

# Mohawk Group



## Declaration Owner

### Mohawk Industries

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## Product

*Hot & Heavy Floating Luxury Vinyl Tile Flooring*

(UNSPSC Class Code 30161707)

EPD represents delivery of product to customers in the United States.

## Functional Unit

The functional unit is one square meter of flooring over a 75-year period

## EPD Number and Period of Validity

SCS-EPD-08570

EPD Valid January 11, 2023 through January 10, 2028

## Product Category Rule

PCR Guidance for Building-Related Products and Services Part A: Life Cycle Assessment Calculation Rules and Report Requirements. Version 3.2. UL Environment. Dec. 2018. UL 10010.

PCR Guidance for Building-Related Products and Services Part B: Flooring EPD Requirements. Version 2. UL Environment. Sept. 2018. UL 10010-7.

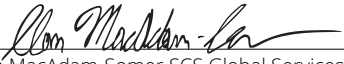
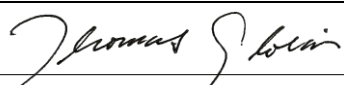
## Program Operator

SCS Global Services

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Declaration URL Link:	<a href="https://www.scsglobalservices.com/certified-green-products-guide">https://www.scsglobalservices.com/certified-green-products-guide</a>																
LCA Practitioner:	Gerard Mansell, Ph.D., SCS Global Services																
LCA Software and LCI database:	OpenLCA v1.10 software and the Ecoinvent v3.6 database																
Product RSL:	30 years																
Markets of Applicability:	United States																
EPD Type:	Product-Specific																
EPD Scope:	Cradle-to-Grave																
LCIA Method and Version:	CML-IA and TRACI 2.1																
Independent critical review of the LCA and data, according to ISO 14044 and ISO 14071	<input checked="" type="checkbox"/> internal <input type="checkbox"/> external																
LCA Reviewer:	 Ian MacAdam-Somer SCS Global Services																
Part A Product Category Rule:	PCR Guidance for Building-Related Products and Services Part A: Life Cycle Assessment Calculation Rules and Report Requirements. Version 3.2. UL Environment. Dec. 2018. UL 10010																
Part A PCR Review conducted by:	Lindita Bushi, PhD (Chair); Hugues Imbeault-Tétreault, ing., M.Sc.A.; Jack Geibig																
Part B Product Category Rule:	PCR Guidance for Building-Related Products and Services Part B: Flooring EPD Requirements. Version 2. UL Environment. Sept. 2018. UL 10010-7																
Part B PCR Review conducted by:	Jack Geibig (chair), Ecoform; Thomas Gloria, Industrial Ecology Consultants; Thaddeus Owen																
Independent verification of the declaration and data, according to ISO 14025 and the PCR	<input type="checkbox"/> internal <input checked="" type="checkbox"/> external																
EPD Verifier:	 Thomas Gloria, Ph.D., Industrial Ecology Consultants																
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<p><b>Disclaimers:</b> This EPD conforms to ISO 14025, 14040, 14044, and 21930.</p> <p><b>Scope of Results Reported:</b> The PCR requirements limit the scope of the LCA metrics such that the results exclude environmental and social performance benchmarks and thresholds, and exclude impacts from the depletion of natural resources, land use ecological impacts, ocean impacts related to greenhouse gas emissions, risks from hazardous wastes and impacts linked to hazardous chemical emissions.</p> <p><b>Accuracy of Results:</b> Due to PCR constraints, this EPD provides estimations of potential impacts that are inherently limited in terms of accuracy.</p> <p><b>Comparability:</b> The PCR this EPD was based on was not written to support comparative assertions. EPDs based on different PCRs, or different calculation models, may not be comparable. When attempting to compare EPDs or life cycle impacts of products from different companies, the user should be aware of the uncertainty in the final results, due to and not limited to, the practitioner's assumptions, the source of the data used in the study, and the specifics of the product modeled.</p> <p>In accordance with ISO 21930:2017, EPDs are comparable only if they comply with the core PCR, use the same sub-category PCR where applicable, include all relevant information modules and are based on equivalent scenarios with respect to the context of construction works.</p>																	

## 1. Mohawk Industries

Mohawk is a leading manufacturer of carpet, wood, laminate, and luxury vinyl tile flooring that began in 1878. Mohawk is committed to growing in ways that are environmentally sound, socially responsible, and make sense for their stakeholders. The Mohawk Group strives to design and manufacture innovative products with reduced environmental and social impacts. As part of the world's largest flooring manufacturer, Mohawk feels a profound sense of responsibility to advance their shared mission of a more sustainable future.

## 2. Product

### 2.1 PRODUCT DESCRIPTION

Hot & Heavy Floating LVT lives up to its name. The bold, oversized formats are the hottest thing in flooring and are made possible due to the loose lay construction. Each jumbo tile and plank is coated with a non-skid backing that together, with the substantial weight of the product, keep tiles on the floor under true commercial traffic. Hot & Heavy not only looks amazing but works to reduce sound transfer and subfloor prep for a fashionable, practical commercial flooring solution.

### 2.2 PRODUCT FLOW DIAGRAM

A flow diagram illustrating the production processes and life cycle phases included in the scope of the EPD is provided below.



## 2.3 APPLICATION

The LVT flooring products provide the primary function of flooring for interior applications. The products are used in various residential and commercial applications including retail, healthcare, education, and hospitality.

## 2.4 DECLARATION OF METHODOLOGICAL FRAMEWORK

The scope of the EPD is cradle-to-grave, including raw material extraction and processing, transportation, product manufacture, product delivery, installation and use, and product disposal. The life cycle phases included in the product system boundary are shown below.

Cut-off and allocation procedures are described below and conform to the PCR and ISO standards.

