



Building with conscience.

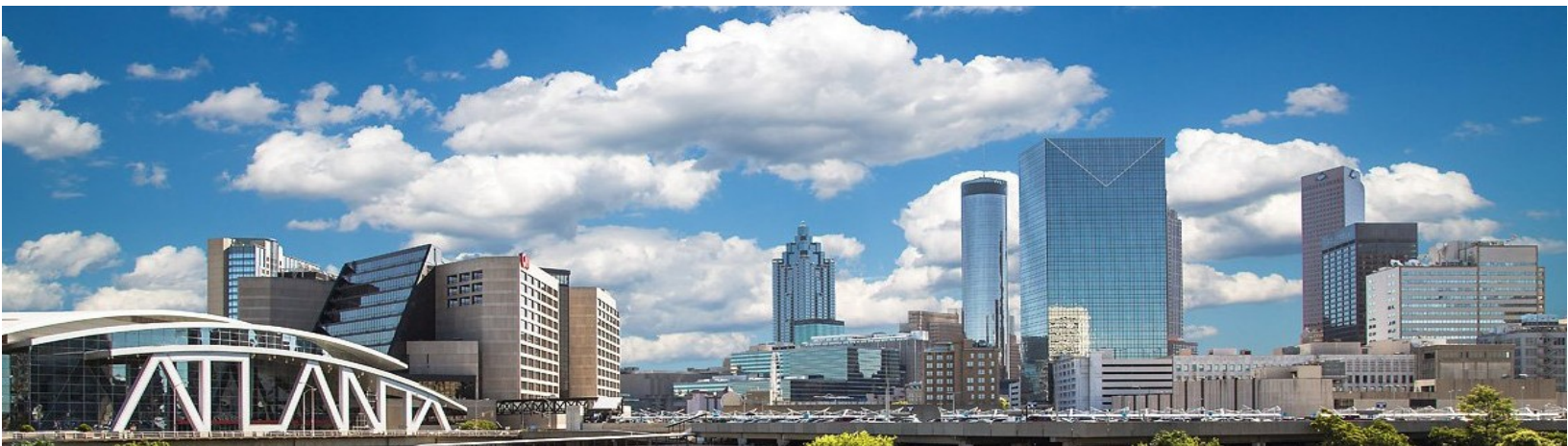




**EPD for Stolit® Lotusan®
in varied textures**

Product Textures: 1.0, 1.0 Dark,
1.5, 1.5 Dark, Freeform, Freeform
Dark.

Stolit® Lotusan® is a ready-mixed exterior textured finish that mimics the self-cleaning capabilities of the lotus leaf. Replicating the lotus plant's ability to send raindrops rolling gently off its leaves, Stolit® Lotusan® resists dirt pick-up while keeping walls clean and attractive. Stolit® Lotusan® with Lotus-Effect™ technology is designed for use as a finish coat over prepared vertical concrete, masonry or plaster substrates and in StoTherm™ ci Lotusan® wall claddings.





PCR Identification	PCR for Architectural Coatings: NAICS 325510 on the basis of ISO 21930: 2007, NSF International, 2017. Valid through June 23, 2022
Compliance to to ISO 14040/44, ISO 14025 and ISO 21930	Yes
Product Category	Exterior Coating
Manufacturer's name	Sto Corp. 3800 Camp Creek Parkway SW, Building 1400, Suite 120 Atlanta, GA 30331 www.stocorp.com (800) 221-2397
EPD program operator	Epsten Group 101 Marietta St. Suite 2600, Atlanta, GA 30303 www.epstengroup.com
Declaration Number	01-002
Date of Certification	December 18 th , 2019
Period of Validity	5 years from date of certification
Functional Unit	One square meter of covered and protected substrate for 60 years
Market-base life used in assessment	10 Years
Design life used in assessment	5 Years
Test method employed for determination of design life	Product default warranty
Amount of colorant needed	See Table 3
Overall Data Quality Assessment Score	Good
Site(s) in which the results of the LCA are representative	STO manufacturing sites in Atlanta, Georgia; Glendale, Arizona; and Rutland, Vermont
Information on where explanatory material can be obtained	See references at the end of this document.
LCA Software and Version Number	GaBi 9.2.0.58
LCI Database and Version Number	GaBi Database Version 8.7, Service Pack 39
This declaration was independently verified in accordance with ISO 14025: 2006 and the reference PCR: PCR for Architectural Coatings: NAICS 325510	Kate McFeaters kmcfeaters@epstengroup.com 
<input type="checkbox"/> Internal <input checked="" type="checkbox"/> External	
This life cycle assessment was conducted in accordance with ISO 14044 and the reference PCR by:	WAP Sustainability Consulting, LLC
This life cycle assessment was independently verified in accordance with ISO 14044 and the reference PCR by:	Kate McFeaters kmcfeaters@epstengroup.com 

