

ENVIRONMENTAL PRODUCT DECLARATION

RUBBER FLOOR TILE

FLEXCO® FLEXTONES®, EVOLVING STYLES®, SPEXTONES, REPEL,
ESD STATIC CONTROL



There are a large number of applications for rubber floor tiles: office and retail, as well as healthcare and education. Rubber flooring adds to beauty and comfort. Low life cycle costs for maintenance and low costs for cleaning are due to the material's high durability and FLEXCO's production values, which generate high quality products.

Pictured above: Evolving Styles – Creative Elements, manufactured in Tusculmbia, Alabama

FLEXCO

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FLEXCO® is a family-owned company with a commitment to workforce and community. It is an integral part of the small town of Tusculmbia, Alabama. FLEXCO has always been a leader in innovation, starting as a rubber tire manufacturer during WWII and evolving into an industry-leading flooring manufacturer with over 65 years of experience. FLEXCO products conform to ASTM quality standards for flooring and wall base; and continuous improvements are made to energy and water use, scrap and product raw ingredients.

FLEXCO products' value and sustainability are validated by life cycle costing and life cycle assessments. Installations in place for more than forty years prove product durability.

Investment in the best materials that are innovative, perform well and are aesthetically pleasing is FLEXCO's sustainability strategy.

For additional information, visit www.flexcofloors.com.



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Rubber Floor Tile – FlexTones, Evolving Styles, SpexTones, Repel, ESD Static Control
RESILIENT FLOORING

According to ISO 14025

This declaration is an environmental product declaration (EPD) in accordance with ISO 14025. EPDs rely on Life Cycle Assessment (LCA) to provide information on a number of environmental impacts of products over their life cycle. Exclusions: EPDs do not indicate that any environmental or social performance benchmarks are met, and there may be impacts that they do not encompass. LCAs do not typically address the site-specific environmental impacts of raw material extraction, nor are they meant to assess human health toxicity. EPDs can complement but cannot replace tools and certifications that are designed to address these impacts and/or set performance thresholds – e.g. Type 1 certifications, health assessments and declarations, environmental impact assessments, etc. Accuracy of Results: EPDs regularly rely on estimations of impacts, and the level of accuracy in estimation of effect differs for any particular product line and reported impact. Comparability: EPDs are not comparative assertions and are either not comparable or have limited comparability when they cover different life cycle stages, are based on different product category rules or are missing relevant environmental impacts. EPDs from different programs may not be comparable.



PROGRAM OPERATOR	UL Environment	
DECLARATION HOLDER	RHC	
DECLARATION NUMBER	4786388448.101.1	
DECLARED PRODUCT	Rubber Floor Tile	
REFERENCE PCR	NSF PCR for Flooring v2.0	
DATE OF ISSUE	March 13, 2017	
PERIOD OF VALIDITY	5 Years	
CONTENTS OF THE DECLARATION	Product definition and information about building physics Information about basic material and the material's origin Description of the product's manufacture Indication of product processing Information about the in-use conditions Life cycle assessment results Testing results and verifications	
The PCR review was conducted by:	PCR Review Panel ncss@nsf.org	
This declaration was independently verified in accordance with ISO 14025 by Underwriters Laboratories <input type="checkbox"/> INTERNAL <input checked="" type="checkbox"/> EXTERNAL	 Wade Stout, UL Environment	
	 Thomas Gloria, Industrial Ecology Consultants	
This life cycle assessment was independently verified in accordance with ISO 14044 and the reference PCR by:		





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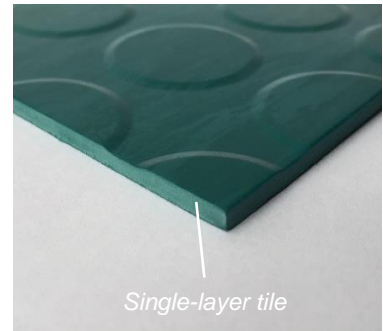
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Product Definition

Product Classification and Description

The declaration for FLEXCO® rubber floor tile covers a broad range of styles produced by the manufacturing plant in Tuscomb, AL. Rubber tile is made from a homogeneous composition of synthetic rubber, fillers, and additives. It is commonly available in thicknesses of 2.0 mm (0.080" or 80 mil), 2.54 mm (0.100" or 100 mil), and 3.2 mm (1/8"). Profile heights range from 0.51 mm (0.020") to 0.89 mm (0.035"). The manufacturing process results in a single layer. Rubber tile is typically used commercially in healthcare, education, retail, hospitality, transportation and office interiors. FLEXCO products are known for their durability and ease of maintenance throughout the product life, while also providing underfoot comfort, reduced noise from foot traffic, and inherent slip resistance. The defined Reference Service Life (RSL) is 40 years.