**Table 1.** Life cycle phases included in the luxury vinyl flooring product system boundary.

Product			Construction Process		Use							End-of-life				Benefits and loads beyond the system boundary
A1	A2	A3	A4	A5	B1	B1	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Raw material extraction and processing	Transport to manufacturer	Manufacturing	Transport	Construction - installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction demolition	Transport	Waste processing	Disposal	Reuse, recovery and/or recycling potential
X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	MND

X = Module Included | MND = Module Not Declared

## 2.5 TECHNICAL DATA

Technical specifications for the flooring products are summarized in Table 2.

**Table 2.** Product characteristics for the **Hot & Heavy Floating LVT** flooring product.

Characteristic		Description			
Sustainable certifications		ISO 14001			
VOC emissions test method		FloorScore®			
Characteristic		Nominal Value	Unit	Min Value	Max Value
Product thickness		5.0 (0.197)	mm (inch)	4.0 (0.157)	6.0 (0.24)
Wear layer thickness (where applicable)		0.50 (0.020)	mm (inch)	0.1 (0.004)	1.0 (0.04)
Product weight		8,100 (26.54)	g/m <sup>2</sup> (oz/ft <sup>2</sup> )	6,000 (19.7)	9,000 (29.5)
Product Form	Tiles	Various	mm (inch)	Various	Various

## 2.6 MARKET PLACEMENT/APPLICATION RULES

Technical specifications and product performance results for the LVT products can be found on the manufacturer's website: [www.mohawkgroup.com](http://www.mohawkgroup.com).

## 2.7 PROPERTIES OF DECLARED PRODUCT AS DELIVERED

The products are delivered for installation in the form of tiles.

## 2.8 MATERIAL COMPOSITION

The primary materials include polyvinyl chloride (PVC), plasticizers, fillers and various stabilizers and coatings.

**Table 3.** Material content for the luxury vinyl flooring products in kg per square meter and percent of total mass.

Component	kg/m <sup>2</sup>	Percent
PVC	2.61	32%
Filler	4.16	51%
Plasticizer	0.996	12%
Stabilizer	0.200	2.5%
Pigments & Coatings	7.45x10 <sup>-2</sup>	0.92%
Other	4.87x10 <sup>-2</sup>	0.60%
<b>Total Product</b>	<b>8.09</b>	<b>100%</b>

No substances required to be reported as hazardous are associated with the production of this product

## 2.9 MANUFACTURING

The vinyl tile flooring is manufactured in South Korea. The vinyl flooring is made primarily from polyvinyl chloride (PVC), calcium carbonate (mineral reinforcement), plasticizers and additives (i.e., pigments and stabilizers). The product is structured with multiple layers including PVC backing, a PVC wear layer and a UV protective layer.

The production of vinyl tile flooring involves the following general manufacturing processes:

- Polyvinyl chloride resins are mixed with calcium carbonate, plasticizers, and pigments in a large industrial mixer.
- The core is extruded to a dough-like consistency. The dough-like substance is then put through calender rollers and squeezed into sheets.
- The LVT sheets are embossed, adhered to the core and then cut into individual planks, profiled, a foamed backing layer adhered and then packaged for shipment.

## 2.10 PACKAGING

The products are packaged for shipment using cardboard cartons, plastic wrap and wooden pallets.

**Table 4.** Material content for the LVT flooring product packaging, in kg per square meter and percent of total mass.

Component	kg/m <sup>2</sup>	Percent
Corrugated	0.190	42%
Plastic	3.56x10 <sup>-3</sup>	0.79%
Wood	0.260	57%
<b>Total Packaging</b>	<b>0.454</b>	<b>100%</b>

### 2.11 PRODUCT INSTALLATION

Installation of the product is accomplished using hand tools with negligible impacts and waste. The impacts associated with packaging disposal are included with the installation phase as per PCR requirements.

### 2.12 USE CONDITIONS

No special conditions of use are noted.

### 2.13 PRODUCT REFERENCE SERVICE LIFE AND BUILDING ESTIMATED SERVICE LIFE

The Reference Service Life (RSL) of the flooring products is 30 years based on the manufacturer's warranted lifetime. The building Estimated Service Life (ESL) is 75 years, consistent with the PCR.

### 2.14 RE-USE PHASE

The flooring products are not reused at end-of-life.

### 2.15 DISPOSAL

At end-of-life, the products may be disposed of in a landfill or via incineration. Although in some instances, vinyl flooring can be recycled into other products, the practice is not typical, nor widely available as a disposal route for the products in the consumer markets considered. It is assumed that no components of the product are recycled at end-of-life.

### 2.16 FURTHER INFORMATION

Further information on the product can be found on the manufacturers' website at [www.mohawkgroup.com/](http://www.mohawkgroup.com/).

## 3. LCA: Calculation Rules

### 3.1 FUNCTIONAL UNIT

The functional unit used in the study is defined as 1 m<sup>2</sup> of floor covering installed for use over a 75-year period. The corresponding reference flow for each product system is presented in Table 6. For the present assessment, a reference service lifetime (RSL) corresponding to the manufacturer's warranted lifetime is assumed. The total number of required product lifecycles during the 75-year period over which the product system is modeled is also summarized for the product in Table 5.

**Table 5.** Reference flow and RSL for the Luxury Vinyl Tile flooring product.

Reference Flow (kg/m <sup>2</sup> )	Reference Service Life – RSL (years)	Replacement Cycle (ESL/RSL-1)
8.09	30	1.5

### 3.2 SYSTEM BOUNDARY

The scope of the EPD is cradle-to-grave, including raw material extraction and processing, transportation, product manufacture, product delivery, installation and use, and product disposal. The life cycle phases included in the EPD scope are described in Table 6 and illustrated in Figure 1.

