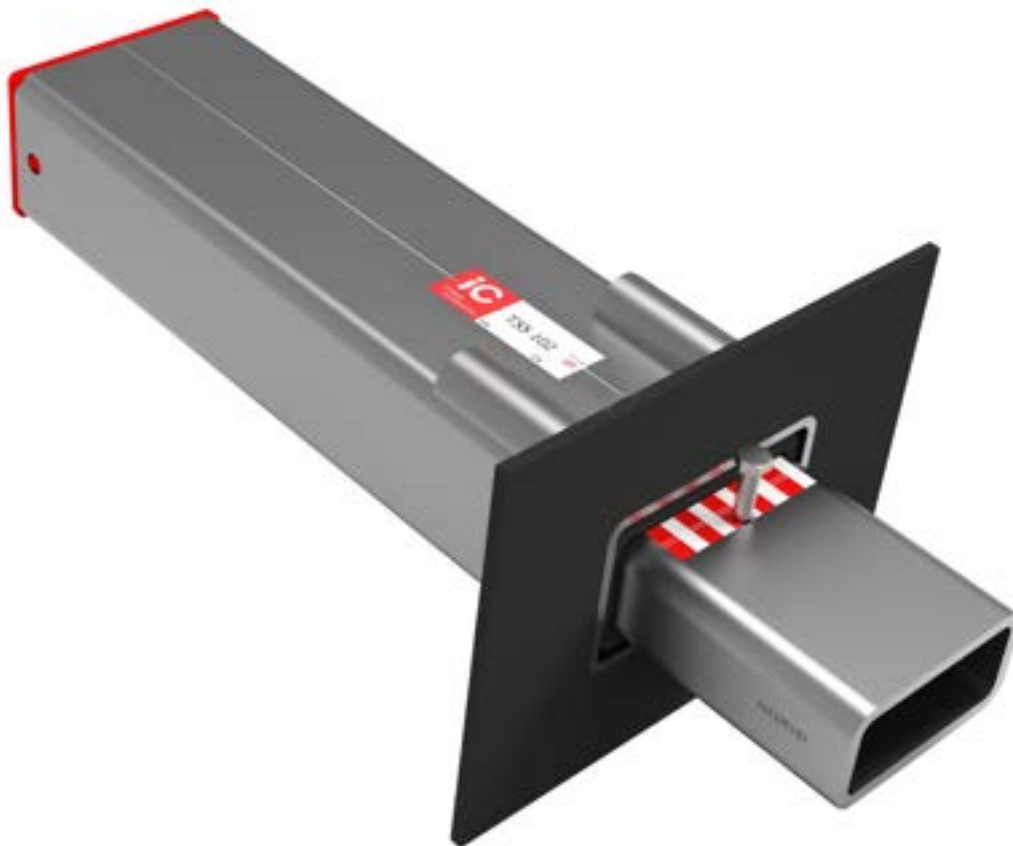


# Environmental product declaration

In accordance with ISO 14025 and EN15804+A2

TSS 102



The Norwegian EPD Foundation

**Owner of the declaration:**

Invisible Connections AS

**Product:**

TSS 102

**Declared unit:**

1 pcs

**This declaration is based on Product Category Rules:**

CEN Standard EN 15804:2012+A2:2019 serves as core PCR

NPCR 013:2021 Part B for Steel and aluminium construction products

**Program operator:**

The Norwegian EPD Foundation

**Declaration number:**

NEPD-8970-8621

**Registration number:**

NEPD-8970-8621

**Issue date:** 05.02.2025

**Valid to:** 05.02.2030

**EPD software:**

LCAno EPD generator ID: 647003

## General information

### Product

TSS 102

### Program operator:

The Norwegian EPD Foundation  
Post Box 5250 Majorstuen, 0303 Oslo, Norway  
Phone: +47 977 22 020  
web: [www.epd-norge.no](http://www.epd-norge.no)

### Declaration number:

NEPD-8970-8621

### This declaration is based on Product Category Rules:

CEN Standard EN 15804:2012+A2:2019 serves as core PCR  
NPCR 013:2021 Part B for Steel and aluminium construction products

### Statement of liability:

The owner of the declaration shall be liable for the underlying information and evidence. EPD Norway shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

### Declared unit:

1 pcs TSS 102

### Declared unit with option:

A1-A3,A4,A5,C1,C2,C3,C4,D

### Functional unit:

Telescopic stair connector with sound reduction.  
Inner and outertube made of steel with a total capacity of 100kN.

