.12e-1	1.48e-1	8.79e-4	0	7.66e-3	0	5.31e+0	0	0	0	0	1.14e-2	7.80e-3	3.31e-2
GWP-fossil	IPCC AR5 GWP 100	kg CO2 eq	9.77e+0	1.71e+0	7.01e-1	1.22e+1	9.88e-1	1.48e-2	0	1.31e-1	0	6.59e+1	0	0	0	0	7.60e-2	9.05e-1	6.73e-1
GWP-total	IPCC AR5 GWP 100	kg CO2 eq	1.35e+1	1.72e+0	7.69e-1	1.60e+1	9.94e-1	2.01e-1	0	1.45e-1	0	8.58e+1	0	0	0	0	7.65e-2	9.05e-1	1.01e+1

Abbreviations:
GWP = Global Warming Potential, 100 years (may also be denoted as GWP-total, GWP-fossil (fossil fuels), GWP-biogenic (biogenic sources), GWP-luluc (land use and land use change)), ODP = Ozone Depletion Potential, AP = Acidification Potential, EP = Eutrophication Potential, SFP = Smog Formation Potential, POCP = Photochemical oxidant creation potential, ADP-Fossil = Abiotic depletion potential for fossil resources, ADP-Minerals&Metals = Abiotic depletion potential for non-fossil resources, WDP = Water deprivation potential, PM = Particular Matter Emissions, IRP = Ionizing radiation, human health, ETP-fw = Eco-toxicity (freshwater), HTP-c = Human toxicity (cancer), HTP-nc = Human toxicity (non-cancer), SQP = Soil quality index.

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Technical Service Life

Impact Category	Method	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
ODP	TRACI 2.1	kg CFC 11 eq	5.34e-7	2.81e-8	1.44e-8	5.77e-7	1.64e-8	1.26e-10	0	1.10e-8	0	1.78e-6	0	0	0	0	8.37e-10	4.12e-9	3.40e-9
AP	TRACI 2.1	kg SO2 eq	4.18e-2	1.16e-2	2.43e-3	5.58e-2	5.29e-3	4.97e-5	0	7.16e-4	0	1.83e-1	0	0	0	0	2.72e-4	3.95e-4	1.40e-3
EP	TRACI 2.1	kg N eq	5.24e-1	1.82e-3	3.52e-3	5.29e-1	1.01e-3	1.64e-3	0	5.39e-4	0	1.59e+0	0	0	0	0	5.17e-5	2.55e-4	5.52e-2
POCP	TRACI 2.1	kg O3 eq	5.75e-1	3.02e-1	3.50e-2	9.12e-1	1.48e-1	8.79e-4	0	7.66e-3	0	3.18e+0	0	0	0	0	7.60e-3	5.20e-3	2.21e-2
GWP-fossil	IPCC AR5 GWP 100	kg CO2 eq	9.77e+0	1.71e+0	7.01e-1	1.22e+1	9.88e-1	1.48e-2	0	1.31e-1	0	3.95e+1	0	0	0	0	5.07e-2	6.03e-1	4.48e-1
GWP-total	IPCC AR5 GWP 100	kg CO2 eq	1.35e+1	1.72e+0	7.69e-1	1.60e+1	9.94e-1	2.01e-1	0	1.45e-1	0	5.15e+1	0	0	0	0	5.10e-2	6.03e-1	6.71e+0

Abbreviations:

GWP = Global Warming Potential, 100 years (may also be denoted as GWP-total, GWP-fossil (fossil fuels), GWP-biogenic (biogenic sources), GWP-luluc (land use and land use change)), ODP = Ozone Depletion Potential, AP = Acidification Potential, EP = Eutrophication Potential, SFP = Smog Formation Potential, POCP = Photochemical oxidant creation potential, ADP-Fossil = Abiotic depletion potential for fossil resources, ADP-Minerals&Metals = Abiotic depletion potential for non-fossil resources, WDP = Water deprivation potential, PM = Particular Matter Emissions, IRP = Ionizing radiation, human health, ETP-fw = Eco-toxicity (freshwater), HTP-c = Human toxicity (cancer), HTP-nc = Human toxicity (non-cancer), SQP = Soil quality index.

