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THE INTERNATIONAL EPD® SYSTEM

CEN Standard EN 15804 serves as the core PCR	
PCR:	PCR 2012:01 Construction products and construction services, Version 2.3 SUB-PCR to PCR 2012:01: Wood and wood-based products for use in construction. PCR 2012:01-SUB-PCR-E (Date: 2018-11-22)
PCR review was conducted by:	The Technical Committee of the International EPD® System. Chair: Massimo Marino. Contact via info@environdec.com
Independent verification of the declaration and data, according to ISO 14025:	☐ EPD process certification ☐ EPD verification
Third party verifier:	Jane Anderson ConstructionLCA Ltd. www.constructionlca.co.uk
Accredited or approved by:	The International EPD® System

General information

Name of declared products

Oriented strand board (OSB), engineered wood-based panel products manufactured at Norbord sites in Inverness and Genk.

Statement of conformity to standards

Environmental Product Declaration in accordance with ISO 14025 and EN 15804. EPD of construction products may not be comparable if they do not comply with EN15804. The following Product Category Rules were used to develop this EPD:

- Construction products and construction services. PCR 2012:01 Version 2.3 (Date: 2018-11-15)
- SUB-PCR to PCR 2012:01: Wood and wood-based products for use in construction. PCR 2012:01-SUB-PCR-E (Date: 2018-11-22)

EPD Program Operator

The International EPD® System (www.environdec.com)

EPD International AB, Box 210 60, SE-100 31, Stockholm, Sweden.

Owner of the Environmental Product Declaration

Norbord Europe Ltd, Morayhill, Dalcross, Inverness, IV2 7JQ, Scotland, UK.

EPD Prepared by

thinkstep Ltd

4 Coleman Street, 6th Floor,

London, EC2R 5AR.

Verified by

Jane Anderson, ConstructionLCA Ltd.

UN CPC Code

31432 Oriented Strand Board (OSB).

Declaration Number

S-P-01850

Date of Issue

31st January 2020

Valid to

30th January 2025

Product

Product description

Oriented strand board (OSB) is an engineered wood-based panel product. It is made from thin strands of wood that are blended with resins and wax to improve the product's resistance to moisture. These strands are shaped into mats that are superimposed on to each other in specific orientations, which serves to maximise the strength of the finished boards. The mats are pressed at high temperature and pressure before having surface treatments applied and being cut into standard sizes.

OSB is manufactured between 8-30 mm thickness with variable dimensions dependent on the end use. The product's favourable mechanical properties make it suitable for structural use in load bearing and challenging conditions. As such, OSB is widely used in flooring, wall sheathing, roofing, timber frames, furniture and packaging applications

Figure 1: OSB timber walling (Norbord Europe Ltd, Norbord Media, 2015).

Company description

Norbord is the UK's largest manufacturer of wood panel boards and have supplied the construction industry for over five decades. Norbord places customers, standards of excellence, control of costs, safety and environmental concerns at the heart of its business.

Brands include SterlingOSB Zero, CaberBoard Flooring and CaberWood MDF, and are manufactured to the highest standards. This backed up by a support team which assists customers with product and technical assistance. Norbord supplies more than 70 key items across our three product ranges and is committed to quality and customer service.

Product specification

This EPD relates to OSB products made by Norbord Europe Ltd at their production sites in Inverness, UK and Genk, Belgium, which are supplied to global customers. Separate results have been prepared for each production site.

The typical material composition of Norbord OSB is given below.

Table 1: Typical material composition of Norbord OSB

Component	Composition
Wood chips	90-93%
Resin	2-4%
Wax	1%
Water	3-5%
Others	<1%

Technical data

The key technical characteristics of Norbord OSB are provided below.

