



BILLERUDKORSNÄS

Pure Decor™

Environmental Product Declaration



www.billerudkorsnas.com



THE INTERNATIONAL EPD® SYSTEM

BillerudKorsnäs

BillerudKorsnäs focuses on offering the packaging market sustainable materials (world-leading paper and board material) and new solutions that increase customers' profitability while at the same time reducing the overall environmental impact.

BillerudKorsnäs is driven by sustainability as a natural and integral part of the whole business and value chain. The raw material comes from responsibly managed forests and manufacturing takes place in resource-efficient production units that are constantly improved to minimize their environmental impact. BillerudKorsnäs has 8 production sites in Sweden, Finland and the UK. Production capacity is close to 3,000 ktonnes, with integrated pulp production. The range of products includes liquid packaging board, cartonboard, liners, fluting, sack- and kraft paper, speciality paper and pulp.

Through our products and solutions, we aim to be part of the response to the world's current major challenges.





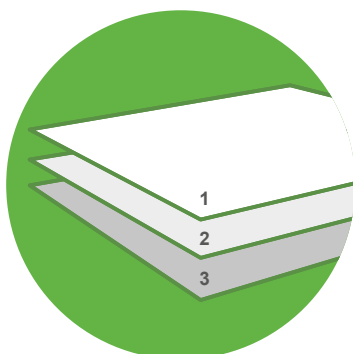
BillerudKorsnäs' operations for production in Sweden, Finland and the UK are fully certified in accordance with

- ISO 9001:2008 Quality Management System
- ISO 14001:2004 Environmental Management System
- PEFC™ Chain of Custody, license code PEFC/05-33-114
- FSC® Chain of Custody, license code FSC-C004906

In addition, certifications for food safety management systems, in accordance with ISO 22000/FSSC 22000, are in place where products are aimed for food contact.

This is an Environmental Product Declaration for Pure Decor™, registered in the International EPD System (www.environdec.com). The declaration has been developed based on the results of a Life Cycle Assessment (LCA) and the Product Category Rules for Processed paper and paperboard (PCR 3214). Information and data given in this EPD can be used as upstream data by a customer who will perform a new EPD within the system boundaries given in a related PCR.

GÄVLE MILL – THE PRODUCTION SITE FOR PURE DECOR



DECLARATION OF CONTENTS

1. Clay coated top side
2. Bleached chemical pulp
3. Unbleached chemical pulp

Pure Decor	Distribution
Bleached chemical pulp	56%
Unbleached chemical pulp	29%
Coating/fillers	15%

PURE DECOR

Pure Decor (formerly BillerudKorsnäs Decor) is a light coated, 100% primary fibre-based white top kraftliner. Pure Decor has high strength and overall thickness combined with a smooth printing surface resulting in high quality print with excellent reproduction of colour images, and minimization of wash-boarding. This product is well established as a liner for high quality post-print, as well as being extensively used for pre-print. Pure Decor is used for products that need strong and stable corrugated packaging with a good printing surface and high visual impact. With 100% primary fibre content, Pure Decor offers high resistance to moisture and suitability for direct food contact. Pure Decor is available in grammages from 120 to 160 gsm (25–33 lb/MSF).*

* Within the paper industry lb/MSF stands for pounds per 1,000 square feet, while gsm is an acronym for grams per square metre.



SYSTEM BOUNDARIES

The international EPD system is a hierarchic approach based on the international standards:

- ISO 9001, Quality management system
- ISO 14001, Environmental management system
- ISO 14025, Type III environmental declarations
- ISO 14044, LCA – Requirements and guidelines

