



# SARAY®

# ENVIRONMENTAL PRODUCT DECLARATION

In accordance  
with ISO 14025 and EN 15804:2012+A2:2019 for

## **B1 Composite Panels**

**Programme:**

The International EPD® System  
[www.environdec.com](http://www.environdec.com)

**Programme Operator:**

EPD International AB

**Local Operator:**

EPD Turkey

**S-P Code:**

S-P-4081

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03-09-2026

# Programme Information

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## Programme

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Product Category Rules (PCR): 2019:14 Version 1.11, 2021-02-05, Construction  
Products and CPC 54 Construction Services, EN 15804:2012 + A2:2019 Sustainability  
of Construction Works

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Independent third-party verification of the declaration and data, according to ISO  
14025:2006:

EPD process certification

EPD verification **X**

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Third party verifier: Prof. Vladimír Kocí

Approved by: The International EPD® System

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Procedure for follow-up of data during EPD validity involves third party verifier:

Yes

No **X**

*The EPD owner has the sole ownership, liability, and responsibility  
for the EPD. EPDs within the same product category but  
from different programmes may not be comparable. EPDs of  
construction products may not be comparable if they do not  
comply with EN 15804.*

# About the Company

Since 1980, Saray Aluminium has been playing a major role in the construction of future architectural buildings with its leading and innovative interior & exterior construction solutions.

Saray manufactures aluminium door&window, curtain wall (facade) and handrail systems, aluminium composite panel, PVC door&window systems, shutter systems, various types of industrial profiles for the sectors such as machinery, lighting, elevator etc. and standard section profiles in various shapes and sizes.

Saray is among the first Turkey's Top 200 Industrial Enterprises and exports %55 of total production more than 60 countries in Europe, Asia, Africa; with its high export amounts Saray receives the "Export Stars of Turkey" award in every year.

Saray Aluminium has CE, ISO 9001, ISO 14001 Qualanod, Qualicoat, TS EN 755, TS EN 12020, SEPRO and GOST-R quality certificates. Saray is a fully integrated enterprise with its aluminium powder coating, aluminium anodizing, extrusion, casting, aluminium composite panel and pvc extrusion, shutter production facilities. With a total of 100.000 sqm covered area, production facilities are located in Cerkez koy/Tekirdag and Gunesli/Istanbul.



# Product Information

LCA Study presented in this report assesses the potential environmental impacts of B1 Composite Panels during their life cycle from raw material supply to disposal.

Saray Al Composite Panels consist of mineral core bonded between two Aluminium panel sheets. Aluminium sheets can be coated with PVDF or Polyester paint.

Raw Material	%
Aluminium Sheet, kg/m <sup>2</sup>	25-35
Mineral Filler, kg/m <sup>2</sup>	60-70
Adhesive, kg/m <sup>2</sup>	0-5
Others, kg/m <sup>2</sup>	0-5

Saray Al Composite Panels are very rigid and strong despite their light weight. Aluminium sheets are painted in any kind of colour, in PVDF or Polyester coatings, including a wide range of metallic and non-metallic colours as well as patterns that imitate other materials, such as wood or marble.

Applications of Saray Al Composite Panels are not limited to external building cladding, but can also be used in any form of cladding such as partitions, false ceilings etc. Al Composite Panels are also widely used within the signage industry as an alternative to heavier, more expensive substrates.

The UN CPC code of the product is 4299, fabricated metal products-Other fabricated metal.

## Technical Specifications

Propoerties	Unit	Value
Thickness	mm	4
Weight	kg/m <sup>2</sup>	7.1
Thermal Conductivity	W/mK	0.056
Core		Mineral Filling

# LCA Informations

## Declared Unit

1 m<sup>2</sup> of B1 Composite Panel

## Time Representativeness

2020

## Database(s) and LCA Software Used

Ecoinvent 3.6, SimaPro 9.1

The inventory for the LCA study is based on the 2020 production figures for Aluminium Composite Panel by SARAY production plants in Çerkezköy, Turkey.