### General information on verification of EPD from EPD tools:

Independent verification of data, other environmental information and the declaration according to ISO 14025:2010, § 8.1.3 and § 8.1.4. Verification of each EPD is made according to EPD-Norway's guidelines for verification and approval requiring that tools are i) integrated into the company's environmental management system, ii) the procedures for use of the EPD tool are approved by EPD-Norway, and iii) the process is reviewed annually by an independent third party verifier. See Appendix G of EPD-Norway's General Programme Instructions for further information on EPD tools

### Verification of EPD tool:

Independent third party verification of the EPD tool, background data and test-EPD in accordance with EPDNorway's procedures and guidelines for verification and approval of EPD tools.

Third party verifier:

Alexander Borg, Asplan Viak AS

(no signature required)

### Owner of the declaration:

Invisible Connections AS  
Contact person:  
Phone:  
e-mail: [terje@invisi.no](mailto:terje@invisi.no)

### Manufacturer:

Invisible Connections AS

### Place of production:

Invisible Connections AS  
  
, Norway

### Management system:

NS-EN 1090

### Organisation no:

992435194

### Issue date:

05.02.2025

### Valid to:

05.02.2030

### Year of study:

2023

### Comparability:

EPD of construction products may not be comparable if they not comply with EN 15804 and seen in a building context.

### Development and verification of EPD:

The declaration is created using EPD tool lca.tools NEPDT038, developed by LCA.no. The EPD tool is integrated in the company's management system, and has been approved by EPD Norway.

Developer of EPD: Terje Berg

Reviewer of company-specific input data and EPD: John Egil Sæther

### Approved:



Håkon Hauan  
Managing Director of EPD-Norway

## Product

### Product description:

Stair connector with sound reduction to be casted in concrete landings.

<https://invisibleconnections.no/produkter/trapp-reposforbindelser/rvk/tss-102/>

### Product specification

Inner and outer tube made of steel. 100kN capacity

Materials	kg	%
Gummi	0,27	2,38
Plastic - Nylon (PA)	0,02	0,18
Plastic - Polyethylene (HDPE)	0,08	0,69
Thermoplastic elastomers (TPE)	0,40	3,52
Metal - Stainless steel	0,03	0,24
Metal - Steel	10,55	92,95
Polymeric Foam	0,01	0,04
Total	11,35	100,00

Packaging	kg	%
Packaging - Pallet	0,35	49,78
Packaging - Plastic	0,00	0,45
Packaging - Wood	0,35	49,78
Total incl. packaging	12,05	100,00

### Technical data:

Certificated after NS EN 1090 and EN 1090 UK

### Market:

Global

### Reference service life, product

Same as building

### Reference service life, building or construction works

100 years

## LCA: Calculation rules

### Declared unit:

1 pcs TSS 102

### Cut-off criteria:

All major raw materials and all the essential energy is included. The production processes for raw materials and energy flows with very small amounts (less than 1%) are not included. These cut-off criteria do not apply for hazardous materials and substances.

### Allocation:

The allocation is made in accordance with the provisions of EN 15804. Incoming energy and water and waste production in-house is allocated equally among all products through mass allocation. Effects of primary production of recycled materials is allocated to the main product in which the material was used. The recycling process and transportation of the material is allocated to this analysis.