Table 2: Key technical characteristics of Norbord OSB

Technical Properties	Unit	Specification	Relevant EN Standard
Thermal conductivity 'K' Value	w/(m.K)	0.13	EN 13986
Linear expansion (65-85% relative humidity)	%	0.15	
Moisture content	%	2-12	EN 322
Modulus of elasticity in bending – major axis	N/mm^2	3500	EN 310
Modulus of elasticity in bending – minor axis	N/mm^2	1400	EN 310
Internal bond (IB)	N/mm^2	0.29-0.34	EN 319
Thickness swelling (24 hr immersion)	%	15	EN 317
Reaction to fire (BS EN 135 01-1)		D	EN 13986
Formaldehyde	mg/100 g	<8	EN 120

LCA system boundaries

The scope of this EPD is covers the OSB production process and upstream burdens associated with production and transport of raw materials and generation of energy. It also accounts for the burdens associated with distributing the finished product out to customers. These activities relate to modules A1-A4, according to EN 15804, as shown in the table below. As such, this EPD is of the type "cradle-to-gate with options". No reference service life is reported, as the use-stage modules (B1-B5) have not been declared.

Table 3: Modules of the production life cycle included in the EPD (X = declared module; MND = module not declared)

Production			Installation		Use stage							End-of-Life				Next product system
Raw material supply (extraction, processing, recycled material)	Transport to manufacturer	Manufacturing	Transport to building site	Installation into building	Use / application	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction / demolition	Transport to EoL	Waste processing for reuse, recovery or recycling	Disposal	Reuse, recovery or 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	MND	MND	MND	MND	MND

Modelling the life cycle

The calculation procedures described in EN ISO 14044:2006 and EN15804:2012 were followed and applied consistently throughout the study. The following Product Category Rules were used to develop this EPD:

- Construction products and construction services. PCR 2012:01 Version 2.3 (Date: 2018-11-15)
- SUB-PCR to PCR 2012:01: Wood and wood-based products for use in construction. PCR 2012:01-SUB-PCR-E (Date: 2018-11-22)

Declared unit

The declared unit for OSB reported in this EPD is 1 m^3 of wood-based panel products manufactured at the Inverness site with an apparent density of 600 kg/m^3. To convert from 1m^3 to 1kg OSB, the results for the Inverness site in this EPD should be divided by the apparent density of 600 kg/m^3.

To convert from 1 m^3 to 1 kg OSB from Inverness, the results in this EPD should be divided by the apparent density of 600 kg/m^3.

The declared unit for OSB manufactured at the Genk site is 1 m^3 of wood-based panel products with an apparent density of 620kg/m^3. To convert from 1m^3 to 1kg OSB, the results for the Genk site in this EPD should be divided by the apparent density of 620 kg/m^3.

To convert from 1 m^3 to 1 kg OSB from Genk, the results in this EPD should be divided by the apparent density of 620 kg/m^3.

System boundary

Figure 2 shows the process steps and activities included within the system boundaries of the EPD study.

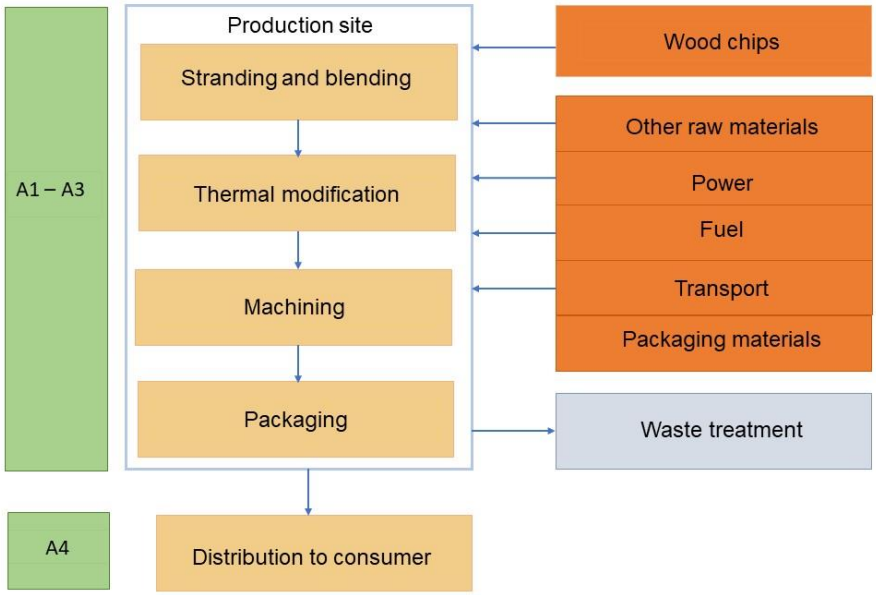

Figure 2: Process flow diagram showing the production and distribution of Norbord OSB

Description of production process

Logs are harvested from Forestry Stewardship Certification (FSC)-managed woodlands and transported to the factory wood yard. The logs are sorted according to species and prepared for processing. The logs are then de-barked (this is used as biofuel in the mill).