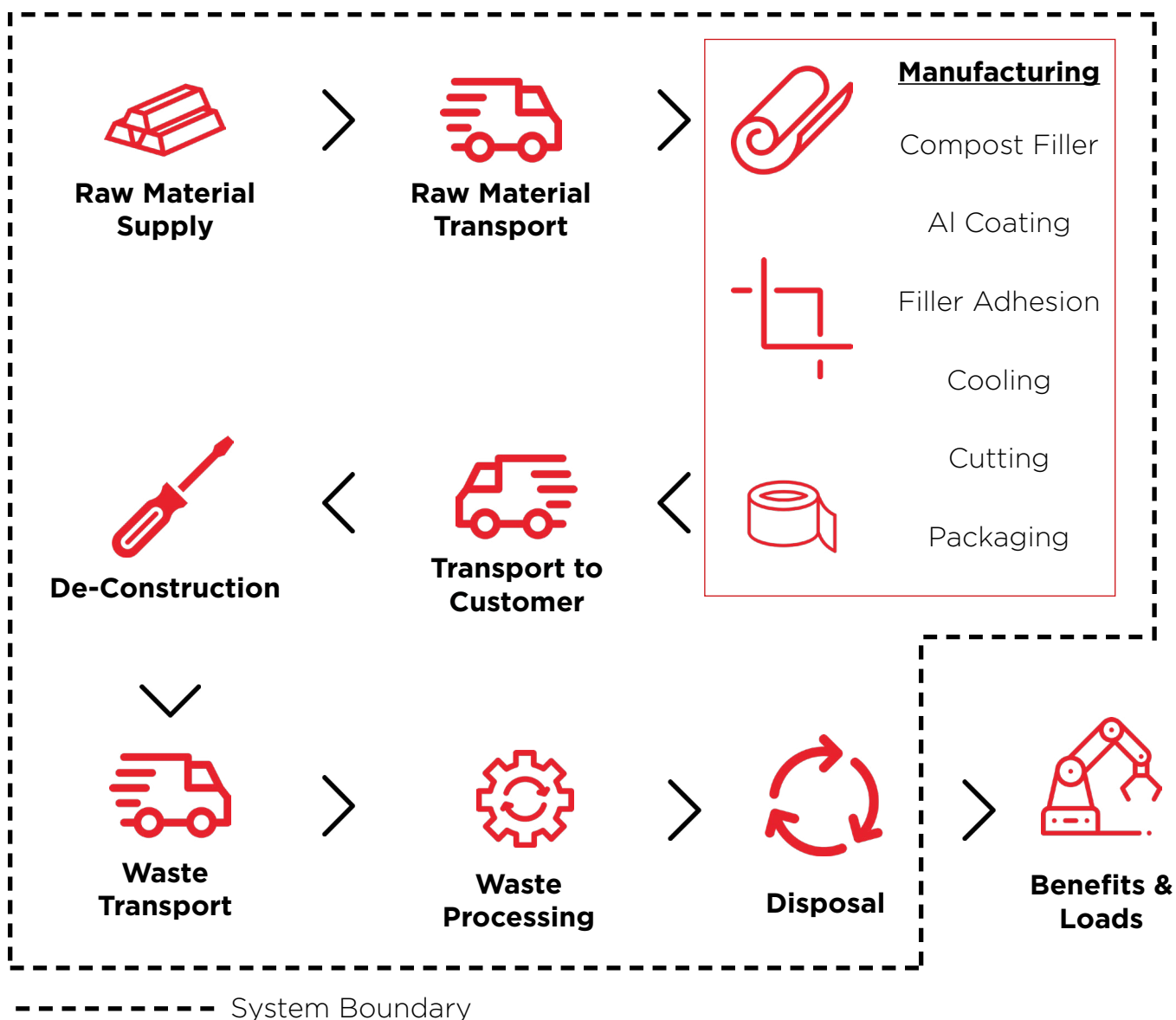
This EPD's system boundary is cradle to grave. The results of the LCA with the indicators as per EPD requirement are given in the following tables for product manufacture (A1, A2, A3), construction process stage (A4), end of life stage (C1, C2, C3, C4) and benefits and load stage (D).