Comparability

In order to support comparative assertions, this EPD meets all comparability requirements stated in ISO 14025:2006. However, differences in certain assumptions, data quality, and variability between LCA data sets may still exist. As such, caution should be exercised when evaluating EPDs from different manufacturers, as the EPD results may not be entirely comparable. Any EPD comparison must be carried out at the building level per ISO 21930 guidelines. The results of this EPD reflect an average performance by the product and its actual impacts may vary on a case-to-case basis.

» Company

We believe in ‘**Building with conscience**’.

That means ensuring that all building products are not only safe, effective and easy to install, but also environmentally responsible and sustainable. We know you’re always looking for the smartest and newest technology to create energy efficient buildings with superior aesthetics.

That’s exactly what our products help you achieve. Products like our wall systems, coatings and finishes are consistent favorites among design professionals, contractors and property owners alike. Whatever your needs or vision may be, we offer products for every type of building project; whether it’s new construction, restoration or panelization, commercial or residential work.

An architect or specifier focuses on aesthetics and feasibility, a contractor needs products that are easy to work with, and a building owner requires high value and low costs on properties. Sto understands these unique needs, and delivers the smart, innovative materials and solutions that make this all possible. That’s why Sto remains the innovative leader in integrated exterior wall systems.

When you combine that commitment to product support and innovation with value-added offerings like consultative design and color services through [Sto Studio](#) or training in proper application techniques through the Sto Institute, you get an integrated exterior wall system solution unmatched in the industry.

» Manufacturing Sites Covered in this EPD

Atlanta Plant

Glendale Plant

Rutland Plant

» Product Identification

Stolit® Lotusan® finishes are offered in various coarseness and color bases that allow more freedom in building exterior designing and finishing. Table 1 lists the products declared in this EPD.

Table 1: List of Stolit® Lotusan® Products

Product Name	Product Number	Base Type	Finish Type
Stolit® Lotusan® 1.0	80190	Tintable White	Fine
Stolit® Lotusan® 1.0 Dark Colors	82190	Deep	Fine
Stolit® Lotusan® 1.5	80191	Tintable White	Medium
Stolit® Lotusan® 1.5 Dark Colors	82191	Deep	Medium
Stolit® Lotusan® Freeform	80193	Tintable White	Freeform
Stolit® Lotusan® Freeform Dark Colors	82193	Deep	Freeform

» Product Description

Stolit® Lotusan® is a series of ready mixed, textured wall coating with Lotus-Effect® technology that mimics the self-cleaning capabilities of the lotus leaf. Stolit® Lotusan® with Lotus-Effect® technology is designed for use as a finish coating over prepared vertical above-grade concrete, masonry or plaster substrates and in StoTherm® Lotusan® Wall Claddings including StoTherm® ci Lotusan®. In this study, Lotusan® 1.0, 1.5 and Freeform are included. Same as Stolit®, two tint bases are offered.



» Performance Features

Mildew Resistance	Ready Mixed	Moisture Resistance	Low VOC & Odor
Vapor Permeable	Integral Color	Water-based	Super Hydrophobic

» Material Composition

The material compositions of Stolit® Lotusan® are listed below:

Table 2: Material composition for Stolit® Lotusan®

	Additives	Colorant	Limestone	Acrylic resin	Silica	Silicate	Surfactant	Water
Stolit® Lotusan® 1.0 Dark Colors	4.68%	0.60%	49.26%	5.01%	21.66%	2.68%	0.05%	15.45%
Stolit® Lotusan® 1.0	4.69%	0.60%	49.24%	5.04%	21.45%	2.70%	0.05%	15.62%
Stolit® Lotusan® 1.5 Dark Colors	4.68%	0.60%	49.98%	4.99%	20.88%	2.85%	0.05%	15.37%
Stolit® Lotusan® 1.5	4.68%	0.60%	49.72%	4.98%	21.37%	2.66%	0.05%	15.35%
Stolit® Lotusan® Freeform Dark Colors	4.73%	0.64%	60.60%	5.37%	8.37%	2.87%	0.11%	16.56%
Stolit® Lotusan® Freeform	4.73%	0.64%	60.06%	5.36%	8.36%	2.87%	0.13%	17.10%