The logs are sliced into thin strands of a pre-defined size in a process called 'stranding.' These strands are stored in wet bins until ready to be dried. The strands are processed through a rotary dryer until the correct strand humidity is reached. Fine particles are sieved off and also used as biofuel.

The strands are mixed with resin and a small quantity of wax. The wax improves the efficiency of the resin and increases the resistance of the mixture to moisture and water absorption. The strands pass through orienters which build a mat from individual layers, which are superimposed perpendicularly to each other. These mats are pressed at high pressure and high temperature. This pressure causes the resins to react and forms a high-density structural panel.

The panels are cut into standard sizes and stamped according to grade. The finished OSB products are stored for a minimum of 48 hours prior to shipping.

The products are packaged and shipped to the consumer by truck (modelled as Euro 6, 28-32 t gross weight capacity). The average delivery transport distance from the Inverness mill to the consumer is 713 km, while for Genk this is 450 km. These delivery distances have been calculated based on average transport distances provided by Norbord Europe Ltd, and as such are representative of a typical use scenario.

Data quality

Data collection followed the guidance provided in EN 15804, clause 4.3.2.

Wood Environment & Infrastructure Solutions UK Ltd supported the data collection process and obtained and reviewed the information provided by Norbord Europe Ltd. These data were cross-

checked for completeness and plausibility using mass balances and stoichiometry, as well as internal and external benchmarking.

All producer-specific data are from 2018 and are based on one-year averaged data, representative of current production at each site.

Background data for LCA modelling were sourced from the GaBi 2019 databases, for which full documentation is available online (thinkstep, 2019). These dataset have documented reference years between 2015 and 2018.

Cut-off criteria

The cut-off criteria applied follow EN 15804, whereby all emissions and their environmental impact contributing greater than 1% to the total must be recorded.

In this assessment, all information gathered from data collection for the production of Norbord OSB has been modelled, i.e. all raw materials used, the electrical energy and other fuels used, use of ancillary materials and all direct production waste. Transport data on input and output flows have also considered. No data on inputs or outputs have knowingly been omitted from the assessment.

Allocation

The only co-products generated during the production of OSB at Norbord's sites in Inverness and Genk were bark and other biomass from the wood processing activities. These were all used as biofuel for the boilers at each site and so were modelled using internal loops.

At the Genk site a small quantity of waste is sent externally for recycling but no allocation has been made for this. Instead a worst-case assumption has been made where all the process impacts are allocated to the OSB.

No other co-products were sold or used outside the mill boundaries.

Results Indicators

The environmental indicators specified in the tables below are assessed for each module included in the life cycle assessment of the Oriented Strand Board.

Table 4: Indicators of life cycle impact assessment inventory on output flows

Indicator	Abbr.	Unit
Global warming potential	GWP	kg CO_2 equivalent
Depletion potential of the stratospheric ozone layer	ODP	kg CFC 11 equivalent
Acidification potential of soil and water	AP	kg SO_2 equivalent
Eutrophication potential	EP	kg $(PO_4)^{3-}$ equivalent
Formation potential of tropospheric ozone	POCP	kg C_2H_4 equivalent
Abiotic depletion potential for non-fossil resources	ADPE	kg Sb equivalent
Abiotic depletion potential for fossil resources	ADPF	MJ, net calorific value

Table 5: Life cycle inventory indicators on use of resources

Indicator	Abbr.	Unit
Use of renewable primary energy as energy carrier	PERE	MJ, net calorific value
Use of renewable primary energy as raw materials	PERM	MJ, net calorific value
Total use of renewable primary energy	PERT	MJ, net calorific value
Use of non-renewable primary energy as energy carrier	PENRE	MJ, net calorific value
Use of non-renewable primary energy as raw materials	PENRM	MJ, net calorific value
Total use of non-renewable primary energy	PENRT	MJ, net calorific value
Use of secondary material	SM	kg
Use of renewable secondary fuels	RSF	MJ, net calorific value
Use of non-renewable secondary fuels	NRSF	MJ, net calorific value
Net use of fresh water	FW	kg