The system boundaries in tabular form for all modules are shown in the table above.

Product Stage			Constrcution Process Stage		Use Stage							End of Life Stage				Benefits and Loads
Raw Material Supply	Transport	Manufacturing	Transport	Construction Installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational Energy Use	Operational Water Use	Deconstruction, demolition	Transport	Waste Processing	Disposal	Future reuse, recycling or energy recovery potentials
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	X	ND	ND	ND	ND	ND	ND	ND	ND	X	X	X	X	X

X = Included in LCA, ND = Not Declared

# System Boundary



## A1: Raw Material Supply

Production for each product starts with mainly locally sourced but some transported from other parts of the world. 'Raw material supply' includes raw material extraction and pretreatment processes before production.

## A2: Raw Material Transport

Transport is relevant for delivery of raw materials and other materials to the plant and the transport of materials within the plant. Transport of raw materials to production site is taken as the weight average values for transport from raw materials supplier in 2020.

### **A3: Manufacturing**

Panel production begins with coating of the aluminium sheets that form the panels and to be placed onto top and bottom layers. Mineral core or organic polymer additives are mixed up at certain percentages and the composed core is inserted into between two aluminium sheets with a particular amount of adhesive in order to laminate the panel layers. Electricity and natural gas are consumed during the manufacturing of Aluminium Composite Panels.

### **A4: Transport to Customer**

Transport of final product to construction site is taken as the weight average values for transport to customers in 2020. The product shipment distance is calculated according to the domestic and international sales rates over the assumed distances. It has been accepted as an average of 500 km by road for domestic and 2000 km by sea for abroad.

### **C1 : Deconstruction and Demolition**

For deconstruction stage, 0.239 MJ electricity use per kg of material was assumed (Gervasio et al., 2018).

### **C2 : Transport**

This stage includes the transportation of the discarded conductors to final disposal. Average distance from demolition site to waste processing site for final disposal is assumed to be 100 km.

### **C3 : Waste Processing**

Wastes can be recycled directly or disposed of according to different scenarios. No process is needed.

### **C4 : Disposal**

Assumed that about 25 per cent of the panels is sent to the landfill for their final fate and this is modelled as such in the LCA.

### **D : Benefits and Loads**

Assumed that 5 per cent of the used aluminium is collected and to be delivered to the recycling processes and this is modelled as such in the LCA.

# More Information

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## **Allocations**

Water consumption, energy consumption and raw material transportation were weighted according to 2020 production figures.

In addition, hazardous and non-hazardous waste amounts were also allocated from the 2020 total waste generation.

## **Cut-Off Criteria**

1% cut-off applied. Data for elementary flows to and from the product system contributing to a minimum of 99% of the declared environmental impacts have been included.

## **REACH Regulation**

No substances included in the Candidate List of Substances of Very High Concern for authorization under the REACH regulations are present in this product either above the threshold for registration with the European Chemicals Agency or above 0.1% (wt/wt).

## **LCA Modelling, Calculation and Data Quality**

The results of the LCA with the indicators as per EPD requirement are given in the LCA result tables. All energy calculations were obtained using Cumulative Energy Demand (LHV) methodology, while fresh water use is calculated with selected inventory flows in SimaPro according to the PCR.

There are no co-product allocations within the LCA study underlying this EPD.

The SimaPro 9.1 LCA software and the Ecoinvent 3.6 LCA database were used to calculate the environmental impacts. The regional energy datasets were used for all energy calculations.

## **Geographical Scope**

The geographical scope of this EPD is global.