» Components related to Life Cycle Assessment

The functional unit for the LCA study was covering and protecting 1 square meter (m²) of substrate for a period of 60 years—the assumed lifetime of a building. The reference flow required for the functional unit is calculated based on the product lifespan scenarios prescribed in the PCR. The market-based lifetime is 10 years, and the design lifetime is determined either based on quality determined by ASTM tests or on the product warrant. By default, Stolit® Lotusan® finishes have a 5-year warranty. In case a finish is applied on Sto’s wall systems, the warranty is extended to 10 years. In this EPD, default warranty is adopted as the design lifetime. The reference flow required for one functional unit is provided in Table 3.

Table 3: Market-based lifetime and reference flow

	Functional Unit	Reference Flow [kg]	Tint needed* [kg]	Reference Flow [kg]	Tint needed* [kg]
Lifespan		Design Lifetime [5 years]		Market-based Lifetime [10 years]	
Stolit® Lotusan® 1.0 Dark Colors	1	29.16	2.60	14.58	1.30
Stolit® Lotusan® 1.0	1	29.16	0.77	14.58	0.38
Stolit® Lotusan® 1.5 Dark Colors	1	33.56	3.00	16.79	1.50
Stolit® Lotusan® 1.5	1	33.56	0.88	16.79	0.44
Stolit® Lotusan® Freeform Dark Colors	1	52.32	4.66	26.16	2.33
Stolit® Lotusan® Freeform	1	52.32	1.37	26.16	0.69

» **Scope and Boundaries of the Life Cycle Assessment**

The LCA was performed in accordance with ISO 14040 standards. The study is a cradle-to-grave LCA and includes the following life stages as prescribed in the PCR.

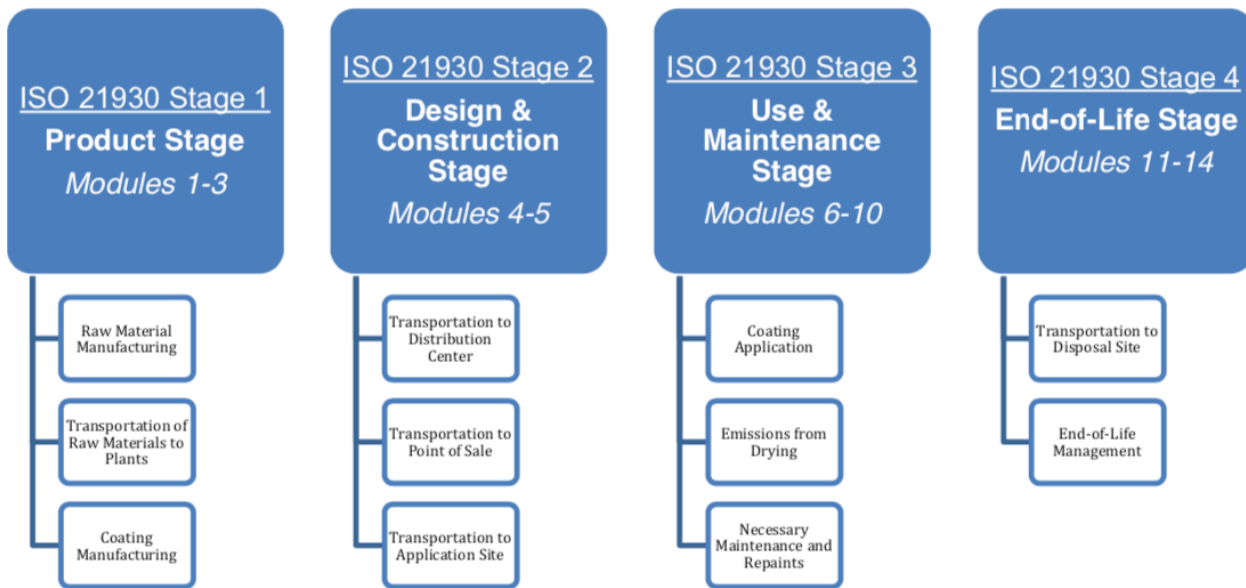


Figure 1: Life stages for the cradle-to-grave LCA

» **Cut-off Criteria**

Material inputs greater than 1% (based on total mass of the final product) were included within the scope of analysis. Material inputs less than 1% were included if sufficient data was available to warrant inclusion and/or the material input was thought to have significant environmental impact. Cumulative excluded material inputs and environmental impacts are less than 5% based on total weight of the functional unit.

