



Registration Number: DAP 003:2019



ECO EPD registration number: 00000879

### Glazed vitrified white body tiles

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VALID UNTIL: 2024-02-27

### PAVIGRÉS CERÂMICAS, S.A.



**PAVIGRÉS**<sup>®</sup>  
GRUPO



VERSION 1.1. EDITION JULY 2015



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## 1. GENERAL INFORMATION

### 1.1. The DAPHabitat System

<b>Program operator:</b>	Sustainable Construction Platform <a href="http://www.centrohabitat.net">www.centrohabitat.net</a> <a href="mailto:centrohabitat@centrohabitat.net">centrohabitat@centrohabitat.net</a>	
<b>Address:</b>	Departamento Engenharia Civil Universidade de Aveiro 3810-193 Aveiro	
<b>Email address:</b>	<a href="mailto:deptecnico@centrohabitat.net">deptecnico@centrohabitat.net</a>	
<b>Telephone number:</b>	(+351) 234 401 576	
<b>Website:</b>	<a href="http://www.daphabitat.pt">www.daphabitat.pt</a>	
<b>Logo:</b>		

### 1.2. EPD owner

<b>Name of the owner:</b>	Pavigrés Cerâmicas, S.A.	
<b>Production site:</b>	Pavigrés Cerâmicas, S.A. – Unidade Fabril Pavigrés, Av. Alto das Domingas, 3780-244 – Aguiçã	
<b>Address (head office):</b>	Pavigrés Cerâmicas, S.A., Av. Alto das Domingas, 3780-244 – Aguiçã	
<b>Telephone:</b>	(+351) 231 510 600	
<b>E-mail:</b>	<a href="mailto:expediente@pavigres.com">expediente@pavigres.com</a>	
<b>Website:</b>	<a href="http://www.pavigres.com">www.pavigres.com</a>	
<b>Logo:</b>		
<b>Information concerning the applicable management Systems:</b>	ISO 9001:2015 – Quality Management Systems ISO 14001:2015 – Environmental Management Systems	
<b>Specific aspects regarding the production:</b>	CAE <sub>Rev.3</sub> n.º 23312 – Manufacture of ceramic tiles and flags	

**Organization's environmental policy:**

PAVIGRÉS CERÂMICAS, S.A.:

Mission:

To create and produce ceramic wall and floor coverings that reinforces the prestige and confidence of PAVIGRES in the global market, ensuring the sustainability and development of the Group.

Policy:

To assume, as a fundamental vector for its success, the permanent focus on the Client, translated into the constant concern of anticipating and responding to market expectations. Present global and integrated solutions of ceramic flooring and wall covering, with products that are presented on the market for their recognized quality and aesthetic value.

This Policy aligns and develops in the following areas:

- Satisfy customers;
- Reward shareholders;
- Protect employees;
- Dignify the relationship with suppliers;
- Protect the environment by minimizing environmental impact and promoting pollution prevention through the implementation of good practices;
- Provide the necessary resources to meet the established objectives and targets, and create conditions for possible investments in new projects focused on the relevant stakeholders, in order to promote the financial consolidation of PAVIGRÉS;
- Continuously improve environmental performance and its Integrated Quality and Environmental Management System.

Objectives of the IQEMS:

- Improve economic/ financial results;
- Increase the range of satisfied customers and promote their loyalty;
- Promote competence and employee satisfaction;
- Monitor Supplier performance and cultivate/ inspire a relationship of honesty and trust with him;
- Comply with the regulatory, legal and other requirements applicable to its activity;
- Protect the environment and prevent pollution.

