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The Norwegian EPD Foundation

## ENVIRONMENTAL PRODUCT DECLARATION

in accordance with ISO 14025, ISO 21930 and EN 15804

Owner of the declaration:	Oy Forcit Ab
Program operator:	The Norwegian EPD Foundation
Publisher:	The Norwegian EPD Foundation
Declaration number:	NEPD-2251-1032-EN
Registration number:	NEPD-2251-1032-EN
ECO Platform reference number:	-
Issue date:	16.06.2020
Valid to:	16.06.2025

### Forprime 25 / Pentex 25 FF

Oy Forcit Ab

[www.epd-norge.no](http://www.epd-norge.no)



## General information

**Product:**

Forprime 25 / Pentex 25 FF

**Program operator:**

The Norwegian EPD Foundation  
P.O. Box 5250 Majorstuen, N-0303 Oslo Norway  
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**Declaration number:**

NEPD-2251-1032-EN

**ECO Platform reference number:**

-

**This declaration is based on Product Category Rules:**

CEN Standard EN 15804 serves as core PCR  
NPCR 024:2016 version 1.0 Explosives and Initiation  
Systems

**Statement of liability:**

The owner of the declaration shall be liable for the underlying information and evidence. EPD Norway shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

**Declared unit:**

1 kg of manufactured, installed and used (detonated)

**Declared unit with option:**

A1-3, A4 and A5

**Functional unit:**

Declared unit is applied instead on functional unit.

**Verification:**

The CEN Norm EN 15804 serves as the core PCR.  
Independent verification of the declaration and data,  
according to ISO14025:2010

internal  external

Third party verifier:

*Alexander Borg*

Alexander Borg, Asplan Viak AS

(Independent verifier approved by EPD Norway)

**Owner of the declaration:**

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**Manufacturer:**

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**Place of production:**

Hanko, Finland

**Management system:**

ISO 9001, ISO 14001

**Organisation no:**

0103189-6

**Issue date:**

16.06.2020

**Valid to:**

16.06.2025

**Year of study:**

LCA was conducted between May 2019 and February 2020. Production data represents year 2018 and 2019 for energy usage.

**Comparability:**

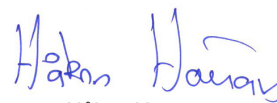
EPDs of construction products may not be comparable if they do not comply with EN 15804 and are not seen in a building context. A comparison of explosives, detonators and initiation systems must be based on scenarios with comparable technical specifications.

**The EPD has been worked out by:**

Emma Salminen  
LCA Consulting Oy




Approved



Håkon Hauan  
Managing Director of EPD-Norway

## Product

### Product description:

Forprime 25 / Pentex 25FF (henceforth referred as Forprime 25) is a primary charge typically used in underground charging to ignite bulk emulsion and ANFO type of explosives with charging units.

Forprime 25 is produced and packed at Hanko production plant in Finland. One Forprime 25 weighs 0,025 kg. Finished explosives are transported by truck to Forcit's warehouses and further to the final user sites.

### Product specification:

Energy content of Forprime 25: 4.0 MJ/kg

Materials	%
Pentaerythritol tetranitrate (PETN)	50-60
Distillates (petroleum), hydrotreated heavy naphthenic	20-30
RDX (Hexogen)	5-10
Nitrocellulose	<2
Ethylene dinitrate	0.2

### Technical data:

1 kg of packed explosive.

EC-type examination certificates:

CE0589 (BAM, Germany), 0589.EXP.0495/18

### Market:

Nordic Countries (Finland, Sweden, Norway)

### Reference service life, product:

Reference service life is not relevant to Explosives.

Explosives are used only once.

