

# ENVIRONMENTAL PRODUCT DECLARATION

In accordance with ISO 14025:2006 for:

*8xxx Series Aluminium Foil*

from

**Assan Alüminyum**



## PROGRAMME

The International EPD® System, [www.environdec.com](http://www.environdec.com)  
EPD® Turkey, [www.epdturkey.org](http://www.epdturkey.org)

## PROGRAMME OPERATOR

EPD® International AB & EPD Turkey

## EPD REGISTRATION NUMBER

EPD-IES-0017787

## VALID UNTIL

2029-11-29

## PUBLICATION DATE

2024-11-30

## REVISION DATE

2026-02-23

# Programme Information

## Programme Information

**Programme:** The International EPD® System

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## Information about verification and reference PCR:

### Product category rules (PCR)

*Basic Aluminium Products and Special Alloys Product Category Classification, 2022:08, version 1.0*  
UN CPC 4153

### PCR review was conducted by

*The Technical Committee of the International EPD® System. See [www.environdec.com/TC](http://www.environdec.com/TC) for a list of members. Review chair: Hüdai Kara. The review panel may be contacted via the Secretariat [www.environdec.com/contact](http://www.environdec.com/contact).*

Independent verification of the declaration and data, according to ISO 14025:2006:

EPD process verification

EPD verification

### Third party verifier

SimaPro partners for India & Sri Lanka, SIPL Pvt Ltdy

### Approved by

The International EPD® System Technical  
Committee, supported by the Secretariat

Procedure for follow-up of data during EPD validity involves third party verifier:

Yes

No

## LCA Study & EPD Design Conducted by

Semtrio Sustainability Consulting  
BUDOTEK Teknopark, No 8/27  
Umraniye / Istanbul Turkey  
[www.semtrio.com](http://www.semtrio.com)



## Assan Alüminyum has the sole ownership, liability, and responsibility for the EPD.

EPDs within the same product category but registered in different EPD programmes may not be comparable. For two EPDs to be comparable, they must be based on the same PCR (including the same version number) or be based on fully-aligned PCRs or versions of PCRs; cover products with identical functions, technical performances and use (e.g. identical declared/functional units); have equivalent system boundaries and descriptions of data; apply equivalent data quality requirements, methods of data collection, and allocation methods; apply identical cut-off rules and impact assessment methods (including the same version of characterisation factors); have equivalent content declarations; and be valid at the time of comparison. For further information about comparability, see ISO 14025.

# Company Information

## Owner of the EPD

### Assan Alüminyum Sanayi ve Ticaret A.Ş.

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Assan Alüminyum, one of the world's leading manufacturers in the flat-rolled aluminium (FRP) industry, producing coil & sheet, foil and pre-painted aluminium products since 1988, offering its products to a variety of sectors such as packaging, distribution, construction, consumer durables, automotive and HVAC. Assan Alüminyum, a subsidiary of Kibar Holding, has an installed annual capacity of 360 thousand tons in its production facilities, with the highest continuous casting capacity in all of Europe and Americas. The company is currently one of the 2 largest aluminium foil manufacturers in Europe, with an aluminium foil production capacity of 130 thousand tons.

Assan Alüminyum received the Aluminium Stewardship Initiative (ASI) Performance Standard Certificate for all of facilities. ASI framework is essential for the company to manage all of its business processes according to global sustainability standards. With the clean energy that the company produces at its Manavgat Renewable Energy Power Plant, it generates and procures I-RECs (International Renewable Energy Certificate) that allow it to fully offset its market-based Scope 2 emissions. The 100% and infinitely recyclable aluminium is recycled at its integrated recycling facility, which helps reduce the carbon footprint of the company. With its global culture, 1700 dedicated employees, Assan Alüminyum exports to more than 70 countries around the world, particularly to West Europe and North America.

## NAME AND LOCATION OF PRODUCTION SITES

### Tuzla Plant

Yayla Mahallesi Rüya Sokak No:2 34940  
Tuzla – İstanbul/Turkey

### Dilovası Plant

Dilovası Organize Sanayi Bölgesi 1. Kısım Dicle  
sok. No 40 41455 / Kocaeli/Turkey



# Product Information

Product Name:

## 8xxx Series Aluminium Foil

Flat rolled aluminium is produced by casting aluminium through the melting of aluminium ingots / t-bars. The cast coils are then rolled down to the desired thickness in cold rolling mills. Aluminium foil is produced by rolling mill-finished coils in foil rolling mills down to thicknesses of 0.2 mm or thinner gauges. Aside from foil rolling, the foil production process may also include the annealing, separating, slitting and packaging processes

Flat rolled aluminium below the thickness of 0.2mm is called aluminium foil. 8xxx series are alloyed with other elements which are not covered by other series, typically iron.

