

# Vinyl Composition Tile (VCT)

Premium Excelon®, Standard Excelon®  
Safety Zone™ Tile, Excelon® SDT™

ACCORDING TO EN 15804, ISO 14025 AND ISO 21930

## Commercial Flooring Leader

Armstrong Flooring™ is committed to delivering solutions that reduce the environmental impact of the buildings you create. From product design and raw material selection, to production and delivery, we work to demonstrate continuous improvement to remain a leader in commercial flooring.

Armstrong Flooring™ Vinyl Composition Tile (VCT) is limestone-based flooring tiles with a PVC binder, featuring a through-pattern construction. VCT with through-color/pattern wear layer retains its color, pattern and appearance longer and has the durability and gouge resistance to withstand heavy foot and rolling load impact.

## Lifecycle Impact Categories

Cradle to grave environmental impacts for 1 m<sup>2</sup> of VCT.



**Primary Energy**  
121.92 MJ



**Eutrophication Potential**  
1.27E-03 kg (PO<sub>4</sub>)<sup>3-</sup>-eq.



**Global Warming Potential**  
5.41 kg CO<sub>2</sub>-eq.



**Ozone Depletion Potential**  
2.82E-09 kg R11-eq.



**Acidification Potential**  
0.020 kg SO<sub>2</sub>-eq.



**Photochem Ozone Creation Potential**  
0.31 kg O<sub>3</sub>-eq.

## Flooring Components:

Limestone Flour, Polyvinyl chloride (PVC), Dioctyl Terephthalate (DOTP),  
Blended Dibenzates, Recycled Material, Acrylate, Pigments

ArmstrongFlooring™



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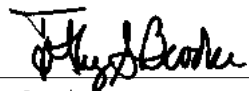
This document is a Type III Environmental Product Declaration by Armstrong Flooring™ that is certified by ASTM as conforming to the requirements of ISO 14025, EN 15804 and ISO 21930. ASTM has assessed that the Life Cycle Assessment (LCA) information fulfills the requirements of ISO 14040 in accordance with the instructions listed in the product category rules cited below. The intent of this document is to further the development of environmentally compatible and sustainable construction methods by providing comprehensive environmental information related to potential impacts in accordance with international standards.

<b>Declaration Number</b>	EPD-0004
<b>Program Operator</b>	ASTM International - 100 Barr Harbor Drive, West Conshohocken, PA, 19428, USA www.astm.org
<b>Manufacturer</b>	Armstrong Flooring, Inc. - 2500 Columbia Avenue, Lancaster, PA 17603
<b>Declared Product &amp; Functional Unit</b>	Vinyl Composition Tile, 1 m <sup>2</sup>
<b>Reference PCR</b>	Part A: PCR for building-related products, 2018 Part B: Flooring EPD Requirements [UL Environment], v2.0 September, 2018
<b>Product Application</b>	Floor covering choice in commercial spaces: • Healthcare • Education • Retail • Hospitality • Office
<b>Product Reference Service Life</b>	30 Years
<b>Markets of Applicability</b>	North America
<b>Date of Issue</b>	June 20, 2020
<b>Date of Validity</b>	5 Years
<b>EPD Type</b>	Product Specific
<b>EPD Scope</b>	Cradle to Grave
<b>Year of Primary Data</b>	2017-2018
<b>LCA Software &amp; Version</b>	GaBi v8.7.1.30
<b>LCI Database(s) &amp; Version</b>	GaBi 2017
<b>LCIA Method</b>	TRACI 2.1

## Verification and Authorization of the Declaration

This declaration and the rules on which this EPD is based have been examined by an independent external verifier in accordance with ISO 14025 and ISO 21930.

This life cycle assessment was independently verified in accordance with ISO 14044 and the reference PCR by:

X 

Tim Brooke  
Vice President, Certification

**Date**  
**June 20, 2020**

X 

Tom Gloria  
External Verifier

**Date**  
**June 20, 2020**

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## 2.0 Product Introduction

### 2.1 Company Description

AHF Products is a leader in the design and manufacturing of flooring. The Armstrong Flooring™ brand’s innovative commercial flooring designs and our comprehensive solutions enable exceptional interior spaces that surpass clients’ expectations. Choose from a breadth of designs and colors to bring a space to life. Our collections of vinyl flooring enhance commercial spaces in healthcare, assisted living, education, corporate, hospitality, retail and more. For more information, visit [ArmstrongFlooring.com](http://ArmstrongFlooring.com).