**Table 6.** *The modules and unit processes included in the scope for the LVT flooring products.*

Module	Module description from the PCR	Unit Processes Included in Scope
A1	Extraction and processing of raw materials; any reuse of products or materials from previous product systems; processing of secondary materials; generation of electricity from primary energy resources; energy, or other, recovery processes from secondary fuels	Extraction and processing of raw materials for the vinyl flooring components.
A2	Transport (to the manufacturer)	Transport of component materials to the manufacturing facilities
A3	Manufacturing, including ancillary material production	Manufacturing of flooring products and packaging (incl. upstream unit processes)
A4	Transport (to the building site)	Transport of product (including packaging) to the building site
A5	Construction-installation process	Impacts from the installation of the product are assumed negligible. Only impacts from packaging disposal are included in this phase.
B1	Product use	Use of the flooring in a commercial building setting. There are no associated emissions or impacts from the use of the product
B2	Product maintenance	Maintenance of products, including periodic cleaning over the 75-year ESL of the assessment.
B3	Product repair	The flooring is not expected to require repair over its lifetime. Impacts from this phase are reported as zero.
B4	Product replacement	The materials and energy required for replacement of the product over the 75-year ESL of the assessment are included in this phase.
B5	Product refurbishment	The flooring is not expected to require refurbishment over its lifetime. Impacts from this phase are reported as zero
B6	Operational energy use by technical building systems	There is no operational energy use associated with the use of the product
B7	Operational water use by technical building systems	There is no operational water use associated with the use of the product
C1	Deconstruction, demolition	Demolition of the product is accomplished using hand tools with no associated emissions and negligible impacts
C2	Transport (to waste processing)	Transport of flooring product to waste treatment at end-of-life
C3	Waste processing for reuse, recovery and/or recycling	The product is disposed of by incineration and/or landfilling which require no waste processing
C4	Disposal	Disposal of flooring product in municipal landfill or incineration
D	Reuse-recovery-recycling potential	Module Not Declared



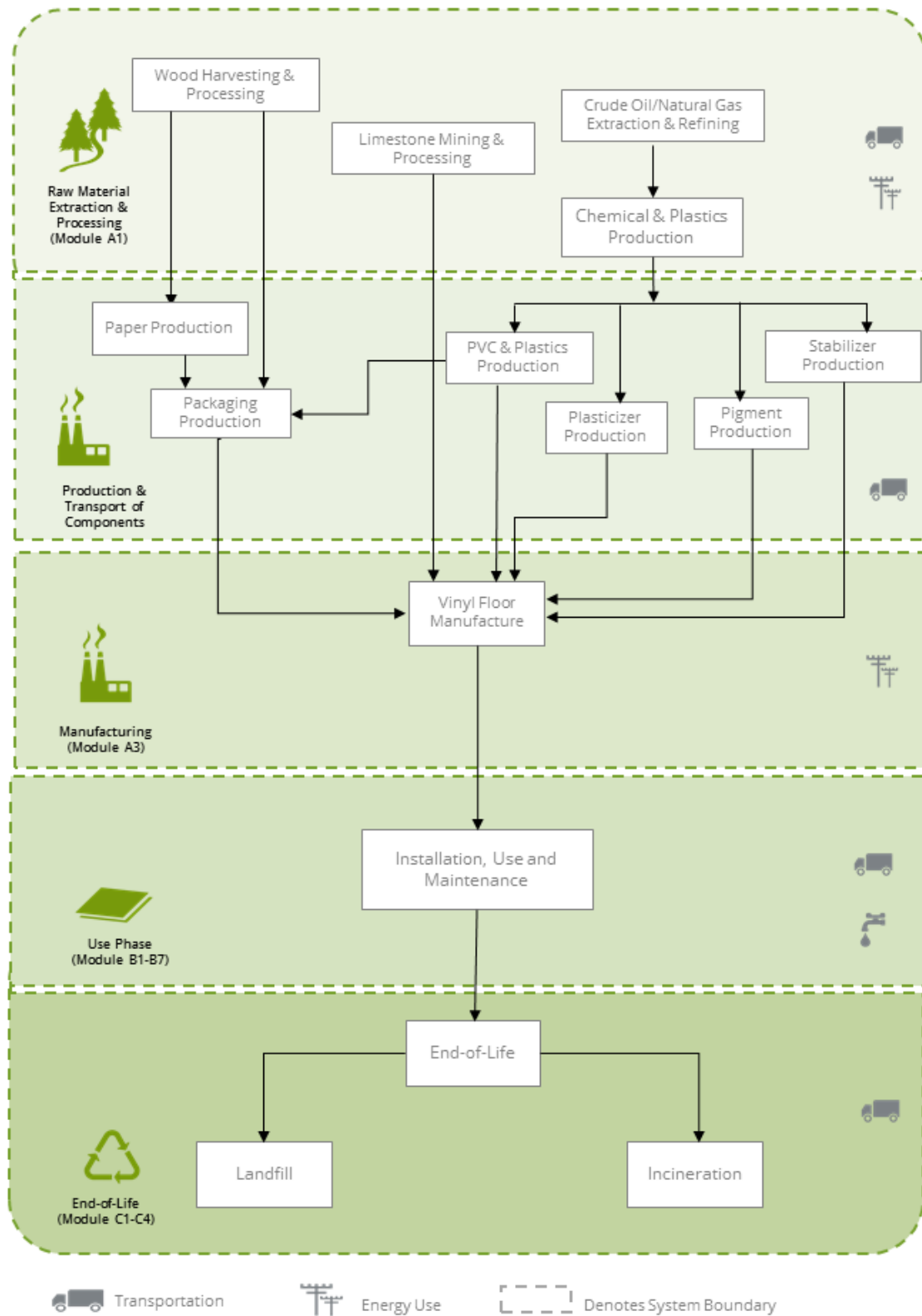


Figure 1. Flow Diagram for the life cycle of the luxury vinyl flooring product system.



### 3.3 PRODUCT SPECIFIC CALCULATION FOR USE PHASE

The recommended cleaning regime is highly dependent on the use of the premises where the floor covering is installed. In high traffic areas more frequent cleaning will be needed compared to areas where there is low traffic. For the purposes of this EPD, average maintenance (moderate traffic levels) is presented based on typical installations.