» **Data Quality**

The overall data quality level was determined to be good. Primary data was collected from Sto’s one each facility in Atlanta, GA, Glendale, AZ and Rutland, VT for the 2018 reference year. When primary data did not exist, secondary data were obtained from the Gabi V8.7 Database Service Pack 39. Overall, both primary and secondary data are considered good quality in terms of geographic, temporal and technological coverage.

» **Estimates and Assumption**

Assumptions were made to represent the cradle-to-grave environmental performance of Sto’s products. These assumptions were made in accordance with the PCR and include the transportation distances, the disposal of packaging material and the product at its end of life and use phase assumptions.

» **Allocation**

General principles of allocation were based on ISO 14040/44. Where possible, allocation was avoided. When allocation was necessary it was done on a physical mass basis.

» **Product Stage**

Stolit® Lotusan® is produced at Sto’s Atlanta, GA, Glendale, AZ and Rutland, VT facilities. This stage includes an aggregation of raw material extraction, supplier processing, delivery, manufacturing and packaging by Sto. Stolit® Lotusan® is supplied in 5-gallon pails.

» **Design and Construction Stage**

The design and construction process stage starts with the packaged product leaving the production site and ends with being delivered to the application site.

During this stage, the finished product is moved from a shipping dock for distribution. The end gate is the application site after the purchaser acquires the finished product and transports it to the application site.

» **Use and Maintenance Stage**

The use stage begins when the user prepares the product before applying it to a substrate and ends with any leftover coating and discarded packaging entering the end-of-life stage. Detailed application instructions are provided online. The application procedure includes mixing and applying. As recommended, an electric drill/mixer and a spray pump are assumed to be used for mixing and application. The equipment is not included in the study as these are multi-use tools and the impacts per declared unit is considered negligible, but electricity to power application tools has been included.

As prescribed in the PCR, 10% of the wet mass of Stolit® is assumed to be unused and properly disposed of.

» **End-of-Life Stage**

Waste Flow	Recycling	Incineration	Land-filling
Paper Packaging	66.6%	6.01%	27.39%
Steel Packaging	33.3%	12.01%	54.69%
Plastic Packaging	9.1%	16.36%	74.54%
Unused Product	0%	0%	100%
Post-Consumer Product	0%	0%	100%

In this stage, the disposal of installation waste, packaging waste and product waste at its’ end of life is included. The disposal pathway of each waste stream is modeled based on the recommendation of PCR and US EPA’s latest waste management fact sheet.

» Life Cycle Assessment Results

As prescribed by the PCR, TRACI 2.1 impact characterization methodology and IPCC 5th assessment report are adopted to calculate the environment impacts. Table 4 provides the acronym key of the impact indicators declared in this EPD.

Table 4: LCIA impact category and LCI Indicator keys

Abbreviation	Parameter	Unit
TRACI 2.1		
AP	Acidification potential of soil and water	kg SO ₂ eq
EP	Eutrophication potential	kg N eq
GWP	Global warming potential including biogenic carbon emission	kg CO ₂ eq
ODP	Depletion of stratospheric ozone layer	kg CFC 11 eq
POCP	Photochemical ozone creation potential	kg O ₃ eq
Resource Use Parameters		
RPR	Use of renewable primary energy	MJ, net calorific value (LHV)
RMR	Use of renewable Material Resources	kg
NRER	Depletion of Non-Renewable Energy Resources	MJ, net calorific value
NRMR	Depletion of Non-Renewable Material Resources	kg
FW	Consumption of Freshwater	m ³
Waste Parameters		
HWD	Disposed-of-hazardous waste	kg
NHWD	Disposed-of non-hazardous waste	kg
Biogenic Carbon Parameter		
BC	Biogenic Carbon	kg CO ₂ eq
Energy Differentiation Parameters		
HWP	Hydro/wind Power	MJ, net calorific value (LHV)
FE	Fossil Energy	MJ, net calorific value (LHV)
BE	Bio-energy	MJ, net calorific value (LHV)
NE	Nuclear Energy	MJ, net calorific value (LHV)
OE	Other Energy	MJ, net calorific value (LHV)