### 2.2 Product Description

Armstrong Flooring™ Vinyl Composition Tile (VCT) is limestone-based flooring tiles with a PVC binder, featuring a through-pattern construction. After years of foot and rolling load traffic, the pattern of the flooring is preserved; wear is less visible and can be restored using simple maintenance methods.

#### 2.2.1 Brands

Premium Excelon®, Standard Excelon®, Safety Zone™ Tile, Excelon® SDT™

#### 2.2.2 Specifications

Armstrong Flooring™ VCT meets or exceeds the performance requirements of ASTM F1066, Standard Specification for Vinyl Composition Tile

#### 2.2.3 Product Specific EPD

This EPD is intended to represent product specific life cycle assessment results for the Armstrong Flooring™ VCT brands in Section 2.2.1

### 2.3 Application

VCT is a widely used commercial resilient flooring option and is routinely used with great success in healthcare, education, and retail segments. Properly installed and maintained, VCT provides decades of proven performance across all commercial segments.

### 2.4 Declaration of Methodological Framework

The Life Cycle Assessment (LCA) was performed according to ISO 14040 and followed the PCR instructions. The cradle-to-grave LCA encompasses all relevant life cycle stages and modules including raw material production; transport of raw materials to the production facility; manufacturing of flooring; packaging; transportation to job site; use phase; and end of life including disposal or recycling. Detailed information regarding cut-off and allocation procedures are in sections 2.5 and 2.9.

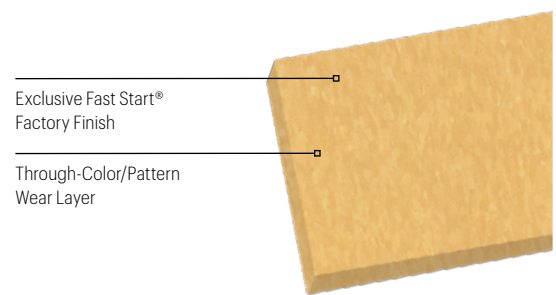
### 2.5 Technical Data

**Table 1: Armstrong Flooring VCT Technical Data**

Armstrong Flooring VCT	Average Value	Unit	Min. Value	Max. Value
Product Thickness	3.2 (0.125)	mm (in.)	-	-
Wear Layer Thickness	3.2 (0.125)	mm (in.)	-	-
Product Weight	7030 (1.4)	g/m <sup>2</sup> (lbs.)	-	-
Product Form	Tile		12 in x 12 in	12 in x 24 in

**Figure 1. Example product structure for VCT**

#### Product Structure



## 2.6 Market Placement / Application Rules

All Armstrong Flooring™ VCT meets or exceeds the performance requirements of ASTM F1066, Standard Specification for Vinyl Composition Floor Tile. It meets the below performance requirements for the following test methods:

**Table 2: VCT Performance and Test Methods**

ASTM F1066			
Performance	Test Method	Requirement	Performance vs. Requirement
Thickness	ASTM F386	Nominal ± 0.005 in.	Meets
Size	ASTM F2055	± 0.016 in. per linear foot	Meets
Squareness	ASTM F2055	0.010 in. maximum	Meets
Indentation – One Minute	ASTM F1914	≥ 0.006 in. to ≤ 0.015 in.	Meets
Indentation @ 115°F	ASTM F1914	< 0.032 in.	Meets
Impact	ASTM F1265	No cracks beyond limit	Meets
Deflection	ASTM F1304	1.0 in. minimum	Meets
Dimensional Stability	ASTM F2199	≤ 0.024 in. per linear foot max.	Meets
Chemical Resistance	ASTM F925	No more than slight change in surface dulling, attack or staining	Meets
Resistance to Heat	ASTM 1514	ΔE not greater than 8.0	Meets
Static Load Resistance @ 125 psi	ASTM F970	≤ 0.005 in.	Meets
Additional Testing			
Static Load Resistance	ASTM F970*	≤ 0.005 in.	2000 psi
Fire Test Data – Flame Spread	ASTM E648	0.45 W/cm <sup>2</sup> or more Class I	Meets
Fire Test Data – Smoke Evolution	ASTM E662	450 or less	Meets
Fire Test Data – Canada	CAN/ULC S-102.2	Use dependent	Flame Spread - 0 Smoke Developed - 5
ADA Standards for Accessible Design	ADA Standards for Accessible Design	Floor surfaces shall be stable, firm and slip-resistant	Meets
Static Coefficient of Friction*	ASTM D2047/ UL 410	≥ 0.5	Meets

