

## **ENVIRONMENTAL PRODUCT DECLARATION**

**no. 02-01/2025**



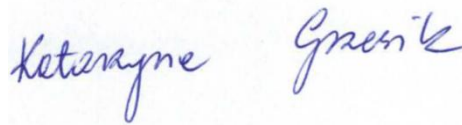
**Fire-resistant glass GAIA**

**POLFLAM Sp. z o.o.**



*Owner of the EPD:* **POLFLAM Sp. z o.o.**  
*Programme owner:* **Łukasiewicz Research Network - Institute of Ceramics and Building Materials**  
*Name of programme:* **Environmental Product Declaration – B2B**  
*Date of issued:* **24.01.2025**  
*Valid until:* **24.01.2030**

**1. GENERAL DATA**

<b>Product of declaration:</b>	Fire resistant glass POLFLAM GAIA: <ul style="list-style-type: none"> <li>• EI, EW, FR 16-20 mm,</li> <li>• EI, EW, FR 21-55 mm,</li> <li>• BR 30-45 mm.</li> </ul>
<b>Program owner:</b> Łukasiewicz Research Network– Institute of Ceramics and Building Materials Environmental Engineering Center in Opole. <a href="http://www.icimb.pl/opole/">http://www.icimb.pl/opole/</a>	<b>Owner of declaration:</b> POLFLAM Sp. z o.o. Jeziorzany, Aleja Krakowska 3 05-555 Tarczyn Telefon: +48 22 726 92 17 Adres: info@polflam.pl <a href="https://www.polflam.pl/">https://www.polflam.pl/</a>
<b>Declared unit:</b>	1 m <sup>2</sup>
<b>Date of issue:</b>	24.01.2025
<b>Declaration valid until:</b>	24.01.2030
<b>Life Cycle Analysis (LCA):</b>	A1-A3, A4, C1-C4 and D according to PN-EN 15804+A2 (Cradle-to-Gate with options)
<b>Product Categorization (PCR) Rules</b>	PN-EN 15804+A2:2020-03 Sustainability of construction works. Environmental Product Declarations. Basic principles of categorization of construction products, ICIMB-PCR A
<b>Representatives:</b>	Polish product, year 2023
<b>Declared durability:</b>	30 years
<b>Reasons for performing LCA:</b>	B2B
<b>Standardy produktu</b>	PN-EN 12543-4
<b>Declarations that are the result of different programs or are not performed in accordance with the standard may not be comparable.</b>	
The Łukasiewicz – Institute of Ceramics and Building Materials Environmental Engineering Center provides access to the Type III environmental declaration for fire-resistant glass POLFLAM GAIA to interested parties.	
<b>The declaration owner is responsible for the information and the base evidence. Łukasiewicz Research Network - Institute of Ceramics and Building Materials Center for Environmental Engineering is not responsible for the manufacturer's information and data and evidence regarding the life cycle assessment.</b>	
<b>Authors' team:</b> Katarzyna Kiprian, M.Sc. Ewa Głodek-Bucyk, Ph.D. Patrik Okoń, M.Sc. <b>Approved:</b>  Joanna Poluszyńska, PhD Director of the Environmental Engineering Center  Ewa Głodek-Bucyk, Ph.D. Leader of the Process Engineering Research Group	<b>Review:</b> CEN standard PN-EN 15804+A2 serves as the main PCR document. Independent verification of declarations and data according to EN ISO 14025:2010  <input type="checkbox"/> Internal <input checked="" type="checkbox"/> External   Katarzyna Grzesik, PhD, DSc

## 2. MANUFACTURER AND PRODUCT DESCRIPTION

POLFLAM has been in the glass industry since 1992 and has specialized in the production and sale of fire-resistant glass since 2005. In February 2019 the acquisition of POLFLAM by Baltisse was completed.

The company has been cooperating since many years with system providers of steel, aluminium and timber systems making Polflam fire-resistant glass available in a wide range of systems for every market. Today POLFLAM is a completely independent manufacturer of fire-resistant glass: from technology to research and production.

POLFLAM GAIA is the world's first low-carbon fire-resistant glass. It has been skillfully crafted by combining our hydrogel technology developed by POLFLAM's research lab with the distinctive attributes of low-carbon float glass. Employing environmentally conscious methods, such as the use of alternative fuels, renewable energy, and raw material recycling, this glass ensures a significantly reduced carbon footprint.

We also offer additional product-related services:

- laboratory facilities for testing fire-resistant glass and complete fire-resistant systems
- advisory services and trainings

POLFLAM<sup>®</sup> is a synonym for product quality, reliable and comprehensive service at every stage of the project.

The group of products covered by the declaration are as follows:

- ◆ Fire-resistant glass EW GAIA
- ◆ Fire-resistant glass EI GAIA
- ◆ Fire-resistant glass BR GAIA
- ◆ Fire-resistant glass FR GAIA

The indicative composition of products covered by the declaration is presented in the table below. The percentage depends on the type of product.