### 3.4 UNITS

All data and results are presented using SI units.

### 3.5 ESTIMATES AND ASSUMPTIONS

- The manufacturing facility is located in Korea. An Ecoinvent inventory dataset for the Korean energy grid mix was used to model resource use and emissions from electricity use at the manufacturing facility.
- Disposal of the product packaging is modeled based on regional statistics regarding municipal solid waste generation and disposal in the United States, as specified in the PCR. The data include end-of-life recycling rates of packaging and product materials. No components of the product are assumed recycled.
- For final disposal of the packaging material and flooring at end-of-life, all materials are assumed to be transported ~32 km (20 miles) by diesel truck to either a landfill, incineration facility, or material reclamation facility (for recycling). Datasets representing disposal in a landfill and waste incineration are from Ecoinvent.

The PCR requires the results for several inventory flows related to construction products to be reported including energy and resource use and waste and outflows. These are aggregated inventory flows, and do not characterize any potential impact; results should be interpreted considering this limitation.

### 3.6 CUT-OFF RULES

According to the PCR, processes contributing greater than 1% of the total environmental impact indicator for each impact are included in the inventory. No data gaps were allowed which were expected to significantly affect the outcome of the indicator results. No known flows are deliberately excluded from this EPD.

### 3.7 DATA SOURCES

Primary data were provided by the manufacturer for their production facility. The sources of secondary LCI data are the Ecoinvent database.

**Table 7.** Data sources for the LVT flooring product system.

Component	Dataset	Data Source	Publication data
<b>PRODUCT</b>			
<b>PVC</b>			
Polyvinyl Chloride	polyvinylchloride production, bulk polymerisation   polyvinylchloride, bulk polymerised   Cutoff, S/RoW	EI v3.6	2019
<b>Filler</b>			
Calcium Carbonate	limestone production, crushed, washed   limestone, crushed, washed   Cutoff, S/RoW	EI v3.6	2019
<b>Plasticizer</b>			
PVC Plasticizer*	diisooheptyl phthalate (DIHP) {GLO}   market for   Alloc Rec U System	EI v3.6	2019
<b>Stabilizer</b>			
Stabilizer	market for chemical, organic   chemical, organic   Cutoff, S/GLO	EI v3.6	2019
	market for chemicals, inorganic   chemical, inorganic   Cutoff, S/GLO	EI v3.6	2019
	market for limestone, crushed, washed   limestone, crushed, washed   Cutoff, S/RoW	EI v3.6	2019
	market for zinc oxide   zinc oxide   Cutoff, S/GLO	EI v3.6	2019
<b>Pigment</b>			
Carbon Black	market for carbon black   carbon black   Cutoff, S/GLO	EI v3.6	2019
<b>Other</b>			
Organic chemicals	market for chemical, organic   chemical, organic   Cutoff, S/GLO	EI v3.6	2019
Glass Fibre	glass fibre production   glass fibre   Cutoff, S/RoW	EI v3.6	2019
Urethane Acrylate	market for polyurethane, flexible foam   polyurethane, flexible foam   Cutoff, S/RoW	EI v3.6	2019
<b>PACKAGING</b>			
Cardboard	containerboard production, linerboard, kraftliner   containerboard, linerboard   Cutoff, S/RoW	EI v3.6	2019
Wrapping Film	packaging film production, low density polyethylene   packaging film, low density polyethylene   Cutoff, S/RoW	EI v3.6	2019
Polyester Strapping	polyethylene terephthalate production, granulate, amorphous   polyethylene terephthalate, granulate, amorphous   Cutoff, S/RoW	EI v3.6	2019
Wood	market for EUR-flat pallet   EUR-flat pallet   Cutoff, S/GLO	EI v3.6	2019
<b>TRANSPORT</b>			
Road transport	market for transport, freight, lorry 16-32 metric ton, EURO4   transport, freight, lorry 16-32 metric ton, EURO4   Cutoff, S/RoW	EI v3.6	2019
Ship transport	transport, freight, sea, container ship   transport, freight, sea, container ship   Cutoff, S/GLO	EI v3.6	2019
<b>RESOURCES</b>			
Grid electricity	market for electricity, medium voltage   electricity, medium voltage   Cutoff, S/KR	EI v3.6	2019
Heat – natural gas	market group for heat, district or industrial, natural gas   heat, district or industrial, natural gas   Cutoff, S/GLO	EI v3.6	2019

\* Inventory data developed for diisooheptyl phthalate (DIHP) was used as a surrogate to represent DOTP in the LCA model.

### 3.8 DATA QUALITY

The data quality assessment addressed the following parameters: time-related coverage, geographical coverage, technological coverage, precision, completeness, representativeness, consistency, reproducibility, sources of data, and uncertainty.