Product Characteristics

Rubber Floor Tile	Average Value	Unit	Minimum Value	Maximum Value
Product thickness	3.0 (0.12")	mm (inch)	2.0 (0.08")	3.2 (1/8")
Wear layer thickness	N/A	mm	N/A	N/A
Product weight	5,330	g/m ²	3,670	5,640
Product Form:	Tiles	N/A	mm (inch)	320 x 320 (12"x12")
	Sheet	N/A	inch	36" x 300"
VOC emissions test method	Compliant with California Department of Public Health Standard v1.1, 2010 and certified by FloorScore® Flooring Products Certification Program for Indoor Air Quality			
Sustainability certifications	Certified to NSF / ANSI – 332 (2015) Sustainability Assessment for Resilient Floor Coverings – Gold Level			

Product Standards and Accreditation

The products considered in the EPD meet or exceed the following technical specifications:

- ASTM F 1344 – Standard Specification for Rubber Floor Tile
- Fire Testing Class 1 when tested in accordance with ASTM E 648/NFPA 253, Standard Test Method for Critical Radiant Flux if applicable
- Fire Testing: Passes Smoke Density of 450 or less when tested in accordance with ASTM E662/NFPA 258 Standard Test Method for Specific Optical Density of Smoke Generated by Solid Materials
- Fire Testing FSR-115; SDC-275 when tested in accordance with CAN/ULC S102.2, Standard test Method for Flame Spread Rating and Smoke Development if applicable
- Anti-fungal Testing ASTM G 21 – Standard Practice for Determining Resistance of Synthetic Polymeric Materials to Fungi





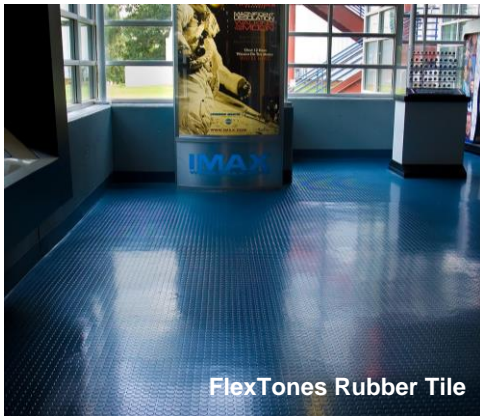
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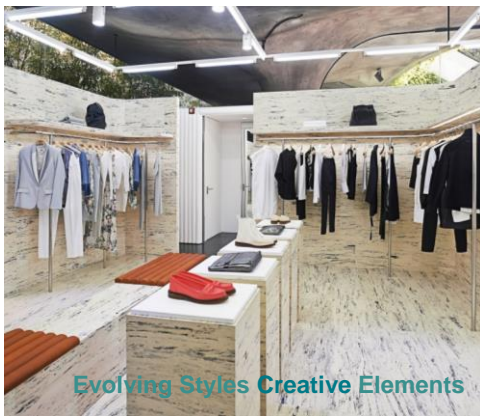
Compliant with FloorScore® Flooring Products Certification Program for Indoor Air Quality. This test program includes volatile organic compounds, including formaldehyde, acetaldehyde, styrene, and other compounds of concern. Certified to NSF / ANSI – 332 (2015) Sustainability Assessment for Resilient Floor Coverings at Gold Level.

Product Lines



FlexTones® Rubber Tile

The raised and textured patterns of FlexTones® rubber tile allow dirt and water to drain off of the walking surface, increasing traction and improving slip resistance. Our low profile versions of flextones rubber tile are ideal for areas with small-wheeled vehicular traffic, such as retail stores, healthcare facilities, airport terminals and more.