\* Testing at loads above 125 psi is outside the scope of the test method. Since testing is conducted on uninstalled flooring, results do not consider the performance of the adhesive, underlayment, or subfloor. These test results are not an indicator of the installed flooring system performance

\*\* Using the James Machine as described in D2047 and as directed in UL 410 for floor covering materials (FCM) using a leather foot under dry conditions. The application of site-applied floor sealers, polishes and other types of finishes routinely used to maintain resilient flooring materials will change the walking surface and consequently the SCOF value.

## 2.7 Material Composition

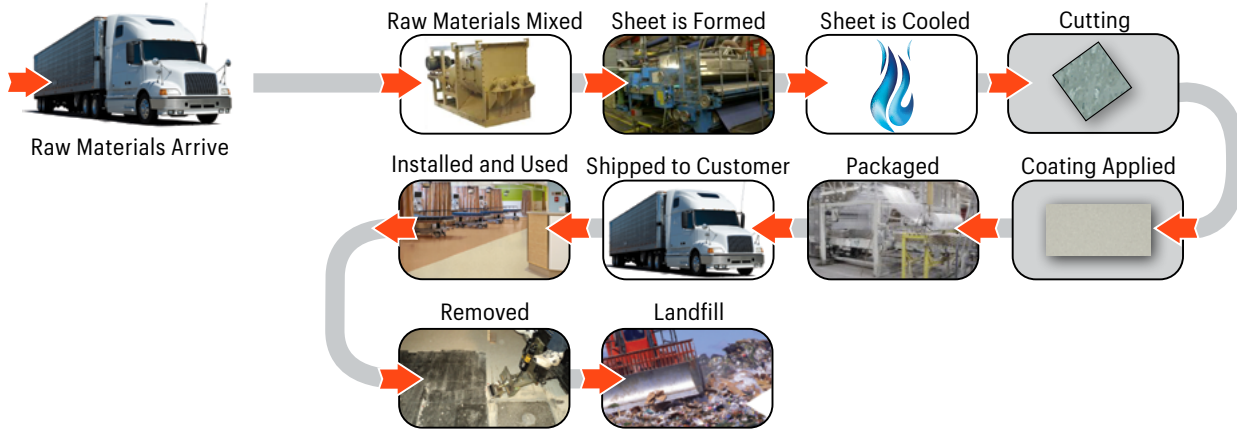
**Table 3: Material Composition for Armstrong Flooring™ VCT**

Material Content	Function	CASRN	Quantity (% by weight)	Availability	
Limestone Flour	Filler	1317-65-3	80-85%	Abundant Mineral	Non-Renewable
Polyvinyl Chloride (PVC)	Binder/Film	9002-86-2	5-10%	Fossil Limited	Non-Renewable
		9003-22-9			
Diethyl Terephthalate (DOTP)	Plasticizer	6422-86-2	1-5%	Fossil Limited	Non-Renewable
Blended Dibenzates	Plasticizer	120-55-8	1-5%	Fossil Limited	Non-Renewable
		19224-26-1			
		21738-31-4			
Recycled Material	Binder	N/A	5%	Fossil Limited	Non-Renewable
Acrylate	Coating	52408-84-1	0.0%	Fossil Limited	Non-Renewable
Pigments	Titanium Dioxide	13463-67-7	0.5-1%	Abundant Mineral	Non-Renewable
	Colored Pigment	Various	0.01-0.1%		

## 2.8 Manufacturing

Vinyl Composition Tile is floor tile primarily used in commercial flooring applications and is comprised mostly of limestone in a vinyl binder matrix. The manufacturing process involves the hot mixing of the raw materials milled and calendered into a hot sheet that is then cooled before punching into floor tiles. VCT will have a factory applied finish to protect the tile face during packaging and installation.

**Figure 2: Process for Manufacturing Vinyl Composition Tile**



## 2.9 Packaging

Armstrong Flooring™ VCT is packaged in a recyclable corrugated box and placed on a wooden pallet for shipping.