### Intended Use of Product

8xxx Series Aluminium Foil is primarily used in automotive heat exchanger applications. . 8xxx Series Aluminium Foil is primarily used in flexible packaging, semi-rigid containers, household foil as well as HVAC-R and insulation.

## Technical Specifications

Technical specification	Test Method	Unit	Value
Density	NA	(kg/m <sup>3</sup> ) x 103	2.71
Melting point (Typical)	NA	°C	630 – 655
Electrical conductivity (Typical) at 20°C/ at 68 °F	EN 14121:2009	MS/m (0.58*%IACS)	28 – 33
Thermal conductivity (Typical) at 25°C/ at 77 °F	NA	W/(m.K)	203 – 240
Average Coefficient of thermal expansion (Typical) 20°C to 100°C /68°F to 212 °F	NA	µm/m.°C	22 -55
Modulus of elasticity (Typical)	NA	GPa	69 – 70
Hardness (typical)	NA	HB	-
Yield strength (min)	EN 485-2	MPa	30
Ultimate tensile strength (min)	EN 485-2	MPa	70
Breaking elongation (min) (50 mm&4D)	EN 485-2	%	2
Chemical composition	EN 485-2	% by mass	96

UN CPC code: 41535 Foil, of aluminium, of a thickness not exceeding 0.2 mm

# LCA Information

## Declared Unit

1 kg of 8xxx Series Aluminium Foil ready to delivery at the factory gate.

## Reference Service Life

Not applicable.

## Time Representativeness

The production data in this LCA study represents the period of 1 January - 31 December 2023.

## Database(s) and LCA software used

SimaPro LCA v9.6.0.1 software with Ecoinvent v3.9.1

## Description of System Boundaries

Cradle to gate with, upstream processes and core processes according to PCR section 4.3.

## Data Quality and Data Collection

Specific data was used for module Core Processes (Processes the manufacturer has influence over) and was gathered from the Assan Alüminyum Tuzla and Dilovası Manufacturing Plant. Specific data includes actual product weights, amounts of raw materials used, product content, energy consumption, transport figures, water consumption and amounts of wastes. For Upstream and Core Processes modules, according to ISO 14044, generic data was applied and was obtained from Ecoinvent v3.9.1