» **Stolit® Lotusan® 1.0 Dark Colors**

	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
Market-based life-time	AP [kg SO ₂ eq]	6.23E-02	5.83E-03	6.11E-03	4.19E-03
	EP [kg N eq]	3.64E-03	4.75E-04	2.23E-04	6.81E-04
	GWP [kg CO ₂ eq]	1.45E+01	1.13E+00	2.90E+00	8.70E-01
	ODP [kg CFC 11 eq]	-5.00E-13	1.08E-16	1.83E-14	2.35E-15
	POCP [kg O ₃ eq]	8.08E-01	1.33E-01	1.15E+00	6.94E-02
	RPRE [MJ]	4.25E+01	4.97E-01	3.10E+00	7.14E-01
	NRPRE [MJ]	2.95E+02	1.61E+01	7.69E+01	1.04E+01
	FW [m3]	7.57E-02	1.91E-03	1.73E-02	1.34E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	1.52E+01	0.00E+00	1.30E+00	0.00E+00
	HWD [kg]	8.52E-07	1.30E-07	1.09E-08	4.34E-08
	NHWD [kg]	1.83E+00	6.06E-04	9.13E-03	1.61E+01
	BC [kg CO ₂ eq]			5.29E+00	
	HWP [MJ]			9.34E-01	
FE [MJ]			1.42E+01		
BE [MJ]			4.62E-01		
NE [MJ]			3.71E+00		
OE [MJ]			3.72E-01		
Design lifetime	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
	AP [kg SO ₂ eq]	1.25E-01	1.17E-02	1.22E-02	8.38E-03
	EP [kg N eq]	7.28E-03	9.50E-04	4.46E-04	1.36E-03
	GWP [kg CO ₂ eq]	2.90E+01	2.26E+00	5.80E+00	1.74E+00
	ODP [kg CFC 11 eq]	-1.00E-12	2.16E-16	3.66E-14	4.70E-15
	POCP [kg O ₃ eq]	1.62E+00	2.66E-01	2.30E+00	1.39E-01
	RPRE [MJ]	8.50E+01	9.94E-01	6.20E+00	1.43E+00
	NRPRE [MJ]	5.90E+02	3.22E+01	1.54E+02	2.08E+01
	FW [m3]	1.51E-01	3.82E-03	3.46E-02	2.68E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	3.03E+01	0.00E+00	2.60E+00	0.00E+00
	HWD [kg]	1.70E-06	2.60E-07	2.18E-08	8.68E-08
	NHWD [kg]	3.66E+00	1.21E-03	1.83E-02	3.22E+01
	BC [kg CO ₂ eq]			1.06E+01	
HWP [MJ]			1.87E+00		
FE [MJ]			2.83E+01		
BE [MJ]			9.23E-01		
NE [MJ]			7.42E+00		
OE [MJ]			7.45E-01		

» **Stolit® Lotusan® 1.0**

	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
Market-based life-time	AP [kg SO ₂ eq]	8.00E-02	5.83E-03	1.86E-03	4.01E-03
	EP [kg N eq]	3.36E-03	4.75E-04	6.83E-05	6.72E-04
	GWP [kg CO ₂ eq]	1.50E+01	1.13E+00	8.76E-01	8.31E-01
	ODP [kg CFC 11 eq]	-4.92E-13	1.08E-16	5.47E-15	2.22E-15
	POCP [kg O ₃ eq]	7.67E-01	1.33E-01	1.12E+00	6.59E-02
	RPRE [MJ]	4.13E+01	4.98E-01	9.63E-01	6.69E-01
	NRPRE [MJ]	2.93E+02	1.61E+01	2.31E+01	9.85E+00
	FW [m3]	7.61E-02	1.92E-03	5.22E-03	1.27E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	1.52E+01	0.00E+00	3.80E-01	0.00E+00
	HWD [kg]	8.49E-07	1.30E-07	3.37E-09	4.11E-08
	NHWD [kg]	1.84E+00	6.06E-04	2.81E-03	1.53E+01
	BC [kg CO ₂ eq]			5.20E+00	
	HWP [MJ]			9.33E-01	
FE [MJ]			1.42E+01		
BE [MJ]			4.61E-01		
NE [MJ]			3.71E+00		
OE [MJ]			3.72E-01		
Design lifetime	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
	AP [kg SO ₂ eq]	1.60E-01	1.17E-02	3.72E-03	8.02E-03
	EP [kg N eq]	6.72E-03	9.50E-04	1.37E-04	1.34E-03
	GWP [kg CO ₂ eq]	3.00E+01	2.26E+00	1.75E+00	1.66E+00
	ODP [kg CFC 11 eq]	-9.84E-13	2.16E-16	1.09E-14	4.44E-15
	POCP [kg O ₃ eq]	1.53E+00	2.66E-01	2.24E+00	1.32E-01
	RPRE [MJ]	8.26E+01	9.96E-01	1.93E+00	1.34E+00
	NRPRE [MJ]	5.86E+02	3.22E+01	4.62E+01	1.97E+01
	FW [m3]	1.52E-01	3.84E-03	1.04E-02	2.54E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	3.03E+01	0.00E+00	7.60E-01	0.00E+00
	HWD [kg]	1.70E-06	2.60E-07	6.74E-09	8.22E-08
	NHWD [kg]	3.68E+00	1.21E-03	5.62E-03	3.06E+01
	BC [kg CO ₂ eq]			1.04E+01	
HWP [MJ]			1.87E+00		
FE [MJ]			2.83E+01		
BE [MJ]			9.23E-01		
NE [MJ]			7.41E+00		
OE [MJ]			7.44E-01		

