

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

C-PCR-030 (TO PCR 2019:14)
VERSION 1.0.0

VALID UNTIL: 2029-06-20



ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

TABLE OF CONTENTS

1	Introduction.....	3
1.1	General.....	3
1.2	Role of this document.....	4
2	General information	5
2.1	Administrative information	5
2.2	Scope	6
3	PCR review and background information.....	7
3.1	Open consultation.....	7
3.2	PCR review	7
3.3	Existing PCRs for the product category	7
3.4	Reasoning for development of c-PCR	8
3.5	Underlying studies used for c-PCR development.....	8
4	Goal and scope, life cycle inventory and life cycle impact assessment	9
4.1	Functional unit or declared Unit.....	9
4.2	System boundaries	10
4.3	System diagram	12
4.4	Cut-off rules.....	12
4.5	Allocation rules.....	12
4.6	Data quality requirements	12
4.7	Environmental performance indicators.....	12
4.8	Including multiple products in the same EPD	12
5	Content and format of EPD	13
5.1	EPD language.....	13
5.2	Unit and quantities.....	13
5.3	Use of images in EPD.....	13
5.4	EPD reporting format.....	13
6	List of abbreviations	14
7	References.....	15
8	Version history of c-PCR.....	16

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

1 INTRODUCTION

1.1 GENERAL

This document constitutes complementary Product Category Rules (c-PCR) for developing Environmental Product Declarations (EPD) in the framework of the International EPD System: a programme for EPDs¹ according to ISO 14025, ISO 14040, ISO 14044, and product-specific standards, such as EN 15804, EN 15941 and ISO 21930 for construction products.² developed in the framework of the International EPD System: a programme for type III environmental declarations³ according to ISO 14025:2006. EPDs are voluntary documents for a company or an industry association to present transparent, consistent, and verifiable information about the environmental performance of their products (goods or services).

The General Programme Instructions (GPI), publicly available on www.environdec.com, includes the rules for the overall administration and operation of the programme and the basic rules for developing EPDs registered in the programme. A PCR complements the GPI and the normative standards by providing specific rules and guidelines for developing an EPD for one or more specific product categories (see Figure 1), thereby enabling the generation of consistent EPDs within a product category.

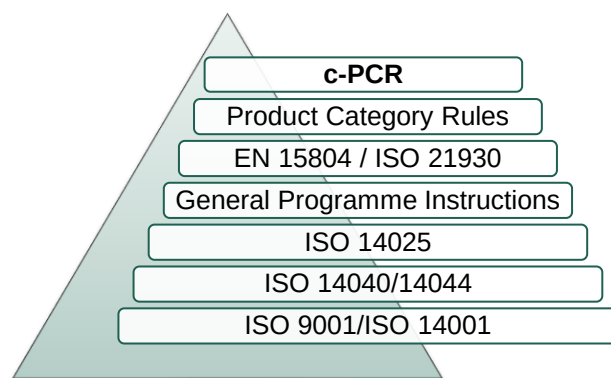


Figure 1. This c-PCR in relation to the hierarchy of standards and other documents.

The present c-PCR uses the following terminology:

- The term “shall” is used to indicate what is obligatory, i.e., a requirement.
- The term “should” is used to indicate a recommendation. Any deviation from a recommendation shall be justified in the EPD development process.
- The terms “may” or “can” are used to indicate an option that is permissible.

For definitions of other terms used in the document, see the GPI, normative standards, and PCR 2019:14 Construction products.

The latest version of the PCR is available on www.environdec.com.

Any references to this PCR shall include the PCR registration number, name, and version number.

Stakeholder feedback on PCRs is very much encouraged. Any comments on this PCR document may be sent directly to the PCR Moderator during its development or during the period of validity.

The programme operator maintains the copyright of the document to ensure that it is possible to publish, update when necessary, and available to all organisations to develop and register EPDs. Stakeholders participating in PCR development should be acknowledged in the final document and on the website.

1 Termed type III environmental declarations in ISO 14025.

2 When standards are referred to in this document, the version listed in Section 7 is intended unless otherwise stated.

3 Type III environmental declarations in the International EPD System are referred to as EPD, Environmental Product Declarations.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

1.2 ROLE OF THIS DOCUMENT

This document provides complementary product category rules (c-PCR) to PCR 2019:14 Construction products, available on www.environdec.com. This document cannot be used by itself but shall be used together with PCR 2019:14 and EN 15804. The document can be used together with any valid version of PCR 2019:14, regardless of the version of PCR 2019:14 referred to in this document.