**Table 1** Indicative composition of the products

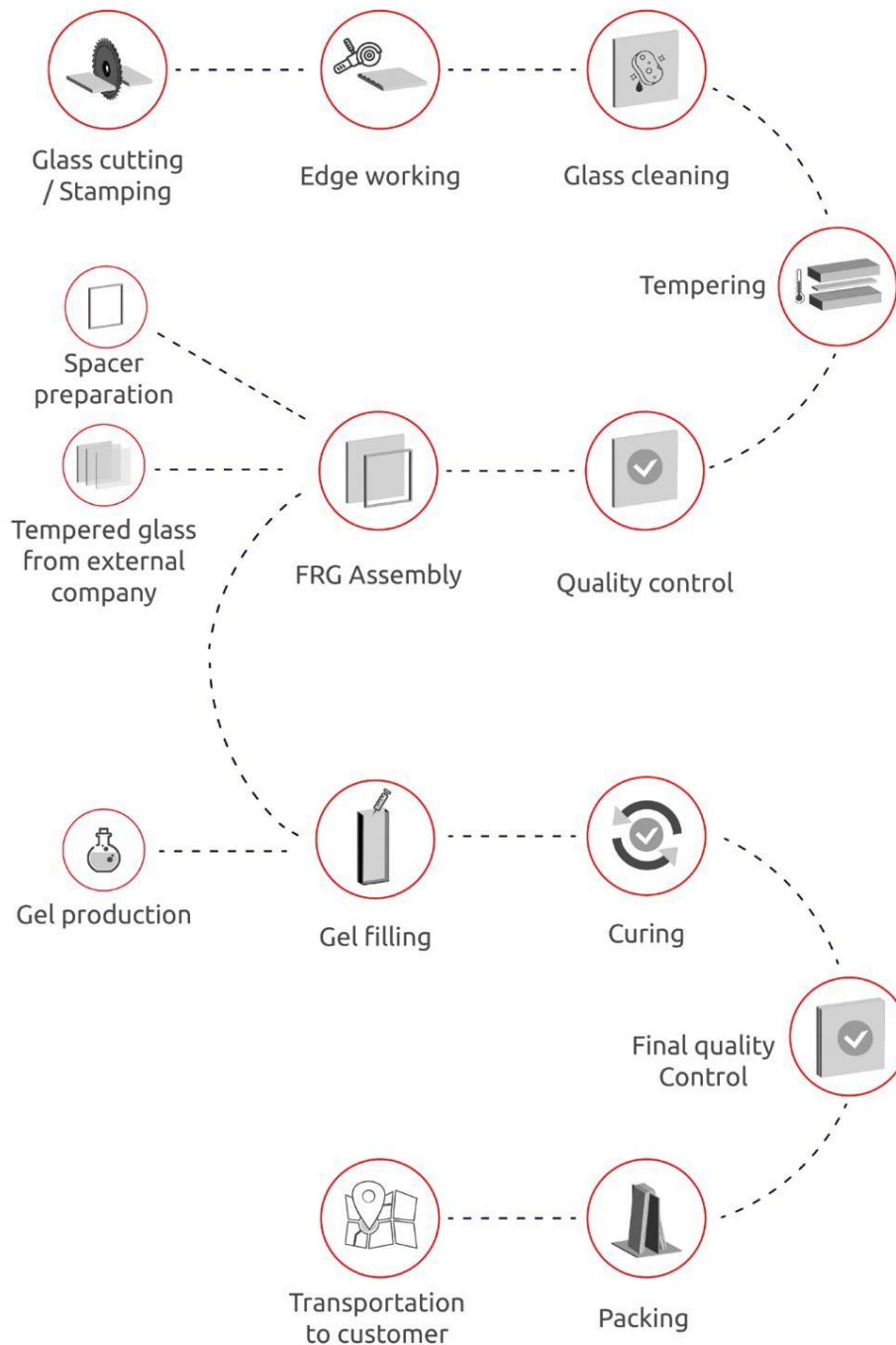
Material	Mass fraction [%]
Glass	50-80
Fire protection interlayer (Hydrogel)	20-40
Sealants	2-6
Spacer	2-6

POLFLAM GAIA fire-resistant glass production begins with the arrival of large-sized low-carbon glass panes, which are then transferred to an automated warehouse connected to the horizontal cutting tables. The glass is cut to the required sizes and marked with a product and an unique ID code for traceability purposes and after that loaded onto an initial sorting system which organizes the material flow. Based on customer requirements, the glass then undergoes special edge treatment: seaming, grinding or polishing. The glass sheets are thoroughly cleaned in the washing machine and then transferred to the tempering furnaces. After the tempering process, the glass panes re-enter the downstream sorting system, where they are awaiting for an assembly process.

The assembly process begins with a vertical washing machine where the glass panes undergo a thorough cleaning process. Each pane undergoes careful inspection in a quality control scanner. Meanwhile, our dedicated team produces the necessary spacer bars for the assembly.

Once the quality control check is completed, the spacer bars are installed between the glass panes. Our assembly process involves combining two glass units separated by spacer bar and primary sealant, forming a cavity that is later filled with a hydrogel. The glass edge is precisely sealed with secondary sealant, ensuring maximum tightness of the cavity. After drying of the edge sealant the cavity is being filled with the hydrogel and then it undergoes

the curing process, further enhancing the performance of POLFLAM glass.  
Before being packed on stillages, each glass unit with applied product labels undergoes a final quality control in accordance with our stringent internal guidelines. This ensures that every glass unit meets our highest quality standards.  
Finally, our finished glass unit is securely packed on either steel or wooden stillages and carefully wrapped with foil.  
The safely packed glass units are then loaded onto trucks, ready for delivery to their final destination.



**Figure 1:** The production diagram of fire-resistant POLFLAM GAIA produced by POLFLAM Sp. z o.o.

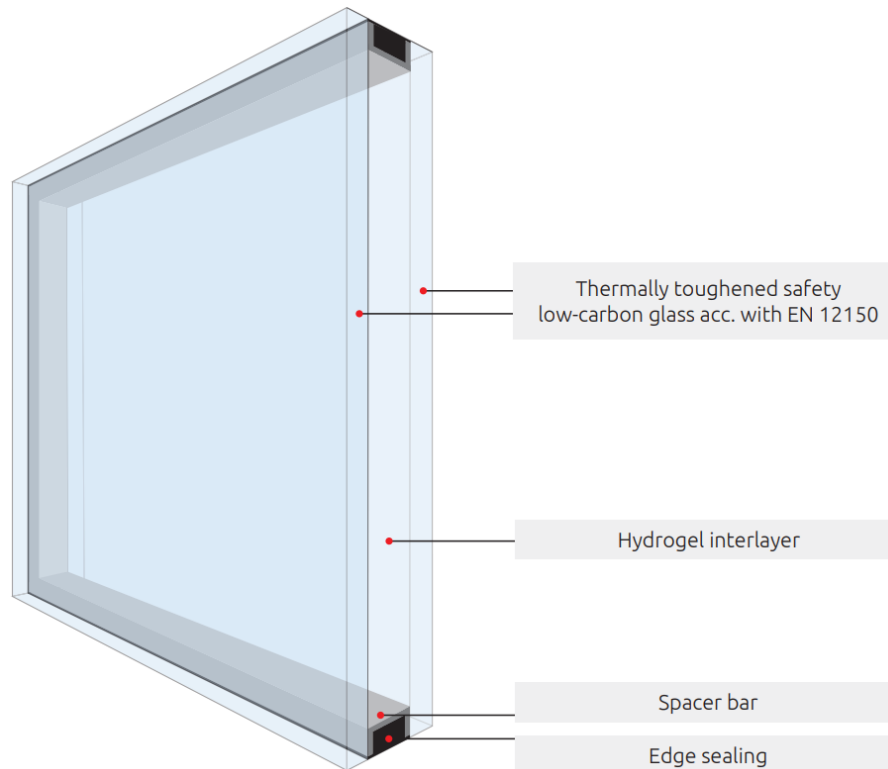
POLFLAM EI GAIA and POLFLAM EW GAIA are fully transparent fire-resistant glasses for various applications. POLFLAM EI GAIA fire-resistant glass meets integrity with full thermal insulation and POLFLAM EW GAIA fire-resistant glass meets integrity with reduced heat radiation. The two product families are based on the hydrogel technology developed by POLFLAM<sup>®</sup> and meets requirements of EN 14449. Monolithic POLFLAM EI GAIA and POLFLAM EW GAIA fire-resistant glass consist of two thermally toughened safety low-carbon glass panes according to EN 12150 with a minimum thickness of 5 mm, separated by a metal or composite spacer bar around the edges of the glass and a single cavity filled with a hydrogel interlayer with a minimal thickness of 6 mm. The spacer bar with applied Butyl on both sides as primary seal is positioned between the two glass panes and sealed around the perimeter with Polysulphide or Silicone as secondary seal. The hydrogel is produced at POLFLAM factory according to the company's own proprietary formula.