Evolving Styles® Creative Elements

Evolving Styles Creative Elements offer so much selection. Choose from two gauges, various tile sizes and sheet rubber flooring. You also have the option of using FLEXCO® Rubber Welding Beads to create a seamless installation for clean rooms and areas that have strict requirements for added hygiene.



Evolving Styles® Wood Elements

Evolving Styles Wood Elements combine a unique wood look with the durability and comfort of rubber. The two gauges, various tile sizes and sheet rubber flooring options open up your opportunities for gymnasiums, all-purpose rooms and other active facilities. FLEXCO® Rubber Welding Beads create a seamless installation.





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SpexTones Rubber Tile

The SpexTones product line is highlighted by speckled coloration that works well for high-traffic areas prone to everyday dirt and scuffing.



Repel™

Repel is perfect in commercial kitchens, automotive centers and machine shops where the presence of oil and grease are present. Repel is available in all rubber tile and stair tread colors, excluding sheet rubber. It is part of the rubber formulation, not a topical treatment that will wear off.



ESD Static Control Rubber Tile

FLEXCO® brings an expanded color palette plus easy maintenance to facilities looking for superior style and safety in their controlled environments with ESD static control rubber tile.





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Material Content of Product

Component	Material	Mass %*	Availability			Origin of raw materials
			Renewable	Non-renewable	Recycled	
Filler	Kaolin	50-60		Mineral abundant		US
Binder	SBR	20-35		Fossil limited		US
Filler	Calcium Carbonate	5-15		Mineral abundant		US
Additive	Various	5-7		Various		US
Additive	Epoxidized Soybean Oil	1-2	Bio-based crop			US

Production of Main Materials

Kaolin: A clay mineral used as inert filler.

Styrene Butadiene Rubber (SBR): A synthetic copolymer that is used as a primary cross-linkable binder in the manufacture of rubber flooring products.

Calcium Carbonate: An abundant mineral found in all parts of the world as the chief substance in rocks (i.e., limestone). It can be ground to varying particle sizes and is widely used as filler in formulated flooring systems.

This product is free of phthalates, flame retardants, perfumes, and metals of concern (e.g., hexavalent chromium, lead, mercury, etc.)

Production of Rubber Flooring

Floor tile is produced in several stages beginning with the mixing of the raw materials. After a thorough mixing, the resulting compound is calendared into sheets, typically referred to as “preforms.” The preforms are then placed in heated molds where they are pressed into tiles and the materials are vulcanized. After the molding operation, the tiles are sanded to obtain the correct thickness, as well as to enhance adhesion, and then trimmed to their finished size for packaging. Packaging materials comprise polyethylene film, corrugated cardboard, and wooden pallets.

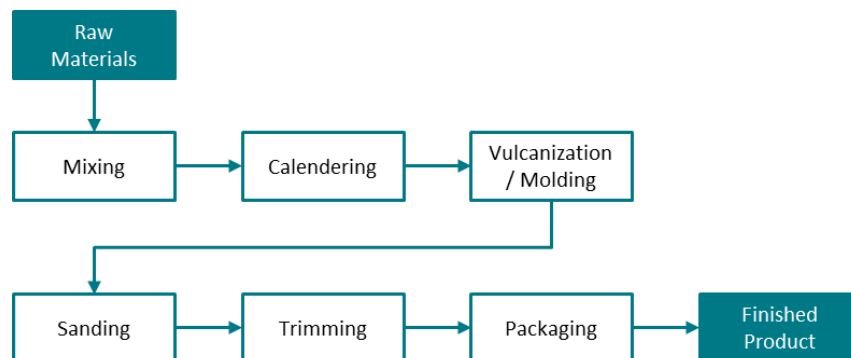


Figure 1: Schematic of production process





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Delivery and Installation of Floor Covering

In this study, transport to construction site by truck and flooring installation in the building are included. Adhesive is required for installation; 250 g/m² are used. During installation, approximately 4.5% of the total material is cut off as waste. Though some of this waste could be recycled, this scrap is modeled as being disposed of in a landfill.