### Data quality:

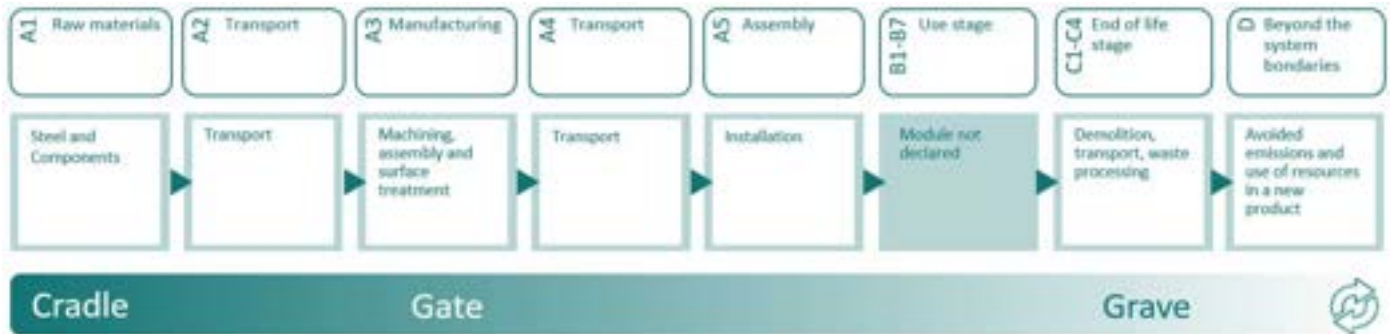
Specific data for the product composition are provided by the manufacturer. The data represent the production of the declared product and were collected for EPD development in the year of study. Background data is based on EPDs according to EN 15804 and different LCA databases. The data quality of the raw materials in A1 is presented in the table below.

Materials	Source	Data quality	Year
Gummi	ecoinvent 3.6	Database	2019
Metal - Stainless steel	ecoinvent 3.6	Database	2019
Metal - Steel	ecoinvent 3.6	Database	2019
Metal - Steel	S-P-02241	EPD	2020
Metal - Steel	S-P-05669	EPD	2022
Packaging - Pallet	Modified ecoinvent 3.6	Database	2019
Packaging - Plastic	ecoinvent 3.6	Database	2019
Packaging - Wood	ecoinvent 3.6	Database	2019
Plastic - Nylon (PA)	ecoinvent 3.6	Database	2019
Plastic - Polyethylene (HDPE)	ecoinvent 3.6	Database	2019
Polymeric Foam	ecoinvent 3.6	Database	2019
Thermoplastic elastomers (TPE)	Ecoinvent 3.6	Database	2019

**System boundaries (X=included, MND=module not declared, MNR=module not relevant)**

Product stage			Construction installation stage		Use stage							End of life stage				Beyond the system boundaries
Raw materials	Transport	Manufacturing	Transport	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery- Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	X	X	MND	MND	MND	MND	MND	MND	MND	X	X	X	X	X

**System boundary:**



**Additional technical information:**

<https://invisibleconnections.no/en>

## LCA: Scenarios and additional technical information

The following information describe the scenarios in the different modules of the EPD.














Products are sent to the factory or building sites that makes the concrete landing.

Packaging are 100% recyclabel. Or can be reused. (pallets and frames)