**Table 8.** *Data quality assessment for the luxury vinyl flooring product system.*

Data Quality Parameter	Data Quality Discussion
<b>Time-Related Coverage:</b> Age of data and the minimum length of time over which data is collected	The most recent available data are used, based on other considerations such as data quality and similarity to the actual operations. Typically, these data are less than 5 years old (typically 2016). All of the data used represented an average of at least one year's worth of data collection, and up to three years in some cases. Manufacturer-supplied data (primary data) are based on annual production for 2019.
<b>Geographical Coverage:</b> Geographical area from which data for unit processes is collected to satisfy the goal of the study	The data used in the analysis provide the best possible representation available with current data. Electricity use for product manufacture is modeled using representative data for South Korea. Surrogate data used in the assessment are representative of global or European operations. Data representative of European operations are considered sufficiently similar to actual processes.
<b>Technology Coverage:</b> Specific technology or technology mix	For the most part, data are representative of the actual technologies used for processing, transportation, and manufacturing operations. Representative fabrication datasets, specific to the type of material, are used to represent the actual processes, as appropriate.
<b>Precision:</b> Measure of the variability of the data values for each data expressed	Precision of results are not quantified due to a lack of data. Data collected for operations were typically averaged for one or more years and over multiple operations, which is expected to reduce the variability of results.
<b>Completeness:</b> Percentage of flow that is measured or estimated	The LCA model included all known mass and energy flows for production of the flooring products. In some instances, surrogate data used to represent upstream and downstream operations may be missing some data which is propagated in the model. No known processes or activities contributing to more than 1% of the total environmental impact for each indicator are excluded.
<b>Representativeness:</b> Qualitative assessment of the degree to which the data set reflects the true population of interest	Data used in the assessment represent typical or average processes as currently reported from multiple data sources and are therefore generally representative of the range of actual processes and technologies for production of these materials. Considerable deviation may exist among actual processes on a site-specific basis; however, such a determination would require detailed data collection throughout the supply chain back to resource extraction.
<b>Consistency:</b> Qualitative assessment of whether the study methodology is applied uniformly to the various components of the analysis	The consistency of the assessment is considered to be high. Data sources of similar quality and age are used; with a bias towards Ecoinvent v3.6 data where available. Different portions of the product life cycle are equally considered; however, it must be noted that final disposition of the product is based on assumptions of current average practices in the United States.
<b>Reproducibility:</b> Qualitative assessment of the extent to which information about the methodology and data values would allow an independent practitioner to reproduce the results reported in the study	Based on the description of data and assumptions used, this assessment would be reproducible by other practitioners. All assumptions, models, and data sources are documented.
<b>Sources of the Data:</b> Description of all primary and secondary data sources	Data representing energy use at manufacturing facility in South Korea represent an annual average and are considered of high quality due to the length of time over which these data are collected, as compared to a snapshot that may not accurately reflect fluctuations in production. For secondary LCI datasets, Ecoinvent v3.6 LCI data are used, with a bias towards the most recent representative data.
<b>Uncertainty of the Information:</b> Uncertainty related to data, models, and assumptions	Uncertainty related to materials in the flooring products and packaging is low. Actual supplier data for upstream operations was not available for all suppliers and the study relied upon the use of existing representative datasets. These datasets contained relatively recent data (<10 years) but lacked geographical representativeness. Uncertainty related to the impact assessment methods used in the study are high. The impact assessment method required by the PCR includes impact potentials, which lack characterization of providing and receiving environments or tipping points.

### 3.9 PERIOD UNDER REVIEW

The period of review is calendar year 2019.

### 3.10 ALLOCATION

Manufacturing resource use was allocated to the products based on product area. Impacts from transportation were allocated based on the mass of material and distance transported.

### 3.11 COMPARABILITY

The PCR this EPD was based on was not written to support comparative assertions. EPDs based on different PCRs, or different calculation models, may not be comparable. When attempting to compare EPDs or life cycle impacts of products from different companies, the user should be aware of the uncertainty in the final results, due to and not limited to, the practitioner's assumptions, the source of the data used in the study, and the specifics of the product modeled.

## 4. LCA: Scenarios and Additional Technical Information

### *Delivery and Installation stage (A4 - A5)*

Distribution of the flooring products to the point of installation is included in the assessment. Transportation parameters for modeling product distribution are summarized in Table 9. Average distances by transport mode were used to represent product distribution to each consumer market.

**Table 9.** Product distribution parameters, per 1 m<sup>2</sup> (A4)

Parameter	Value
Diesel truck – Fuel utilization (L/100 km)	18.7
Diesel truck – Capacity utilization (%)	76%
Diesel truck – Distance (km)	800
Ocean freighter – Fuel utilization (ton/ton-km)	2.5
Ocean freighter – Capacity utilization (%)	65%
Ocean freighter – Distance (km)	18,000
Gross mass of products transported (kg)	8.54

The impacts associated with the product installation are assumed negligible. The impacts associated with packaging disposal are included with the installation phase as per PCR requirements.

**Table 10.** *Installation parameters for the LVT flooring products, per 1 m<sup>2</sup>.*

Parameter		Value
Ancillary materials (kg)		neg.
Net freshwater consumption (m <sup>3</sup> )		-
Electricity consumption (kWh)		-
Product loss per functional unit (kg)		neg.
Waste materials generated by product installation (kg)		neg.
Output materials resulting from on-site waste processing (kg)		n/a
Mass of packaging waste (kg)	Corrugated	0.190
	Plastic	3.56x10 <sup>-3</sup>
	Wood	0.260
Biogenic carbon contained in packaging (kg CO <sub>2</sub> )		0.792
Direct emissions (kg)		-

**Use stage (B1)**

No impacts are associated with the use of the product over the Reference Service Lifetime.

**Maintenance stage (B2)**

According to the manufacturer, typical maintenance involves regular sweeping and damp mopping. The present assessment is based on a recommended weekly cleaning schedule including sweeping and damp mopping with a neutral cleaner.

**Table 11.** *Maintenance parameters for the flooring products, per 1 m<sup>2</sup>.*

Parameter	Unit	Value
Maintenance cycle	Cycles / RSL	1,560
Maintenance cycle	Cycles / ESL	3,900
Maintenance process	-	Damp mopping
Net freshwater consumption	m <sup>3</sup> /m <sup>2</sup> /yr	0.0058
Cleaning agent	kg/m <sup>2</sup> /yr	0.0119
Maintenance process	-	Vacuuming
Electricity	kWh/m <sup>2</sup> /yr	0.022
Further assumptions	-	Moderate traffic; weekly maintenance

**Repair/Refurbishment stage (B3; B5)**

Product repair and refurbishment are not relevant during the lifetime of the product.

**Replacement stage (B4)**

The materials and energy required for replacement of the product over the 75-year ESL of the assessment are included in this stage.

**Building operation stage (B6 – B7)**

There is no operational energy or water use associated with the use of the product.