Monolithic POLFLAM EI GAIA and POLFLAM EW GAIA fire-resistant glass are designed for internal applications and as Insulated Glass Units for external building applications.

POLFLAM EI GAIA and POLFLAM EW GAIA fire-resistant glass are available in the fire resistance classes according to EN 13501-2:

- EI 15 up to EI 180
- EW 30 up to EW 120

Construction of the fire-resistant glass is presented below:



**Figure 2:** Diagram of the construction of fire -resistant glass produced by POLFLAM Sp. z o.o.

**DESCRIPTION AND APPLICATION OF PRODUCTS:**

Monolithic POLFLAM GAIA fire-resistant glass, made from 5 mm thermally toughened safety low-carbon glass, is used in internal partitions, windows, doors, and facades.

**Table2** Technical data - monolithic fire-resistant glass POLFLAM GAIA EW, EI.

POLFLAM GAIA		EI 15	EI 30	EI 60		EI 90		EI 120		EI 180
Nominal thickness [mm]		16	20	25	28	32	35	35	40	55
Thickness tolerance [mm]		± 2	± 2	± 2	± 2	± 3	± 3	± 3	± 3	± 3
Weight [kg/m <sup>2</sup> ]		33	38	45	49	52	57	57	64	83
Fire resistance	EN 13501-2	EI 15	EI 30	EI 60	EI 60	EI 90	EI 90	EI 120	EI 120	EI 180
Light transmittance $\tau_v$ [%]	EN 410	88*	87	87	87	85	87	87	86	85
Total solar energy transmittance g [%]	EN 410	73*	72	70	71	68	70	70	68	66
Thermal properties $U_g$ [W/m <sup>2</sup> K]	EN 673	4.8*	4.4	4.0*	3.7	3.6*	3.3	3.3	3.0	NPD
Sound reduction index $R_w$ (C; C <sub>v</sub> ) [dB]	EN 12758	41 (-2; -3)	42 (-2; -3)	44 (-2; -4)	45 (-1; -3)	45 (-2; -3)	47 (-1; -4)	47 (-1; -4)	48 (-1; -4)	45 (-1; -4)
Pendulum body impact resistance	EN 12600	1(B)1								
Reaction to fire	EN 13501-1	B-s1, d0								
Max. temperature range		-40 °C / +50 °C								
Curved glass		yes								

\* estimated value

POLFLAM GAIA		EW 30		EW 60		EW 90		EW 120	
Nominal thickness [mm]		16	20	16	20	16	20	16	20
Thickness tolerance [mm]		± 2	± 2	± 2	± 2	± 2	± 2	± 2	± 2
Weight [kg/m <sup>2</sup> ]		33	38	33	38	33	38	33	38
Fire resistance	EN 13501-2	EW 30	EW 30	EW 60	EW 60	EW 90	EW 90	EW 120	EW 120
Light transmittance $\tau_v$ [%]	EN 410	88*	87	88*	87	88*	87	88*	87
Total solar energy transmittance g [%]	EN 410	73*	72	73*	72	73*	72	73*	72
Thermal properties $U_g$ [W/m <sup>2</sup> K]	EN 673	4.8*	4.4	4.8*	4.4	4.8*	4.4	4.8*	4.4
Sound reduction index $R_w$ (C; C <sub>v</sub> ) [dB]	EN 12758	41 (-2; -3)	42 (-2; -3)	41 (-2; -3)	42 (-2; -3)	41 (-2; -3)	42 (-2; -3)	41 (-2; -3)	42 (-2; -3)
Pendulum body impact resistance	EN 12600	1(B)1							
Reaction to fire	EN 13501-1	B-s1, d0							
Max. temperature range		-40 °C / +50 °C							
Curved glass		yes							

\* estimated value

**POLFLAM BR GAIA fire-resistant glass**

POLFLAM BR GAIA fire-resistant glass can be installed with the vertical sides of the glasses directly connected (butt-joint) to each other without the use of vertical posts or framing system and is based on a 10 mm thermally toughened safety low-carbon glass.

**Table 3** Technical data - monolithic fire-resistant glass POLFLAM GAIA BR

POLFLAM BR GAIA		EI 30	EI 60		EI 90	EI 120
Nominal thickness [mm]		30	35	38	45	50
Thickness tolerance [mm]		± 2	± 3	±3	± 3	± 3
Weight [kg/m <sup>2</sup> ]		65	69	75	82	90
Fire resistance	EN 13501-2	EI 30	EI 60	EI 60	EI 90	EI 120
Light transmittance $\tau_v$ [%]	EN 410	84	84	84	84	84
Total solar energy transmittance g [%]	EN 410	68	67	67	64	66
Thermal properties $U_g$ [W/m <sup>2</sup> K]	EN 673	4.6*	4.2*	3.6*	3.8*	2.9
Sound reduction index $R_w$ (C; $C_w$ ) [dB]	EN 12758	44 (-2; -3)	44 (-2; -3)	44 (-1; -3)	47 (-2; -3)	46 (-1; -3)
Pendulum body impact resistance	EN 12600	1(B)1				
Reaction to fire	EN 13501-1	B-s1, d0				
Max. temperature range		-40 °C / +50 °C				
Curved glass		yes				

\* estimated value

**Monolityczne szkło ogniochronne POLFLAM GAIA FR**

POLFLAM FR GAIA fire-resistant glass can be installed in the FR System allowing fire-resistant glass to be installed directly in openings of walls of various materials without the need for a commercial fire-resistant framing system and is based on a 5 mm thermally toughened safety low-carbon glass.

