

**Environmental
Product
Declaration**

According to ISO14025+EN15804 A2 (+indicators A1)

This declaration is for:
Calumex® C.S.A.

Provided by:
Caltra Nederland B.V.



MRPI® registration
1.1.00748.2025

program operator
Stichting MRPI®
publisher
Stichting MRPI®
www.mrpi.nl

date of first issue
12-12-2024
date of this issue
12-12-2024
expiry date
12-12-2029



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MRPI® REGISTRATION

1.1.00748.2025

DATE OF THIS ISSUE

12-12-2024

EXPIRY DATE

12-12-2029

SCOPE OF DECLARATION

This MRPI®-EPD certificate is verified by Gert-Jan Vroege, Eco-Intelligence. The LCA study has been done by Max Molhuizen, SGS Search. The certificate is based on an LCA-dossier according to ISO14025+EN15804 A2 (+indicators A1). It is verified according to the 'MRPI®-EPD verification protocol November 2020.v4.0'. EPDs of construction products may not be comparable if they do not comply with EN15804+A2. Declaration of SVHC that are listed on the 'Candidate list of Substances of Very High Concern for authorisation' when content exceeds the limits for registration with ECHA.

PROGRAM OPERATOR

Stichting MRPI®
Kingsfordweg 151
1043 GR
Amsterdam

PRODUCT

Calumex® C.S.A.

DECLARED UNIT / FUNCTIONAL UNIT

1000 Weight per piece (kg)

DESCRIPTION OF PRODUCT


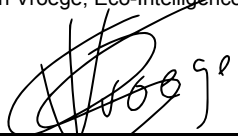
Calumex® C.S.A. is a high-performance calcium sulfoaluminate (CSA) cement clinker specifically designed to deliver rapid setting, high early strength, and exceptional durability. Engineered with advanced CSA technology, it ensures controlled ettringite formation during hydration, effectively compensating for natural shrinkage while enhancing dimensional stability. This makes Calumex® C.S.A. an ideal solution for demanding construction applications such as precast concrete elements, repair mortars, and other specialty cementitious systems.

VISUAL PRODUCT



MORE INFORMATION

https://caltra.com

<p>Ing. L. L. Oosterveen MSc. MBA Managing Director MRPI</p>	<p>DEMONSTRATION OF VERIFICATION</p>
	<p>CEN standard EN15804 serves as the core PCR [1]</p>
	<p>Independent verification of the declaration an data according to ISO14025+EN15804 A2 (+indicators A1) internal: external: X</p>
	<p>Third party verifier: Gert-Jan Vroege, Eco-Intelligence </p>
<p>[1] PCR = Product Category Rules</p>	



DETAILED PRODUCT DESCRIPTION (PART 1)

Production

Calumex® C.S.A. is produced with kiln temperatures that tend to be lower than traditional cements, this way Calumex® C.S.A. is actively reducing their energy consumption during manufacturing. Its formulation requires less limestone, which minimizes CO2 emissions during calcination, and its softer clinker further optimizes energy use by reducing grinding requirements. Calumex® C.S.A. strives to achieve a lower environmental footprint by combining these factors in the production phase.

DETAILED PRODUCT DESCRIPTION (PART 2)

Application

In application, Calumex® C.S.A. achieves rapid strength development, reaching up to 80% of its final strength within the first 24 hours. This allows for accelerated project timelines while maintaining long-term structural reliability. Its low alkalinity, with a pH of 10.5–11, makes it compatible with glass fiber reinforcements and helps prevent alkali-silica reactions, improving its suitability for advanced materials and specialized formulations. The product's exceptional durability also reduces the need for repairs or replacements, supporting sustainable construction practices by lowering material usage and waste over the lifecycle of a structure.

Calumex® C.S.A. strives to reduce their environmental impact by minimising the energy needed in the production where possible and by using materials with lower environmental footprints where it is technical possible and there is enough demand. Its unique properties align with the growing need for innovative, sustainable construction materials that maintain exceptional performance and reliability.