» **Stolit® Lotusan® 1.5 Dark Colors**

	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage	
Market-based life-time	AP [kg SO ₂ eq]	6.98E-02	6.71E-03	7.02E-03	4.82E-03	
	EP [kg N eq]	3.76E-03	5.47E-04	2.56E-04	7.84E-04	
	GWP [kg CO ₂ eq]	1.68E+01	1.31E+00	3.33E+00	1.00E+00	
	ODP [kg CFC 11 eq]	-5.83E-13	1.24E-16	2.11E-14	2.70E-15	
	POCP [kg O ₃ eq]	8.62E-01	1.53E-01	1.32E+00	7.99E-02	
	RPRE [MJ]	4.70E+01	5.73E-01	3.56E+00	8.22E-01	
	NRPRE [MJ]	3.32E+02	1.85E+01	8.86E+01	1.20E+01	
	FW [m3]	8.52E-02	2.21E-03	1.99E-02	1.54E-03	
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	
	NRMR [kg]	1.75E+01	0.00E+00	1.50E+00	0.00E+00	
	HWD [kg]	9.85E-07	1.50E-07	1.25E-08	4.99E-08	
	NHWD [kg]	2.10E+00	6.98E-04	1.05E-02	1.86E+01	
	BC [kg CO ₂ eq]			6.13E+00		
	HWP [MJ]			1.08E+00		
	FE [MJ]			1.63E+01		
	BE [MJ]			5.32E-01		
	NE [MJ]			4.27E+00		
	OE [MJ]			4.29E-01		
	Design lifetime	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
		AP [kg SO ₂ eq]	1.40E-01	1.34E-02	1.40E-02	9.64E-03
EP [kg N eq]		7.52E-03	1.09E-03	5.12E-04	1.57E-03	
GWP [kg CO ₂ eq]		3.36E+01	2.62E+00	6.66E+00	2.00E+00	
ODP [kg CFC 11 eq]		-1.17E-12	2.48E-16	4.22E-14	5.40E-15	
POCP [kg O ₃ eq]		1.72E+00	3.06E-01	2.64E+00	1.60E-01	
RPRE [MJ]		9.40E+01	1.15E+00	7.12E+00	1.64E+00	
NRPRE [MJ]		6.64E+02	3.70E+01	1.77E+02	2.40E+01	
FW [m3]		1.70E-01	4.42E-03	3.98E-02	3.08E-03	
RMR [kg]		0.00E+00	0.00E+00	0.00E+00	0.00E+00	
NRMR [kg]		3.49E+01	0.00E+00	3.00E+00	0.00E+00	
HWD [kg]		1.97E-06	3.00E-07	2.50E-08	9.98E-08	
NHWD [kg]		4.20E+00	1.40E-03	2.10E-02	3.72E+01	
BC [kg CO ₂ eq]				1.23E+01		
HWP [MJ]				2.15E+00		
FE [MJ]				3.26E+01		
BE [MJ]				1.06E+00		
NE [MJ]				8.54E+00		
OE [MJ]				8.58E-01		