Health, Safety, and Environmental Aspects during Installation

Installed product waste and packaging waste are assumed to be sent to a landfill (although packaging material is often recycled in local systems). Landfill emissions from paper, plastic, and wood packaging are allocated to installation.

Following installation procedures correctly is critical to meeting the health and safety of workers during installation. Procedures are described on the product Specifications (see document links in section Cleaning and Maintenance.)

Use Stage

The service life of rubber flooring will vary depending on the amount of foot traffic, furnishing type and use, type of equipment used for floor maintenance and frequency of maintenance. The level of maintenance is also dependent on the actual use and desired appearance of the floor. For this product, the defined Reference Service Life (RSL) is 40 years. This means that the product will meet its functional requirements for an average of 40 years before replacement. Since the EPD must present results for both one-year and 60-year time periods, impacts are calculated for both time horizons.

Cleaning and Maintenance



The recommended cleaning regime is highly dependent on the use of the premises where the floor covering is installed. In high traffic areas, more frequent cleaning will be needed compared to areas where there is low traffic. For the purposes of this EPD, average maintenance is presented based on typical installations as summarized in the list of use and maintenance activities to accompany Table B in the Results section.

Product-specific cleaning regimes can be found here:
http://www.FLEXCOfloors.com/technical-support/?cbg_tz=240

Maintenance instructions

Prevention of Structural Damage

Heavy furniture and equipment should be kept off the floor for a minimum of 72 hours after floor installation to allow the adhesive to set. Damage from wheeled vehicles, castered furniture and dollies can be prevented by using proper furniture rests, wheels or casters with suitable widths and diameters for the loads to be carried.

Moisture in subfloors is an important consideration for the successful installation of rubber flooring. To avoid damage from moisture, recommended guidelines in ASTM F 7100 Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring and ASTM F 1482 Standard Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring should be followed.





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Health Aspects during Use



The flooring products in this EPD comply with the VOC emissions requirements in the California Department of Public Health (CDPH) Standard Method v1.1 as certified by the FloorScore® Certification Program for Indoor Air Quality. The flooring products also meet Collaborative for High Performance Schools (CHPS) criteria. These tests, closed chamber laboratory tests over 14 days, ensure there is no or minimal off-gassing of volatile organic compounds from the FLEXCO products.

Low VOC cleaning materials for use in maintaining rubber flooring are available through FLEXCO.

End of Life

Based on current best information a small amount of construction waste is incinerated or recycled, but for the purposes of this EPD 100% of all flooring removal waste is disposed of in a landfill.

Additional Environmental Information (Operations, Raw Materials, Chemicals of Concern)

Additional Information about Energy: FLEXCO works with the Alabama Technology Network (ATN), whose mission is to provide industry and business, particularly manufacturing, the tools, training, and resources to grow and excel. ATN works through the local Alabama community college system in partnership with the federal NIST Manufacturing Extension Partnership. In 2013, FLEXCO was recognized by ATN with an Alabama E3 Award for Energy Achievement.



Additional Information about Raw Materials: In 2015, FLEXCO Corporation’s parent company, RHC Family Companies, joined the Sustainable Purchasing Leadership Council (SPLC) and uses SPLC guidance in purchasing decisions. In 2014-15, RHC assisted a key supplier to open a manufacturing plant in Fostoria, Ohio, moving production from South Korea to the U.S. This action won an Outstanding Case Study Award from the SPLC in May 2016 for ‘on-shoring’ a supplier.





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Additional Information about Chemicals of Concern: FLEXCO Corporation follows the Lowell Center Framework to remove chemicals of concern from all products. For 30 years, FLEXCO has been a leader in removing hazardous components from building materials including most recently switching to a green pigment without heavy metals (traces of Lead, Hexavalent Chromium, Mercury, and Cadmium) in 2011. In 2015, RHC joined the Health Product Declaration Collaborative, and is using HPD 2.0 to prioritize work on chemicals of concern and actively participating in HPDC work groups (in 2016 and 2017, the third party certification technical working group).



A balance between product quality, chemical risk, and cost is pursued in evaluating raw materials and the production process. Product quality includes durability, aesthetics, ease of maintenance and cleaning—all the aspects of the product that customers rely upon. Chemical risk includes hazard, exposure, and concentration of chemicals of concern. Members of the engineering, chemistry, technical & installation services, and sustainability groups are continuously searching out and evaluating new possible materials and processes.