Comparisons cannot be made between product-specific or industry average EPDs at the design stage of a project, before a building has been specified. Comparisons may be made between product-specific or industry average EPDs at the time of product purchase when product performance and specifications have been established and serve as a functional unit for comparison. Environmental impact results shall be converted to a functional unit basis before any comparison is attempted. Any comparison of EPDs shall be subject to the requirements of ISO 21930 or EN 15804. EPDs are not comparative assertions and are either not comparable or have limited comparability when they have different system boundaries. EPDs are not comparative assertions and are either not comparable or have limited comparability when they have different system boundaries, are based on different product category rules or are missing relevant environmental impacts. Such comparison can be inaccurate, and could lead to erroneous selection of materials or products which are higher-impact, at least in some impact categories.

Resource Use Indicators

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Market Service Life

Indicator	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
PERE	MJ, net calorific value	4.98e+0	2.25e-1	6.90e-1	5.89e+0	1.27e-1	3.44e-3	0	8.10e-2	0	3.01e+1	0	0	0	0	9.78e-3	1.90e-2	1.64e-1
PERM	MJ, net calorific value	7.92e+1	9.15e-2	1.59e-1	7.95e+1	4.97e-2	7.50e-4	0	6.71e-1	0	3.98e+2	0	0	0	0	3.82e-3	4.83e-3	3.41e-2
PERT	MJ, net calorific value	8.42e+1	3.16e-1	8.48e-1	8.54e+1	1.77e-1	4.19e-3	0	7.52e-1	0	4.28e+2	0	0	0	0	1.36e-2	2.38e-2	1.98e-1
PENRE	MJ, net calorific value	1.21e+2	2.38e+1	8.60e+0	1.53e+2	1.40e+1	1.04e-1	0	2.02e+0	0	8.38e+2	0	0	0	0	1.07e+0	4.05e+0	4.20e+0
PENRM	MJ, net calorific value	6.67e-3	3.68e-4	5.27e-4	7.56e-3	2.04e-4	6.87e-6	0	2.83e-4	0	3.89e-2	0	0	0	0	1.55e-5	1.58e-5	3.32e-4
PENRT	MJ, net calorific value	1.21e+2	2.38e+1	8.60e+0	1.53e+2	1.40e+1	1.04e-1	0	2.02e+0	0	8.38e+2	0	0	0	0	1.07e+0	4.05e+0	4.20e+0
ADPF	MJ, net calorific value	1.35e+1	3.33e+0	6.46e-1	1.75e+1	1.96e+0	1.27e-2	0	2.16e-1	0	9.72e+1	0	0	0	0	1.51e-1	6.03e-1	4.94e-1
SM	kg	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
RSF	MJ, net calorific value	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
NRSF	MJ, net calorific value	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
RE	MJ	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
FW	m3	1.06e-1	2.69e-3	3.60e-3	1.12e-1	1.58e-3	7.61e-5	0	4.21e-3	0	5.71e-1	0	0	0	0	1.21e-4	4.01e-4	3.72e-3

Abbreviations:

RPRE or PERE = Renewable primary resources used as energy carrier (fuel), RPRM or PERM = Renewable primary resources with energy content used as material, RPRT or PERT = Total use of renewable primary resources with energy content, NRPRE or PENRE = Non-renewable primary resources used as an energy carrier (fuel), NRPRM or PENRM = Non-renewable primary resources with energy content used as material, NRPRRT or PENRT = Total non-renewable primary resources with energy content, SM: Secondary materials, RSF = Renewable secondary fuels, NRSF = Non-renewable secondary fuels, RE = Recovered energy, ADPF = Abiotic depletion potential, FW = Use of net freshwater resources, VOCs = Volatile Organic Compounds.