**Disposal stage (C1 - C4)**

The disposal stage includes removal of the products (C1); transport of the flooring products to waste treatment facilities (C2); waste processing (C3); and associated emissions as the product degrades in a landfill or is burned in an incinerator

(C4). For the flooring products, no emissions are generated during demolition (C1) while no waste processing (C3) is required for incineration or landfill disposal.

Transportation of waste materials at end-of-life (C2) assumes a 20 mile (~32 km) average distance to disposal, consistent with assumptions used in the US EPA WARM model. The recycling rates used for the product packaging are based on regional statistics regarding municipal solid waste generation and disposal in the United States for 2015, from the US Environmental Protection Agency. No recycling of the product materials is assumed at end-of-life. The relevant disposal statistics used for the packaging are summarized in Table 12 and Table 13. For material not recycled, 80% are assumed landfilled and 20% incinerated.

**Table 12.** *Recycling rates for packaging materials at end-of-life.*

Material	Recycling rate (%)
<b>Recycling Rates</b>	
Paper & Pulp	78%
Wood	26%
Plastics	15%
<b>Disposal of Non-recyclables</b>	
Landfill	80%
Incineration	20%

**Table 13.** *End-of-life disposal scenario parameters for the flooring products.*

Parameter		Value
Assumptions for scenario development		100% landfill
Collection process		
Collected with mixed construction waste (kg)		8.09
Recovery		n/a
Disposal	Landfill (kg)	8.09
Removals of biogenic carbon (kg CO <sub>2</sub> eq)		n/a

## 5. LCA: Results

Results of the Life Cycle Assessment are presented below. It is noted that LCA results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks.

The following environmental impact category indicators are reported using characterization factors based on the U.S. EPA's Tool for the Reduction and Assessment of Chemical and Other Environmental Impacts – TRACI 2.1 and CML-IA.

CMLI-A Impact Category	Unit	TRACI 2.1 Impact Category	Unit
Global Warming Potential (GWP)	kg CO <sub>2</sub> eq	Global Warming Potential (GWP)	kg CO <sub>2</sub> eq
Depletion potential of the stratospheric ozone layer (ODP)	kg CFC 11 eq	Ozone Depletion Potential (ODP)	kg CFC 11 eq
Acidification Potential of soil and water (AP)	kg SO <sub>2</sub> eq	Acidification Potential (AP)	kg SO <sub>2</sub> eq
Eutrophication Potential (EP)	kg (PO <sub>4</sub> ) <sup>3-</sup> eq	Eutrophication Potential (EP)	kg N eq
Photochemical Oxidant Creation Potential (POCP)	kg C <sub>2</sub> H <sub>4</sub> eq	Smog Formation Potential (SFP)	kg O <sub>3</sub> eq
Abiotic depletion potential (ADP-elements) for non-fossil resources	kg Sb eq	Fossil Fuel Depletion Potential (ADP <sub>fossil</sub> )	MJ Surplus, LHV
Abiotic depletion potential (ADP-fossil fuels) for fossil resources	MJ, LHV		

These impact categories are globally deemed mature enough to be included in Type III environmental declarations. Other categories are being developed and defined and LCA should continue making advances in their development. However, the EPD users shall not use additional measures for comparative purposes.

The following inventory parameters, specified by the PCR, are also reported.

Resources	Unit	Waste and Outflows	Unit
RPR <sub>E</sub> : Renewable primary resources used as energy carrier (fuel)	MJ, LHV	HWD: Hazardous waste disposed	kg
RPR <sub>M</sub> : Renewable primary resources with energy content used as material	MJ, LHV	NHWD: Non-hazardous waste disposed	kg
NRPR <sub>E</sub> : Non-renewable primary resources used as an energy carrier (fuel)	MJ, LHV	HLRW: High-level radioactive waste, conditioned, to final repository	kg
NRPR <sub>M</sub> : Non-renewable primary resources with energy content used as material	MJ, LHV	ILLRW: Intermediate- and low-level radioactive waste, conditioned, to final repository	kg
SM: Secondary materials	MJ, LHV	CRU: Components for re-use	kg
RSF: Renewable secondary fuels	MJ, LHV	MR: Materials for recycling	kg
NRSF: Non-renewable secondary fuels	MJ, LHV	MER: Materials for energy recovery	kg
RE: Recovered energy	MJ, LHV	EE: Recovered energy exported from the product system	MJ, LHV
FW: Use of net fresh water resources	m <sup>3</sup>	-	-



**Table 14.** Life Cycle Impact Assessment (LCIA) results for the **Hot & Heavy Floating LVT** flooring products over a 75-yr time horizon. Results reported in MJ are calculated using lower heating values. All values are rounded to three significant digits.