» **Stolit® Lotusan® 1.5**

	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
Market-based life-time	AP [kg SO ₂ eq]	9.14E-02	6.71E-03	2.14E-03	4.62E-03
	EP [kg N eq]	3.86E-03	5.47E-04	7.86E-05	7.74E-04
	GWP [kg CO ₂ eq]	1.72E+01	1.31E+00	1.01E+00	9.57E-01
	ODP [kg CFC 11 eq]	-5.68E-13	1.24E-16	6.30E-15	2.55E-15
	POCP [kg O ₃ eq]	8.80E-01	1.53E-01	1.29E+00	7.58E-02
	RPRE [MJ]	4.74E+01	5.73E-01	1.11E+00	7.70E-01
	NRPRE [MJ]	3.35E+02	1.85E+01	2.65E+01	1.13E+01
	FW [m3]	8.69E-02	2.21E-03	6.01E-03	1.46E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	1.75E+01	0.00E+00	4.40E-01	0.00E+00
	HWD [kg]	9.78E-07	1.50E-07	3.88E-09	4.73E-08
	NHWD [kg]	2.12E+00	6.98E-04	3.23E-03	1.76E+01
	BC [kg CO ₂ eq]			5.98E+00	
	HWP [MJ]			1.07E+00	
	FE [MJ]			1.63E+01	
	BE [MJ]			5.31E-01	
	NE [MJ]			4.27E+00	
OE [MJ]			4.29E-01		
Design lifetime	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
	AP [kg SO ₂ eq]	1.83E-01	1.34E-02	4.28E-03	9.24E-03
	EP [kg N eq]	7.72E-03	1.09E-03	1.57E-04	1.55E-03
	GWP [kg CO ₂ eq]	3.44E+01	2.62E+00	2.02E+00	1.91E+00
	ODP [kg CFC 11 eq]	-1.14E-12	2.48E-16	1.26E-14	5.10E-15
	POCP [kg O ₃ eq]	1.76E+00	3.06E-01	2.58E+00	1.52E-01
	RPRE [MJ]	9.48E+01	1.15E+00	2.22E+00	1.54E+00
	NRPRE [MJ]	6.70E+02	3.70E+01	5.30E+01	2.26E+01
	FW [m3]	1.74E-01	4.42E-03	1.20E-02	2.92E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	3.49E+01	0.00E+00	8.80E-01	0.00E+00
	HWD [kg]	1.96E-06	3.00E-07	7.76E-09	9.46E-08
	NHWD [kg]	4.24E+00	1.40E-03	6.46E-03	3.52E+01
	BC [kg CO ₂ eq]			1.20E+01	
	HWP [MJ]			2.15E+00	
	FE [MJ]			3.26E+01	
	BE [MJ]			1.06E+00	
NE [MJ]			8.54E+00		
OE [MJ]			8.57E-01		

» **Stolit® Lotusan® Freeform Dark Colors**

	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
Market-based life-time	AP [kg SO ₂ eq]	1.13E-01	1.05E-02	1.10E-02	7.51E-03
	EP [kg N eq]	6.53E-03	8.52E-04	3.99E-04	1.22E-03
	GWP [kg CO ₂ eq]	2.57E+01	2.04E+00	5.20E+00	1.56E+00
	ODP [kg CFC 11 eq]	-7.86E-13	1.93E-16	3.28E-14	4.22E-15
	POCP [kg O ₃ eq]	1.46E+00	2.39E-01	2.06E+00	1.25E-01
	RPRE [MJ]	7.50E+01	8.93E-01	5.56E+00	1.28E+00
	NRPRE [MJ]	5.27E+02	2.89E+01	1.38E+02	1.88E+01
	FW [m3]	1.35E-01	3.44E-03	3.10E-02	2.41E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	2.72E+01	0.00E+00	2.33E+00	0.00E+00
	HWD [kg]	1.54E-06	2.34E-07	1.95E-08	7.78E-08
	NHWD [kg]	3.15E+00	1.09E-03	1.64E-02	2.89E+01
	BC [kg CO ₂ eq]			9.44E+00	
	HWP [MJ]			1.68E+00	
	FE [MJ]			2.54E+01	
	BE [MJ]			8.28E-01	
NE [MJ]			6.65E+00		
OE [MJ]			6.68E-01		
Design lifetime	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
	AP [kg SO ₂ eq]	2.26E-01	2.10E-02	2.20E-02	1.50E-02
	EP [kg N eq]	1.31E-02	1.70E-03	7.98E-04	2.44E-03
	GWP [kg CO ₂ eq]	5.14E+01	4.08E+00	1.04E+01	3.12E+00
	ODP [kg CFC 11 eq]	-1.57E-12	3.86E-16	6.56E-14	8.44E-15
	POCP [kg O ₃ eq]	2.92E+00	4.78E-01	4.12E+00	2.50E-01
	RPRE [MJ]	1.50E+02	1.79E+00	1.11E+01	2.56E+00
	NRPRE [MJ]	1.05E+03	5.78E+01	2.76E+02	3.76E+01
	FW [m3]	2.70E-01	6.88E-03	6.20E-02	4.82E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	5.44E+01	0.00E+00	4.66E+00	0.00E+00
	HWD [kg]	3.08E-06	4.68E-07	3.90E-08	1.56E-07
	NHWD [kg]	6.30E+00	2.18E-03	3.28E-02	5.78E+01
	BC [kg CO ₂ eq]			1.89E+01	
	HWP [MJ]			3.35E+00	
	FE [MJ]			5.08E+01	
BE [MJ]			1.66E+00		
NE [MJ]			1.33E+01		
OE [MJ]			1.34E+00		