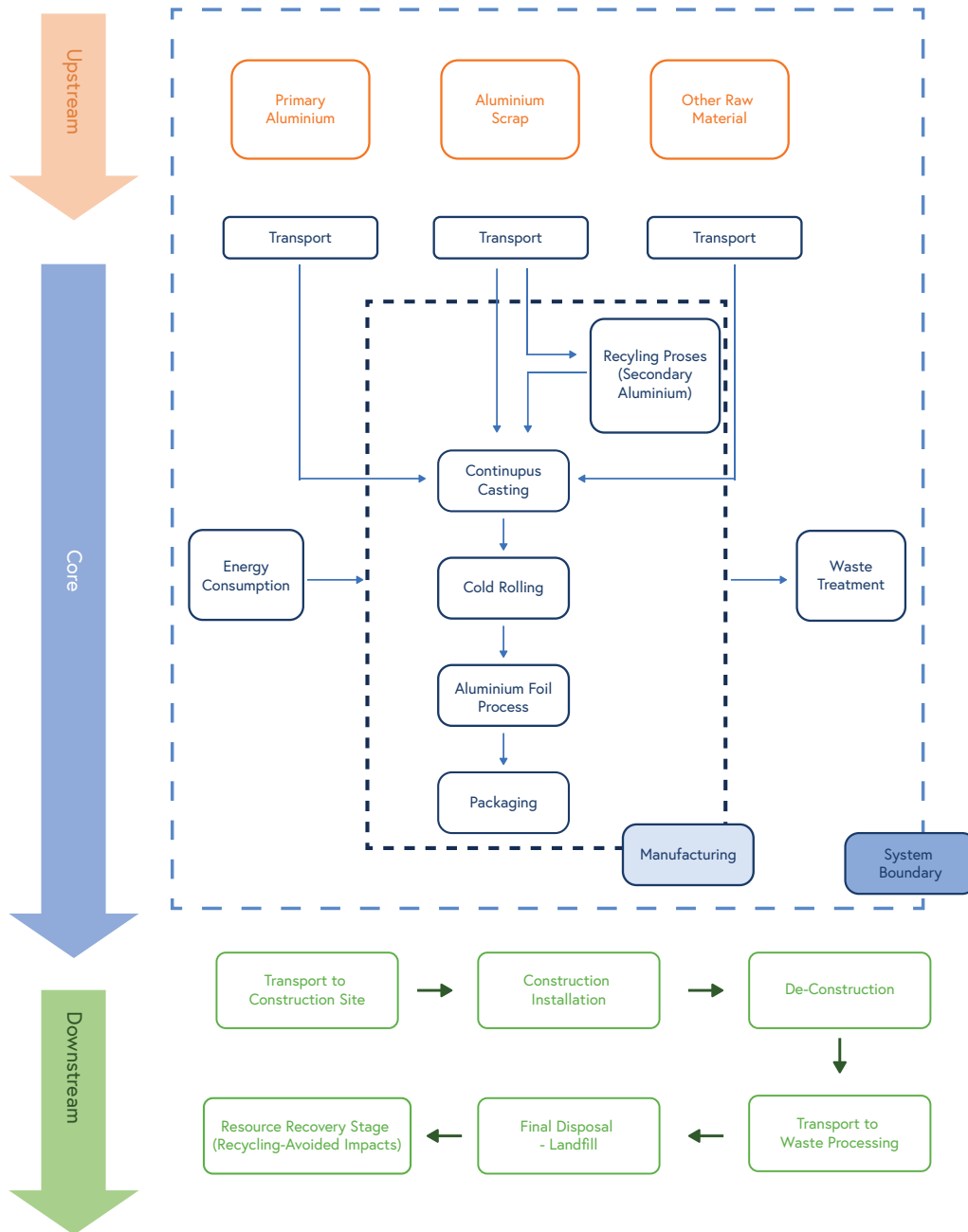
## Allocation

Allocation was avoided by dividing the unit process into two or more sub-processes and collecting the environmental data related to these sub-processes.

## Cut-off Rules

Life Cycle Inventory data for a minimum of 99 % of total inflows to the three life cycle stages have been included and a cut-off rule of 1% regarding energy, mass, and environmental relevance was applied.

# System Diagram



# Description of Declared Modules

## Upstream

The upstream module covers the extraction and procurement of raw materials used for the product. At this stage, only activities related to the production of raw materials are evaluated. The raw materials used include cast roll, aluminum scrap recycling, and cold rolled aluminum sheet. This process represents the start of the product's life cycle, where the first environmental impacts occur.

## Core

The core module covers the transportation of raw materials, processing, production processes, energy use, process emissions, waste management, and product packaging. This stage is the critical process where the environmental impacts of production and other facility activities are evaluated. Materials such as cast roll, aluminum scrap recycling (secondary aluminium), and cold rolled aluminum sheet produced in our production line are included in this stage. In addition, electricity, transportation processes, natural gas consumption, and packaging materials used in the core stage are also considered.

## Downstream

The downstream module covers the stages of product use, reuse, recycling, and disposal after it reaches the end-user. However, the Environmental Product Declaration (EPD) for this module excludes these processes, following a "cradle-to-gate" approach instead of a "gate-to-grave" evaluation. As a result, downstream processes are not included in this assessment.

# Content Declaration Including Packaging

## Content declaration of 8xxx Series Aluminium Foil

Product Content	Mass, kg	Post-consumer recycled material, mass-% of product	Pre-consumer recycled material, mass-% of product	Biogenic material, mass-% of product	Biogenic material, kg C/product or declared unit
Aluminium product	0.995	5.09%	20.11%	0.00%	0.00
Others, kg	0.005	0.00%	0.00%	0.00%	0.00
TOTAL	1.000	5.09%	20.11%	0.00%	0.00

## Content declaration of Packaging of 8xxx Series Aluminium Foil

Packaging Materials	Mass, kg	Mass-% (versus the product)	Biogenic material, kg C/product or declared unit
Wooden Pellet	5.00E-02	5.00%	2.27E-02
PE film	1.00E-02	1.00%	1.65E-03
Cardboard	4.31E-03	0.43%	2.74E-01

There is no recycled material use for packing.

# Environmental Information

## Potential Environmental Impact

Parameter	Unit	Upstream	Core	Total	
Global warming potential (GWP)	Fossil	kg CO <sub>2</sub> eq.	6.19	0.66	6.85
	Biogenic	kg CO <sub>2</sub> eq.	4.34E-03	-0.08	-0.08
	Land use and land transformation	kg CO <sub>2</sub> eq.	0.05	1.72E-04	0.05
	Total	kg CO <sub>2</sub> eq.	6.24	0.58	6.82
Ozone layer depletion (ODP)	kg CFC 11 eq.	5.46E-08	1.20E-04	1.20E-04	
Acidification potential (AP)	mol H <sup>+</sup> eq.	0.04	9.23E-04	0.04	
Eutrophication potential (EP)	Aquatic freshwater	kg P eq.	2.44E-03	4.88E-05	2.44E-03
	Aquatic marine	kg N eq.	6.14E-03	2.46E-04	6.14E-03
	Aquatic terrestrial	mol N eq.	0.06	2.51E-03	0.06
Photochemical oxidant creation potential (POCP)	kg NMVOC eq.	0.02	2.74E-03	0.02	
Abiotic depletion potential (ADP)*	Metals and minerals	kg Sb eq.	1.27E-05	9.46E-07	1.27E-05
	Fossil resources	MJ, net calorific value	37.3	0.50	37.3
Water deprivation potential (WDP)*	m <sup>3</sup> world eq. deprived	1.95	0.03	1.98	