**Table 4** Technical data - monolithic fire-resistant glass POLFLAM GAIA FR.

POLFLAM FR GAIA		EI 30	EI 60	EI 90	EI 120	EI 180
Nominal thickness [mm]		20	25	35	35	55
Thickness tolerance [mm]		± 2	± 3	±3	± 3	± 2
Weight [kg/m <sup>2</sup> ]		38	45	57	57	83
Fire resistance	EN 13501-2	EI 30	EI 60	EI 90	EI 120	EI 180
Light transmittance $\tau_v$ [%]	EN 410	87	87	87	87	85
Total solar energy transmittance g [%]	EN 410	72	70	70	70	66
Thermal properties $U_g$ [W/m <sup>2</sup> K]	EN 673	4.4	4.0*	3.3	3.4*	NPD
Sound reduction index $R_w$ (C; $C_w$ ) [dB]	EN 12758	44 (-2; -3)	44 (-2; -4)	47 (-1; -4)	45 (-1; -4)	45 (-1; -4)
Pendulum body impact resistance	EN 12600	1(B)1				
Reaction to fire	EN 13501-1	B-s1, d0				
Maximum temperature range		-40 °C / +50 °C				
Curved glass		yes				

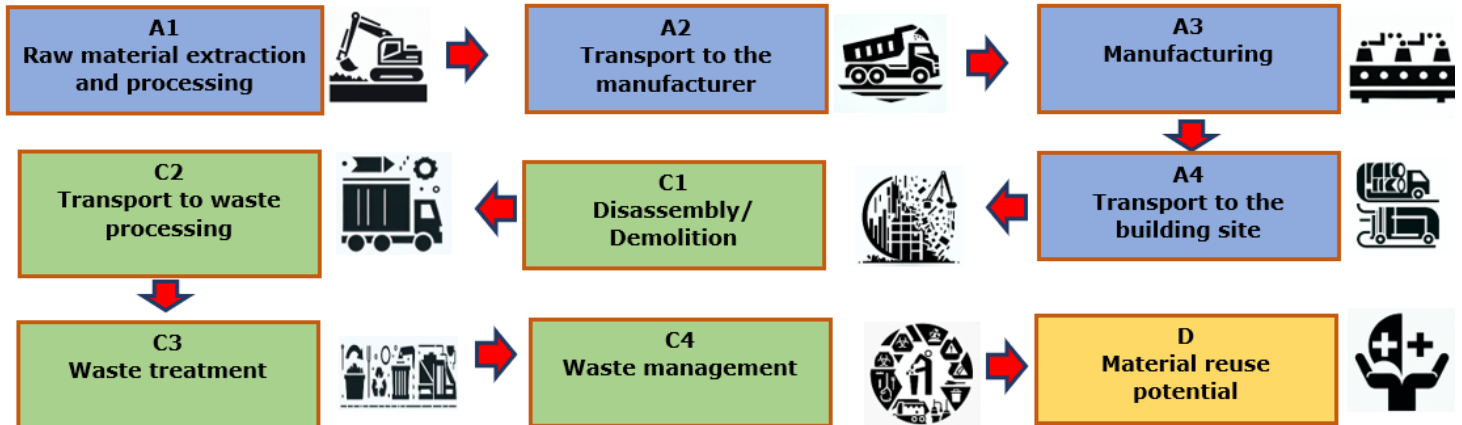
\* estimated value

### 3. LCA: CALCULATION RULES

The environmental declaration is based on average data provided by the owner of the declaration POLFLAM Sp. z o.o. for production plant located in Jeziorzany

#### System limitations

The life cycle analysis of the tested products includes modules A1-A3, C1-C4 and D (Cradle to Gate with options) in accordance with EN 15804.



#### Data collection period

Data on the production process were provided in 2024 for the period 01.01.2023 - 31.12.2023 (12 months) and correspond to the production technology of the time

#### Declared unit

**1 m<sup>2</sup>**

#### Assumptions

**A1** – extraction and consumption of raw materials refers to specific mass shares in the production process, per unit declared of the product,

**A2** – distances from the place of obtaining raw materials to the production plant individual for each raw material, means of transport differentiated due to the method of delivery of raw materials,

**A3** – CO<sub>2</sub>, NO<sub>x</sub>, SO<sub>2</sub> and dust emission values from the production process obtained as a result of estimation based on fuel consumption,

**A4** – refers to the transport of the final product to the construction site is treated as the average weight values of transports to customers,

**C1** - describes the handling of POLFLAM GAIA fire-resistant glass during disassembly/demolition. Calculations are made on the basis of the developed scenario,

**C2** – refers to the transport of construction waste to a recovery or disposal plant. Calculations are made on the basis of the developed scenario,

**C3** – takes into account the environmental impact during the processing of demolition waste containing elements of POLFLAM GAIA fire-resistant glass in a waste recovery plant. Calculations are made on the basis of the developed scenario,

**C4** – takes into account the environmental impact of storage and recycling of POLFLAM GAIA fire-resistant glass elements. Calculations are made on the basis of the developed scenario,

**D** – concerns the impact and effects of the use of secondary material. The calculations are performed based on the developed scenario.

<b>Cut-off-criteria</b>	99% of all bulk streams involved in the production process were taken into account. All the energy used in the process was taken into account in the environmental declaration.
<b>General data</b>	<p>The data for the calculations come from Ecoinvent v. 3.10 and have been supplemented with KOBiZE <i>CO<sub>2</sub>, SO<sub>2</sub>, NO<sub>2</sub>, CO and total particulate matter emission indicators for electricity, December 2024.</i></p> <p>Emission factors for electricity were determined using the actual KOBiZE data. The Polish electricity emission factor (Ecoinvent supplemented with current national data from KOBiZE) is 0.597 kg CO<sub>2</sub>/kWh. A detailed analysis of data quality was part of an external audit</p>
<b>Allocation</b>	All data on the components manufactured in the plant were provided by the owner of the declaration POLFLAM Sp. z o.o. and were referred to the declared unit of the product – 1 m <sup>2</sup> . The allocation rules used in this EPD are based on the general ICIMB-PCR A principles.

#### **4. LCA: SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION**

The life cycle assessment has been developed in accordance with the requirements of PN-EN ISO 15804+A2:2020, PN-EN ISO 14025 and PN-EN ISO 14040. The rules for product categorization have been adopted in accordance with the PN-EN 15804 standard.

For the life cycle analysis of products covered by the cradle to gate with options environmental declaration, scenarios have been developed for modules A4, C1-C4 and D:

**Module A4 – Transport to the construction site** – Transport is carried out by trucks with a load capacity of 16-32 tons meeting the EURO 6 emission standards, the average distance from the plant to the customer is 350 km – data from the customer. Transport with 100% load capacity was assumed for the calculations.

**Module C1 - Demolition/Demolition** – Manual demolition and initial sorting of waste on site were adopted. The consumption of energy and other raw materials in this module has been omitted due to negligible values. The separated fractions from the fire-resistant glass separation are directed to the waste treatment plant. The modulus is zero.

**Module C2 – Transport** – Waste is transported to the treatment plant, where, after separating the recyclable fraction and the fraction intended for landfill, the appropriate quantities are directed to further processes.

- 100% of the waste constituting used fire-resistant glass is transported to a recovery plant. It is assumed that 70% of fire-resistant glass is recycled and 30% is landfilled.
- Transport is carried out by trucks with a load capacity of 7.5-16 tons, meeting the EURO 6 emission standards.
- Transport to the recycling plant and to the landfill takes place at a distance of 100 km from the demolition site.