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Technical Service Life

Indicator	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
PERE	MJ, net calorific value	4.98e+0	2.25e-1	6.90e-1	5.89e+0	1.27e-1	3.44e-3	0	8.10e-2	0	1.81e+1	0	0	0	0	6.52e-3	1.26e-2	1.09e-1
PERM	MJ, net calorific value	7.92e+1	9.15e-2	1.59e-1	7.95e+1	4.97e-2	7.50e-4	0	6.71e-1	0	2.39e+2	0	0	0	0	2.55e-3	3.22e-3	2.27e-2
PERT	MJ, net calorific value	8.42e+1	3.16e-1	8.48e-1	8.54e+1	1.77e-1	4.19e-3	0	7.52e-1	0	2.57e+2	0	0	0	0	9.07e-3	1.59e-2	1.32e-1
PENRE	MJ, net calorific value	1.21e+2	2.38e+1	8.60e+0	1.53e+2	1.40e+1	1.04e-1	0	2.02e+0	0	5.03e+2	0	0	0	0	7.16e-1	2.70e+0	2.80e+0
PENRM	MJ, net calorific value	6.67e-3	3.68e-4	5.27e-4	7.56e-3	2.04e-4	6.87e-6	0	2.83e-4	0	2.33e-2	0	0	0	0	1.03e-5	1.05e-5	2.21e-4
PENRT	MJ, net calorific value	1.21e+2	2.38e+1	8.60e+0	1.53e+2	1.40e+1	1.04e-1	0	2.02e+0	0	5.03e+2	0	0	0	0	7.16e-1	2.70e+0	2.80e+0
ADPF	MJ, net calorific value	1.35e+1	3.33e+0	6.46e-1	1.75e+1	1.96e+0	1.27e-2	0	2.16e-1	0	5.83e+1	0	0	0	0	1.00e-1	4.02e-1	3.29e-1
SM	kg	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
RSF	MJ, net calorific value	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
NRSF	MJ, net calorific value	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
RE	MJ	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
FW	m3	1.06e-1	2.69e-3	3.60e-3	1.12e-1	1.58e-3	7.61e-5	0	4.21e-3	0	3.43e-1	0	0	0	0	8.08e-5	2.67e-4	2.48e-3

Abbreviations:

RPRE or PERE = Renewable primary resources used as energy carrier (fuel), RPRM or PERM = Renewable primary resources with energy content used as material, RPRT or PERT = Total use of renewable primary resources with energy content, NRPRE or PENRE = Non-renewable primary resources used as an energy carrier (fuel), NRPRM or PENRM = Non-renewable primary resources with energy content used as material, NRPRRT or PENRT = Total non-renewable primary resources with energy content, SM: Secondary materials, RSF = Renewable secondary fuels, NRSF = Non-renewable secondary fuels, RE = Recovered energy, ADPF = Abiotic depletion potential, FW = Use of net freshwater resources, VOCs = Volatile Organic Compounds.

Waste and Output Flow Indicators

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Market Service Life

Indicator	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
HWD	kg	1.71e-2	5.66e-4	2.71e-2	4.48e-2	3.48e-4	1.85e-4	0	1.08e-4	0	2.27e-1	0	0	0	0	2.68e-5	9.01e-5	9.31e-3
NHWD	kg	1.66e+0	1.04e+0	2.93e-1	2.99e+0	6.71e-1	2.44e-1	0	1.64e-2	0	1.96e+1	0	0	0	0	5.17e-2	2.20e-2	1.23e+1
RWD	kg	9.45e-5	4.96e-6	8.01e-6	1.07e-4	2.82e-6	7.91e-8	0	2.16e-6	0	5.52e-4	0	0	0	0	2.16e-7	3.97e-7	3.78e-6
CRU	kg	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
MFR	kg	0	0	2.57e-2	2.57e-2	0	0	0	0	0	1.28e-1	0	0	0	0	0	0	0
MER	kg	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
EEE	MJ	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
EET	MJ	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Abbreviations:

HWD = Hazardous waste disposed, NHWD = Non-hazardous waste disposed, RWD = Radioactive waste disposed, HLRW = High-level radioactive waste, ILLRW = Intermediate- and low-level radioactive waste, CRU = Components for re-use, MFR or MR = Materials for recycling, MER = Materials for energy recovery, MNER = Materials for incineration, no energy recovery, EE or EEE = Recovered energy exported from the product system, EET = Exported thermal energy.