Component (> 1%)	%
CSA	1-90%
Other	1-10%

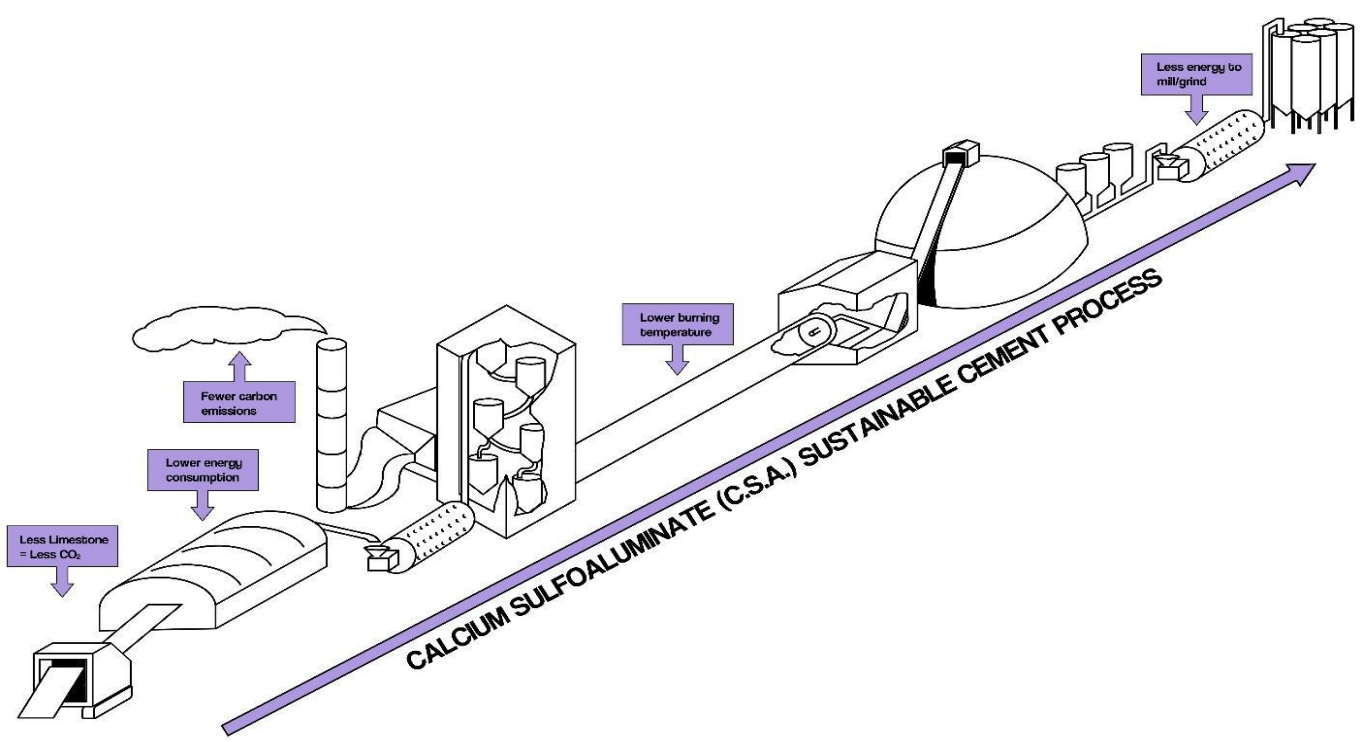
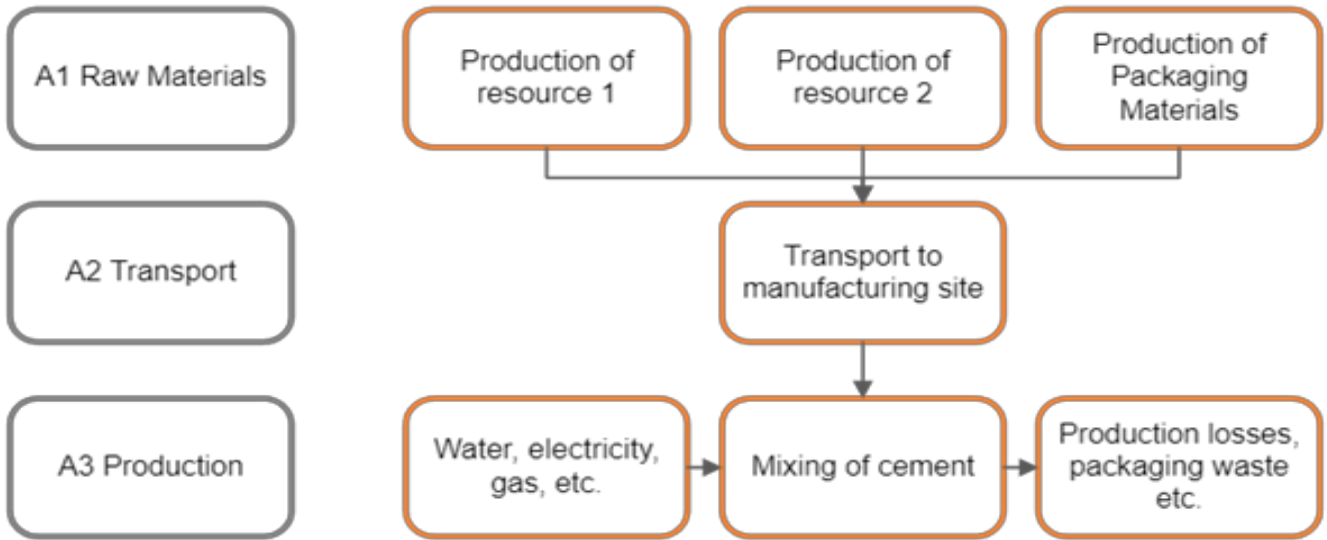
SCOPE AND TYPE