LCA Results

# Environmental Impacts

Impact Category	Unit	A1-A3	A4	C1	C2	C3	C4	D
GWP - Fossil	kg CO <sub>2</sub> eq	32.5	0.211	0.287	0.064	0	0.142	-12.1
GWP - Biogenic	kg CO <sub>2</sub> eq	0.093	71.9E-6	0.003	48.5E-6	0	0.551	-0.023
GWP - Luluc	kg CO <sub>2</sub> eq	0.449	96.4E-6	0.003	19.5E-6	0	34.4E-6	-248E-3
GWP - Total	kg CO <sub>2</sub> eq	33.1	0.211	0.293	0.064	0	0.693	-12.4
ODP	kg CFC-11 eq	2.60E-6	48.1E-9	8.11E-9	15.7E-9	0	6.64E-9	-950E-9
AP	mol H <sup>+</sup> eq	0.235	0.003	0.002	206E-6	0	311E-6	-0.097
EP - Freshwater	kg P eq	0.011	12.7E-6	303E-6	4.73E-6	0	1.81E-5	-0.004
*EP - Freshwater	kg PO <sub>4</sub> eq	0.033	38.9E-6	0.001	14.5E-6	0	55.3E-6	-0.013
EP - Marine	kg N eq	0.033	0.001	307E-6	46.0E-6	0	0.001	-0.012
EP - Terrestrial	mol N eq	0.351	0.008	0.003	0.001	0	0.001	-0.128
POCP	kg NMVOC	0.119	0.002	0.001	198E-6	0	405E-6	-0.043
ADPE	kg Sb eq	0.001	2.90E-6	692E-9	1.14E-6	0	317E-9	-55.9E-6
ADPF	MJ	447	3.14	3.16	1.04	0	0.672	-116
WDP	m <sup>3</sup> depriv.	15.2	0.008	0.134	0.003	0	0.017	-3.10
PM	disease inc.	2.66E-6	13.8E-9	8.06E-9	5.63E-9	0	4.36E-9	-1.18E-6
IR	kBq U-235 eq	3.27	0.015	0.004	0.005	0	0.004	-1.31
ETP - FW	CTUe	861	2.34	2.76	0.828	0	373	-357
HTTP - C	CTUh	70.3E-9	87.2E-12	50.8E-12	20.1E-12	0	43.5E-12	-35.4E-9
HTTP - NC	CTUh	1.08E-6	2.36E-9	2.43E-12	907E-12	0	161E-11	-514E-9
SQP	Pt	70.1	2.52	0.182	1.19	0	1.18	-20.7
Acronyms	GWP-total: Climate change, GWP-fossil: Climate change- fossil, GWP-biogenic: Climate change - biogenic, GWP-luluc: Climate change - land use and transformation, ODP: Ozone layer depletion, AP: Acidification terrestrial and freshwater, EP-freshwater: Eutrophication freshwater, EP-marine: Eutrophication marine, EP-terrestrial: Eutrophication terrestrial, POCP: Photochemical oxidation, ADPE: Abiotic depletion - elements, ADPF: Abiotic depletion - fossil resources, WDP: Water scarcity, PM: Respiratory inorganics - particulate matter, IR: Ionising radiation, ETP-FW: Ecotoxicity freshwater, HTP-c: Cancer human health effects, HTP-nc: Non-cancer human health effects, SQP: Land use related impacts, soil quality.							
Legend	A1: Raw Material Supply, A2: Transport, A3: Manufacturing, A1-A3: Sum of A1, A2, and A3, A4: Transport to Site, C1: De-Construction, C2: Waste Transport, C3: Waste Processing, C4: Disposal, D: Benefits and Loads Beyond the System Boundary.							
Disclaimer 1	This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.							
Disclaimer 2	The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator.							
*Disclaimer 3	EP-freshwater: This indicator has been calculated as "kg P eq" as required in the characterization model. (EUTREND model, Struijs et al, 2009b, as implemented in ReCiPe; <a href="http://eplca.jrc.ec.europa.eu/LCDN/developerEF.xhtml">http://eplca.jrc.ec.europa.eu/LCDN/developerEF.xhtml</a> )							