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Technical Service Life

Indicator	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
HWD	kg	1.71e-2	5.66e-4	2.71e-2	4.48e-2	3.48e-4	1.85e-4	0	1.08e-4	0	1.36e-1	0	0	0	0	1.79e-5	6.01e-5	6.21e-3
NHWD	kg	1.66e+0	1.04e+0	2.93e-1	2.99e+0	6.71e-1	2.44e-1	0	1.64e-2	0	1.17e+1	0	0	0	0	3.44e-2	1.46e-2	8.18e+0
RWD	kg	9.45e-5	4.96e-6	8.01e-6	1.07e-4	2.82e-6	7.91e-8	0	2.16e-6	0	3.31e-4	0	0	0	0	1.44e-7	2.64e-7	2.52e-6
CRU	kg	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
MFR	kg	0	0	2.57e-2	2.57e-2	0	0	0	0	0	7.70e-2	0	0	0	0	0	0	0
MER	kg	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
EEE	MJ	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
EET	MJ	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Abbreviations:

HWD = Hazardous waste disposed, NHWD = Non-hazardous waste disposed, RWD = Radioactive waste disposed, HLRW = High-level radioactive waste, ILLRW = Intermediate- and low-level radioactive waste, CRU = Components for re-use, MFR or MR = Materials for recycling, MER = Materials for energy recovery, MNER = Materials for incineration, no energy recovery, EE or EEE = Recovered energy exported from the product system, EET = Exported thermal energy.

Carbon Emissions and Removals

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Market Service Life

Indicator	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
BCRP	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
BCEP	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
BCRK	kg CO2	-5.65e-2	0	0	-5.65e-2	0	0	0	0	0	-2.83e-1	0	0	0	0	0	0	0
BCEK	kg CO2	0	0	5.65e-2	5.65e-2	0	0	0	0	0	2.83e-1	0	0	0	0	0	0	0
BCEW	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
CCE	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
CCR	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
CWNR	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Abbreviations:

BCRP = Biogenic Carbon Removal from Product, BCEP = Biogenic Carbon Emission from Product, BCRK = Biogenic Carbon Removal from Packaging, BCEK = Biogenic Carbon Emission from Packaging, BCEW = Biogenic Carbon Emission from Combustion of Waste from Renewable Sources Used in Production Processes, CCE = Calcination Carbon Emissions, CCR = Carbonation Carbon Removals, CWNR = Carbon Emissions from Combustion of Waste from Non-Renewable Sources used in Production Processes, GWP-luc = Carbon Emissions from Land-use Change.

per 1 m2 of covered and protected flooring surface for a period of 60 years.

Industrial - Technical Service Life

Indicator	Unit	A1	A2	A3	A1A2A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4
BCRP	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
BCEP	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
BCRK	kg CO2	-5.65e-2	0	0	-5.65e-2	0	0	0	0	0	-1.70e-1	0	0	0	0	0	0	0
BCEK	kg CO2	0	0	5.65e-2	5.65e-2	0	0	0	0	0	1.70e-1	0	0	0	0	0	0	0
BCEW	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
CCE	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
CCR	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
CWNR	kg CO2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0

Abbreviations:

BCRP = Biogenic Carbon Removal from Product, BCEP = Biogenic Carbon Emission from Product, BCRK = Biogenic Carbon Removal from Packaging, BCEK = Biogenic Carbon Emission from Packaging, BCEW = Biogenic Carbon Emission from Combustion of Waste from Renewable Sources Used in Production Processes, CCE = Calcination Carbon Emissions, CCR = Carbonation Carbon Removals, CWNR = Carbon Emissions from Combustion of Waste from Non-Renewable Sources used in Production Processes, GWP-luc = Carbon Emissions from Land-use Change.

Scenarios

Transport to the building/construction site (A4)

A4 Module

Fuel Type:	Diesel
Vehicle Type:	Truck and Trailer
Transport Distance:	1500 km
Capacity Utilization:	33 %
Packaging Mass:	1.391 kg
Gross density of products transported:	1097 kg/m ³
Weight of products transported:	12.665 kg
Volume of products transported:	0.012 m ³
Capacity utilization volume factor:	1
Assumptions for scenario development:	Transport distance includes finished product to distribution center and distribution center to point of sale.- Passenger van assumed for point of sale to application site, with a distance of 8km using same packaging and capacity assumptions.