## 2.10 Installation

Armstrong Flooring™ VCT must be installed in strict accordance with the Armstrong Flooring™ Installation Instructions. The Installation Instructions provide all the information needed to properly install Armstrong Flooring™ VCT to ensure it will look great and perform exactly as it should. Visit [ArmstrongFlooring.com](http://ArmstrongFlooring.com).

## 2.11 Use Conditions

Recommended maintenance practices are provided in the installation guide and are required as part of the warranty. Warranty details can be found at [ArmstrongFlooring.com](http://ArmstrongFlooring.com). For Armstrong Flooring™ VCT, the recommended maintenance is representative of medium intensity maintenance, as shown in Table 6. Because maintenance procedures often vary depending on the building owner's maintenance practices, level of use, and traffic conditions, Table 6 provides low, medium and high maintenance scenarios. The low intensity maintenance scenario results in lower environmental impacts. For example, less scrubbing means less water consumption and a lower eutrophication potential.

## 2.12 Reference Service Life & Estimated Building Service Life

Per the PCR, this product has a 25 year reference service life and is intended for a building with a 75-year estimated service life.

## 2.13 Disposal

At the end of life, this product is assumed to be disposed per PCR requirements (UL, 2018) as shown in Table 4. Waste classification is based on the Resource Conservation and Recovery Act. Disposal in municipal landfill or commercial incineration facilities is permissible and should be done in accordance with local, state, and federal regulations.

**Table 4: End of Life Assumptions**

Component	Recycled	Landfilled	Incinerated
Product	0%	100%	0%
Paper Packaging	75%	20%	5%

## 2.14 Further Information

Please visit [ArmstrongFlooring.com](http://ArmstrongFlooring.com) for additional information regarding Armstrong Flooring™ VCT.

## 3.1 Functional Unit

The functional unit for this EPD is 1 m<sup>2</sup> of 2.0 mm Armstrong Flooring™ VCT for use over 1 year. Flooring System View: In order to understand the complete view of a flooring system, life cycle information is included for the total flooring system based on 1 square meter (m<sup>2</sup>) view. This includes the flooring, adhesives and finishes applied during the use stage.

## 3.2 System Boundaries

The system boundaries studied as part of this life cycle assessment include the following stages which are shown in Table 4:

Production stage – Modules A1 to A3 which include the extraction manufacture and transportation of raw materials flooring production.

Construction Stage – Modules A4-A5 which include the transportation to job site and installation.

Use Stage – Includes on Modules B2 (Use) and B4 (Replacement) as the other modules B1, B3 and B5-B7 are declared as having zero impact as no repair or refurbishment is expected once the product is installed. The use stage accounts for cleaning of the floor.

End-of-Life – Modules C1-C4 which include disposal

Each module includes provisions of all relevant materials, products and energy. Potential impacts and waste are consider in the module in which they occur. Per the PCR, capital goods and infrastructure flows are assumed to not significantly affect LCA results or conclusions and thus are excluded from the analysis.

**Table 5: Construction Works Assessment Information**

Production Stage	Construction Stage	Use Stage	End-Of-Life Stage
Extraction & Upstream Production A1			
Transport to Factory A2			
Manufacturing A3			
Transport to Site A4			
Installation A5			
Use B1			
Maintenance B2			
Repair B3			
Replacement B4			
Refurbishment B5			
Operational Energy Use B6			
Operational Water Use B7			
De-construction / Demolition C1			
Transport to waste processing or Disposal C2			
Waste Processing C3			
Disposal C4			
X	X	X	X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X
X	X		X

### 3.3 Product for Use Phase (Module B1-B7)

For this study, it was assumed that VCT would last 25 years and therefore would need to be replaced 2 times over the building’s useful life if properly installed and maintained. The useful life indicated in the PCR for flooring is 75 years. Recommended maintenance practices are provided in the Armstrong Flooring™ Installation Instructions and required as part of the warranty. For VCT, the recommended maintenance is representative of medium intensity maintenance, as shown in Table 6. Because maintenance procedures often vary depending on the building owner’s maintenance practices, level of use, and traffic conditions, Table 6 provides low, medium and high maintenance scenarios.