### 1.3. Information concerning the EPD

<b>Authors:</b>	1. Centro Tecnológico da Cerâmica e do Vidro 2. PAVIGRÉS CERÂMICAS, S.A.
<b>Contact of the authors:</b>	1. CTCV materials: habitat   iParque – Parque Tecnológico de Coimbra - Lote 6   3040-540 Antanhol - Portugal (T) +351 239 499 200 Marisa Almeida: <a href="mailto:marisa@ctcv.pt">marisa@ctcv.pt</a> 2. Pavigrés Cerâmicas, S.A., Av. Alto das Domingas, 3780-244 - Aguim (T) +351 231 510 600; E. <a href="mailto:qualidade@pavigres.com">qualidade@pavigres.com</a>
<b>Emission date:</b>	2019-02-28
<b>Registration date:</b>	2019-03-20
<b>Registration number:</b>	DAP 003:2019
<b>Valid until:</b>	2024-02-27
<b>Representativity of the EPD (location, manufacturer, group of manufacturers):</b>	EPD of one (1) product class, produced in one (1) industrial plant belonging to one (1) sole producer (Pavigrés Cerâmicas, S.A.).
<b>Where to consult explanatory material:</b>	<a href="http://www.pavigres.com">www.pavigres.com</a>
<b>Type of EPD:</b>	EPD from cradle to gate (A1-A3)

### 1.4. Demonstration of the verification

External independent verification, accordingly with the standard ISO 14025:2009 and EN 15804:2012+A1:2015

**Organismo de Certificação**



(CERTIF – Associação para a Certificação)

**Verifier**



(Ricardo Mateus)

### 1.5. EPD Registration

**Program Operator**




(Plataforma para a Construção Sustentável)

## 1.6. PCR of reference

Nome	Emission date	Number of registration on the data base	Version	Valid until
PCR: Basic module for construction products and services	September 2015	PCR-mb001	Version 2.0.	January 2021
PCR: Floor covering	February 2014	RCP001:2014	Version 1.0	February 2019
PCR: Wall covering	February 2014	RCP002:2014	Version 1.0	February 2019

## 1.7. Information concerning the product/product class

<b>Identification of the product:</b>	Glazed vitrified white body tiles for wall and floor covering																		
<b>Illustration of the product:</b>																			
<b>Brief description of the product:</b>	<p>Glazed vitrified white body ceramic tiles produced by the PAVIGRÉS CERÂMICAS, S.A group, used as floor and wall coverings, both indoors and outdoors in residential and public areas. This product is impermeable and has a high mechanical resistance, being available in the market a panoply of aesthetic and dimensional options, as much in visual effects as of texture and colours.</p> <p>In this EPD the results are given per unit mass (1 kg) of the product. However, since the production process is the same, regardless of the thickness or shape of the products, it is possible to convert these results to other units - m<sup>2</sup>, for example - using conversion factors, according to the weights indicated in the following table:</p> <p style="text-align: center;"><b>Table 1: Conversion factors</b></p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>Thickness (mm)</th> <th>Weight (kg/m<sup>2</sup>)</th> </tr> </thead> <tbody> <tr> <td>6</td> <td>12,9</td> </tr> <tr> <td>7,2</td> <td>16,0</td> </tr> <tr> <td>8,3</td> <td>18,0</td> </tr> </tbody> </table> <p>NOTE: Table of average weights per m<sup>2</sup> (kg/m<sup>2</sup>), depending on the thickness of the product. For more precise information on the weights per unit area of each reference, please consult the weights and packaging table on PAVIGRÉS website.</p>	Thickness (mm)	Weight (kg/m <sup>2</sup> )	6	12,9	7,2	16,0	8,3	18,0										
Thickness (mm)	Weight (kg/m <sup>2</sup> )																		
6	12,9																		
7,2	16,0																		
8,3	18,0																		
<b>Main technical characteristics of the product:</b>	<p style="text-align: center;"><b>Table 2: Technical characteristics</b></p> <table border="1" style="width: 100%;"> <thead> <tr> <th>Standard required by the norm</th> <th>Mean value of tolerances</th> <th>Test norm</th> </tr> </thead> <tbody> <tr> <td><b>Dimensional characteristics</b></td> <td>Linear dimensions ± 0,2% Orthogonality ± 0,3% Straightness of edges ± 0,2% Flatness ± 0,2% Thickness ± 3%</td> <td>NP EN ISO 10545-2</td> </tr> <tr> <td><b>Water absorption</b></td> <td>≈1,5%</td> <td>NP EN ISO 10545-3</td> </tr> <tr> <td><b>Breaking strength in N</b></td> <td>(6mm) ≥ 720N (7mm) ≥ 1050N (8,3mm) ≥ 1500N</td> <td>NP EN ISO 10545-4</td> </tr> <tr> <td><b>Rupture modulus N / mm<sup>2</sup></b></td> <td>≥40 N/mm<sup>2</sup></td> <td></td> </tr> <tr> <td><b>Resistance to surface abrasion</b></td> <td>Indicated for each ref.</td> <td>NP EN ISO 10545-7</td> </tr> </tbody> </table>	Standard required by the norm	Mean value of tolerances	Test norm	<b>Dimensional characteristics</b>	Linear dimensions ± 0,2% Orthogonality ± 0,3% Straightness of edges ± 0,2% Flatness ± 0,2% Thickness ± 3%	NP EN ISO 10545-2	<b>Water absorption</b>	≈1,5%	NP EN ISO 10545-3	<b>Breaking strength in N</b>	(6mm) ≥ 720N (7mm) ≥ 1050N (8,3mm) ≥ 1500N	NP EN ISO 10545-4	<b>Rupture modulus N / mm<sup>2</sup></b>	≥40 N/mm <sup>2</sup>		<b>Resistance to surface abrasion</b>	Indicated for each ref.	NP EN ISO 10545-7
Standard required by the norm	Mean value of tolerances	Test norm																	
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<b>Rupture modulus N / mm<sup>2</sup></b>	≥40 N/mm <sup>2</sup>																		
<b>Resistance to surface abrasion</b>	Indicated for each ref.	NP EN ISO 10545-7																	