Installation in to the building/construction site (A5)

A5 Module

Product Lost per Functional Unit:	0.25 kg
Mass of Packaging Waste Specified by Type:	1.391 kg
VOC Test Method:	ASTM D-2369

Reference Service Life

B1 Module

RSL:	60 Years
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Declared Product Properties:

Environmentally friendly, advanced hybrid technology coating designed for aggressive immersion applications. Provides protection against microbiologically induced corrosion (MIC) and hydrogen sulfide corrosion found in wastewater treatment service. UL approved for ANSI/NSF Std. 61 potable water (if manufactured at a certified location). Certified by UL to meet the drinking water criteria of NSF/ANSI/CAN 600. Complies with 21 CFR 175.300 Method D, E, & G and Direct Dry Food Contact. Complies with Greenbook. Passes ASTM G210 - Severe Wastewater Analysis Tests (SWAT). Cold temperature cure. Fast cure and walk on time. Excellent barrier properties, low permeability. Single-coat application 60 to 125 mils. Bridges normal shrinkage cracks in concrete. true monolithic film on steel and concrete. Encapsulates rivets, bolts, and edges in one coat. Outstanding abrasion, impact and tear resistance. Combines polyurethane and polyurea technologies to form a hybrid polyurethane. VOC value: 0. This product is part of a coating system consisting of primer (for concrete in some conditions) and single coat. Dudick's Primer 67LV was included as part of the system in the LCA model.

Design Application Parameters:

Plural component airless spray is the required method of application. Substrate temperature for metal must be between 35°F and 140°F. Relative humidity must not exceed 95%. Application on substrate from 110 to 140°F will require special application techniques, please consult Technical Service for details. Industry standards are for substrate temperatures to be 5°F (3°C) above the dew point. Caution: This product has some moisture tolerance, but it can be moisture sensitive depending on conditions. Excessive material temperatures can reduce film build. This product requires onsite mixing. Cure cycle is temperature-dependent and affected by direct sunlight. Consult product technical data sheet for detailed application parameters.

An Assumed Quality of Work, When Installed in Accordance with The Manufacturer's Instructions:

Excellent immersion protection, including against microbiologically induced corrosion (MIC) and hydrogen sulfide corrosion, is achieved when installed in accordance with manufacturer's instructions. Theoretical coverage is 21.5 ft²/gal at 92.5 mils.

Outdoor Environment:

Reactamine 760 will tend to yellow or darken in exterior UV exposure but will not affect performance.

Maintenance:

Maintenance (B2)

B2 Module

Maintenance Cycle:

60 Cycles/RSL

60 Cycles/ESL

Maintenance Process Information:

Daily mopping with a cleaning solution such as Hillyard SM-1® Industrial Cleaner Degreaser, at a ratio of 1/2 cup cleaning solution to 1 gallon of mop water, is included as a required maintenance activity per the PCR.

Replacement (B4)

B4 Module

Reference Service Life:

10 Years

Replacement Cycle:

5 (ESL/RSL)-1

Further assumptions for scenario development:

Product is assumed to be applied in an industrial environment. A 10 year market service lifetime and a 15 year technical service lifetime was adopted in the LCA model. For the market service-based lifetime, one initial coating application and 5 recoats are required to maintain the average lifespan of a building, assumed to be 60 years. For the technical service-based lifetime, one initial coating application and 3 recoats are required to maintain the 60 year building lifespan.

End of Life

C1 - C4 Modules

Collection Process

Collected Separately:

12.665 kg

Recovery

Landfill:

12.665 kg

Incineration:

0.253 kg

Disposal

Product or Material for Final Disposal:

12.665 kg

Assumptions for scenario development:

The US EPA WARM model was used to determine the processes used to dispose of waste materials, including packaging materials, scrap, hazardous waste, and unused product.

Interpretation

Data was collected for 12 month periods spanning calendar years 2022 and 2023 to ensure the representativeness of business activities and post-consumer materials. Manufacturing data represents Carboline's production facilities in Green Bay, Wisconsin and Lake Charles, Louisiana. Secondary data was obtained from ecoinvent v3.9.1, representing the most recent years available. The overall quality of the data used is considered representative of the product systems.

The system boundary is cradle to grave, excluding: construction of major capital equipment; research and development activities; point of sale infrastructure; coating applicator and its maintenance and operation; human labor and employee transport; raw material, forming, and disposal impacts from secondary/tertiary packaging; disposal of packaging materials not associated with final product; impacts associated with tool (mop) required for maintenance cleaning; building operational energy and water use; deconstruction and demolition.

Overall, the production and construction stages (modules A1-A5) combined with the replacement module of the use stage (B4), have the highest impact across all impact categories, followed by the end-of-life stage (C1-C4). Note that the B4 module includes the A1-A5 modules for each recoat required for the product's lifetime. The upstream raw material phase (A1) is the primary contributor to all impact categories. This is largely due to the number of different raw material processes required to produce the product.