Package (mass 0,16 kg/kg of Forprime 25)	%
Plastic pipe	93
Plastic bag	<1
Cardboard box	7

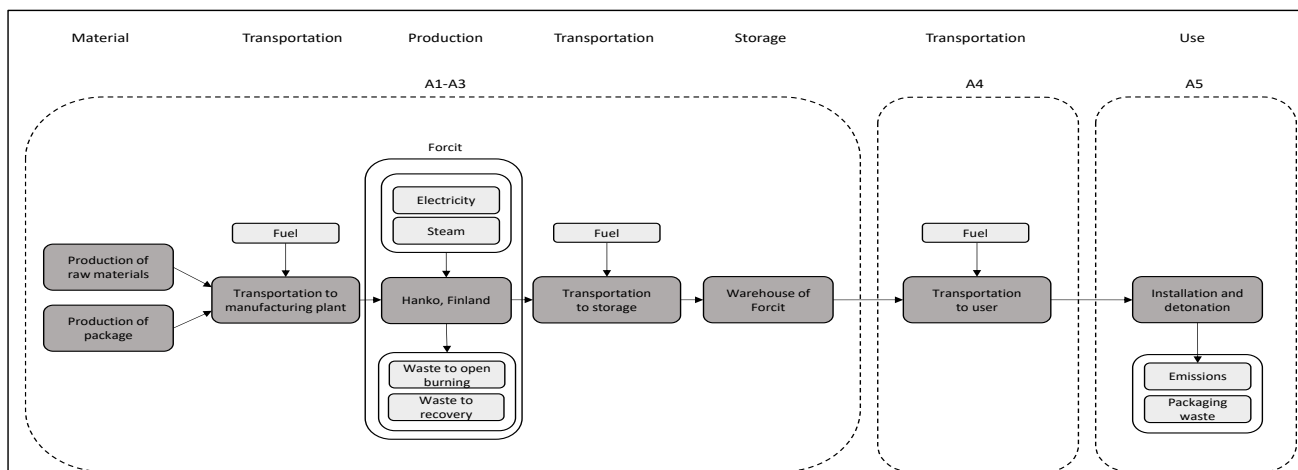
## LCA: Calculation rules

### Declared unit:

1 kg of manufactured, installed and used (detonated) product.

### System boundary:

Flow chart is presented below. The main unit processes of each life cycle stage are presented in the dark grey boxes. The main background processes and detonation emissions are presented in the light grey boxes.



### Data quality:

Specific data is used to model A4 transportation, detonation stage and production operations at Hanko plant. Specific data represent years 2018 and 2019. Locations of raw material suppliers and A2 transportation of raw materials are partly modelled based on specific data.

Generic data is used to model the production of raw materials, energy etc. (background processes). Generic data is mainly from Gabi Professional database. Ecoinvent database and literature sources are also used to fill data gaps. Characterization factors are based on EN 15804:2012. Ozone depletion potential result is deemed the most uncertain of the assessed environmental impact results due to the usage of secondary data that includes CFCs.

Data used is not older than 10 years.

### Cut-off criteria:

All major raw material and energy inputs are included. Production processes of specific raw materials and energy flows that are used in minor quantities (<1% of total mass input or energy use of a unit process) are not included in the assessment. This cut-off rule does not apply for hazardous materials and substances.

### Allocation:

Allocation is conducted in accordance with the provisions of EN 15804. Energy and water inputs, and municipal waste generated are allocated equally among all products manufactured at the Hanko plant through mass allocation. Influence of primary production of a recycled material is allocated to the main product for which the material was used. The recycling process and transportation of the material is allocated to this analysis.

## LCA: Scenarios and additional technical information

The following information describes the scenarios in the different modules of the EPD.

Forprime 25 is produced at Hanko production plant in Finland where the product components are mixed and the final products are packed in plastic pipes. The finished product cartridges are transported to customers in cardboard boxes via Forcitr's warehouses. In calculation it is assumed that both the storage and final users of the product are located in Finland.

No auxiliary materials or substances are used in the installation (A5-1) stage. The detonation emissions are calculated based on balanced chemical reaction at final stage and in 1 bar.

The key calculating values related to A4, A5-1 and A5-2 stages are presented in tables below.