**Table 6: Estimated Maintenance Intensity & Assumptions**

Maintenance Schedule	Number Of Times Performed In 1 Year (365 Days)			Additional Resource Consumption
	Low	Medium	High	
Sweep/Dry Mop	260	260	260	None
Damp Mop	26	52	104	Water, pre-diluted cleaner
Scrubbing/Spray Buff	6	12	24	Floor finish, electricity
Stripping/Floor Finish	1	2	4	

### 3.4 Units

The PCR require SI units for all LCA results.

### 3.5 Estimations and Assumptions Transportation

Per the PCR (UL, 2018) a distance of 800 km (497 miles) by diesel-powered truck is used to represent the distribution of product to the installation site. For products manufactured outside of the United States, inbound transportation by cargo ship is also included. Additionally, transportation is assumed to be 161 km (100 miles) by diesel-powered truck for the following:

- Product to building site
- Installation waste to disposal
- Deconstructed product to end of life destination

### 3.6 Cut-off Rules

Cut-off rules are consistent with PCR (UL, 2018). No known flows were deliberately excluded.

### 3.7 Data Sources

All gate-to-gate, primary foreground data was collected for the flooring manufacturing process. This foreground data was from annual production for the year of 2017. Relevant background data was taken from the database provided in the GaBi 8.7.1.30 software system for life cycle engineering. The GaBi database provides the life cycle inventory data for the raw and process materials obtained from the background system.

### 3.8 Data Quality

A variety of tests and checks were performed throughout the project to ensure high quality of the completed LCA. Checks included data verification and triangulation against several sources including published LCA studies. Overall, the data quality is considered to be good to high quality.

**Temporal:** All of the primary data is taken from 12 months of continuous operation in the 2017 calendar year. All secondary data were obtained from the GaBi 2018 databases.

**Geographical:** All primary and secondary data were collected specific to the countries or regions under study. Where country-specific or region-specific data were unavailable, proxy data were used. Geographical representativeness is considered to be high.

**Technological:** All primary and secondary data were modeled to be specific to the technologies or technology mixes under study. Where technology-specific data were unavailable, proxy data were used. Technological representativeness is considered to be high.

### 3.9 Period under review

Primary data was collected during 2018. This analysis is intended to represent production in 2017.

### 3.10 Allocation

No co-product or multi-input process allocation occurs in the product system. For reuse, recycling, and recovery allocation, the cut-off allocation approach is adopted in the case of any recycled content, which is assumed to enter the system burden-free. Only environmental impacts from the point of recovery and forward (e.g., collection, sorting, processing, etc.) are considered. With the exception of biobased packaging waste, product and packaging waste is modeled as being disposed in a landfill rather than incinerated or recycled. Plastic and other construction waste is assumed to be inert in landfills so no system expansion or allocation is necessary as landfill gas is not produced. In the case of biobased packaging waste disposed during installation, landfill gas from the decomposition of this waste is assumed to be collected and used to produce electricity. It is assumed that this recovered energy offsets energy produced by the U.S. average grid.

### 3.11 Comparability and Benchmarking

EPDs from different Program Operators may not be comparable. EPD comparability may only be achieved when product category definition and description are identical, all life cycle stages are considered, the scope and goals of the LCA are identical and other requirements identified in ISO 14025 are met. Armstrong Flooring™ EPDs are comparable.

### Life Cycle Assessment Scenarios

The following information is required by the PCR to be documented.

**Table 7: Transportation to the Building Site (A4)**

Name	Value	Unit
Fuel Type	Diesel	-
Liters of Fuel	35	L/100 km
Vehicle Type	Truck (trailer)	-
Transportation Distance	800	km
Capacity Utilization (including Empty Runs, Mass Based)	78	%
Gross Density of Products Transported	2.1	kg/m <sup>2</sup>
Capacity Utilization Volume Factor	1	-



**Table 8: Installation into the Building (A5)**

Name	Value	Unit
Ancillary Materials	0.37	kg
Electricity Consumption	0.02	MJ
Waste Materials at the Construction Site	0.26	kg

**Table 9: Reference Service Life**

Name	Value	Unit
Reference Service Life	25	years

**Table 10: Maintenance (B2)**

Name	Value	Unit
Maintenance Process Information (Cite Source)	Armstrong Flooring™ Maintenance Recommendations	
Maintenance Cycle (Reference Service Life)	1,560 (weekly)	Cycles/RSL
Maintenance Cycle (Estimated Service Life)	3,900 (weekly)	Cycles/ESL
Net Freshwater Consumption: Municipal Water to POTW	0.11	kg/ESL
Ancillary Materials (Pre-diluted Cleaner)	306.7	L/ESL
Energy Input for Spray Buffing	5.67	kWh/ESL