<b>Resistance to thermal shock</b>	Resistant	NP EN ISO 10545-9
<b>Frost resistance</b>	Resistant	NP EN ISO 10545-12
<b>Resistance to hair cracking</b>	Guaranteed	NP EN ISO 10545-11
<b>Resistance to household products and swimming-pool additives</b>	Guaranteed	NP EN ISO 10545-13
<b>Resistance to low/ high concentrations of acids and alkalis</b>	To be confirmed	NP EN ISO 10545-13
<b>Resistance to staining</b>	Guaranteed	NP EN ISO 10545-14
<b>Cadmium and lead release</b>	Below the limit of quantification: < 0,2 mg Pb/l < 0,02 mg Cd/l	NP EN ISO 10545-15
<b>Anti-slip features (slipperiness)</b>	To be confirmed	DIN 51130 DIN 51097 ENV 12633

(see link of the technical datasheets with all data:  
[http://pavigres.com/ficheiros/caracteristicas\\_tecnicas/caracteristicas-tcnicas.pdf](http://pavigres.com/ficheiros/caracteristicas_tecnicas/caracteristicas-tcnicas.pdf))

<b>Description of the products' application:</b>	<p>Glazed vitrified white body tiles for the following applications:</p> <ul style="list-style-type: none"> <li>• Floor covering</li> <li>• Wall covering</li> <li>• Indoor covering</li> <li>• Outdoor covering</li> <li>• Areas and residential buildings</li> <li>• Areas and public buildings</li> <li>• Areas and industrial buildings</li> </ul>
<b>Reference service life:</b>	Not specified.
<b>Placing on the market / Rules of application in the market / Technical rules of the product:</b>	<p>EN 14411:2012 EN ISO 10545 DIN 51130 DIN 51097 ENV 12633 BS 7976-2</p>
<b>Quality control:</b>	According to the technical standards of the product.
<b>Special delivery conditions:</b>	Not applicable
<b>Components and substances to declare:</b>	Not applicable
<b>History of the LCA studies:</b>	--