Impact Category	A1	A2	A3	A4	A5	B2	B4	C2	C4
<b>CML-IA</b>									
GWP (kg CO <sub>2</sub> eq)	10.9	0.399	0.498	2.60	8.28x10 <sup>-2</sup>	9.59	27.7	0.330	3.64
	20%	0.72%	0.89%	4.7%	0.15%	17%	50%	0.59%	6.5%
ODP (kg CFC-11 eq)	3.33x10 <sup>-6</sup>	7.00x10 <sup>-8</sup>	3.97x10 <sup>-8</sup>	4.35x10 <sup>-7</sup>	3.80x10 <sup>-9</sup>	5.65x10 <sup>-7</sup>	5.93x10 <sup>-6</sup>	5.75x10 <sup>-8</sup>	2.31x10 <sup>-8</sup>
	32%	0.67%	0.38%	4.2%	0.04%	5.4%	57%	0.55%	0.22%
AP (kg SO <sub>2</sub> eq)	4.14x10 <sup>-2</sup>	1.57x10 <sup>-3</sup>	1.78x10 <sup>-3</sup>	4.22x10 <sup>-2</sup>	1.11x10 <sup>-4</sup>	4.29x10 <sup>-2</sup>	0.134	1.54x10 <sup>-3</sup>	9.67x10 <sup>-4</sup>
	16%	0.59%	0.67%	16%	0.04%	16%	50%	0.58%	0.36%
EP (kg (PO <sub>4</sub> ) <sup>3-</sup> eq)	1.44x10 <sup>-2</sup>	3.72x10 <sup>-4</sup>	1.15x10 <sup>-3</sup>	5.30x10 <sup>-3</sup>	5.23x10 <sup>-4</sup>	1.82x10 <sup>-2</sup>	6.54x10 <sup>-2</sup>	3.33x10 <sup>-4</sup>	2.15x10 <sup>-2</sup>
	11%	0.29%	0.91%	4.2%	0.41%	14%	51%	0.26%	17%
POCP (kg C <sub>2</sub> H <sub>4</sub> eq)	2.69x10 <sup>-3</sup>	5.44x10 <sup>-5</sup>	1.22x10 <sup>-4</sup>	1.14x10 <sup>-3</sup>	1.67x10 <sup>-5</sup>	2.82x10 <sup>-3</sup>	7.27x10 <sup>-3</sup>	5.10x10 <sup>-5</sup>	7.73x10 <sup>-4</sup>
	18%	0.36%	0.82%	7.6%	0.11%	19%	49%	0.34%	5.2%
ADPE (kg Sb eq)	1.84x10 <sup>-6</sup>	4.10x10 <sup>-10</sup>	4.17x10 <sup>-9</sup>	1.72x10 <sup>-9</sup>	1.20x10 <sup>-11</sup>	6.01x10 <sup>-8</sup>	2.77x10 <sup>-6</sup>	9.02x10 <sup>-11</sup>	4.00x10 <sup>-10</sup>
	39%	0.01%	0.09%	0.04%	0.00%	1.3%	59%	0.00%	0.01%
ADPF (MJ eq)	237	5.89	6.35	35.6	0.309	198	439	4.51	2.38
	26%	0.63%	0.68%	3.8%	0.03%	21%	47%	0.49%	0.26%
<b>TRACI 2.1</b>									
GWP (kg CO <sub>2</sub> eq)	10.7	0.398	0.494	2.60	7.64x10 <sup>-2</sup>	9.44	26.8	0.330	3.26
	20%	0.74%	0.91%	4.8%	0.14%	17%	50%	0.61%	6.0%
ODP (kg CFC-11 eq)	3.49x10 <sup>-6</sup>	9.31x10 <sup>-8</sup>	5.01x10 <sup>-8</sup>	5.79x10 <sup>-7</sup>	5.05x10 <sup>-9</sup>	6.81x10 <sup>-7</sup>	6.49x10 <sup>-6</sup>	7.66x10 <sup>-8</sup>	3.05x10 <sup>-8</sup>
	30%	0.81%	0.44%	5.0%	0.04%	5.9%	56%	0.67%	0.27%
AP (kg SO <sub>2</sub> eq)	4.26x10 <sup>-2</sup>	1.83x10 <sup>-3</sup>	2.02x10 <sup>-3</sup>	4.53x10 <sup>-2</sup>	1.47x10 <sup>-4</sup>	4.44x10 <sup>-2</sup>	0.145	1.91x10 <sup>-3</sup>	2.74x10 <sup>-3</sup>
	15%	0.64%	0.71%	16%	0.05%	16%	51%	0.67%	0.96%
EP (kg N eq)	2.84x10 <sup>-2</sup>	4.66x10 <sup>-4</sup>	2.33x10 <sup>-3</sup>	3.56x10 <sup>-3</sup>	1.40x10 <sup>-3</sup>	3.68x10 <sup>-2</sup>	0.142	2.50x10 <sup>-4</sup>	5.80x10 <sup>-2</sup>
	10%	0.17%	0.86%	1.3%	0.51%	13%	52%	0.09%	21%
SFP (kg O <sub>3</sub> eq)	0.532	4.37x10 <sup>-2</sup>	3.81x10 <sup>-2</sup>	0.864	3.71x10 <sup>-3</sup>	0.507	2.33	5.39x10 <sup>-2</sup>	2.16x10 <sup>-2</sup>
	12%	0.99%	0.87%	20%	0.08%	12%	53%	1.2%	0.49%
FFD (MJ eq)	30.1	0.792	0.603	4.88	4.30x10 <sup>-2</sup>	23.9	56.0	0.640	0.287
	26%	0.67%	0.51%	4.2%	0.04%	20%	48%	0.55%	0.24%

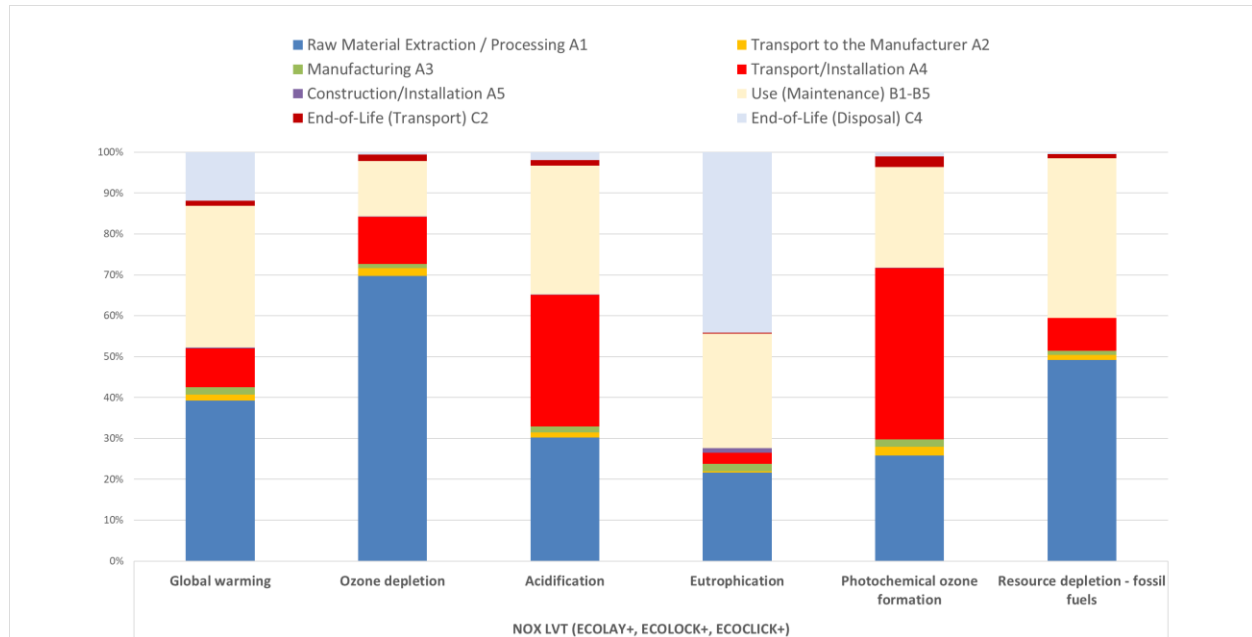
**Table 15.** Resource use and waste flows for the **Hot & Heavy Floating LVT** flooring products over a 75-yr time horizon. Results reported in MJ are calculated using lower heating values. All values are rounded to three significant digits.