**Module C3 - Waste treatment** - All waste goes to the waste treatment plant. Electricity consumption per 1 kg of waste is 0.03 kWh/kg, and fuel consumption is 0.315 MJ/kg. The following processes were assumed for the calculations: unloading (loader), crushing (crusher.)

**Module C4 – Waste management** – It has been assumed that waste that can no longer be used in any other way is sent to the landfill. These are wastes separated in the processing process (module C3).

**Module D - Material reuse potential** - for fire-resistant glass, it is assumed that 70% of the product is recycled.

## 5. LCA: RESULTS

The table below shows the LCA modules included in the calculation of the environmental impact categories for the products covered by the declaration.

<b>SYSTEM BOUNDARIES (X –MODULE INCLUDED IN LCA, MND – MODULE NOT DECLARED)</b>																
Products stage			Construction process stage		Use stage							End-of-life stage				Benefits and loads beyond the system boundary
Raw material supply	Transport	Production	Transport	Construction process	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction	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	MND	MND	MND	MND	MND	MND	MND	MND	X	X	X	X	X

The following tables present the results of the LCA analysis for fire-resistant glass GAIA. Explanations of the abbreviations used to describe the impact categories are given below:

<b>GWP-total</b>	Global warming potential
<b>GWP-fossil</b>	Global warming potential fossil fuel
<b>GWP-biogenic</b>	Global warming potential biogenic
<b>GWP-luluc</b>	Global warming potential land use and land change
<b>ODP</b>	Depletion potential of the stratospheric ozone layer
<b>AP</b>	Acidification potential of land and water
<b>EP-freshwater</b>	Eutrophication potential, fraction of nutrients reaching freshwater end compartment
<b>EP-marine</b>	Eutrophication potential, fraction of nutrients reaching marine end compartment
<b>EP-terrestrial</b>	Eutrophication potential, Accumulated Exceedance
<b>POCP</b>	Formation potential of tropospheric ozone photochemical oxidants
<b>ADP-minerals&amp;metals</b>	Abiotic depletion potential for nonfossil resources
<b>ADP-fossil</b>	Abiotic depletion potential for fossil resources
<b>WDP</b>	Water (user) deprivation potential
<b>PM</b>	Potential incidence of disease due to PM emissions
<b>IRP</b>	Potential Human exposure efficiency relative to U235
<b>ETP-fw</b>	Potential comparative Toxic Unit for ecosystems
<b>HTP-c</b>	Potential comparative Toxic Unit for humans (cancerogenic)
<b>HTP-nc</b>	Potential comparative Toxic Unit for humans (non-cancerogenic)
<b>SQP</b>	Potential soil quality index
<b>PERE</b>	Use of renewable primary energy excluding renewable primary energy resources used as raw materials
<b>PERM</b>	Use of renewable primary energy resources used as raw materials
<b>PERT</b>	Total use of renewable primary energy resources
<b>PEN-RE</b>	Use of non-renewable primary energy resources excluding non-renewable primary energy resources used as raw materials
<b>RE</b>	Use of non-renewable primary energy resources used as raw materials
<b>PENRT</b>	Total use of non-renewable primary energy resources

**SM** Use of secondary material  
**RSF** Use of renewable fuels  
**NRSF** Use of non-renewable secondary fuels  
**FW** Use of net fresh water

**MAIN IMPACT INDICATORS: 1 m<sup>2</sup> POLFLAM GAIA EI, EW, FR 16-20 mm**

Life Cycle Stage											
Indicator	Unit	A1	A2	A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO <sub>2</sub> eq.	2,52E+01	1,43E+01	1,55E+01	6,66E-02	0,00E+00	0,00E+00	4,02E-01	8,42E-01	2,03E-02	-5,50E-01
GWP-fossil	kg CO <sub>2</sub> eq.	2,54E+01	1,43E+01	1,92E+01	6,65E-02	0,00E+00	0,00E+00	4,02E-01	8,41E-01	2,02E-02	-4,93E-01
GWP-biogenic	kg CO <sub>2</sub> eq.	-2,10E-01	9,90E-03	-3,71E+00	4,61E-05	0,00E+00	0,00E+00	2,35E-04	9,40E-04	5,18E-05	-5,68E-02
GWP-luluc	kg CO <sub>2</sub> eq.	1,78E-02	4,75E-03	3,97E-02	2,21E-05	0,00E+00	0,00E+00	1,27E-04	4,11E-04	3,23E-06	-2,17E-04
ODP	kg CFC11 eq.	1,23E-06	2,84E-07	8,86E-08	1,32E-09	0,00E+00	0,00E+00	8,03E-09	9,41E-09	7,55E-10	-4,52E-09
AP	mol H+ eq.	2,70E-01	2,98E-02	7,88E-02	1,39E-04	0,00E+00	0,00E+00	7,89E-04	6,38E-03	2,44E-04	-1,71E-03
EP-freshwater	kg PO <sub>4</sub> eq.	6,67E-03	9,69E-04	2,02E-02	4,50E-06	0,00E+00	0,00E+00	2,63E-05	3,10E-04	9,21E-07	-2,20E-05
EP-marine	kg N eq.	5,59E-02	7,15E-03	1,52E-02	3,33E-05	0,00E+00	0,00E+00	1,86E-04	2,66E-03	5,39E-05	-1,06E-03
EP-terrestrial	mol N eq.	6,54E-01	7,72E-02	1,25E-01	3,59E-04	0,00E+00	0,00E+00	2,01E-03	2,85E-02	5,89E-04	-7,13E-03
POCP	kg NMVOC eq.	1,72E-01	4,95E-02	3,86E-02	2,30E-04	0,00E+00	0,00E+00	1,33E-03	8,47E-03	2,38E-04	-3,64E-03
ADP-minerals & metals	kg Sb eq.	4,15E-04	4,65E-05	3,34E-05	2,16E-07	0,00E+00	0,00E+00	1,28E-06	5,58E-07	2,54E-08	-6,81E-07
ADP-fossil	MJ	3,34E+02	2,01E+02	2,16E+02	9,35E-01	0,00E+00	0,00E+00	5,61E+00	1,04E+01	5,04E-01	-3,67E+00
WDP	WDP (m <sup>3</sup> ) world ekw	2,05E+01	8,35E-01	9,74E-01	3,88E-03	0,00E+00	0,00E+00	2,14E-02	2,95E-02	1,74E-03	5,60E-01

**ADDITIONAL IMPACT INDICATORS: 1 m<sup>2</sup> POLFLAM EI, EW, FR 16-20 mm**

Life Cycle Stage											
Indicator	Unit	A1	A2	A3	A4	A5	C1	C2	C3	C4	D
PM	Disease incidence	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
IRP	kBq U235 eq.	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ETP-fw	CTUe	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
HTP-c	CTUh	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
HTP-nc	CTUh	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
SQP	-	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