## 2. ENVIRONMENTAL PERFORMANCE OF THE PRODUCT

### 2.1. Calculation rules of the LCA

<b>Declared unit:</b>	1 kg of glazed vitrified white body tiles for wall and floor covering (including packaging)
<b>Functional unit:</b>	--
<b>System boundaries:</b>	EPD from cradle to gate
<b>Criteria for the exclusion:</b>	<p>According to paragraph 6.3.5 of EN 15804, the exclusion criterion for unitary processes is 1% of the total energy consumed and 1% of the total mass of the inputs, paying particular attention not to exceed a total of 5% of energy and mass flows excluded in the product step.</p> <p>The following cases were not considered in this study, as they may fall under the exclusion criteria:</p> <ul style="list-style-type: none"> <li>• Environmental loads associated with the construction of industrial infrastructures and the manufacture of machinery and equipment;</li> <li>• Environmental loads relating to infrastructure (vehicle and road production and maintenance) for the transport of pre-products;</li> <li>• Long term emissions.</li> </ul>
<b>Assumption and limitations:</b>	<p>For processes over which producers have no influence or specific information, such as the extraction of raw materials, generic data from the Ecoinvent v3.3 databases were used.</p> <p>The dataset used to model the production of electricity and natural gas was adapted to the national reality. The electric mix was updated for the year 2016 through information from the National Energy Networks (REN), the Energy Services Regulatory Authority (ERSE) and the General Board of Energy and Geology (DGEG) in order to obtain more current results regarding the environmental impacts generated by the electricity grid in Portugal. The natural gas process was modelled according to the information provided by the DGEG Energy Report in Portugal (2015), regarding the countries where the importation comes from.</p> <p>The environmental impacts indicated in this EPD are a simple average of all PAVIGRÉS glazed vitrified white body ceramic tiles fabricated in 2016, (since they are produced only in Pavigrés industrial plant).</p>
<b>Quality and other characteristics about the information used in the LCA:</b>	The production data collected correspond to the year 2016 and are in line with reality. The generic data used belong to the Ecoinvent v3.3 databases and meet the quality criteria (age, geographical and technological coverage, plausibility, etc.) of generic data.
<b>Allocation rules:</b>	The allocation rules adopted were based on the annual production at the Pavigrés plant.
<b>Comparability of EPD for construction products:</b>	The EPDs for construction products and services may not be comparable if they are not produced in accordance with EN 15804 and EN 15942 and in accordance with the comparability conditions determined by ISO 14025.