» **Stolit® Lotusan® Freeform**

	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
Market-based life-time	AP [kg SO ₂ eq]	1.42E-01	1.05E-02	3.34E-03	7.20E-03
	EP [kg N eq]	5.78E-03	8.52E-04	1.23E-04	1.21E-03
	GWP [kg CO ₂ eq]	2.60E+01	2.04E+00	1.57E+00	1.49E+00
	ODP [kg CFC 11 eq]	-6.63E-13	1.93E-16	9.82E-15	3.98E-15
	POCP [kg O ₃ eq]	1.27E+00	2.39E-01	2.01E+00	1.18E-01
	RPRE [MJ]	7.24E+01	8.93E-01	1.73E+00	1.20E+00
	NRPRE [MJ]	5.15E+02	2.89E+01	4.14E+01	1.77E+01
	FW [m3]	1.35E-01	3.44E-03	9.37E-03	2.28E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	2.72E+01	0.00E+00	6.90E-01	0.00E+00
	HWD [kg]	1.46E-06	2.34E-07	6.04E-09	7.37E-08
	NHWD [kg]	3.17E+00	1.09E-03	5.04E-03	2.74E+01
	BC [kg CO ₂ eq]			9.24E+00	
	HWP [MJ]			1.67E+00	
	FE [MJ]			2.54E+01	
	BE [MJ]			8.28E-01	
NE [MJ]			6.65E+00		
OE [MJ]			6.68E-01		
Design lifetime	Indicator	1. Product Stage	2. Design & Construction Stage	3. Use & Maintenance Stage	4. End-of-Life Stage
	AP [kg SO ₂ eq]	2.84E-01	2.10E-02	6.68E-03	1.44E-02
	EP [kg N eq]	1.16E-02	1.70E-03	2.46E-04	2.42E-03
	GWP [kg CO ₂ eq]	5.20E+01	4.08E+00	3.14E+00	2.98E+00
	ODP [kg CFC 11 eq]	-1.33E-12	3.86E-16	1.96E-14	7.96E-15
	POCP [kg O ₃ eq]	2.54E+00	4.78E-01	4.02E+00	2.36E-01
	RPRE [MJ]	1.45E+02	1.79E+00	3.46E+00	2.40E+00
	NRPRE [MJ]	1.03E+03	5.78E+01	8.28E+01	3.54E+01
	FW [m3]	2.70E-01	6.88E-03	1.87E-02	4.56E-03
	RMR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00
	NRMR [kg]	5.44E+01	0.00E+00	1.38E+00	0.00E+00
	HWD [kg]	2.92E-06	4.68E-07	1.21E-08	1.47E-07
	NHWD [kg]	6.34E+00	2.18E-03	1.01E-02	5.48E+01
	BC [kg CO ₂ eq]			1.85E+01	
	HWP [MJ]			3.35E+00	
	FE [MJ]			5.08E+01	
BE [MJ]			1.66E+00		
NE [MJ]			1.33E+01		
OE [MJ]			1.34E+00		

» Interpretation

For all the products in study, the majority of the environmental impacts come from the Product Stage, which includes raw material sourcing, transportation and manufacturing. The only exception is POCP whose dominant source is Use & Maintenance Stage because of VOC emission in the curing process. From a functional unit perspective, the lifetime of the product and the coverage rate play a major role in scaling the impacts. This explains why products of coarse finishes have a higher impact than those of fine finishes.

» Reference

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