### Transportation from production plant to storage (A2 internal transportation)

Type	Capacity utilization (incl. return)	Type of vehicle	Distance* km	Fuel consumption	Value
Truck	100	EURO 5 truck	821	l/tkm	0,02

\*One-way distance is applied since other cargo are transported.

### Transport from storage to user (A4)

Type	Capacity utilization (incl. return) %	Type of vehicle	Distance** km	Fuel consumption	Value
Delivery van	50	Delivery van	20	l/tkm	0,13

\*\* Transportation distance is from storage to user, including return trip.

### Installation stage of explosive (A5-1)

	Unit	Value
Product	kg	1

No auxiliary materials or substances are needed on installation stage. Forprime 25 is a ready-to-use product when entering the user site.

### Detonation stage of explosive (A5-2)

Emission to air	Unit	Value
Carbon	kg	0,26
Methane	kg	0,03
Carbon dioxide	kg	0,05
Water	kg	0,33
Nitrogen	kg	0,11
Sodium carbonate	kg	0
Carbon monoxide*	kg	0,04

\* Formed in secondary reactions.

One Forprime 25 weighs 0,025 kg. The ratio for using Forprime 25 in e.g. facecharging is one Forprime 25 for approximately 6 kg other explosives. For production charging the ratio is one Forprime 25 for approximately 40 kg of other explosives.

## LCA: Results

Life cycle stages A1-A5 are included. The environmental impact results and LCI results related to inputs and output are presented per declared unit (1 kg of manufactured, installed and detonated product). Results are calculated according to the EN 15804:2012 requirements.

System boundaries (X=included, MND= module not declared, MNR=module not relevant)

Product stage			Assembly stage		Use stage							End of life stage				Beyond the system boundaries
Raw materials	Transport	Manufacturing	Transport	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	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	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND

### Environmental impact

Parameter	Unit	A1-3	A4	A5-1	A5-2
GWP	kg CO <sub>2</sub> -eq.	3,12E+00	7,78E-03	1,57E-02	8,00E-01
ODP	kg CFC11-eq.	6,17E-10	2,17E-18	3,78E-18	0,00E+00
POCP	kg C <sub>2</sub> H <sub>4</sub> -eq.	1,45E-03	1,37E-06	1,06E-07	1,26E-03
AP	kg SO <sub>2</sub> -eq.	5,82E-03	1,58E-05	3,46E-06	0,00E+00
EP	kg PO <sub>4</sub> <sup>3-</sup> -eq.	8,57E-04	3,68E-06	6,86E-07	4,62E-02
ADPM	kg Sb-eq.	1,35E-06	7,09E-10	5,49E-11	0,00E+00
ADPE	MJ	9,99E+01	1,18E-01	5,90E-03	0,00E+00

GWP Global warming potential; ODP Depletion potential of the stratospheric ozone layer; POCP Formation potential of tropospheric photochemical oxidants; AP Acidification potential of land and water; EP Eutrophication potential; ADPM Abiotic depletion potential for non fossil resources; ADPE Abiotic depletion potential for fossil resources

### Resource use

Parameter	Unit	A1-3	A4	A5-1	A5-2
RPEE	MJ	7,41E+00	7,05E-03	9,59E-04	0,00E+00
RPEM	MJ	1,60E-01	0,00E+00	0,00E+00	0,00E+00
TPE	MJ	7,57E+00	7,05E-03	9,59E-04	0,00E+00
NRPE	MJ	9,10E+01	1,19E-01	6,64E-03	0,00E+00
NRPM	MJ	1,35E+01	0,00E+00	0,00E+00	0,00E+00
TRPE	MJ	1,04E+02	1,19E-01	6,64E-03	0,00E+00
SM	kg	9,80E-04	0,00E+00	0,00E+00	0,00E+00
RSF	MJ	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
W	m <sup>3</sup>	2,66E-02	1,19E-05	4,57E-05	0,00E+00