See Figure 2 for an illustration on how PCR 2019:14 and this c-PCR relates to each other and the EPDs that may be based on them.

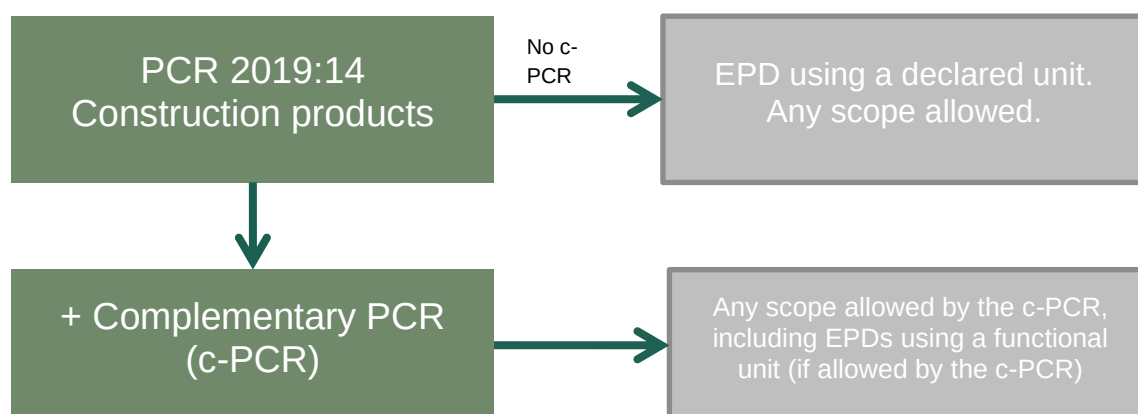


Figure 2. Overview of using PCR 2019:14 directly to develop an EPD or how to use it together with a c-PCR.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

2 GENERAL INFORMATION

2.1 ADMINISTRATIVE INFORMATION

Name:	Abrasive products
Registration number and version:	c-PCR-030, version 1.0.0
Programme:	 INTERNATIONAL EPD SYSTEM
Programme operator:	EPD International AB, Box 210 60, SE-100 31 Stockholm, Sweden Website: www.environdec.com E-mail: support@environdec.com
PCR Moderator:	Eva Knüpffer, Nora Siepker, Ramboll Deutschland GmbH, eva.knuepffer@ramboll.com
PCR Committee:	Ramboll Deutschland GmbH, 3M Company - Abrasive Systems Division (ASD), August Rüggeberg GmbH & Co. KG, Federation of European Producers of Abrasives (FEPA), Federchimica (Italian Federation of the Chemical Industry), Hermes Schleifmittel GmbH, Hilti Deutschland AG, Imerys S.A., Klingspor AG, Lukas-Erzett GmbH & Co. KG, Mirka Ltd., Ramboll Deutschland GmbH, Roxor Abrasives B.V., Saint-Gobain Abrasifs S.A., SAIT Abrasivi SPA, Starcke Schleifmittelwerk GmbH & Co KG, Tyrolit Schleifmittelwerke Swarovski KG, Verband Deutscher Schleifmittelwerke e.V. (German Abrasive Association), VSM Vereinigte Schmirgel- und Maschinen-Fabriken AG, Weiler Abrasives GmbH, EA Consulting
Date of publication and last revision:	2025-04-23 (version 1.0.0) See Section 8 for a version history of the c-PCR.
Valid until:	2029-06-20
Schedule for renewal:	This document will be revised upon its expiration. In case a c-PCR is developed by a CEN Product TC, the standard will replace this c-PCR with a transition period of 90 days.
Standards conformance:	For compliance to standards and other documents, see PCR 2019:14. Although sometimes used in construction, abrasive products are not construction products even though it follows the basic concept of the construction sector standards.
PCR language(s):	This PCR was developed and is available in English. In case of translated versions, the English version takes precedence in case of any discrepancies.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

2.2 SCOPE

2.2.1 PRODUCT CATEGORY DEFINITION AND DESCRIPTION

This c-PCR serves the assessment of the environmental performance of abrasive products and the declaration of this performance by an EPD. Please note that only finished products are concerned. The product category is represented by products under two UN CPC classifications:

- Class 3791 - millstones, grindstones, grinding wheels and the like, without frameworks, for working stones, and parts thereof, of natural stone, of agglomerated natural or artificial abrasives, or of ceramics; natural or artificial abrasive powder or grain, on a base of textile, paper or other material
- Subclass 35333 - polishes and creams, for footwear, furniture, floors, coachwork, glass or metal

For further information, check <https://unstats.un.org/unsd/classifications/Family/Detail/1074> and [https://unstats.un.org/unsd/classifications/Econ/Download/In%20Text/CPCv2.1_complete\(PDF\)_English.pdf](https://unstats.un.org/unsd/classifications/Econ/Download/In%20Text/CPCv2.1_complete(PDF)_English.pdf).

If an EPD for a product under these classifications shall be created according to this c-PCR, the main purpose of the product shall correspond to one of the following functions:

- Grinding: Removing material of a surface in its most general sense by use of an abrasive product and with a relatively high material removal rate.
- Cutting: Creating a new surface *on* a workpiece (more precisely: two new surfaces on both sides of the cut) where the abrasive is applied to as the cutting edge. Unlike grinding, the purpose of cutting is the creation of the new surface area and not the removal of material.
- Drilling: Creating a mainly circular shaped void *within* a workpiece. The purpose is the shape and volume of the void and not the removal of material.
- Surface conditioning: Modifying the surface properties of the workpiece i.e., a removal of ridges, without a significant change of dimension or shape.

Other products that are not included in the above UN CPC classifications but have one of the mentioned functions can also use this c-PCR. For those cases, the moderator of this c-PCR or the Secretariat shall be contacted to check and confirm the applicability of this c-PCR for the requested product. The use of the c-PCR can only be approved if the product is not covered by another c-PCR (existing or under development) of the International EPD System.

2.2.2 TYPE OF EPD AND INFORMATION MODULES INCLUDED

Following the requirements in PCR 2019:14, an EPD based on this c-PCR shall be a type “c” (“cradle to grave and module D”) EPD, including modules A1-A5, B1-B7, C1-C4 and D.

Section 4.2 below provide more information on each life-cycle stage concerning the product category in scope.

2.2.3 GEOGRAPHICAL SCOPE

This c-PCR may be used globally.

2.2.4 EPD VALIDITY

See PCR 2019:14.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

3 PCR REVIEW AND BACKGROUND INFORMATION

This c-PCR was developed in accordance with the PCR development process described in the GPI of the International EPD System, including open consultation and review.

3.1 OPEN CONSULTATION

3.1.1 VERSION 2024-06-18

This c-PCR was available for open consultation from 2023-11-24 until 2024-01-24, during which any stakeholder was able to provide comments by contacting the PCR Moderator and/or the Secretariat.

Stakeholders were invited via e-mail or other means to take part in the open consultation and were encouraged to forward the invitation to other relevant stakeholders. The following stakeholder provided comments during the open consultation and agreed to be listed as contributor in the c-PCR and at www.environdec.com:

- Verband Deutscher Schleifmittelwerke e.V. VDS

3.2 PCR REVIEW

3.2.1 VERSION 2026-06-18

PCR review panel:	The Technical Committee of the International EPD System. A full list of members is available at www.environdec.com . The review panel may be contacted via info@environdec.com . Members of the Technical Committee were requested to state any potential conflict of interest with the PCR Committee, and if there were conflicts of interest they were excused from the review.
Chair of the PCR review:	Diogo Aparecido Lopes Silva
Review dates:	2024-03-12 until 2024-04-04

3.3 EXISTING PCRS FOR THE PRODUCT CATEGORY

As part of the development of this c-PCR, existing PCRs/c-PCRs and other internationally standardised methods that could potentially act as c-PCRs were considered to avoid unnecessary overlaps in scope and to ensure harmonisation with established methods of relevance for the product category. The existence of such documents was checked among the following EPD programmes and international standardisation bodies:

- International EPD System, www.environdec.com
- IBU Institut Bauen und Umwelt e.V., www.ibu-epd.com
- EPD Norge, www.epd-norge.no
- UL Environment, www.UL.com
- PEP Ecopassport, www.pep-ecopassport.org
- NSF, <https://www.nsf.org/standards-development/product-category-rules>

Table 1 lists the identified PCRs and other standardised methods.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

Table 1 Existing PCRs/c-PCRs and other internationally standardized methods that were considered to avoid overlap in scope and to ensure harmonisation with established methods.