Corporate Environmental Sustainability Goals: Corporate environmental sustainability goals for four key metrics have been set for the period 2016-2025. These metrics and their goals are:

Metric	Goal	Measured as:
Energy Intensity	20% reduction	kWh/pound of product
Greenhouse Gases	20% reduction	kg CO ₂ -equivalents/pound of product
Waste to Landfill	25% reduction	Pounds waste/pound of product
Water Used/Consumed	20% reduction	Gallons water/pound of product

The corporate sustainability goals are documented in the Corporate Sustainability Report. Progress will be updated tri-annually to RHC stakeholders.





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Life Cycle Assessment

A full Life Cycle Assessment has been carried out according to ISO 14040 and 14044, per the Product Category Rule (PCR) for Flooring: Carpet, Resilient, Laminate, Ceramic, Wood – Version 2, as published by NSF International [NSF 2014].

The main purpose of EPDs is for use in business-to-business communication. As all EPDs are publicly available via the Program Operator and therefore are accessible to the end consumer, they can also be used in business-to-consumer communication.

Functional Unit

The declaration refers to the functional unit of 1m² installed flooring.

Cut-off Criteria

Cut-off criteria were applied in keeping with the PCR. Raw materials each representing 0.5% or less of total incoming raw material mass were cut off, amassing to no more than 2% for the tile product formulation. Ultimately, cumulative omitted mass or environmental impacts remained below 5%, as required by the PCR. For manufacturing, the utilized thermal and electrical energy, the required packaging materials, and all direct production waste were included in the analysis.

LCA Background Data

As a general rule, specific data derived from specific production processes or average data derived from specific production processes are preferred as the basis for calculating LCA results.

For life cycle modeling of the considered products, the GaBi ts Software System for Life Cycle Engineering, developed by thinkstep AG, was used to model the product systems considered in this assessment [GABI TS 2016]. All relevant background datasets, including those for energy, transportation, and auxiliary materials, were taken from the GaBi 2016 databases. The datasets in the GaBi databases are documented online [GABI TS 2016].

Data Quality

A variety of tests and checks were performed throughout the project to ensure high quality of the completed project. Checks included an extensive review of project-specific LCA models and background data used.

Temporal Coverage

Foreground data are based on 2015 averaged data. Background datasets are all based on data from the last 10 years (since 2006), with the majority of datasets based on data from 2012 or later.

Technological Coverage

Data represent manufacturing of molded rubber flooring at a single Flexco manufacturing facility. Waste, emissions and energy use are based on measured data during the reference year. Raw material inputs in the calculation for this EPD are based on Flexco product formulation, scaled to annual production.

Geographical Coverage

The analysis represents production at a single US plant in Tusculumbia, AL. Manufacturing energy inputs are representative for the US region included, but proxy datasets were used as needed for raw material inputs to address





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lack of data for a specific material or for a specific geographical region. These proxy datasets were chosen for their technological representativeness of the actual materials.

System Boundaries

The EPD system boundary is defined according to the NSF PCR for flooring [NSF 2014]. According to the PCR, the product life cycle is to be divided into five stages:

- Sourcing and extraction,
- Manufacturing,
- Delivery and installation,
- Use, and
- End-of-life.

Impacts and aspects related to wastage (i.e., waste generation, transport and waste processing and final disposal of waste products and materials) are considered in the module in which the wastage occurs.

Allocation

Co-Product Allocation

No co-product allocation occurs in the product system.

Multi-Input Processes Allocation

No multi-input allocation occurs in the product system.

Recovery Allocation

Product and packaging waste is modeled as being disposed in a landfill rather than incinerated or recycled. Plastic and other construction waste is assumed to be inert in landfills, so no system expansion or allocation is necessary as landfill gas is not produced. In the case of bio-based packaging waste disposed during installation, landfill gas from the decomposition of this waste can be collected and used to produce electricity. Following the cut-off approach, however, no energy credits or offsets are given.