Table 6: Life cycle inventory indicators on waste categories

Indicator	Abbr.	Unit
Hazardous waste disposed	HWD	kg
Non-hazardous waste disposed	NHWD	kg
Radioactive waste disposed	RWD	kg

Table 7: Life cycle inventory indicators on output flows

Indicator	Abbr.	Unit
Components for reuse	CRU	kg
Materials for recycling	MFR	kg
Materials for energy recovery	MER	kg
Exported electrical energy	EEE	MJ
Exported thermal energy	EET	MJ

LCA Results – Inverness mill

The results of this study for OSB manufactured at the Inverness mill are reported in the following tables.

Table 8: LCA results for 1 m^3 oriented strand board (Inverness) – environmental impact

Parameters describing environmental impacts*					
Indicator	**Unit**	**A1**	**A2**	**A3**	**A4**
GWP	[kg CO_2-eq.]	-8.71E+02	1.68E+01	-7.19E+00	3.30E+01
ODP	[kg CFC11-eq.]	1.80E-12	2.07E-15	4.78E-12	4.84E-15
AP	[kg SO_2-eq.]	3.29E-01	4.51E-01	6.59E-03	2.24E-02
EP	[kg PO_4^{3-}-eq.]	4.36E-02	5.01E-02	1.89E-03	3.06E-03
POCP	[kg ethene-eq.]	3.15E-02	2.43E-02	3.90E-04	-6.94E-04
ADPE	[kg Sb-eq.]	2.21E-05	3.81E-07	3.92E-07	3.27E-07
ADPF	[MJ]	2.73E+03	2.09E+02	2.98E+01	4.47E+02

GWP = Global warming potential; ODP = Ozone depletion potential; AP = Acidification potential; EP = Eutrophication potential; POCP = Photochemical ozone creation potential; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources, WSP = Water scarcity potential

Table 9: LCA results for 1 m^3 oriented strand board (Inverness) – resource use, primary energy

Parameters describing resource use, secondary materials and fuels, use of water*					
Parameter	**Unit**	**A1**	**A2**	**A3**	**A4**
PERE	[MJ]	3.18E+03	6.39E-01	6.40E+00	1.35E+00
PERM	[MJ]	1.05E+04		1.07E+02	
PERT	[MJ]	1.37E+04	6.39E-01	1.13E+02	1.35E+00
PENRE	[MJ]	2.45E+03	2.09E+02	2.42E+01	4.49E+02
PENRM	[MJ]	7.44E+02		8.17E+00	
PENRT	[MJ]	3.20E+03	2.09E+02	3.24E+01	4.49E+02
SM	[kg]			1.14E-01	
RSF	[MJ]				
NRSF	[MJ]				
FW	[m^3]	8.02E-01	1.16E-03	-4.78E-02	1.86E-03

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

Table 10: LCA results for 1 m³ oriented strand board (Inverness) – output flows at end of life and waste categories

Parameters describing environmental impacts*					
Parameter	**Unit**	**A1**	**A2**	**A3**	**A4**
HWD	[kg]	7.13E-06	2.16E-08	5.42E-07	3.18E-08
NHWD	[kg]	1.54E+00	1.36E-03	4.41E-01	3.83E-03
RWD	[kg]	1.87E-01	2.50E-04	1.01E-03	5.18E-04
CRU	[kg]				
MFR	[kg]				
MER	[kg]			8.27E-01	
EEE	[MJ]				
EET	[MJ]				

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

LCA Results – Genk mill

The results of this study for OSB manufactured at the Genk mill are reported in the following tables.