NAME OF PCR/c-PCR/STANDARD	PROGRAMME/STANDARDISATION BODY	REGISTRATION NUMBER, VERSION NUMBER/DATE OF PUBLICATION	SCOPE
Graphite products	EPD International	PCR 2023:02, Version 1.0.1 (2023-04-27)	Also UN CPC group 379, but different class (graphite products, class 3795). No overlap with abrasive products of this c-PCR (class 3791).

3.4 REASONING FOR DEVELOPMENT OF C-PCR

This c-PCR was developed to provide requirements and guidelines additional to those in PCR 2019:14 and EN 15804, for developing EPDs for the product category. The c-PCR thereby enables different practitioners to generate consistent results when assessing the environmental impact of products of the same product category, and thereby it supports comparability of products within a product category.

3.5 UNDERLYING STUDIES USED FOR C-PCR DEVELOPMENT

The methodological choices made during the development of this c-PCR (declared/functional unit, system boundary, allocation methods, impact categories, data quality rules, etc.) were primarily based on the following underlying studies (not publicly available):

- Ramboll (2023): LCA study on Grinding with a fiber disc. Not published
- Ramboll (2023): Grinding with a refurbished steel disc. Not published
- Ramboll (2023): Surface conditioning with a polishing product. Not published
- Ramboll (2023): Drilling with an abrasive material. Not published
- Ramboll (2023): Cutting with a cut off wheel. Not published

Major findings relevant for this PCR from the LCA studies listed above are:

- Raw material extraction is a significant contributor to the climate change impact category.
- Product manufacturing had relevant impact in some studies.
- Energy consumption in the use stage can be a relevant contributor.
- Module B6 is relevant if abrasive products can be refurbished.
- Modules B1-B4 and B7 were not relevant.
- Transport had relevant impact in some studies.
- Refurbishing leads to reduction of emissions in Module A3.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

4 GOAL AND SCOPE, LIFE CYCLE INVENTORY AND LIFE CYCLE IMPACT ASSESSMENT

This section provides specific rules, requirements, and guidelines for developing an EPD for the product category as defined in [Section 2.2.1](#).

4.1 FUNCTIONAL UNIT OR DECLARED UNIT

The functional unit should be used an EPD is developed. If the use stage is unknown or there are numerous use stages, a declared unit may be used. The declared unit shall relate to the typical applications of products. The declared unit is independent of the function of the product.

For each of the functions described in Section 2.2.1, the associated functional unit from below shall be used for the EPD.

- Grinding: The removal of 1 kg of material from the workpiece.
- Cutting: The creation of a new surface of 1 m² on the workpiece (considering both newly created areas) by removal of material.
- Drilling: The creation of a void of 1 dm³ within the workpiece by removal of material.
- Surface conditioning: The modification of the properties of 1 m² existing surface without significantly changing its initial shape. Note: Measurements should be performed before and after the product application, i.e., for roughness or gloss. If such measurements are not meaningful for this application, the surface condition before and after the application shall be described in detail. Photos are suggested as a useful addition to this description.

The declared unit in the EPD shall be declared applying one of the unit types listed below. A different unit may be declared for reasons that shall be explained in the EPD. In such cases, information shall be provided on how to convert this unit to one or more of the required unit types.

One unit of product as specified at gate (leaving modules A1-A3):

- An item (piece), an assemblage of items, e.g., 1 grinding wheel, 1 cutting disc, 1 coated sheet or belt (dimensions shall be specified).
- Mass (kg), e.g., 1 kg of polishing paste.
- Length (m), e.g., 1 m of cutting wire (dimensions shall be specified).
- Area (m²), e.g., 1 m² of unconverted coated abrasive "jumbo" (dimensions shall be specified).
- Volume (L), e.g., 1 L of liquid polishing paste.