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Results

Life Cycle Impact Assessment

Per the guiding PCR, Table A discloses the total potential impacts associated with the activities necessary to bring 1 m² of product to market and includes end-of-life impacts, regardless of the amount of time that the product is used by the customer.

Table A: Life cycle stage impacts, Cradle to Install and End-of-Life for 1 m² flooring

Impact Category	Units	Sourcing and Extraction	Manufacturing	Delivery and Installation	End-of-Life	TOTAL
Abiotic Depletion Potential, Elements*	kg Sb-eq.	0.000158	5.30E-06	1.76E-06	9.42E-08	0.000165
Abiotic Depletion Potential, Fossil*	MJ	263	221	18.7	3.86	507
Acidification Potential*	kg SO ₂ -eq.	0.0273	0.022	0.00427	0.00333	0.0569
Eutrophication Potential*	kg PO ₄ ³⁻ -eq.	0.00426	0.00274	0.00196	0.00147	0.0104
Global Warming Potential*	kg CO ₂ -eq.	11.5	15.9	1.57	0.256	29.2
Ozone Depletion Potential*	kg R11-eq.	4.84E-10	1.31E-09	5.04E-11	4.71E-12	1.84E-09
Photochemical Ozone Creation Potential*	kg Ethene-eq.	0.00362	0.0113	0.000882	0.00151	0.0174
Primary Energy Demand, Non-Renewable**	MJ	269	232	19.2	3.95	524
Primary Energy Demand, Renewable**	MJ	7.16	17.8	0.395	0.239	25.6

* CML 2001 – April 2015 ** Impact indicators

Per the guiding PCR, Table B discloses the average 1-year potential impacts associated with product use and maintenance.

Table B: Average one year Use stage impacts for 1 m² flooring

Impact Category	Units	Average 1 year Use and Maintenance Impacts
Abiotic Depletion Potential, Elements*	kg Sb-eq.	7.56E-08
Abiotic Depletion Potential, Fossil*	MJ	1.5
Acidification Potential*	kg SO ₂ -eq.	0.000189
Eutrophication Potential*	kg PO ₄ ³⁻ -eq.	0.000187
Global Warming Potential*	kg CO ₂ -eq.	0.0922
Ozone Depletion Potential*	kg R11-eq.	0.0000383
Photochemical Ozone Creation Potential*	kg Ethene-eq.	9.34E-12
Primary Energy Demand, Non-Renewable**	MJ	1.59
Primary Energy Demand, Renewable**	MJ	0.0494

* CML 2001 – April 2015 ** Impact indicators

List of Use and Maintenance Activities to accompany Table B

Maintenance Activity	Frequency over user defined 40-year service life of product	Annual consumption of energy and resources
Dry mop	40 x 365 times (daily)	-
Damp mop / neutral cleaner	40 x 52 times (weekly)	Neutral detergent: 119 ml/m ² Water: 5.8 L/m ²
Buff	40 x 12 times (monthly)	Finish: 0.12 L / m ² Electricity: 0.022 kWh/m ²





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Per the guiding PCR, Table C discloses the total potential impacts associated with all stages of the product, including use stage, over the entire life of a building. The building reference service life (RSL) is defined as 60 years. The user-defined product RSL is 40 years.

Table C: Life cycle stage impacts, Cradle-to-Grave impacts over the 60-year building service life for 1m² flooring

Impact Category	User defined RSL of product = 40 years Number of installations over 60 years = 1.5						
	Units	Sourcing and Extraction	Manu- facturing	Delivery and Installation	Use	End-of- Life	TOTAL
Abiotic Depletion Potential, Elements*	kg Sb-eq.	0.000238	7.95E-06	2.63E-06	4.53E-06	1.41E-07	0.000253
Abiotic Depletion Potential, Fossil*	MJ	395	331	28.1	89.9	5.78	850
Acidification Potential*	kg SO ₂ -eq.	0.0409	0.033	0.00641	0.0114	0.00499	0.0967
Eutrophication Potential*	kg PO ₄ ³⁻ -eq.	0.00639	0.00411	0.00294	0.0112	0.0022	0.0269
Global Warming Potential*	kg CO ₂ -eq.	17.2	23.8	2.35	4.71	0.385	48.4
Ozone Depletion Potential*	kg R11-eq.	7.25E-10	1.96E-09	7.56E-11	5.6E-10	7.07E-12	3.33E-09
Photochemical Ozone Creation Potential*	kg Ethene-eq.	0.00543	0.017	0.00132	0.0023	0.00227	0.0283
Primary Energy Demand, Non-Renewable**	MJ	403	349	28.8	95.1	5.93	882
Primary Energy Demand, Renewable**	MJ	10.7	26.8	0.592	2.96	0.358	41.4