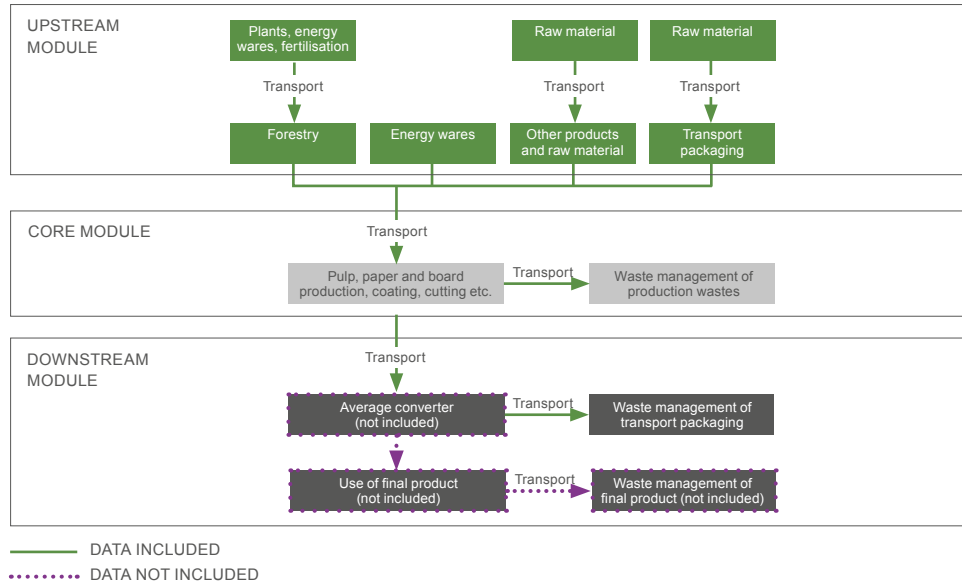
The systems are divided into three life cycle phases:

UPSTREAM: Forestry, production of fertilisers, energy wares and chemicals, auxiliary products and other raw materials, transport packaging.

CORE: Transportation of all materials (including wood) to the core processes,

production of internal and external pulp, production of paper and paperboard, cutting and packing of the products and treatment of waste generated from the production processes.

DOWNSTREAM: Distribution of the product to the customer and waste management of transport packaging.



ENVIRONMENTAL PERFORMANCE

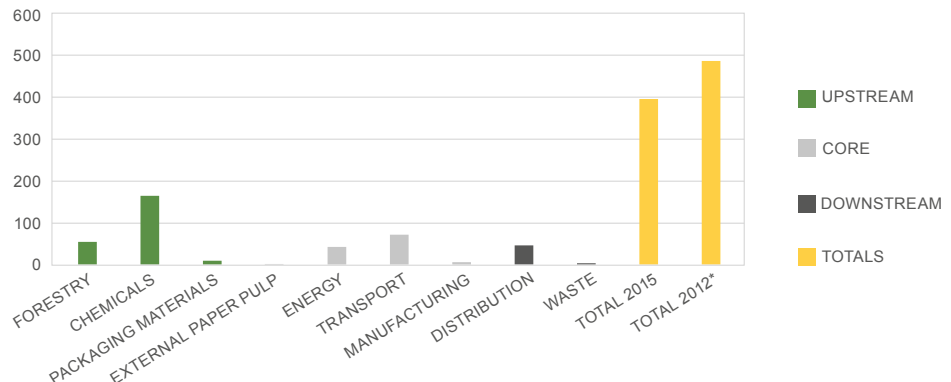
The environmental impact of three selected grammages representing a low, medium and high grammage within the product range are presented in the table below.

The declared unit is one tonne (1,000 kg) of the product delivered at the gate of an average converter/customer in Europe. As additional result, the environmental impact is presented also per 1,000 m².

The carbon footprint (greenhouse gas emissions over the life cycle) is presented as an average for the three grammages covered in the following diagram as global warming potential 100 years (GWP100) in kg CO₂ equivalents per tonne product. The 18.7% reduction compared to previous EPD is mainly a result of less use of fossil energy in the production plant.

AVERAGE GREENHOUSE GAS EMISSIONS PURE DECOR 2015

kg CO₂eq/TONNE



*THE PREVIOUS EPD PUBLISHED 2013-12-19

These previous results are recalculated according to the new methodology and characterization factors stated by product category rules of today.



POTENTIAL ENVIRONMENTAL IMPACT PURE DECOR

The table presents the potential environmental impact per declared unit as defined by the product category rules for processed paper and paper-board (CPC 3214). Data for the calculation is taken from the actual production of the product during 2015, without any corrections for production irregularities between grammages.