**INDICATORS DESCRIPTIONS RESOURCE CONSUMPTION: 1 m<sup>2</sup> POLFLAM GAIA EI, EW, FR 16-20 mm**

Life Cycle Stage											
Indicator	Unit	A1	A2	A3	A4	A5	C1	C2	C3	C4	D
PERE	MJ	3,97E+02	3,46E+00	8,78E+01	1,61E-02	0,00E+00	0,00E+00	1,09E-01	4,18E-01	2,00E-02	-6,95E-02
PERM	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
PERT	MJ	3,97E+02	3,46E+00	8,78E+01	1,61E-02	0,00E+00	0,00E+00	1,09E-01	4,18E-01	2,00E-02	-6,95E-02
PEN-RE	MJ	3,37E+02	2,02E+02	2,73E+02	9,39E-01	0,00E+00	0,00E+00	5,59E+00	1,13E+01	9,72E-01	-4,20E+00
RE	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
PENRT	MJ	3,37E+02	2,02E+02	2,73E+02	9,39E-01	0,00E+00	0,00E+00	5,59E+00	1,13E+01	9,72E-01	-4,20E+00
SM	kg	5,91E-01	0,00E+00	1,16E-01	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
RSF	MJ	2,67E+02	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
NRSF	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
FW	m <sup>3</sup>	3,86E-01	3,72E-02	3,41E-01	1,73E-04	0,00E+00	0,00E+00	1,42E-03	4,75E-03	4,86E-05	-5,24E-04

**INDICATORS DESCRIBING OUTPUT STREAMS AND WASTE: 1 m<sup>2</sup> POLFLAM GAIA  
EI, EW, FR 16-20 mm**

Indicator	Unit (expressed per DU)	Life Cycle Stage										
		A1	A2	A3	A4	A5	C1	C2	C3	C4	D	
Hazardous waste	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Non-hazardous waste	kg	WN	WN	1,95E-06	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Radioactive waste	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Components for re-use	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Materials for recycling	kg	WN	WN	1,16E-01	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Materials for recycling	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Materials for energy recovery	MJ/energy carrier	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00

**CARBON ORGANIC**

**Contents organic carbon in product (kg C<sub>org</sub>)** **0,00E+00**

**Contents organic carbon in packaging (kg C<sub>org</sub>)** **5,75E-02**

**MAIN IMPACT INDICATORS: 1 m<sup>2</sup> POLFLAM GAIA EI, EW, FR 21-55 mm**

Indicator	Unit	Life Cycle Stage									
		A1	A2	A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO <sub>2</sub> eq.	3,29E+01	1,42E+01	1,55E+01	6,66E-02	0,00E+00	0,00E+00	3,34E-01	7,00E-01	1,66E-02	-5,84E-01
GWP-fossil	kg CO <sub>2</sub> eq.	3,31E+01	1,42E+01	1,92E+01	6,65E-02	0,00E+00	0,00E+00	3,34E-01	6,99E-01	1,65E-02	-5,37E-01
GWP-biogenic	kg CO <sub>2</sub> eq.	-1,89E-01	9,86E-03	-3,69E+00	4,61E-05	0,00E+00	0,00E+00	1,96E-04	7,82E-04	4,23E-05	-4,63E-02
GWP-luluc	kg CO <sub>2</sub> eq.	2,45E-02	4,73E-03	3,96E-02	2,21E-05	0,00E+00	0,00E+00	1,05E-04	3,41E-04	2,63E-06	-1,78E-04
ODP	kg CFC11 eq.	1,45E-06	2,83E-07	8,85E-08	1,32E-09	0,00E+00	0,00E+00	6,68E-09	7,82E-09	6,16E-10	-3,42E-09
AP	mol H+ eq.	3,18E-01	2,96E-02	7,87E-02	1,39E-04	0,00E+00	0,00E+00	6,56E-04	5,31E-03	2,59E-04	-1,49E-03
EP-freshwater	kg PO <sub>4</sub> eq.	9,07E-03	9,64E-04	2,02E-02	4,50E-06	0,00E+00	0,00E+00	2,19E-05	2,58E-04	7,52E-07	-1,80E-05
EP-marine	kg N eq.	6,31E-02	7,12E-03	1,51E-02	3,33E-05	0,00E+00	0,00E+00	1,55E-04	2,21E-03	4,40E-05	-1,14E-03
EP-terrestrial	mol N eq.	7,36E-01	7,68E-02	1,25E-01	3,59E-04	0,00E+00	0,00E+00	1,67E-03	2,37E-02	4,81E-04	-5,98E-03
POCP	kg NMVOC eq.	2,02E-01	4,93E-02	3,86E-02	2,30E-04	0,00E+00	0,00E+00	1,11E-03	7,04E-03	1,94E-04	-3,00E-03
ADP-minerals & metals	kg Sb eq.	6,14E-04	4,63E-05	3,34E-05	2,16E-07	0,00E+00	0,00E+00	1,06E-06	4,64E-07	2,07E-08	-5,56E-07
ADP-fossil	MJ	4,61E+02	2,00E+02	2,16E+02	9,35E-01	0,00E+00	0,00E+00	4,66E+00	8,66E+00	4,11E-01	-2,82E+00
WDP	WDP (m <sup>3</sup> ) world ekw	2,48E+01	8,31E-01	9,67E-01	3,88E-03	0,00E+00	0,00E+00	1,78E-02	2,46E-02	1,42E-03	4,64E-01





RSF	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
NRSF	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
FW	m <sup>3</sup>	9,78E-01	6,56E-03	4,58E-01	1,73E-04	0,00E+00	0,00E+00	4,28E-03	1,81E-02	1,27E-04	-1,58E-03

**INDICATORS DESCRIBING OUTPUT STREAMS AND WASTE: 1 m<sup>2</sup> POLFLAM GAIA  
BR 30-45 mm**

Indicator	Unit (expressed per DU)	Life Cycle Stage									
		A1	A2	A3	A4	A5	C1	C2	C3	C4	D
Hazardous waste	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Non-hazardous waste	kg	WN	WN	1,95E-06	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Radioactive waste	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Components for re-use	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Materials for recycling	kg	WN	WN	2,33E-01	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Materials for energy recovery	kg	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00
Exported energy	MJ/energy carrier	WN	WN	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00	0,00E+00