## Resource Use

Impact Category	Unit	A1-A3	A4	C1	C2	C3	C4	D
PERE	MJ	164	0.033	0.755	0.013	0	0.034	-87.3
PERM	MJ	0	0	0	0	0	0	0
PERT	MJ	164	0.033	0.755	0.013	0	0.034	-87.3
PENRE	MJ	447	3.14	3.16	1.04	0	0.672	-116
PENRM	MJ	0	0	0	0	0	0	0
PENRT	MJ	447	3.14	3.16	1.04	0	0.672	-116
SM	kg	0	0	0	0	0	0	0
RSF	MJ	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0
FW	m <sup>3</sup>	0.180	0.001	0.001	216E-6	0	0.001	-0.067
Acronyms	PERE: Use of renewable primary energy excluding resources used as raw materials, PERM: Use of renewable primary energy resources used as raw materials, PERT: Total use of renewable primary energy, PENRE: Use of non-renewable primary energy excluding 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, SM: Secondary material, RSF: Renewable secondary fuels, NRSF: Non-renewable secondary fuels, FW: Net use of fresh water.							
Legend	A1: Raw Material Supply, A2: Transport, A3: Manufacturing, A1-A3: Sum of A1, A2, and A3, A4: Transport to Site, C1: De-Construction, C2: Waste Transport, C3: Waste Processing, C4: Disposal, D: Benefits and Loads Beyond the System Boundary.							

## Output Flows

Impact Category	Unit	A1-A3	A4	C1	C2	C3	C4	D
HWD	kg	0.092	0	0	0	0	0	0
NHWD	kg	0.432	0	0	0	0	0	0
RWD	kg	0	0	0	0	0	0	0
CRU	kg	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	0	0
MER	kg	0	0	0	0	0	0	0
EE (Electrical)	MJ	0	0	0	0	0	0	0
EE (Thermal)	MJ	0	0	0	0	0	0	0
Acronyms	HWD: Hazardous waste disposed, NHWD: Non-hazardous waste disposed, RWD: Radioactive waste disposed, CRU: Components for reuse, MFR: Material for recycling, MER: Materials for energy recovery, EE (Electrical): Exported energy electrical, EE (Thermal): Exported energy, Thermal.							
Legend	A1: Raw Material Supply, A2: Transport, A3: Manufacturing, A1-A3: Sum of A1, A2, and A3, A4: Transport to Site, C1: De-Construction, C2: Waste Transport, C3: Waste Processing, C4: Disposal, D: Benefits and Loads Beyond the System Boundary.							

# References

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/GPI/ General Programme Instructions of the International EPD® System. Version 4.0.

/EN ISO 9001/ Quality Management Systems - Requirements

/EN ISO 14001/ Environmental Management Systems - Requirements

/EN ISO 50001/ Energy Management Systems - Requirements

/ISO 14020:2000/ Environmental Labels and Declarations — General principles

/EN 15804:2012+A2:2019/ Sustainability of construction works - Environmental Product Declarations — Core rules for the product category of construction products

/ISO 14025/ DIN EN ISO 14025:2009-11: Environmental labels and declarations - Type III environmental declarations — Principles and procedures

/ISO 14040/44/ DIN EN ISO 14040:2006-10, Environmental management - Life cycle assessment - Principles and framework (ISO14040:2006) and Requirements and guidelines (ISO 14044:2006)

/PCR for Construction Products and CPC 54 Construction Services/ Prepared by IVL Swedish Environmental Research Institute, Swedish Environmental Protection Agency, SP Trä, Swedish Wood Preservation Institute, Swedisol, SCDA, Svenskt Limträ AB, SSAB, The International EPD System, 2019:14 Version 1.11 DATE 2019-12-20

/The International EPD® System/ The International EPD® System is a programme for type III environmental declarations, maintaining a system to verify and register EPD®s as well as keeping a library of EPD®s and PCRs in accordance with ISO 14025. [www.environdec.com](http://www.environdec.com)

/Ecoinvent / Ecoinvent Centre, [www.ecoinvent.org](http://www.ecoinvent.org)