For any product, the assessment of the technical performance (i.e., the measurement and/or calculation of performance characteristics of the product) is based on operation in the product's optimal application setting. This optimal application setting is the foundation for the use stage scenario description. It shall also be stated in the EPD providing there is enough information for a third party to replicate and contain at minimum the following information (if applicable for the particular product):

- Type of tool or machinery used (electrical battery, electrical corded, high frequency, gasoline, pneumatic, alkylate, etc.).
- Power classification of the machinery used (kW, etc.).
- Rotation (or applicable) speed of the product (m/s, RPM, etc.).
- Other application parameters that are required to reproduce the application, e.g. angle, force/pressure, feed/feedspeed (°, N, N/m², etc.).
- Type and consumption quantities of auxiliary materials such as lubricants or cooling agents (water, oil, air, etc. and volume).
- Type of workpiece the abrasive is used on. Specify the shape, dimensions, properties and the material of the workpiece e.g. stainless steel 304 plate, 100 mm x 6 mm, 44 HRC.

On top of the product unit selected, corresponding product packaging shall be added.

As the functional unit is not expressed as a function provided during a set time period it is not relevant to define a Reference Service Life (RSL). However, every time a functional unit is used in the EPD, a Technical Service Life for the product shall be

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

calculated and presented. The Technical Service Life for abrasives is not time-based, but is directly related to the functional unit and expresses how much abrasives were necessary to provide the service described by the functional unit. The Technical Service Life should be based on performance conditions specified above as well as documented in the EPD which will include a clearly defined use scenario. Indeed, the Technical Service Life is intrinsically linked with the use stage and the application settings mentioned above. For example, the force applied during grinding, presence of lubricant in surface conditioning, the machine power in cutting, or the rotational speed in drilling. The typical Technical Service Life for grinding, for example, would be expressed as the number of abrasive products necessary to remove 1 kg of material on the workpiece of the defined use scenario (e.g., 3 grinding wheels), and the Technical Service Life for surface conditioning would be as well the number of abrasive products necessary to modify the properties of 1 m² of initial surface without changing its initial shape (e.g., 4 non-woven discs). Note that the Technical Service Life is not necessary a whole number and can have decimals (e.g., 1.7 belts).

4.2 SYSTEM BOUNDARIES

In deviation to the definitions given in EN 15804, names of information modules and lifecycle stages shall be amended to the context of abrasive products (in contrast to construction products). These amendments are provided in Table 2.

Table 2. EN 15804 nomenclature adaptations for abrasive products.

Nomenclature in EN 15804	Nomenclature for abrasive products, as used in this c-PCR
Construction process stage (A4-A5)	Distribution and setup stage (A4-A5)
Installation (A5)	Setup (A5)
Deconstruction (C1)	Disassembly (C1)

EPDs based on this c-PCR shall be of type “c” and cover product stage (A1-A3), distribution and setup stage (A4-A5), use stage (B1-B7), end-of-life stage (C1-C4) as well as benefits and loads beyond the system boundary (D).

The following modules are not applicable for abrasive products and shall hence not be declared: B2 Maintenance, B3 Repair or B4 Replacement. All actual, technical possibilities to reset an abrasive from a non-functional to a functional state, for example through a recoating of a carrier material, is covered by the following definition of module B5 Refurbishment:

The module “refurbishment” covers the combination of all technical and associated administrative actions during the service life of a product associated with the return [...] to a condition in which it can perform its required functions. These activities cover a concerted programme of maintenance, repair and/or replacement activity [...]. Restoration activities should be included within refurbishment.

[see section 6.3.5.4.2 of EN 15804]

Table 3 summarizes the modules that are required for an EPD of abrasive products.

Table 3. Life-cycle stages to be covered in the EPD.

Life cycle stage	Information module		c EPD
A1-A3 Product stage	A1	Raw material supply	Included
	A2	Transport	Included
	A3	Manufacturing	Included
A4-A5 Distribution and Setup stage	A4	Distribution	Included
	A5	Setup	Included
B1-B7 Use stage	B1	Use	Included
	B2	Maintenance	Excluded, not applicable for abrasive products
	B3	Repair	Excluded, not applicable for abrasive products
	B4	Replacement	Excluded, not applicable for abrasive products
	B5	Refurbishment	Included
	B6	Operational energy use	Included

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

	B7	Operational water use	Included
C1-C4 End-of-life stage	C1	Disassembly	Included
	C2	Transport	Included
	C3	Waste processing	Included
	C4	Waste disposal	Included
D Benefits and loads beyond the system boundary (optional)	D	Reuse, recovery, recycling, potential	Included

The following subsections describe the covered information modules and the respective processes. For detailed information on each module, see EN 15804 (Section 6.3.5). Here, only specific descriptions related to this c-PCR are provided.