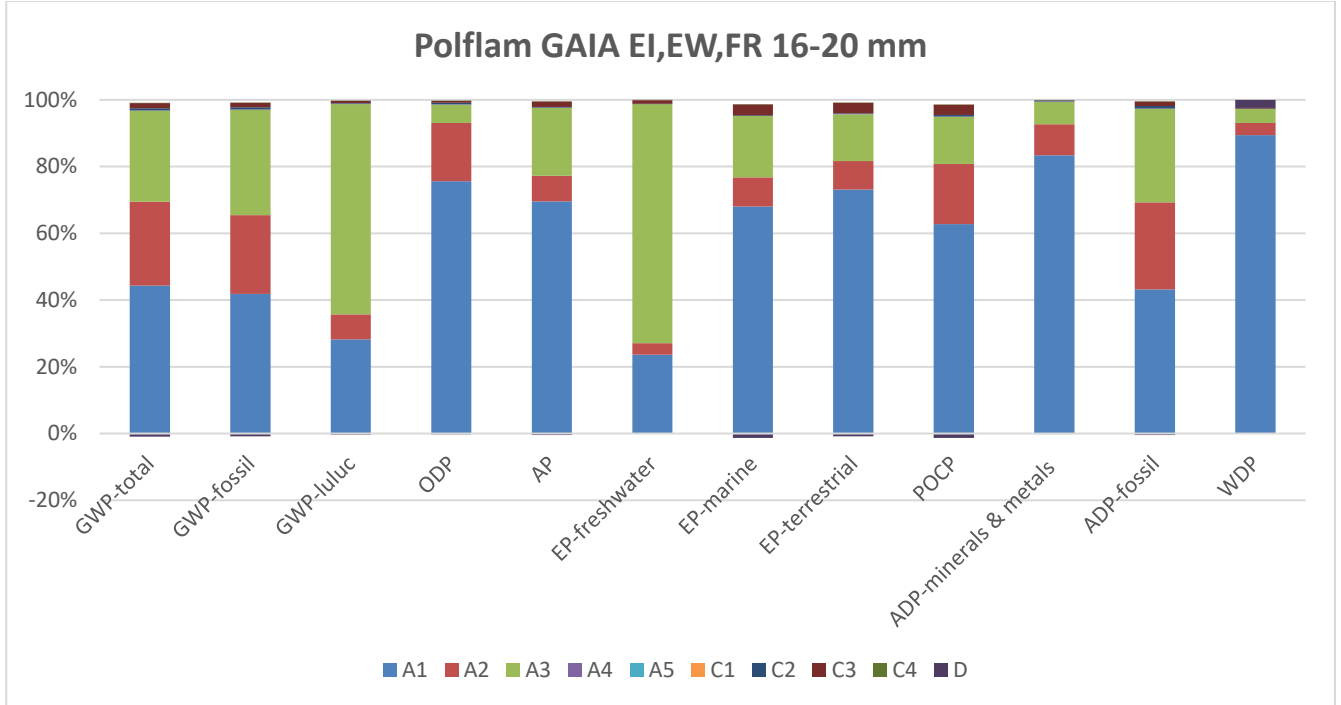
**CARBON BIOGENIC**

**Contents organic carbon in product (kg C<sub>org</sub>)** **0,00E+00**

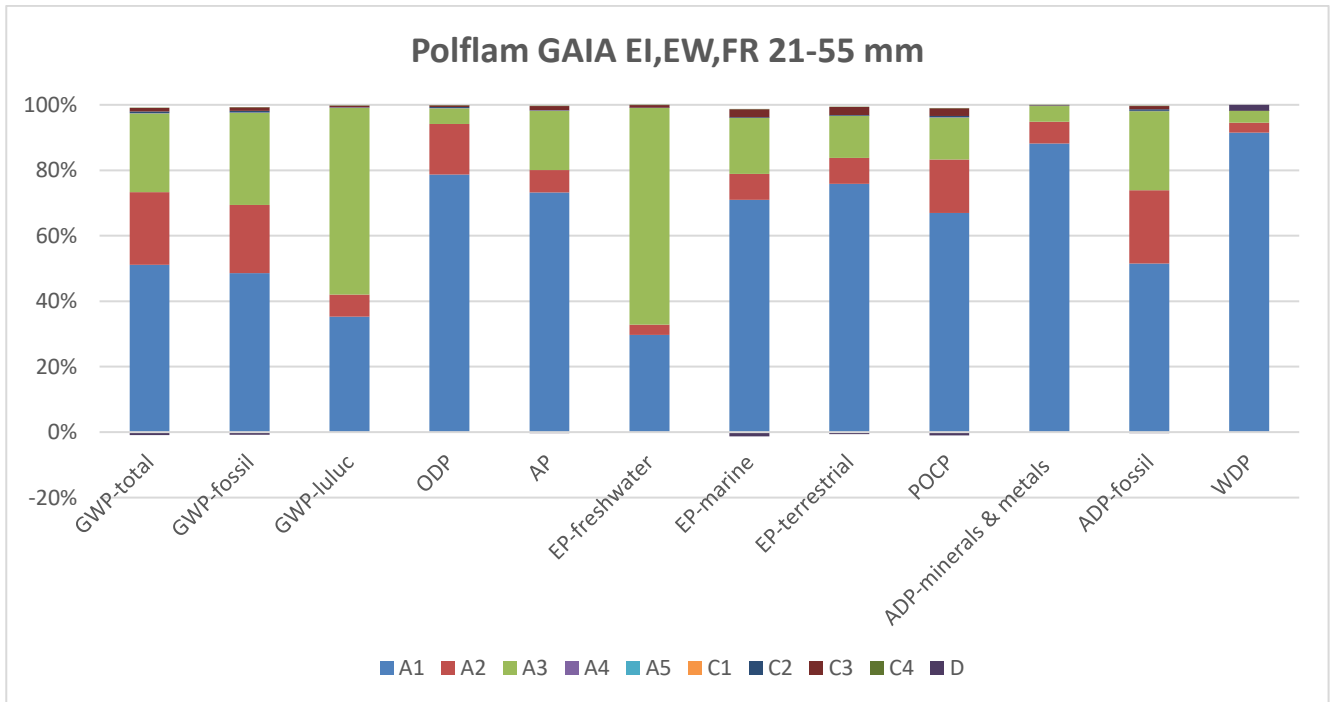
**Contents organic carbon in packaging (kg C<sub>org</sub>)** **1,15E-01**