/SimaPro/ SimaPro LCA Software, Pré Consultants, the Netherlands, [www.pre-sustainability.com](http://www.pre-sustainability.com)


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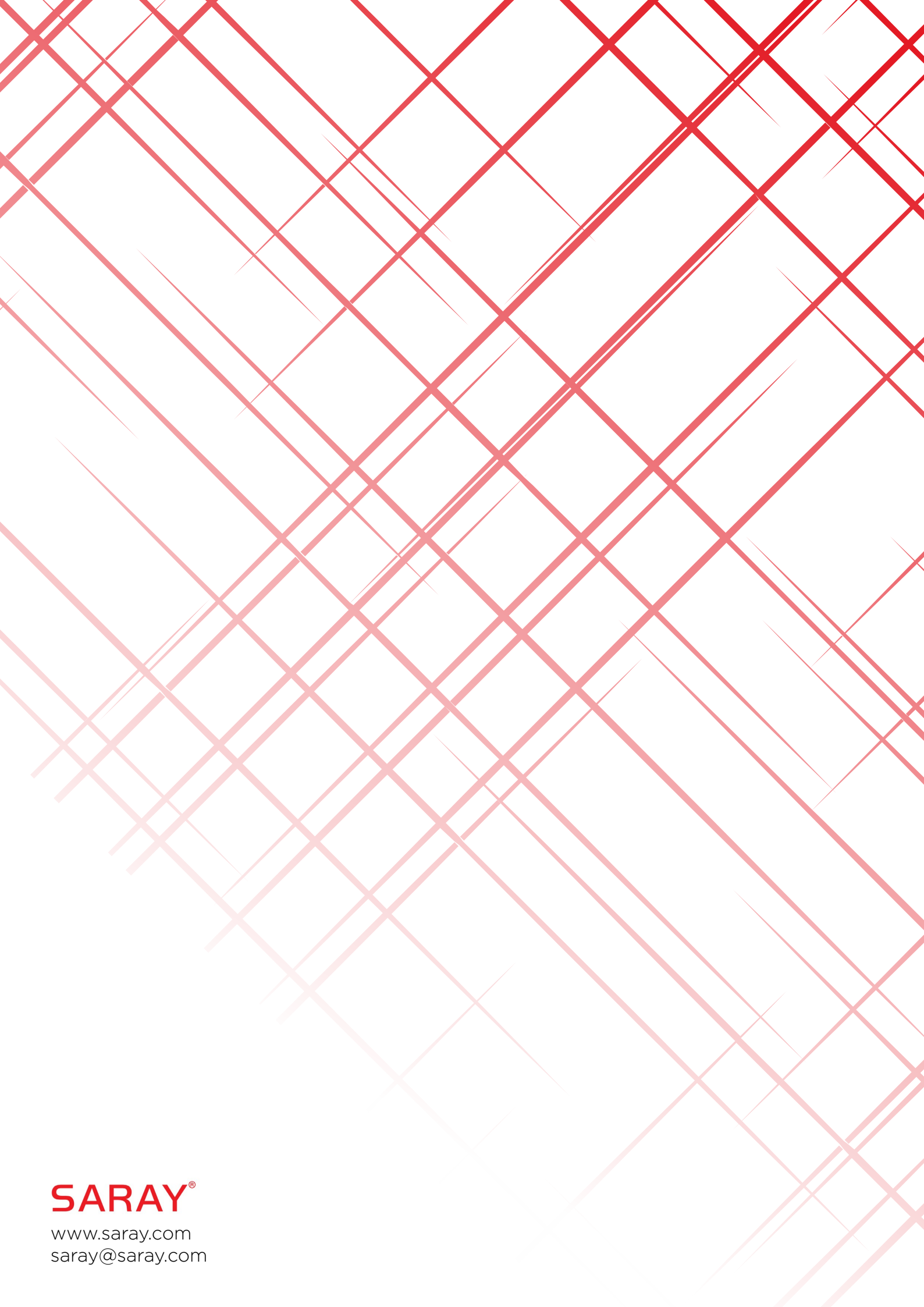


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