Table 11: LCA results for 1 m³ oriented strand board (Genk) – environmental impact

Parameters describing environmental impacts*					
Indicator	**Unit**	**A1**	**A2**	**A3**	**A4**
GWP	[kg CO_2-eq.]	-9.48E+02	1.73E+01	-1.04E+01	2.16E+01
ODP	[kg CFC11-eq.]	2.14E-12	2.21E-15	3.42E-14	3.17E-15
AP	[kg SO_2-eq.]	1.74E-01	3.76E-01	8.01E-03	1.47E-02
EP	[kg PO_4^{3-}-eq.]	3.07E-02	4.19E-02	2.43E-03	2.00E-03
POCP	[kg ethene-eq.]	2.18E-02	2.01E-02	3.19E-04	-4.55E-04
ADPE	[kg Sb-eq.]	2.27E-05	3.49E-07	4.45E-07	2.14E-07
ADPF	[MJ]	2.20E+03	2.18E+02	3.60E+01	2.93E+02

GWP = Global warming potential; ODP = Ozone depletion potential; AP = Acidification potential; EP = Eutrophication potential; POCP = Photochemical ozone creation potential; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources, WSP = Water scarcity potential

Table 12: LCA results for 1 m3 oriented strand board (Genk) – resource use, primary energy

Parameters describing resource use, secondary materials and fuels, use of water*					
Parameter	**Unit**	**A1**	**A2**	**A3**	**A4**

Parameters describing resource use, secondary materials and fuels, use of water*					
PERE	[MJ]	1.98E+03	6.67E-01	1.05E+01	8.86E-01
PERM	[MJ]	1.08E+04		1.36E+02	
PERT	[MJ]	1.28E+04	6.67E-01	1.47E+02	8.86E-01
PENRE	[MJ]	2.14E+03	2.19E+02	3.01E+01	2.94E+02
PENRM	[MJ]	6.12E+02		8.99E+00	
PENRT	[MJ]	2.75E+03	2.19E+02	3.91E+01	2.94E+02
SM	[kg]				
RSF	[MJ]				
NRSF	[MJ]				
FW	[m^3]	8.09E-01	1.15E-03	-1.62E-01	1.22E-03

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

Table 13: LCA results for 1 m^3 oriented strand board (Genk) – output flows at end of life and waste categories

Parameters describing environmental impacts*					
Parameter	**Unit**	**A1**	**A2**	**A3**	**A4**
HWD	[kg]	6.78E-06	2.11E-08	6.04E-07	2.09E-08
NHWD	[kg]	1.44E+00	1.52E-03	2.72E-01	2.51E-03
RWD	[kg]	2.19E-01	2.60E-04	1.23E-03	3.40E-04
CRU	[kg]				
MFR	[kg]				
MER	[kg]			2.35E+00	
EEE	[MJ]				
EET	[MJ]				

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

Interpretation

The following figures shows the percentage contribution of each mill process to the environmental impact categories at the Inverness and Genk mills, respectively.