This EPD is a specific EPD made for Calumex® C.S.A. produced in facility Mijdrecht, The Netherlands. The material input are from suppliers across the globe. The data collection is done in production year 2023. The results are calculated with SimaPro 9.5.0.0, using the databases ecoinvent 3.6 and the NMD process database 3.9 (cut-off method system model).

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USER STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARIES
Raw material supply	Transport	Manufacturing	Transport gate to site	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	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

X = Modules Assessed

ND = Not Declared



REPRESENTATIVENESS

This EPD is representative for Calumex® C.S.A., which is produced by Caltra Nederland B.V. at one (1) production site located in Mijdrecht, the Netherlands.

ENVIRONMENTAL IMPACT per functional unit or declared unit (indicators A1)

Eenheid		A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
ADPE	kg Sb eq.	4,39E-04	1,35E-03	2,30E-04	2,02E-03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ADPF	MJ	1,00E+03	1,76E+03	2,12E+02	2,97E+03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
GWP	kg CO2 eq.	4,16E+02	1,35E+02	1,61E+01	5,67E+02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ODP	kg CFC11 eq.	8,14E-06	2,18E-05	8,79E-07	3,08E-05	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
POCP	kg ethene eq.	3,57E-02	1,67E-01	7,84E-03	2,11E-01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
AP	kg SO2 eq.	3,52E-01	2,93E+00	8,54E-02	3,36E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
EP	kg (PO4) 3- eq.	4,86E-02	2,98E-01	1,21E-02	3,59E-01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

Toxicity indicators and ECI (Dutch market)

HTP	kg DCB eq.	1,27E+01	7,70E+01	4,95E+00	9,46E+01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
FAETP	kg DCB eq.	2,76E-01	1,31E+00	4,90E-01	2,08E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
MAETP	kg DCB eq.	1,17E+03	6,03E+03	3,67E+02	7,56E+03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
TETP	kg DCB eq.	4,96E-02	2,34E-01	9,86E-02	3,83E-01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ECI	euro	2,41E+01	2,92E+01	1,79E+00	5,50E+01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ADPF	kg Sn eq.	4,82E-01	8,45E-01	1,02E-01	1,43E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

- ADPE = Abiotic Depletion Potential for non-fossil resources
- ADPF = Abiotic Depletion Potential for fossil resources
- GWP = Global Warming Potential
- ODP = Depletion potential of the stratospheric ozone layer
- POCP = Formation potential of tropospheric ozone photochemical oxidants
- AP = Acidification Potential of land and water
- EP = Eutrophication Potential
- HTP = Human Toxicity Potential
- FAETP = Fresh water aquatic ecotoxicity potential
- MAETP = Marine aquatic ecotoxicity potential
- TETP = Terrestrial ecotoxicity potential
- ECI = Environmental Cost Indicator
- ADPF = Abiotic Depletion Potential for fossil resources

ENVIRONMENTAL IMPACT per functional unit or declared unit (core indicators A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
GWP-total	kg CO2 eq	4,18E+02	1,36E+02	1,63E+01	5,70E+02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
GWP-fossil	kg CO2 eq	4,17E+02	1,36E+02	1,63E+01	5,70E+02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
GWP-biogenic	kg CO2 eq	1,39E-01	-5,20E-02	-1,17E-03	8,59E-02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
GWP-luluc	kg CO2 eq	1,99E-02	1,09E-01	6,04E-02	1,89E-01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ODP	kg CFC11 eq	9,60E-06	2,75E-05	1,01E-06	3,81E-05	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
AP	mol H+ eq.	4,57E-01	3,62E+00	1,06E-01	4,18E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
EP-fresh water	kg PO4 eq.	5,98E-04	6,98E-04	7,63E-04	2,06E-03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
EP-marine	kg N eq.	1,18E-01	8,18E-01	2,30E-02	9,58E-01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
EP-terrestrial	mol N eq.	1,43E+00	9,12E+00	2,43E-01	1,08E+01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
POCP	kg NMVOC eq.	3,69E-01	2,41E+00	6,46E-02	2,85E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ADP-minerals & metals	kg Sb eq.	4,39E-04	1,35E-03	2,28E-04	2,02E-03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ADP-fossil	MJ, net calorific value	9,11E+02	1,77E+03	1,99E+02	2,88E+03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
WDP	m3 world eq. Deprived	1,15E+01	3,53E+00	6,43E+00	2,14E+01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