Parameter	A1	A2	A3	A4	A5	B2	B4	C2	C4
<b>Resources</b>									
RPR <sub>E</sub> (MJ)	9.98	6.54x10 <sup>-2</sup>	10.5	0.313	2.42x10 <sup>-3</sup>	19.5	31.5	1.66x10 <sup>-2</sup>	9.07x10 <sup>-2</sup>
	14%	0.09%	15%	0.43%	0.00%	27%	44%	0.02%	0.13%
RPR <sub>M</sub> (MJ)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
NRPR <sub>E</sub> (MJ)	INA	INA	INA	INA	INA	INA	INA	INA	INA
NRPR <sub>M</sub> (MJ)	INA	INA	INA	INA	INA	INA	INA	INA	INA
SM (kg)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
RSF/NRSF (MJ)	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.
RE (MJ)	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.
FW (m <sup>3</sup> )	0.682	4.28x10 <sup>-3</sup>	4.13x10 <sup>-2</sup>	1.95x10 <sup>-2</sup>	2.05x10 <sup>-4</sup>	1.58	1.13	1.48x10 <sup>-3</sup>	5.16x10 <sup>-3</sup>
	20%	0.12%	1.2%	0.56%	0.01%	46%	33%	0.04%	0.15%
<b>Wastes</b>									
HWD (kg)	1.27x10 <sup>-4</sup>	1.57x10 <sup>-5</sup>	9.35x10 <sup>-6</sup>	6.29x10 <sup>-5</sup>	7.79x10 <sup>-7</sup>	1.09x10 <sup>-4</sup>	3.54x10 <sup>-4</sup>	1.23x10 <sup>-5</sup>	7.17x10 <sup>-6</sup>
	18%	2.3%	1.3%	9.0%	0.11%	16%	51%	1.8%	1.0%
NHWD (kg)	0.958	0.282	6.42x10 <sup>-2</sup>	0.868	0.191	0.863	15.7	2.14x10 <sup>-2</sup>	8.11
	3.5%	1.0%	0.24%	3.2%	0.70%	3.2%	58%	0.08%	30%
HLRW (kg)	3.86x10 <sup>-5</sup>	3.21x10 <sup>-7</sup>	8.60x10 <sup>-6</sup>	1.40x10 <sup>-6</sup>	1.22x10 <sup>-8</sup>	3.95x10 <sup>-5</sup>	7.43x10 <sup>-5</sup>	7.61x10 <sup>-8</sup>	5.18x10 <sup>-7</sup>
	24%	0.20%	5.3%	0.86%	0.01%	24%	45%	0.05%	0.32%
ILLRW (kg)	2.54x10 <sup>-4</sup>	3.89x10 <sup>-5</sup>	2.44x10 <sup>-5</sup>	2.42x10 <sup>-4</sup>	2.10x10 <sup>-6</sup>	2.00x10 <sup>-4</sup>	9.11x10 <sup>-4</sup>	3.21x10 <sup>-5</sup>	1.30x10 <sup>-5</sup>
	15%	2.3%	1.4%	14%	0.12%	12%	53%	1.9%	0.76%
CRU (kg)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
MR (kg)	0.00	0.00	0.00	0.00	0.218	0.00	0.327	0.00	0.00
	0.00%	0.00%	0.00%	0.00%	40%	0.00%	60%	0.00%	0.00%
MER (kg)	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.
EE (MJ)	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.	Neg.

INA = Indicator not assessed | Neg. = Negligible

## 6. LCA: Interpretation

The contributions to total impact indicator results are dominated by the product replacement phase (B4) of the assessment. Of the remaining life cycle phases, with the exception of the Ozone Depletion Potential indicator, the product use and maintenance phase (B2) is the largest contributor to overall impacts followed by the raw material extraction and processing (A1) and product distribution (A5) phases. Other life cycle phase contributions are minimal.



**Figure 2.** Contribution analysis for the *Hot & Heavy Floating LVT* flooring products –TRACI 2.1. (excluding product replacements).

## 7. Additional Environmental Information

### 7.1 ENVIRONMENT AND HEALTH DURING MANUFACTURING

The manufacturing facility is certified to ISO 9001 and ISO 14001 – Environmental management systems.

### 7.2 ENVIRONMENT AND HEALTH DURING INSTALLATION

The LVT flooring products meet the requirements of the following:

- CDPH/EHLB Standard Method v1.2-2017 (California Section 01350)

### 7.3 ENVIRONMENTAL ACTIVITIES AND CERTIFICATIONS

For more information on Mohawk certifications and environmental initiatives please view the website at <https://www.mohawkgroup.com/>.

## 8. References

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