Transport from production place to user (A4)	Capacity utilisation (incl. return) %	Distance (km)	Fuel/Energy Consumption	Unit	Value (Liter/tonne)
Truck, 16-32 tonnes, EURO 6 (km)	36,7 %	1000	0,043	l/tkm	43,00
Assembly (A5)					
Unit	Value				
Waste, packaging, plastic film (LDPE), to average treatment (kg) - A5, inkl. 85 km transp.	kg	0,0031			
Waste, packaging, wood beam, softwood, raw, dried, u=20%, average treatment (kg) - A5, inkl. 85 km transp.	kg	0,34			
Waste, packaging, pallet, EUR wooden pallet, reusable, average treatment (kg) - A5, inkl. 85 km transp.	kg	0,34			
Transport to waste processing (C2)					
Capacity utilisation (incl. return) %	Distance (km)	Fuel/Energy Consumption	Unit	Value (Liter/tonne)	
Truck, 16-32 tonnes, EURO 6 (km)	36,7 %	250	0,043	l/tkm	10,75
Waste processing (C3)					
Unit	Value				
Materials to recycling (kg)	kg	9,51			
Waste treatment per kg Polyethylene (PE), incineration with fly ash extraction (kg) - CH - C3	kg	0,098			
Waste treatment per kg Rubber, incineration with fly ash extraction (kg) - CH - C3	kg	0,27			
Waste treatment per kg Plastic, Mixture, incineration (kg)	kg	0,40			
Disposal (C4)					
Unit	Value				
Waste, scrap steel, to landfill (kg)	kg	1,060			
Landfilling of ashes from incineration of Polypropylene (PP), process per kg ashes and residues (kg) - CH - C4	kg	0,0029			
Waste, scrap steel, for incineration (kg)	kg	0,0089			
Landfilling of ashes from incineration of Rubber, process per kg ashes and residues (kg) - CH - C4	kg	0,014			
Landfilling of ashes from incineration of Plastics, Mixture, process per kg ashes and residues (kg)	kg	0,0095			
Benefits and loads beyond the system boundaries (D)					
Unit	Value				
Substitution of primary steel with net scrap (kg)	kg	8,63			
Substitution of electricity (MJ)	MJ	0,53			
Substitution of thermal energy, district heating, in Norway (MJ)	MJ	8,0061			

## LCA: Results

The LCA results are presented below for the declared unit defined on page 2 of the EPD document.

Environmental impact										
Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D	
 GWP-total	kg CO <sub>2</sub> -eq	2,84E+01	1,77E+00	1,06E+00	0	4,41E-01	2,09E+00	6,32E-03	-9,55E+00	
 GWP-fossil	kg CO <sub>2</sub> -eq	2,95E+01	1,76E+00	9,99E-03	0	4,41E-01	2,09E+00	6,31E-03	-9,54E+00	
 GWP-biogenic	kg CO <sub>2</sub> -eq	-1,15E+00	7,30E-04	1,05E+00	0	1,83E-04	6,05E-05	5,63E-06	-5,34E-03	
 GWP-luluc	kg CO <sub>2</sub> -eq	1,33E-02	6,28E-04	2,52E-06	0	1,57E-04	1,97E-05	1,15E-06	-5,85E-03	
 ODP	kg CFC11 -eq	1,05E-06	4,00E-07	1,57E-09	0	9,99E-08	8,05E-09	2,37E-09	-3,38E-03	
 AP	mol H+ -eq	9,49E-02	5,07E-03	7,87E-05	0	1,27E-03	2,88E-04	5,27E-05	-4,76E-02	
 EP-FreshWater	kg P -eq	2,15E-04	1,41E-05	1,17E-07	0	3,52E-06	8,05E-07	5,90E-08	-5,89E-04	
 EP-Marine	kg N -eq	2,24E-02	1,00E-03	3,39E-05	0	2,51E-04	1,13E-04	1,96E-05	-9,89E-03	
 EP-Terrestrial	mol N -eq	2,43E-01	1,12E-02	3,61E-04	0	2,81E-03	1,19E-03	2,18E-04	-1,01E-01	
 POCP	kg NMVOC -eq	1,41E-01	4,30E-03	9,29E-05	0	1,07E-03	2,90E-04	6,17E-05	-4,80E-02	
 ADP-minerals&metals <sup>1</sup>	kg Sb-eq	3,63E-04	4,87E-05	1,59E-07	0	1,22E-05	3,47E-07	4,85E-08	-1,64E-04	
 ADP-fossil <sup>1</sup>	MJ	3,87E+02	2,67E+01	1,16E-01	0	6,67E+00	2,66E-01	1,61E-01	-8,06E+01	
 WDP <sup>1</sup>	m <sup>3</sup>	4,06E+02	2,58E+01	1,80E-01	0	6,45E+00	1,37E+00	4,79E-01	4,84E+02	

GWP-total = Global Warming Potential total; 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