- GWP-total = Global Warming Potential total
- GWP-fossil = Global Warming Potential fossil fuels
- GWP-biogenic = Global Warming Potential biogenictotal
- GWP-luluc = Global Warming Potential land use and land use change
- ODP = Depletion potential of the stratospheric ozone layer
- AP = Acidification Potential, Accumulated Exceedence
- EP-freshwater = Eutrophication Potential, fraction of nutrients reaching freshwater end compartment
- EP-marine = Eutrophication Potential, fraction of nutrients reaching marine end compartment
- EP-terrestrial = Eutrophication Potential, Accumulated Exceedence
- POCP = Formation potential of tropospheric ozone photochemical oxidants
- ADP-minerals & metals = Abiotic Depletion Potential for non-fossil resources [1]
- ADP-fossil = Abiotic Depletion for fossil resources potential [1]
- WDP = Water (user) deprivation potential, deprivation-weighted water consumption [1]

Disclaimer [1]:

- 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 experience with the indicator.

ENVIRONMENTAL IMPACT per functional unit or declared unit (additional indicators A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
PM	Disease incidence	3,59E-06	4,94E-06	6,73E-07	9,21E-06	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
IRP	kBq U235 eq.	1,48E+00	7,56E+00	4,31E-01	9,47E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ETP-fw	CTUe	5,00E+03	1,23E+03	3,10E+02	6,53E+03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
HTP-c	CTUh	1,77E-08	8,48E-08	5,80E-09	1,08E-07	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
HTP-nc	CTUh	4,33E-07	1,06E-06	1,83E-07	1,68E-06	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
SQP	-	2,14E+02	4,52E+02	1,77E+02	8,44E+02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

- PM = Potential incidence of disease due to PM emissions
- IRP = Potential Human exposure efficiency relative to U235 [1]
- ETP-fw = Potential Comparative Toxic Unit for ecosystems [2]
- HTP-c = Potential Comparative Toxic Unit for humans [2]
- HTP-nc = Potential Comparative Toxic Unit for humans, non-cancer [2]
- SQP = Potential soil quality index [2]

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.

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 experience with the indicator.

OUTPUT FLOWS AND WASTE CATEGORIES per functional unit or declared unit (A1 en A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
HWD	kg	1,69E-03	2,02E-03	5,73E-04	4,29E-03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
NHWD	kg	5,56E+00	2,23E+01	1,30E+01	4,08E+01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
RWD	kg	2,08E-03	1,22E-02	4,85E-04	1,47E-02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
CRU	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
MFR	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
MER	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
EEE	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
ETE	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

- HWD = Hazardous Waste Disposed
- NHWD = Non Hazardous Waste Disposed
- RWD = Radioactive Waste Disposed
- CRU = Components for reuse
- MFR = Materials for recycling
- MER = Materials for energy recovery
- EEE = Exported Electrical Energy
- ETE = Exported Thermal Energy

RESOURCE USE per functional unit or declared unit (A1 and A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
PERE	MJ	1,63E+01	1,45E+01	7,52E+01	1,06E+02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
PERM	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
PERT	MJ	1,63E+01	1,45E+01	7,52E+01	1,06E+02	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
PENRE	MJ	9,93E+02	1,88E+03	2,12E+02	3,09E+03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
PENRM	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
PENRT	MJ	9,93E+02	1,88E+03	2,12E+02	3,09E+03	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
SM	kg	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
RSF	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
NSRF	MJ	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
FW	m3	3,55E-01	1,21E-01	1,99E-01	6,75E-01	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

- PERE = Use of renewable energy excluding renewable primary energy resources
- PERM = Use of renewable energy resources used as raw materials
- PERT = Total use of renewable primary energy resources
- PENRE = Use of non-renewable primary energy resources excluding non-renewable 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 materials
- RSF = Use of renewable secondary fuels
- NSRF = Use of non-renewable secondary fuels
- FW = Use of net fresh water

BIOGENIC CARBON CONTENT per functional unit or declared unit (A1 and A2)

	Unit	A1	A2	A3	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
BCCpr	kg C	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
BCCpa	kg C	0,00E+00	0,00E+00	0,00E+00	0,00E+00	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND

- BCCpr = Biogenic carbon content in product
- BCCpa = Biogenic carbon content in packaging



CALCULATION RULES (PART 1)

Declared unit

The declared unit for the life cycle assessment is 1000 kg of Calumex® C.S.A.