	UPSTREAM kg/tonne	CORE kg/tonne	DOWNSTREAM kg/tonne	TOTAL kg/tonne	TOTAL kg/1,000 m ²
PURE DECOR 120 GSM (25 lb/MSF)					
Global warming potential excl biogenic carbon (CO ₂ eq.)	244.8	126.2	48.2	419.1	50.3
Global warming potential incl biogenic carbon (CO ₂ eq.)	-963.2	1,517.6	51.5	606.0	72.7
Acidification potential (SO ₂ eq.)	2.24	2.25	0.12	4.62	0.55
Eutrophication potential (PO ₄ ³⁻ eq.)	0.49	1.06	0.13	1.68	0.20
Photochemical oxidant formation potential (C ₂ H ₄ eq.)	0.19	0.34	-0.01	0.52	0.06
PURE DECOR 145 GSM (30 lb/MSF)					
Global warming potential excl biogenic carbon (CO ₂ eq.)	191.0	117.2	48.2	356.4	51.7
Global warming potential incl biogenic carbon (CO ₂ eq.)	-1,123.0	1,545.2	51.5	473.8	68.7
Acidification potential (SO ₂ eq.)	1.11	2.11	0.12	3.34	0.48
Eutrophication potential (PO ₄ ³⁻ eq.)	0.36	0.98	0.13	1.48	0.21
Photochemical oxidant formation potential (C ₂ H ₄ eq.)	0.13	0.34	-0.01	0.46	0.07
PURE DECOR 160 GSM (33 lb/MSF)					
Global warming potential excl biogenic carbon (CO ₂ eq.)	240.2	113.5	48.2	401.9	64.3
Global warming potential incl biogenic carbon (CO ₂ eq.)	-1,108.7	1,558.3	51.5	501.1	80.2
Acidification potential (SO ₂ eq.)	2.24	1.99	0.12	4.36	0.70
Eutrophication potential (PO ₄ ³⁻ eq.)	0.51	0.97	0.13	1.61	0.26
Photochemical oxidant formation potential (C ₂ H ₄ eq.)	0.18	0.33	-0.01	0.51	0.08

USE OF RESOURCES

The following table presents the total resources used in the upstream, core and downstream phases for three selected grammages representing a low, medium and high grammage within the product range. Data for the calculation is taken from the actual production of the product during 2015, without any corrections for production irregularities between grammages.

	UPSTREAM	CORE	DOWNSTREAM	TOTAL	UNIT
PURE DECOR 120 GSM (25 lb/MSF)					
Material resources, renewable					
Biomass	618			618	kg/tonne
Other	166.8	2.0	10.5	179.3	kg/tonne
Material resources, non-renewable					
Calcite	19.4	0.57	0.43	20.4	kg/tonne
Gravel	54.9	15.1	1.4	71.4	kg/tonne
Inert rock	45.7	0.37	0.072	46.2	kg/tonne
Limestone (calcium carbonate)	114.8	0.45	0.010	115.3	kg/tonne
Sodium chloride (rock salt)	32.6	0.34	0.012	32.9	kg/tonne
Other	22.3	8.9	0.22	31.4	kg/tonne
Energy resources, renewable					
Energy from biomass	378.9	15,056.8	36.5	15,472.2	MJ/tonne
Energy from hydropower	214.3	1,413.9	50.7	1,678.9	MJ/tonne
Other	103.7	2.6	21.9	128.2	MJ/tonne
Energy resources, non-renewable					
Crude oil (resource)	42.8	33.7	7.1	83.6	kg/tonne
Hard coal (resource)	21.1	1.4	3.5	26.0	kg/tonne
Natural gas (resource)	29.2	1.7	1.3	32.2	kg/tonne
Uranium (resource)	1.9	0.1	0.3	2.3	g/tonne
Other	16.7	0.7	9.5	26.9	kg/tonne
Secondary resources					
Electricity use at manufacturing		663.0		663.0	kWh/tonne
Water use					
Total water use	26.2	113.0	0.2	139.3	m ³ /tonne
Water use at manufacturing		92.4		92.4	m ³ /tonne