### Acronyms

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

\* Disclaimer: The results of this environmental impact indicator shall be used with care as the uncertainties of these results are high or as there is limited experience with the indicator.

## Potential Environmental Impact – Additional Voluntary Indicators

Impact category	Unit	Upstream	Core	Total
Eutrophication	kg PO4 eq	0.01	2.79E-04	0.01
Human toxicity	kg 1,4-DB eq	12.6	0.95	13.6
Fresh water aquatic ecotox.	kg 1,4-DB eq	7.49	4.33	11.8
Marine aquatic ecotoxicity	kg 1,4-DB eq	2.55E04	2.15E03	2.77E04
Terrestrial ecotoxicity	kg 1,4-DB eq	0.06	0.01	0.07

# Environmental Information

## Potential Environmental Impact – Resource Use Indicators

	Parameter	Unit	Upstream	Core	Total
Primary energy resources – Renewable	Use as energy carrier	MJ, net calorific value	16.3	6.01	22.3
	Used as raw materials	MJ, net calorific value	0	0	0
	Total	MJ, net calorific value	16.3	6.01	22.3
Primary energy resources – Non-renewable	Use as energy carrier	MJ, net calorific value	38.7	0.53	39.3
	Used as raw materials	MJ, net calorific value	0	0	0
	Total	MJ, net calorific value	38.7	0.53	39.3
Secondary material		kg	0.60	0	0.60
Renewable secondary fuels		MJ, net calorific value	0	0	0
Non-renewable secondary fuels		MJ, net calorific value	0	0	0
Net use of fresh water		m <sup>3</sup>	0.27	0.01	0.28

## Waste Indicators

Impact category	Unit	Up Stream	Core	Total
Hazardous waste disposed	kg	0	0	0
Non-hazardous waste disposed	kg	0	1.82E-03	1.82E-03
Radioactive waste disposed	kg	0	0	0

## Output Flows Indicators

Impact category	Unit	Up Stream	Core	Total
Components for reuse	kg	0	0	0
Material for recycling	kg	0	0	0
Materials for energy recovery	kg	0	2.16E-02	2.16E-02
Exported energy, electricity	MJ per energy carrier	0	0	0
Exported energy, thermal	MJ per energy carrier	0	0	0

## Revisions

### Revision 001, 2026-01-23

The content declaration, waste production and output flows have been updated.

### Revision 002, 2026-02-23

The revisions include using the latest International EPD System logo, adding GPI 4 as a reference for the PCR, simplifying the Company Information section, and adding the version date information to the revisions section.

# References

- ISO 14040 Environmental management - Life cycle assessment - Principles and framework
- ISO 14044 2006 Environmental management - Life cycle assessment - Requirements and guidelines
- ISO 14025 2006 Environmental labels and declarations - Type III environmental declarations - Principles and procedures
- ISO 14021 2016 Environmental labels and declarations
- ISO 14020 2000 Environmental labels and declarations - General principles
- EN 15804:2012+A2:2019 Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction products
- The International EPD® System [www.environdec.com](http://www.environdec.com)
- The International EPD® System The General Programme Instructions v5.0.0
- The International EPD® System General Programme Instructions (GPI) for the International EPD® System, Version 4 <https://www.environdec.com/resources/documentation#generalprogrammeinstructions>
- The International EPD® System PCR 2022:08, Basic Aluminium Products and Special Alloys, version 1.0
- Ecoinvent 3.9.1 [www.ecoinvent.org](http://www.ecoinvent.org)
- SimaPro LCA Software [www.simapro.com](http://www.simapro.com)
- Assan Alüminyum [www.assanaluminyum.com/en/](http://www.assanaluminyum.com/en/)
- Aluminium Recycling in LCA European Aluminium Association, 2013

## Contact

### Third party verifier

SimaPro partners for India & Sri Lanka, SIPL Pvt Ltdy



LCA, GHG and ESG Consultants

### Owner of Declaration

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### LCA Practitioner & EPD Design

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### Programme Operator

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