Data collection

Input- and output data has been provided by Caltra of the production year 2023 for the following inventory categories:

- Materials (raw materials and auxiliary materials);
- Energy (electricity and heat);
- Emissions to air, water and soil;
- Treatment and disposal of production wastes.

Data quality

Data was validated by SGS at the process level. This means that not only the mass balance was verified, but that in the case of major deviations from the average (for all type of in- and output) the suppliers were asked for further explanation.

Allocations

Allocation of environmental interventions can apply to multi-input, multi-output, recycling and reuse processes. No allocation of multi output processes is applied in this study. For other allocations, the provisions from the EN 15804 are followed.

Cut-off criteria

This LCA contains all relevant data. The following processes are not included in this LCA:

- Assumed is that the maintenance and use of auxiliary equipment have a negligible contribution to the total (<1%). Because of this, these processes are not taken in account in this LCA, except such processes that are included in the Ecoinvent background data.
- Assumed is that the capital goods and infrastructure processes have a negligible contribution. These processes are not taken in account in this LCA, except such processes that are included in the Ecoinvent background data.

There is no reason to believe that relevant in- or outputs are excluded from this study.

SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION (PART 1)

Calumex® C.S.A. is a Calcium Sulfoaluminate cement clinker produced using a mix of limestone, calcium sulfate and high purity bauxite, resulting in an unparalleled ye'elemite content. On its own Calumex® C.S.A. is a slow reacting cement, but when combined with the proper source of sulphate it can be applied in cement mixes to accelerate setting times and significantly improve early strength development, through the controlled formation of ettringite.

The formation of ettringite results in positive expansion, thereby compensating for the shrinkage commonly found in Portlandcement mixes.

Applying Calumex® C.S.A. will lower the alkalinity of the cement matrix, making it more suited for glass fiber reinforced cement applications. pH will remain sufficiently high to protect steel rebar or fibers.

Calumex® C.S.A. has a wide variety of possible applications where a rapid set and high early strengths are required.

When applying Calumex® C.S.A., the following characteristics are attained:

- Higher expansive value
- Fast setting and rapid hardening
- High and early strength
- No loss of strength over time
- Improved sulfate and alkali resistance
- Excellent freeze/thaw performance

SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION (PART 2)

Technical data

In the table below, the compressive strength of the products is presented. The Vicat-time (min) from the beginning >2:00 to end <4:00 is tested.

	Temperature (°C)	Tim (min)	Compressive strength - 1 (avg)	Compressive strength - 1 (avg)	Compressive strength - 1 (avg)
Compressive Strength development (MPa)	> 55	≤ 55:00	30 (± 4)	35 (± 4)	41 (± 4)



SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION (PART 3)

Applying the above indicative mixing ratio, setting times will be reduced from 3-4 hours to several minutes. If needed, the setting times can be easily adjusted by applying commonly used cement retarding agents such as citric or tartaric acid.

The values given above are indications and will depend on the type and source of sulfate and Portlandcement used. Always carefully test your mixes before applying them in practice.

SCENARIOS AND ADDITIONAL TECHNICAL INFORMATION (PART 4)

Product stage (A1-A3)

This stage consists of the extraction of raw materials, energy which occurs upstream to the manufacturing process, transportation of raw materials, processing of the raw materials into the final product with all processes and energy required for production as well as packaging materials.

Data collection was performed by Caltra in cooperation with their suppliers. The manufacturer compiled mass and energy balances based on average production in year 2023. The production facility in Mijdrecht uses renewable electricity from photovoltaic panels (own production) in their production process.

DECLARATION OF SVHC

No substances of very high concern are present in concentrations greater than 0,1% by weight in the product.

REFERENCES

NMD Bepalingsmethode Milieuprestatie Bouwwerken 1.1, NMD March 2022.

EN 15804:2012+A2:2019 Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction products.

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ISO, 2006. "Environmental management. Life cycle assessment – Requirements and Guidelines". ISO 14044:2006.

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