2.1.1. Flow diagram of input and output of the processes

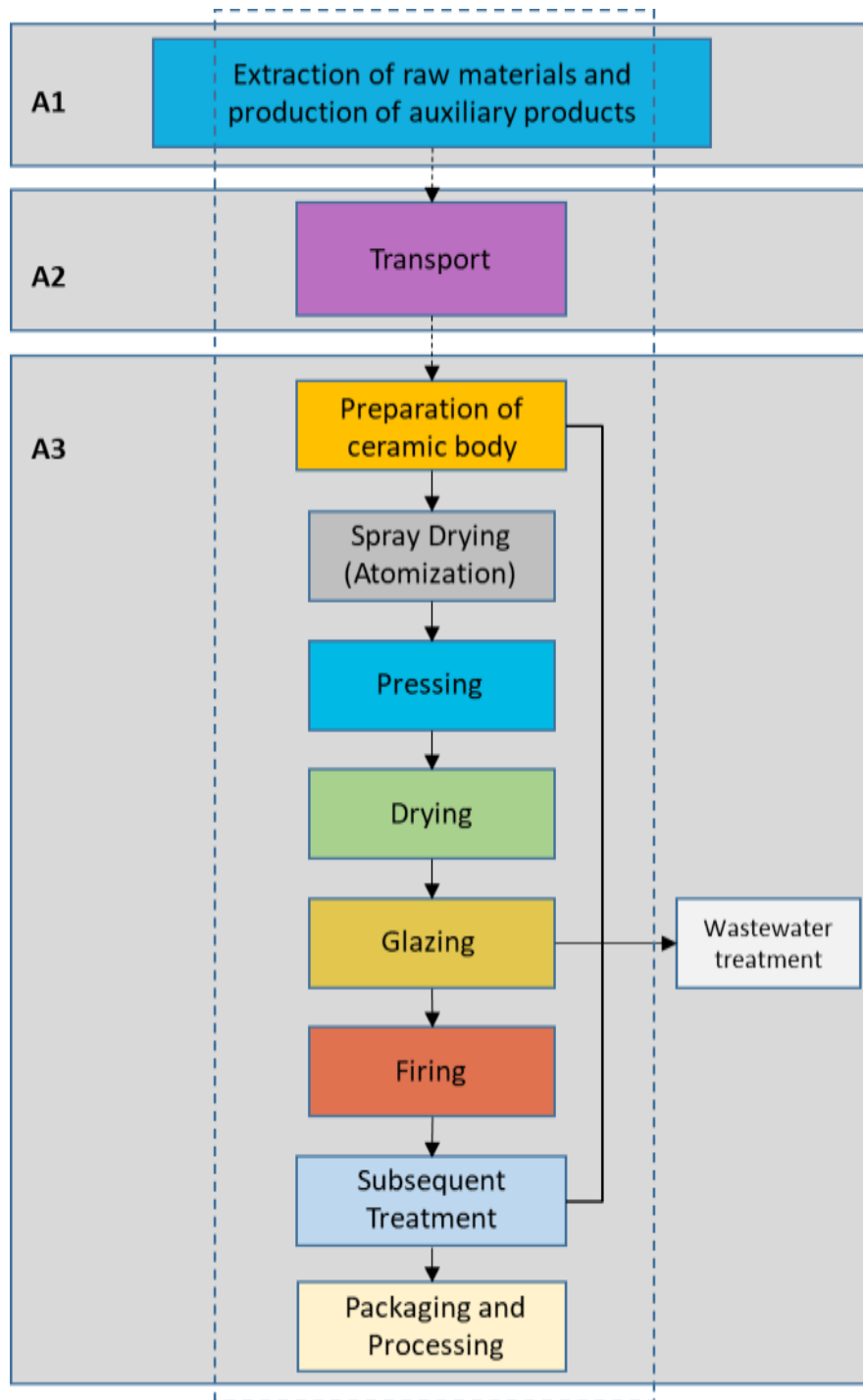


Figure 1 - Life cycle stages of glazed vitrified white body tiles (A1-A3).

This DAP evaluates the A1-A3 stage of the products life cycle, including the stage of extraction and production of all products and materials used as raw material, transportation of these materials from the suppliers to the industrial units of PAVIGRÉS and the processing of these materials to the production of final products, including their packaging.

A1 - Extraction and processing of raw materials: this step includes the extraction and eventual processing of raw materials

**A2 - Transport:** Raw materials and auxiliary materials come from truck or truck, boat and truck again.

**A3 - Production:** This stage includes the design and development, storage of raw materials, pulp preparation, forming (by pressing), drying, glazing or decoration, firing and choice, subsequent treatment (e.g. polishing), packaging and storage.

Pavigrés Cerâmicas, S.A., (in Pavigrés, Grespor and Cerev production plants) is dedicated to the production of ceramic tiles (flooring and wall coverings, in porcelain and non-porcelain stoneware, glazed and unglazed) by spray dried powder pressing, followed by drying and firing. Natural raw materials, processed raw materials and additives are used, in which the main ones are: clays, feldspars, sands and kaolins.

Hard raw materials (sand, feldspar, etc.) are subject to grinding and milling, and the clay is subjected to suspension (wet mixing); subsequently, are mixed and homogenized (storage and agitation) constituting the final composition of the ceramic body.

The ceramic body in the form of casting slip is subsequently coloured and atomized (spray drying process) to form the ceramic powder which, after homogenization, is pressed - shaped by pressing. The raw pressed tiles are subjected to a quick drying cycle, to eliminate their residual moisture and, finally, to be subjected to the firing process, which will give them all the final physical and chemical characteristics.

The fuel used in the spray drying, drying and firing processes is Natural Gas.