RPEE Renewable primary energy resources used as energy carrier; RPEM Renewable primary energy resources used as raw materials; TPE Total use of renewable primary energy resources; NRPE Non renewable primary energy resources used as energy carrier; NRPM Non renewable primary energy resources used as materials; TRPE Total use of non renewable primary energy resources; SM Use of secondary materials; RSF Use of renewable secondary fuels; NRSF Use of non renewable secondary fuels; W Use of net fresh water

### End of life - Waste

Parameter	Unit	A1-3	A4	A5-1	A5-2
HW	kg	9,96E-08	6,59E-09	9,77E-11	0,00E+00
NHW	kg	1,87E-02	1,00E-05	4,89E-04	0,00E+00
RW	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00

HW Hazardous waste disposed; NHW Non hazardous waste disposed; RW Radioactive waste disposed

### End of life - Output flow

Parameter	Unit	A1-3	A4	A5-1	A5-2
CR	kg	8,45E-03	0,00E+00	0,00E+00	0,00E+00
MR	kg	1,74E-02	0,00E+00	0,00E+00	0,00E+00
MER	kg	4,62E-03	0,00E+00	1,21E-02	0,00E+00
EEE	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00
ETE	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00

CR Components for reuse; MR Materials for recycling; MER Materials for energy recovery; EEE Exported electric energy; ETE Exported thermal energy

Reading example:  $9,0 \text{ E-03} = 9,0 \cdot 10^{-3} = 0,009$

## Additional Norwegian requirements

### Greenhouse gas emissions from electricity use in the manufacturing phase

Electricity used at Hanko production plant is modelled with basic grid mix electricity dataset. Average electricity grid mix of Finland is modelled with Gabi Professional database. All the necessary background data is included. Country specific individual characteristics are considered. Data represents year 2016.

Data source	Amount	Unit
Gabi Professional database. Electricity grid mix of Finland.	0,174	kg CO <sub>2</sub> -eq./kWh

### Dangerous substances

- The product contains no substances given by the REACH Candidate list or the Norwegian priority list
- The product contains substances given by the REACH Candidate list or the Norwegian priority list that are less than 0,1 % by weight.
- The product contains dangerous substances, more then 0,1% by weight, given by the REACH Candidate List or the Norwegian Priority list, see table.
- The product contains no substances given by the REACH Candidate list or the Norwegian priority list. The product is classified as hazardous waste (Avfallsforskiten, Annex III), see table.

Name	CAS no.	Amount
Pentaerythritol tetranitrate (PETN)	78-11-5	50-60%
Distillates (petroleum), hydrotreated heavy naphtenic	64742-52-5	20-30%
RDX (Hexogen)	121-82-4	5-10%
Nitrocellulose	603-037-00-6	<2%
Ethylene dinitrate	628-96-6	0,20 %

### Indoor environment





No tests have been carried out on the product concerning indoor climate. Not relevant.

### Carbon footprint

Carbon footprint has not been worked out for the product.

## Bibliography

ISO 14025:2010	<i>Environmental labels and declarations - Type III environmental declarations - Principles and procedures</i>
ISO 14044:2006	<i>Environmental management - Life cycle assessment - Requirements and guidelines</i>
EN 15804:2012+A1:2013	<i>Sustainability of construction works - Environmental product declaration - Core rules for the product category of construction products</i>
ISO 21930:2007	<i>Sustainability in building construction - Environmental declaration of building products</i>
The Norwegian EPD Foundation. 2016.	<i>Product-category rules, NPCR 024 version 1.0, Explosives and Initiation Systems.</i>
LCA Consulting Oy. 2020.	<i>LCA Study Report. Oy Forcit Ab products. Forprime 25, Fordyn, Offshore Kemiitti, Kemiitti 810, Kemiitti 510, Kemiitti 610, Kemix A. Report version 1.1.</i>
thinkstep. 2016.	<i>Gabi Professional database.</i>
ISO 14001:2015	<i>Environmental management systems — Requirements with guidance for use.</i>
ISO 9001:2015	<i>Quality management systems — Requirements.</i>

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