**6. INTERPRETATION OF LCA**

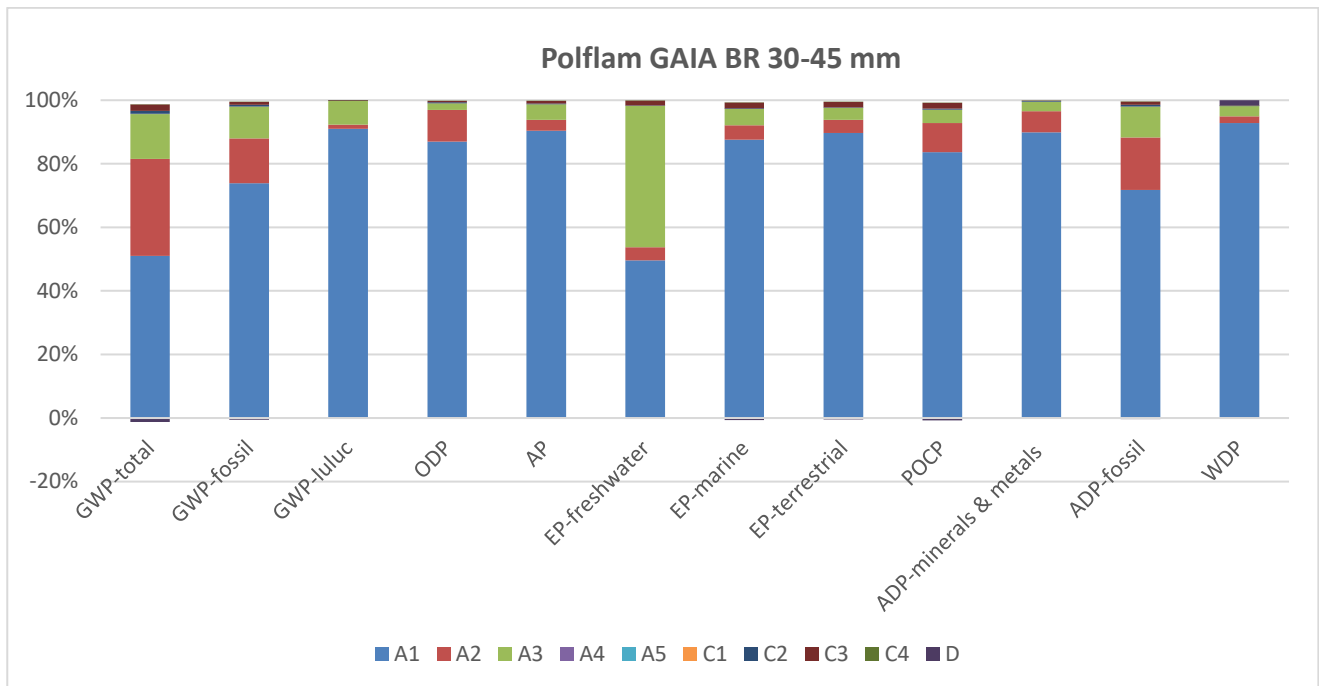
Figures 3, 4, 5 show contributions of the each life cycle module to the basic impact categories for fire-resistant glass POLFLAM GAIA:



**Figure 3** Shares of life cycle modules on the main categories of influence - POLFLAM GAIA 16-20 mm EI, EW, FR



**Figure 4** Shares of life cycle modules on the main categories of influence - POLFLAM GAIA 21-55 mm EI, EW, FR.



**Figure 5** Shares of life cycle modules on the main categories of influence - POLFLAM GAIA 30-45 mm BR.

## LITERATURE

- ✓ ICIMB-PCR A. General Product Category Rules for Construction Products.
- ✓ PN-EN ISO 14025:2014-04, Environmental labels and declarations -- Type III environmental declarations -- Rules and procedures.
- ✓ PN-EN 15804+A2:2020, Sustainability of building structures -- Environmental product declarations -Basic principles of categorization of construction products.
- ✓ PN-EN ISO 14040:2009 Environmental management. Life Cycle Assessment. Principles and structure.
- ✓ PN-EN ISO 14044:2009, Environmental management. Life Cycle Assessment. Requirements and guidelines.
- ✓ EN 15942:2012, Sustainability of construction works – Environmental product declarations – Communication format business-to-business.
- ✓ PN-EN ISO 12543-4:2022-05, Glass in construction – Laminated glass and safety laminated glass – Part 4: Durability test methods.
- ✓ PN-EN 572-1:2012, Glass in building. Basic soda-lime silicate glass products- Definitions and general physical and mechanical properties.
- ✓ KOBiZE CO<sub>2</sub>, SO<sub>2</sub>, NO<sub>x</sub>, CO and total particulate matter emission factors for electricity, December 2023.
- ✓ M. Asif, A. Davidson, T.Muneer, MImech: LIFE CYCLE OF WINDOW MATERIALS - A COMPARATIVE ASSESSMENT FICBSE Millennium Fellow School of Engineering , Napier University, 10 Colinton Road, Edinburgh EH10 5DT, U.K.
- ✓ Asif, M., Muneer, T. and Kubie, J, "Sustainability analysis of window frames", Building Services Engineering Research and Technology. 2005, vol. 26, no. 1, pp. 71-87.
- ✓ Weir, G. and Muneer, T., "Energy and environmental impact analysis of double-glazed windows", Energy Conversion and Management 1998, vol. 39, no. 3-4, pp. 243-256.
- ✓ Heinz Stichnothe<sup>1,2</sup> and Adisa Azapagic<sup>1</sup> Life cycle assessment of recycling PVC window frames Resources Conservation and Recycling · February 2013 DOI: 10.1016/j.resconrec.2012.12.005
- ✓ Additional explanatory material can be obtained from the company page of the declaration owner: <https://polflam.pl/>



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**PROCESS ENGINEERING RESEARCH GROUP**

## TYPE III ENVIRONMENTAL DECLARATION CERTIFICATE

no. 02-01/2025

**Products:**

**FIRE-RESISTANT GLASS GAIA**

**Owner:**

**POLFLAM Sp. z o.o.**

**Jeziorzany, 3 Aleja Krakowska  
05-555 Tarczyn**

The declaration was developed in accordance with the requirements of the standard:

**PN-EN 15804+A2: 2020-03**

Sustainability of construction works  
Environmental product declarations  
Core rules for the product category of construction products

The declaration was verified in accordance with the requirements of the standard:

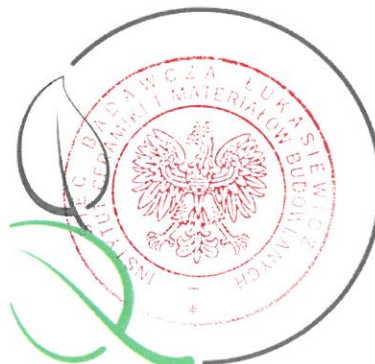
**PN-EN ISO 14025:2010**

Environmental labels and declarations  
Type III environmental declarations. Principles and procedures

The certificate was issued for the first time on **January 24, 2025** and is valid for 5 years or until the said EPD is amended.

**Process Engineering  
Research Group Leader**

Ewa Głodek-Bucyk, PhD Eng.



**Director of  
Environmental  
Engineering Center**

Joanna Poluszyńska, PhD

**Opole, January 2025**