4.2.1 PRODUCT STAGE: MODULES A1-A3

In general, see PCR 2019:14 and Section 6.3.5.2 of EN 15804. Special attention shall be paid to the packaging materials of the raw materials (A1), their respective transports (A2) and end-of-life treatment in manufacturing waste (A3) as they can have relevant impact.

4.2.2 DISTRIBUTION AND SETUP STAGE: MODULES A4-A5

See PCR 2019:14 and Section 6.3.5.3 of EN 15804 where the rules for module A4 and A5 Installation shall be applied on module A5 Setup.

Module A5 Setup includes all efforts needed to prepare the product to ensure the correct use of the abrasive (e.g., mounting, truing and dressing). This specifically includes the waste handling of the packaging material (incl. potential for module D) and the production and transportation of potential auxiliary products required before the first use.

4.2.3 USE STAGE: MODULES B1-B7

See PCR 2019:14 and Section 6.3.5.4 of EN 15804.

The use of consumables (oil, lubricant, coolant, etc.) shall be included in module B1 Use, if relevant.

If such consumables are required during use but can be used significantly longer than just for one fulfilment of the functional unit, they may be omitted based on the cut-off rules (see Section 4.4). This shall be clearly documented and justified in the EPD.

Module B6 Operational energy use shall include consumables (fuel, etc.).

Module B7 Operational water use shall include the wastewater treatment based on the geographic region where the product is used. If different wastewater treatments are obligatory due to applicable regulations (for example for highly specialised abrasive products that are only used in regulated, industrial settings), these treatment methods shall be included instead.

4.2.4 END-OF-LIFE (EOL) STAGE: MODULES C1-C4

See PCR 2019:14 and Section 6.3.5.5 of EN 15804. In addition, the end-of-life stage shall be based on current waste handling systems in the geographic region where the product is expected to be disposed according to the geographical scope of the EPD. The used scenario shall be clearly documented and justified in the EPD, describing the adopted method for waste handling, for example recycling, incineration and/or landfill.

If applicable, module C1 Disassembly shall include all energy and auxiliary consumption required to remove the abrasive product from the machinery and until the machinery is ready for the setup of the next abrasive product.

4.2.5 BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARY: MODULE D

See PCR 2019:14 and Section 6.4.3.3 of EN 15804.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

4.2.6 OTHER BOUNDARY SETTING

See PCR 2019:14 and EN 15804.