PURE DECOR 145 GSM (30 lb/MSF)	UPSTREAM	CORE	DOWNSTREAM	TOTAL	UNIT
Material resources, renewable					
Biomass	669			669	kg/tonne
Other	141.2	2.0	10.5	153.7	kg/tonne
Material resources, non-renewable					
Calcite	4.7	0.53	0.43	5.6	kg/tonne
Gravel	45.8	14.8	1.4	62.1	kg/tonne
Inert rock	40.8	0.37	0.072	41.2	kg/tonne
Limestone (calcium carbonate)	88.8	0.45	0.010	89.3	kg/tonne
Sodium chloride (rock salt)	30.6	0.29	0.012	30.9	kg/tonne
Other	12.6	8.8	0.22	21.6	kg/tonne
Energy resources, renewable					
Energy from biomass	342.8	15,452.5	36.5	15,831.8	MJ/tonne
Energy from hydropower	182.8	1,411.7	50.7	1,645.1	MJ/tonne
Other	94.5	2.6	21.9	118.9	MJ/tonne
Energy resources, non-renewable					
Crude oil (resource)	36.6	30.7	7.1	74.4	kg/tonne
Hard coal (resource)	14.1	1.3	3.5	18.9	kg/tonne
Natural gas (resource)	22.6	1.6	1.3	25.5	kg/tonne
Uranium (resource)	1.6	0.1	0.3	2.0	g/tonne
Other	12.2	0.6	9.5	22.3	kg/tonne
Secondary resources					
Electricity use at manufacturing		662.0		662.0	kWh/tonne
Water use					
Total water use	19.3	111.7	0.2	131.2	m ³ /tonne
Water use at manufacturing		91.2		91.2	m ³ /tonne
PURE DECOR 160 GSM (33 lb/MSF)					
Material resources, renewable					
Biomass	689			689	kg/tonne
Other	145.8	2.0	10.5	158.3	kg/tonne
Material resources, non-renewable					
Calcite	20.7	0.52	0.43	21.7	kg/tonne
Gravel	59.5	14.9	1.4	75.8	kg/tonne
Inert rock	41.4	0.37	0.072	41.9	kg/tonne
Limestone (calcium carbonate)	79.5	0.46	0.010	79.9	kg/tonne
Sodium chloride (rock salt)	32.6	0.28	0.012	32.9	kg/tonne
Other	23.1	8.8	0.22	32.2	kg/tonne
Energy resources, renewable					
Energy from biomass	401.4	15,632.8	36.5	16,070.7	MJ/tonne
Energy from hydropower	203.8	1,420.0	50.7	1,674.5	MJ/tonne
Other	100.0	2.6	21.9	124.5	MJ/tonne
Energy resources, non-renewable					
Crude oil (resource)	40.0	29.5	7.1	76.6	kg/tonne
Hard coal (resource)	21.2	1.3	3.5	25.9	kg/tonne
Natural gas (resource)	24.0	1.6	1.3	26.8	kg/tonne
Uranium (resource)	1.7	0.1	0.3	2.1	g/tonne
Other	16.2	0.6	9.5	26.3	kg/tonne
Secondary resources					
Electricity use at manufacturing		666.0		666.0	kWh/tonne
Water use					
Total water use	18.6	112.7	0.2	131.5	m ³ /tonne
Water use at manufacturing		92.1		92.1	m ³ /tonne
WASTE					
		PURE DECOR 120 GSM (25 lb/MSF)	PURE DECOR 145 GSM (30 lb/MSF)	PURE DECOR 160 GSM (33 lb/MSF)	UNIT
Hazardous waste		0.09	0.09	0.09	kg/tonne
Other waste		272	218	190	kg/tonne



ADDITIONAL ENVIRONMENTAL INFORMATION: POTENTIAL ENVIRONMENTAL GAIN

Waste minimisation

All products produced at the Gävle mill are based on primary fibres with high strength properties enabling reduction of packaging weight.

Recyclability and recovery

Pure Decor is recoverable through material recycling and energy recovery in accordance with the material requirements in EN 13430:2004 and EN 13431:2004.

Waste handling

All board and paper products produced by BillerudKorsnäs meet the targets specified in the EU's waste management hierarchy within the EU Waste Framework Directive 2008/98/EC as well as the essential requirements of the EU Packaging Waste Directive 94/62/EC.

Biodegradability

BillerudKorsnäs products are based on pulp consisting of cellulose, hemicellulose and some lignin which will be degraded by micro-organisms in nature. The decomposition time required depends on several factors such as temperature, humidity, microbiological activity, and pH. For a product to be classified as

biodegradable, at least 90% shall be biodegraded under aerobic conditions, according to the standard EN 13432:2000. As this varies between products and grammages, more information is provided by BillerudKorsnäs upon request.