### 2.1.2. Description of the system boundaries

(✓ = included; ✖ = module not declared)

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARY
Raw material supply	Transport	Manufacturing	Transport	Construction installation process	Use	Maintenance	Repair	Replacement	Rehabilitation	Operational energy use	Operational water use	De-constructions, demolition	Transport	Waste processing	Disposal	Re-use, recovery, recycling potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
✓	✓	✓	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖	✖

## 2.2. PARAMETERS DESCRIBING ENVIRONMENTAL IMPACTS

		Global warming potential; GWP	Depletion potential of the stratospheric ozone layer; ODP	Acidification potential of soil and water, AP	Eutrophication potential, EP	Formation potential of tropospheric ozone, POCP	Abiotic depletion potential for non-fossil resources	Abiotic depletion potential for fossil resources
		kg CO <sub>2</sub> equiv.	kg CFC 11 equiv.	kg SO <sub>2</sub> equiv.	kg (PO <sub>4</sub> ) <sup>3-</sup> equiv.	kg C <sub>2</sub> H <sub>4</sub> equiv.	kg Sb equiv.	MJ, P.C.I.
<b>Raw material supply</b>	<b>A1 – A3</b>	5,70E-01	8,36E-08	1,96E-03	1,62E-04	1,08E-04	2,69E-07	8,86E+00
<b>Transport</b>								
<b>Manufacturing</b>								
<b>Total</b>	<b>Total</b>	5,70E-01	8,36E-08	1,96E-03	1,62E-04	1,08E-04	2,69E-07	8,86E+00

LEGEND:

Product stage

**NOTE:** LHV - lower heating value.  
Values expressed by declared unit (1 kg).

## 2.3. Parameters describing resource use

		Primary energy						Secondary materials and fuels, and use of water			
		EPR	RR	TRR	EPNR	RNR	TRNR	MS	CSR	CSNR	Net use of fresh water
		MJ, P.C.I.	MJ, P.C.I.	MJ, P.C.I.	MJ, P.C.I.	MJ, P.C.I.	MJ, P.C.I.	kg	MJ, P.C.I.	MJ, P.C.I.	m <sup>3</sup>
<b>Raw material supply</b>	<b>A1 – A3</b>	8,96E-01	2,15E-01	1,11E+00	9,03E+00	0,00E+00	9,03E+00	0,00E+00	0,00E+00	0,00E+00	1,64E-03
<b>Transport</b>											
<b>Manufacturing</b>											
<b>Total</b>	<b>Total</b>	8,96E-01	2,15E-01	1,11E+00	9,03E+00	0,00E+00	9,03E+00	0,00E+00	0,00E+00	0,00E+00	1,64E-03

Values expressed by declared unit (1 kg)

LEGEND:

Product stage

**EPR** = use of renewable primary energy excluding renewable primary energy resources used as raw materials;  
**RR** = use of renewable primary energy resources used as raw materials;  
**TRR** = total use of renewable primary energy resources (EPR + RR);  
**EPNR** = use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials;  
**RNR** = use of non-renewable primary energy resources used as raw materials;  
**TRNR** = total use of non-renewable primary energy resources (EPNR + RNR);  
**MS** = use of secondary material;  
**CSR** = use of renewable secondary fuels;  
**CSNR** = use of non-renewable secondary fuels.

## 2.4. Other environmental information describing different waste categories

		Hazardous waste disposed kg	Non-hazardous waste disposed kg	Radioactive waste disposed ** kg
Raw material supply Transport Manufacturing	A1 –A3	6,29E-04	5,91E-05	8,50E-06
<b>Total</b>	<b>Total</b>	6,29E-04	5,91E-05	8,50E-06

Values expressed by declared unit (1 kg)

LEGEND:



Product stage

\*\* The radioactive waste component does not come from the activity of PAVIGRÉS (A3). It is a component derived from the upstream activities (A1 and A2), namely from the production of electricity.

## 2.5. Other environmental information describing output flows

Parameters	Units*	Results
Components for re-use	kg	N/A
Materials for recycling	kg	1,95E-01
Materials for energy recovery	kg	0,00E+00
Exported energy	MJ by energy carrier	N/A

\* expressed by functional unit or declared unit (kg)

### 3. SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION

This EPD evaluates only the production stage of the product, integrating steps A1 to A3. Thus, the following scenarios of the construction step (modules A4 and A5), step of use (B1 to B7) and end of life step (C1 to C4), are not applicable.