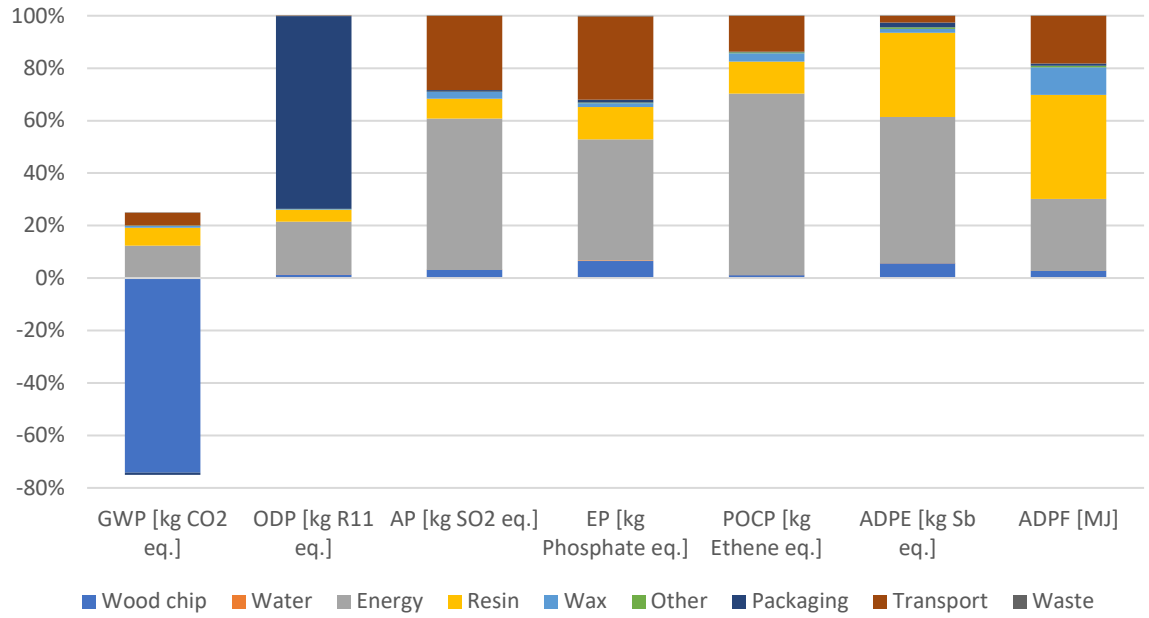

Figure 3: Contribution from different materials and process steps to the total impact (A1-A4) for the impact categories assessed in this EPD study for OSB manufactured in Inverness

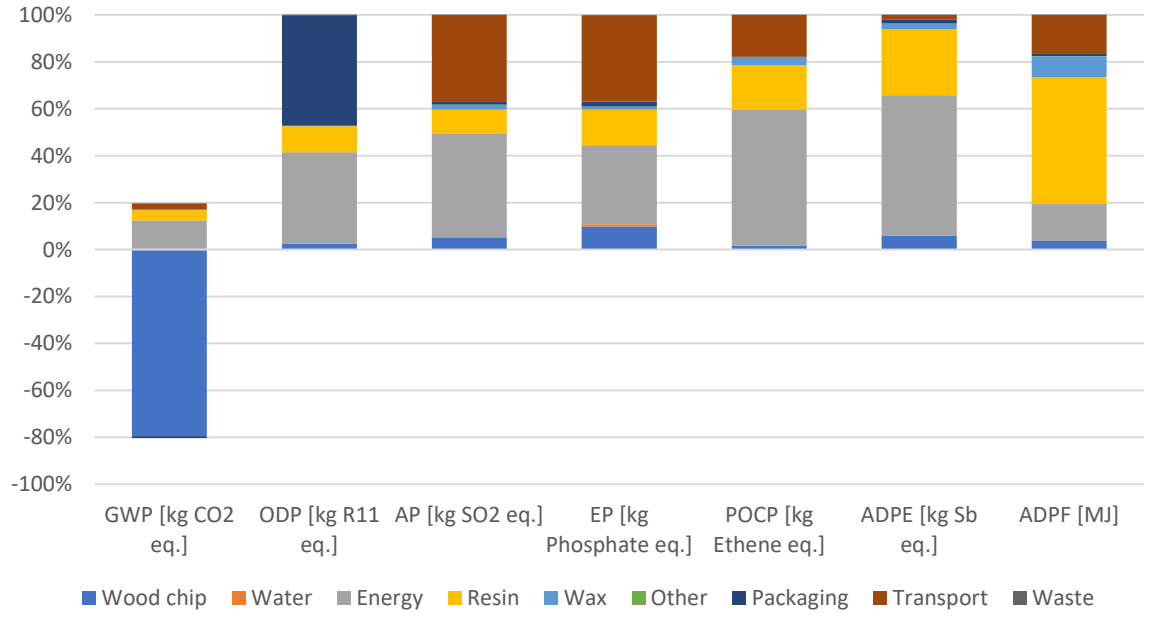

Figure 4: Contribution from different materials and process steps to the total impact (A1-A4) for the impact categories assessed in this EPD study for OSB manufactured in Genk.

The results show that for both sites the sequestered carbon in the wood chip raw material is the greatest contributor to the global warming potential (GWP). ODP, AP, EP, POCP and ADPE are all largely driven by energy production. Most energy used at each mill was derived from non-renewable resources. The dominant contributor to abiotic depletion for fossil resources (ADPF) was the use of

resins at both sites. The resins are the main component of the product sourced from non-renewable resources, with the remainder of the product composed of wood. Production of resin also has substantial burdens in POCP and ADPE impact categories.

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