The construction phase (A4-A5), includes the transportation of the product from manufacturing to the customer. The highest impact categories in this phase include ecotoxicity, fossil fuel depletion, and global warming. The transportation miles from the point of sale to the application site (A4) account for low impacts across all impact categories. Installation (A5) is the primary driver in this stage for environmental impacts due to disposal of product packaging waste.

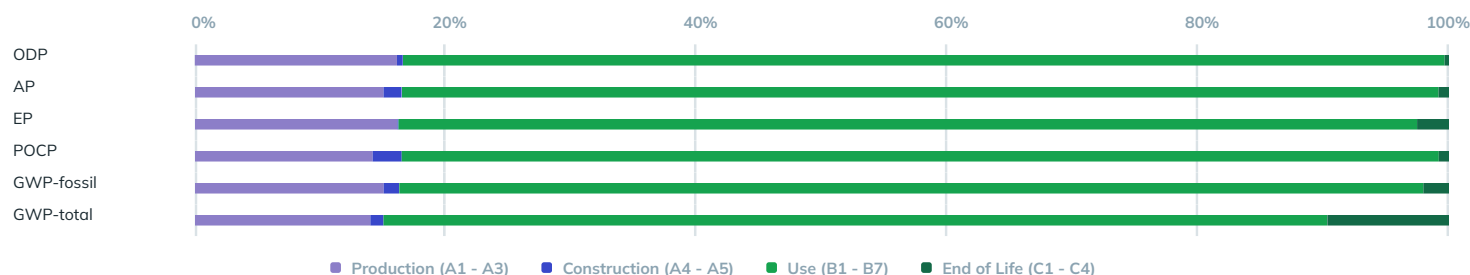
The use phase includes maintenance cleaning and recoats of the product. The maintenance of the product provides marginal contribution to the overall impact categories. As mentioned above, the replacement module (B4) is the primary impact driver for all the products.

The end-of-life phase (C1-C4) is the second most impactful lifecycle stage. Disposal contributes the highest to eutrophication, ecotoxicity, and non-carcinogens. Acidification and ozone depletion have the lowest impacts in this phase. Transportation to the disposal point phase (C2) has a relatively small contribution to all product life cycle impacts.

Limitations are as follows:

- The study is only applicable to the defined scenarios.
- Environmental declarations from different programs may not be comparable (ISO 14025:2006). Even when the same PCR is followed, different LCA software and background LCI datasets may lead to different results for upstream or downstream of the life cycle stages declared.
- With the current availability of data, it is nearly impossible to follow the entire supply chain associated with the product in a company-specific way. Many of the processes within the supply chains are modeled using average industry data with varying amounts of specificity (e.g., data on a more-or-less specific technology or region). This makes it difficult to accurately determine how well the unit process data represents the actual factors in the products' life cycle.
- Primary data was modeled based on information provided by Carboline, supplemented by data from technical and safety data sheets. Proxy materials were used when suitable secondary data sets were not available.
- Material input and transportation distances are presented as averages and may not account for variations in material efficiency and supplier locations.
- While generic data sets used for material inputs, transport, and waste processing are of good quality, actual impacts from material suppliers, transport carriers, and local waste processing may differ.
- Datasets used in some instances were older than 10 years, but were judged best representation available.
- The impact assessment methodology categories do not encompass all potential environmental impact categories.
- Characterization factors used within the impact assessment methodology may entail varying levels of uncertainty.
- LCA results are expressed relatively and should not be interpreted as predicting impacts on specific environmental categories, exceeding thresholds, safety margins, or risks.

The overall data quality assessment score is judged to be "good". This judgement includes an assessment of "good" for the modeling of technology (primary drivers of model emissions are modeled using the same or similar but different technology), "fair" for time representation (dominant emissions sources are primarily within 10 years of age), and "good" for geography, completeness, and reliability, which are based on comprehensive primary data collection.



Additional Environmental Information

Before using this product, it is recommended that the operator read and follow all caution statements on the product data sheet and on the SDS for this product, and personal protective equipment must be used as directed.

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- [12] Facts and figures about materials, waste and recycling (2018). <https://www.epa.gov/facts-and-figures-about-materials-waste-and-recycling>.