"Reading example: 9,0 E-03 = 9,0\*10<sup>-3</sup> = 0,009"

\*INA Indicator Not Assessed

1. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator

## Remarks to environmental impacts

### Additional environmental impact indicators

Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
 PM	Disease incidence	9,15E-07	1,08E-07	9,64E-10	0	2,70E-08	1,44E-09	1,04E-09	-8,12E-07
 IRP <sup>2</sup>	kgBq U235 -eq	8,68E-01	1,17E-01	4,20E-04	0	2,91E-02	9,21E-04	7,05E-04	2,99E-02
 ETP-fw <sup>1</sup>	CTUe	8,11E+01	1,98E+01	1,31E-01	0	4,94E+00	4,05E+00	1,05E-01	-5,33E+02
 HTP-c <sup>1</sup>	CTUh	7,94E-09	0,00E+00	1,50E-11	0	0,00E+00	9,20E-11	6,00E-12	-4,58E-08
 HTP-nc <sup>1</sup>	CTUh	1,10E-07	2,16E-08	6,97E-10	0	5,40E-09	2,44E-09	1,01E-10	9,90E-07
 SQP <sup>1</sup>	dimensionless	1,03E+02	1,87E+01	6,60E-02	0	4,66E+00	5,26E-02	5,73E-01	-1,04E+01








PM = Particulate Matter emissions; IRP = Ionizing radiation – human health; ETP-fw = Eco toxicity – freshwater; HTP-c = Human toxicity – cancer effects; HTP-nc = Human toxicity – non cancer effects; SQP = Potential Soil Quality Index (dimensionless)

"Reading example: 9,0 E-03 = 9,0\*10<sup>-3</sup> = 0,009"

\*INA Indicator Not Assessed

1. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator
2. This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor due to radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.






Resource use										
Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D	
 PERE	MJ	3,14E+01	3,82E-01	2,38E-03	0	9,55E-02	2,23E-02	3,20E-03	-1,06E+01	
 PERM	MJ	9,65E+00	0,00E+00	-9,62E+00	0	0,00E+00	0,00E+00	0,00E+00	0,00E+00	
 PERT	MJ	4,10E+01	3,82E-01	-9,61E+00	0	9,55E-02	2,23E-02	3,20E-03	-1,06E+01	
 PENRE	MJ	3,71E+02	2,67E+01	1,16E-01	0	6,67E+00	2,66E-01	1,61E-01	-8,06E+01	
 PENRM	MJ	1,65E+01	0,00E+00	-1,32E-01	0	0,00E+00	-1,21E+01	0,00E+00	0,00E+00	
 PENRT	MJ	3,87E+02	2,67E+01	-1,61E-02	0	6,67E+00	-1,19E+01	1,61E-01	-8,06E+01	
 SM	kg	9,62E-01	0,00E+00	0,00E+00	0	0,00E+00	0,00E+00	4,02E-03	0,00E+00	
 RSF	MJ	1,99E-01	1,37E-02	6,93E-05	0	3,42E-03	5,53E-04	7,00E-05	3,42E-01	
 NRSF	MJ	1,18E-01	4,88E-02	7,84E-04	0	1,22E-02	0,00E+00	1,49E-03	9,74E+00	
 FW	m <sup>3</sup>	9,44E-02	2,85E-03	8,39E-05	0	7,13E-04	1,19E-03	1,92E-04	-2,50E-02	

PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non renewable primary energy resources used as raw materials; PENRT = Total use of non renewable primary energy resources; SM = Use of secondary materials; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Net use of fresh water

"Reading example: 9,0 E-03 = 9,0\*10<sup>-3</sup> = 0,009"






\*INA Indicator Not Assessed

End of life - Waste										
Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D	
 HWD	kg	2,26E-02	1,38E-03	0,00E+00	0	3,44E-04	0,00E+00	1,82E-02	-4,94E-02	
 NHWD	kg	3,53E+00	1,30E+00	3,65E-01	0	3,24E-01	0,00E+00	1,08E+00	-3,90E+00	
 RWD	kg	2,36E-03	1,82E-04	0,00E+00	0	4,54E-05	0,00E+00	8,38E-08	2,27E-05	

HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed

\*Reading example: 9,0 E-03 =  $9,0 \cdot 10^{-3} = 0,009$

\*INA Indicator Not Assessed

End of life - Output flow										
Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D	
 CRU	kg	0,00E+00	0,00E+00	3,28E-01	0	0,00E+00	0,00E+00	0,00E+00	0,00E+00	
 MFR	kg	9,18E-01	0,00E+00	1,59E-03	0	0,00E+00	9,51E+00	4,22E-03	0,00E+00	
 MER	kg	9,81E-03	0,00E+00	3,62E-01	0	0,00E+00	3,68E-01	1,21E-08	0,00E+00	
 EEE	MJ	8,38E-04	0,00E+00	2,52E-01	0	0,00E+00	5,60E-01	2,47E-04	0,00E+00	
 EET	MJ	1,27E-02	0,00E+00	3,81E+00	0	0,00E+00	8,47E+00	3,74E-03	0,00E+00	

CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported energy electrical; EET = Exported energy thermal

\*Reading example: 9,0 E-03 =  $9,0 \cdot 10^{-3} = 0,009$

\*INA Indicator Not Assessed

Biogenic Carbon Content		
Indicator	Unit	At the factory gate
Biogenic carbon content in product	kg C	0,00E+00
Biogenic carbon content in accompanying packaging	kg C	3,06E-01

Note: 1 kg biogenic carbon is equivalent to 44/12 kg CO<sub>2</sub>

## Additional requirements

### Greenhouse gas emissions from the use of electricity in the manufacturing phase

National production mix from import, low voltage (production of transmission lines, in addition to direct emissions and losses in grid) of applied electricity for the manufacturing process (A3).

Electricity mix	Source	Amount	Unit
Electricity, Norway (kWh)	ecoinvent 3.6	24,33	g CO <sub>2</sub> -eq/kWh

### Dangerous substances

The product contains no substances given by the REACH Candidate list.

### Indoor environment

## Additional Environmental Information

Additional environmental impact indicators required in NPCR Part A for construction products									
Indicator	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
GWPIOBC	kg CO <sub>2</sub> -eq	3,01E+01	1,77E+00	1,00E-02	0	4,41E-01	2,09E+00	7,57E-03	-1,43E+01

GWPI-IOBC: Global warming potential calculated according to the principle of instantaneous oxidation. In order to increase the transparency of biogenic carbon contribution to climate impact, the indicator GWP-IOBC is required as it declares climate impacts calculated according to the principle of instantaneous oxidation. GWP-IOBC is also referred to as GWP-GHG in context to Swedish public procurement legislation.

## Bibliography

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






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Graafland and Iversen, (2022) EPD generator for EPD generator for NPCR 013 Part B for Steel and Aluminum, Background information for EPD generator application and LCA data, LCA.no report number: 08.22

NPCR Part A: Construction products and services. Ver. 2.0. April 2021, EPD-Norge.

NPCR 013 Part B for Steel and Aluminium Construction Products , Ver. 4.0, 06.10.2021, EPD Norway.

 Global program operator	<b>Program operator and publisher</b> The Norwegian EPD Foundation Post Box 5250 Majorstuen, 0303 Oslo, Norway	Phone: +47 977 22 020 e-mail: post@epd-norge.no web: www.epd-norge.no
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	<b>Author of the Life Cycle Assessment</b> LCA.no AS Dokka 6A, 1671 Kråkerøy, Norway	Phone: +47 916 50 916 e-mail: post@lca.no web: www.lca.no
	<b>Developer of EPD generator</b> LCA.no AS Dokka 6A, 1671 Kråkerøy, Norway	Phone: +47 916 50 916 e-mail: post@lca.no web: www.lca.no
	ECO Platform ECO Portal	web: www.eco-platform.org web: ECO Portal