#### 3.1. Additional environmental information concerning the release of dangerous substances

According to Decree-Law no. 183/2009, of 10<sup>th</sup> August, which re-establishes the legal regime for landfilling, the leaching tests carried out on PAVIGRÉS fired broken ware show that the broken ware have parameters for inert landfill.

##### Other additional information:

##### Environmental protection

PAVIGRÉS environmental management is based on the ISO 14001:2015 standard on environmental management systems, on a principle of continuous improvement of environmental performance.

The company adopts an approach of environmental protection and pollution prevention, both in terms of production processes and products, trying to reduce the consumption of resources. Raw materials, energy and water are vital components of all processes.

PAVIGRÉS reuses a series of wastes and by-products inherent to its manufacturing process, such as dust from extractors and broken ware from processes before firing, into the production process, promoting circular economy.

It also recirculates almost half of the water after treatment in its ETARI (industrial wastewater treatment plant) for the production process.

At the energy level it also recovers hot air from the cooling zone of the furnaces to other processes (e.g. drying and spray drying).

Protection of the environment, reduction of waste production, efficient use of natural resources and reduction of environmental risks is paramount. The activities related to the activities of monitoring and operational control of its environmental aspects and impacts are managed according to the environmental management system according to ISO 14001: 2015.

Continuous improvement is a priority in the areas of energy efficiency, energy efficiency projects, opportunity assessment, energy policy development and implementation and reduction of greenhouse gas emissions.

##### Occupational Health and Safety

Samplings and analyses are carried out in the area of employee health and safety, as well as the safety of working conditions. Existing and potential risks are assessed and measures taken to reduce them to acceptable levels.

## REFERENCES

- ✓ **Ecoinvent database v3.3** (2016). ([www.ecoinvent.org](http://www.ecoinvent.org))
- ✓ **EN 15804:2012+A1:2015** Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products;
- ✓ **EN 15942:2011** Sustainability of construction works – Environmental product declarations – Communication format business-to-business.
- ✓ **Energy Services Regulatory Authority (ERSE)** – Special Regime Production (PRE) (2016) (in <http://www.erse.pt/pt/desempenhoambiental/prodregesp/2016/Paginas/2016.aspx>)
- ✓ **General Board of Energy and Geology (DGEG)** – Energy in Portugal Report (2015)
- ✓ **General Board of Energy and Geology (DGEG)** – Monthly Data of Electrical Energy (2016). (in <http://www.dgeg.gov.pt?cr=15125>)
- ✓ **Instruções Gerais do Sistema DAPHabitat**, Version 1.0, March 2013 (in [www.daphabitat.pt](http://www.daphabitat.pt));
- ✓ **National Energy Networks (REN)** – Information Centre – Monthly Statistics (2016). (in <http://www.centrodeinformacao.ren.pt/PT/InformacaoExploracao/Paginas/EstatisticaMensal.aspx>)
- ✓ **NP ISO 14025:2009** Rótulos e declarações ambientais – Declarações ambientais Tipo III – Princípios e procedimentos;
- ✓ **Regras para a Categoria de Produto (RCP) – Modelo base para produtos e serviços de construção**. DAPHabitat System. Version 2.0, September of 2015 (in [www.daphabitat.pt](http://www.daphabitat.pt));
- ✓ **Regras para a Categoria de Produto (RCP) – Revestimento de Paredes**. Wall covering. RCP002:2014. DAPHabitat System. Version 1.0, February 2014 (in [www.daphabitat.pt](http://www.daphabitat.pt));
- ✓ **Regras para a Categoria de Produto (RCP) – Revestimento de Pavimento**. Floor covering. RCP001:2014. DAPHabitat System. Version 1.0, February 2014 (in [www.daphabitat.pt](http://www.daphabitat.pt));