Uptake of carbon dioxide in growing forests

Carbon stocks are increasing in Swedish forest ecosystems, mainly in the living biomass, due to the fact that the forest growth rate is higher than the harvest rate. The high growth rate is a result of silvicultural legislation and sustainable forest management practices. The long-term forest management is to a large extent driven by the demand for round wood from the forest industry. According to the Swedish Environmental Protection Agency, an amount corresponding to more than 80% of all greenhouse gas emissions in Sweden 2015 was captured by the net forest growth. Future scenarios for harvest rates in Sweden over the next 20 years conclude that the harvest rate will remain significantly lower than the growth rate.

BILLERUDKORSNÄS' ENVIRONMENT TARGET AREAS

BillerudKorsnäs is actively pursuing improvement to minimize the environmental impact from all parts of the operations. It is BillerudKorsnäs' vision to entirely phase out fossil fuels from the production. To this end, the company replaces fossil fuels with bioenergy and continually invests in process optimization to decrease the use of resources and increase energy efficiency. BillerudKorsnäs' climate related targets were in late 2017 submitted for approval by the Science Based Targets initiative. The approval scientifically ensures that the company contributes to the global work to minimize greenhouse gas emissions and to combat global warming. Updated information is found on BillerudKorsnäs' website.

Fossil-free production in Sweden

- The proportion of biofuels used in the manufacturing processes shall be further increased, from 97.6% as in 2015, in order to get fossil fuels entirely phased out at all Swedish production sites.

Fossil-free transportation within Sweden

- The fuels used for BillerudKorsnäs' domestic truck transportation of wood and finished goods shall be fossil free.

Increased energy efficiency

- The amount of energy used in production shall be lowered. The energy efficiency is measured as the energy use per tonne of product produced.



DEFINITIONS

Acidification

Decrease of the pH value in terrestrial and water systems.

CTMP and BCTMP

CTMP is a kind of unbleached pulp, according to the production process a chemi-thermomechanical pulp. BCTMP is the same type but bleached.

Eutrophication

Eutrophication is the disturbance of the nutritional balance in the soil and waters due to an added amount of nutrition. In aquatic systems, this leads to increased production of biomass, which may lead to oxygen deficiency and fewer living organisms.

Global warming potential

Global warming is caused by increases in the atmospheric concentration of carbon dioxide (CO₂) and other greenhouse gases, such as methane and nitrous oxide, that absorb and reflect heat. The global warming potential (GWP) is declared as CO₂ equivalents. The amount of biogenic carbon (CO₂eq.) presented is captured from the atmosphere by forest growth during the upstream phase and stored in the specific product as carbon until it is released again during later phases. Carbon is still stored in the product when it reaches the customer.

Hazardous waste

Wastes such as chemical waste, used oil, soot and radioactive waste from the production of nuclear power are classified as hazardous.

Photochemical oxidant formation

Hydrocarbons and volatile organic carbons (VOCs) contribute to ground level ozone formation, which has toxic effects on humans and vegetation.

PCR

Product Category Rules specify Environmental Product Declaration requirements for a specified sector or product category.
See www.environdec.com

Uptake of carbon dioxide in growing forests

In photosynthesis, carbon dioxide from the atmosphere is removed and stored in the growing biomass. In Sweden, the forest growth rate is higher than the harvest rate, in forest land leading to a net removal of CO₂ from the atmosphere.

Water use

Water use at manufacturing is the total amount of water used for cooling and the production process at the board and paper mill. Water use in upstream, core, and downstream phases is the total amount of water used for all processes related to the product.

REFERENCES

Swedish Environmental Protection Agency
National Inventory Report Sweden 2017,
Greenhouse Gas Emission Inventories 1990–2015
IVL report: Life cycle assessment of
BillerudKorsnäs virgin fiber-based packaging
materials, December 2017

VERIFICATIONS

EPD Program: The International EPD® System
Note: EPDs from different programs may not be comparable
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Valid within the following geographical area:
Europe
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Production of CTMP–2015
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Contact via info@environdec.com.
PCR moderator: Lucia Rigamonti.
PCR: Product category rules for processed paper and paperboard (CPC 3214), Version 2016-04-01
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Accredited or approved by: The International EPD® System
For more information: www.environdec.com

CONTACT

Mikael Andersson
Senior Vice President Division Board
Phone +46 (0) 555 410 00
For further information visit
www.billerudkorsnas.com

We challenge
conventional packaging
for a sustainable future