* CML 2001 – April 2015 ** Inventory indicators

Interpretation

The diagram below offers a view of the results in Table C, normalized to 100%.

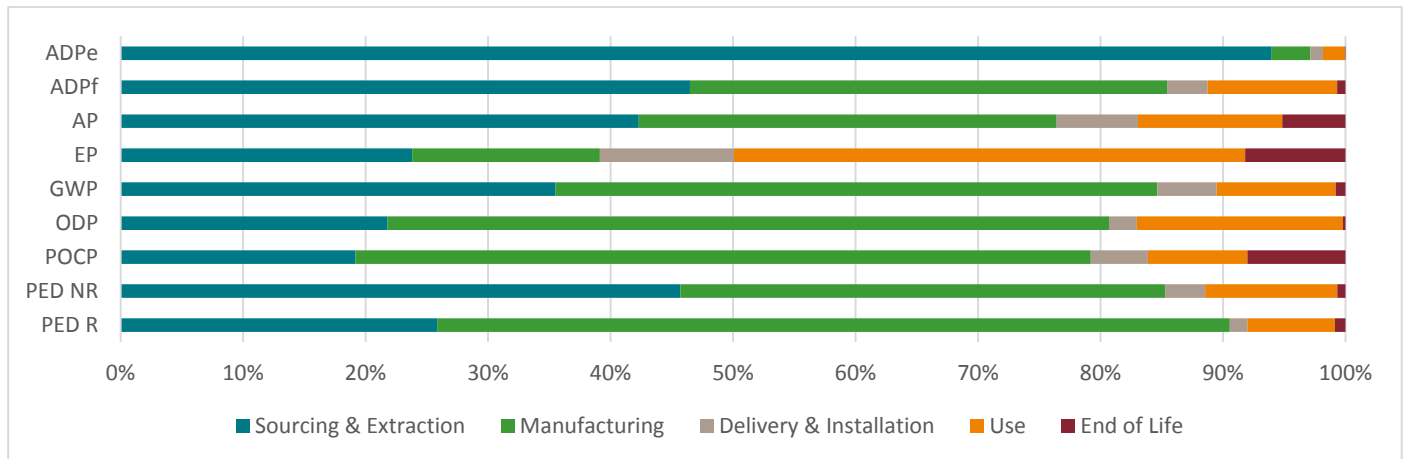


Figure 2: Normalized impacts, by life cycle stage

Over the 60-year life of an installation in a building, the upstream production of raw materials, the manufacturing of the flooring product, and the recommended maintenance during use represent the largest contributors in each impact category considered. Use-phase Eutrophication Potential (EP) is largely driven by municipal wastewater treatment.





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References

GABI TS 2016	thinkstep AG; GaBi ts: Software-System and Database for Life Cycle Engineering. Copyright, TM. Stuttgart, Echterdingen, 1992-2016.
EN 15804	EN 15804:2012-02 Sustainability of construction works - Environmental Product Declarations - Core rules for the product category of construction products
ISO 14025	ISO 14025:2011-10 Environmental labels and declarations - Type III environmental declarations - Principles and procedures
ISO 14040	ISO 14040:2009-11 Environmental management - Life cycle assessment - Principles and framework
ISO 14044	ISO 14044:2006-10 Environmental management - Life cycle assessment - Requirements and guidelines
NSF 2014	NSF Product Category Rule for Flooring: Carpet, Resilient, Laminate, Ceramic, Wood – Version 2

Contact Information

Study Commissioner



Please call us with any question about FLEXCO rubber products or this Environmental Product Declaration. Thank you for your business, for more than 60 years.

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LCA Practitioner



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