4.3 SYSTEM DIAGRAM

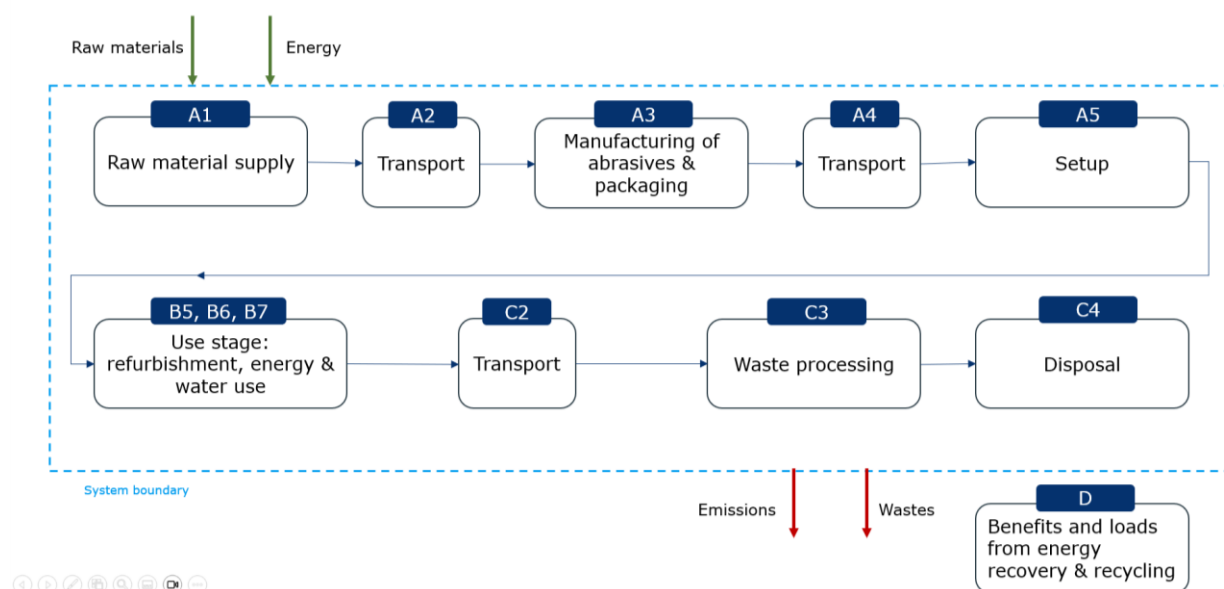


Figure 3. System diagram illustrating the processes that are included in the product system, divided into life-cycle stages and information modules.

4.4 CUT-OFF RULES

See PCR 2019:14 and EN 15804.

4.5 ALLOCATION RULES

See PCR 2019:14 and EN 15804.

4.6 DATA QUALITY REQUIREMENTS

See PCR 2019:14 and EN 15804.

4.7 ENVIRONMENTAL PERFORMANCE INDICATORS

See PCR 2019:14 and EN 15804.

4.8 INCLUDING MULTIPLE PRODUCTS IN THE SAME EPD

See PCR 2019:14.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

5 CONTENT AND FORMAT OF EPD

See PCR 2019:14.

5.1 EPD LANGUAGE

See PCR 2019:14.

5.2 UNIT AND QUANTITIES

See PCR 2019:14.

5.3 USE OF IMAGES IN EPD

See PCR 2019:14.

5.4 EPD REPORTING FORMAT

See PCR 2019:14.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

6 LIST OF ABBREVIATIONS

In addition to abbreviations listed in PCR 2019:14:

dm ³	cubic decimetre
kW	kilowatt
m/s	meter per second
RPM	rotations per minute
N	Newton
N/m ²	Newton per square meter
HRC	Rockwell

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

7 REFERENCES

CEN (2021) EN 15804:2012+A2:2019/AC:2021, Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products.

EPD International (2023) PCR 2023:02 Graphite products, version 1.0.1. www.environdec.com.

EPD International (2025) General Programme Instructions of the International EPD System. Version 5.0.1, dated 2025-02-27. www.environdec.com.

EPD International (2025) PCR 2019:14 Construction products, version 2.0.0. www.environdec.com.

ISO (2006a) ISO 14025:2006, Environmental labels and declarations – Type III environmental declarations – Principles and procedures.

ISO (2006b) ISO 14040:2006, Environmental management – Life cycle assessment – Principles and framework.

ISO (2006c) ISO 14044: 2006, Environmental management – Life cycle assessment – Requirements and guidelines.

ISO (2017) ISO 21930:2017, Sustainability in buildings and civil engineering works -- Core rules for environmental product declarations of construction products and services.

Ramboll (2023) LCA study on Grinding with a fiber disc. Not published.

Ramboll (2023) Grinding with a refurbished steel disc. Not published.

Ramboll (2023) Surface conditioning with a polishing product. Not published.

Ramboll (2023) Drilling with an abrasive material. Not published.

Ramboll (2023) Cutting with a cut off wheel. Not published.

United Nations Statistics Division (2015) Central Product Classification (CPC) Version 2.1. <https://unstats.un.org/unsd/classifications/Econ/cpc>, accessed 2024-05-15.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

8 VERSION HISTORY OF C-PCR

VERSION 2024-06-20

Original version of this c-PCR.

VERSION 1.0.0, 2025-04-24

- Updated with prolonged validity, until five years from the original publication of the c-PCR.
- Changed from version date to version number.
- Other editorial changes and clarifications, e.g., related to the use of the c-PCR (see Section 1.2).
- Removed references to specific sections of PCR 2019:14, as the sections of PCR 2019:14 changed as of the publication of version 2.0.0 in 2025-04-07 and as this c-PCR is applicable together with any version of PCR 2019:14.

ABRASIVE PRODUCTS

PRODUCT CATEGORY CLASSIFICATION: UN CPC 3791 AND 35333

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