**Table 11: Replacement (B4)**

Name	Value	Unit
Reference Service Life	30	Years
Replacement Cycle	1.5	-
Ancillary Materials (Adhesive)	0.56	kg
Electricity Consumption	0.03	MJ
Waste Materials at the Construction Site	0.39	kg

**Table 12: End of Life (C1-C4)**

Name	Description	Value	Unit
Collection Process	Collect Separately	3.3	kg
Disposal	Product or Materials for Final Disposition	3.3	kg

## 4.0 Life Cycle Assessment Results

The results in this EPD represent product specific results for one square meter of Armstrong Flooring™ products. Caution should be used when trying to compare the results presented in this EPD to other products.

### 4.1 Life Cycle Assessment Impact Results

Results for the life cycle assessment are presented in the tables below. The Product Category Rules for Flooring require impacts be calculated for a building life of 75 years. This means that during a 75 year time frame, the floor is manufactured, installed, maintained, and replaced multiple times depending upon the floor's reference service life. The estimated reference service life for the VCT product is provided in Table 9. The total 75-year impacts are calculated by adding the values from all of the modules plus 74 times the impact value shown in module B2. Additionally, impacts for a 1-year service life including disposal are shown in the tables below.

**Table 13: Impact Assessment Results for 1 m<sup>2</sup> of VCT**

VCT	TRACI 2.1 IMPACT CATEGORY	Global Warming Air, incl. Biogenic Carbon	Ozone Depletion Air	Acidification	Eutrophication	Smog Air	Resources, Fossil Fuels
	Units	kg CO2 eq.	kg CFC 11 eq.	kg SO2 eq.	kg N eq.	kg O3 eq.	MJ
Production	A1-A3	3.52	0.00	0.01	0.00	0.16	7.58
Transport	A4	0.71	0.00	0.00	0.00	0.08	1.35
Install	A5	0.43	0.00	0.00	0.00	0.02	2.03
Maintain	B2	0.31	0.00	0.00	0.00	0.01	0.78
Replace	B4	9.905	5.64E-09	3.72E-02	2.18E-03	0.570	23.078
Transport	C2	0.148	0.000	0.001	0.000	0.016	0.278
Disposal	C4	0.293	0.000	0.001	0.000	0.026	0.577
Recycling	D	0	0	0	0	0	0
<b>Total</b>	<b>1 Year</b>	5.41	2.82E-09	0.020	1.27E-03	0.31	12.60
<b>Total</b>	<b>75 Years</b>	25.478	8.64E-09	0.104	0.012	1.74	93.47

## 4.2. Life Cycle Inventory Results

Tables 14 and 15 provide life cycle inventory results for products included in this EPD. Inventory data are not included for non-renewable primary energy resources used as raw materials, use of secondary materials (SM), use of renewable secondary fuels (RSF), or use of non-renewable secondary fuels (NRSF) as values for these inventory categories are zero.

**Table 14: Resources Use for 1 m<sup>2</sup> of VCT**

VCT	Resource Use Parameters	Total Use of Renewable Primary Energy Resources	Renewable Primary Energy Used as Energy Carrier	Total Use of Non-Renewable Primary Energy Resources	Non-Renewable Primary Energy Used as Energy Carrier	Use of Net Fresh Water Resources (FW)
	Units	[MJ, LHV]	[MJ, LHV]	[MJ, LHV]	[MJ, LHV]	[m <sup>3</sup> ]
Production	A1-A3	7.59	7.59	76.77	76.77	0.02
Transport	A4	0.31	0.31	10.90	10.90	0.00
Install	A5	0.11	0.11	16.10	16.10	0.00
Maintain	B2	0.32	0.32	7.12	7.12	0.00
Replace	B4	17.48	17.48	236.22	236.22	0.03
Transport	C2	0.06	0.06	2.25	2.25	0.00
Disposal	C4	0.35	0.35	4.97	4.97	0.00
Recycling	D	0.00	0.00	0.00	0.00	0.00
<b>Total</b>	<b>1 Year</b>	8.74	8.74	118.11	118.11	0.02
<b>Total</b>	<b>75 Years</b>	49.75	49.75	881.21	881.21	-0.23

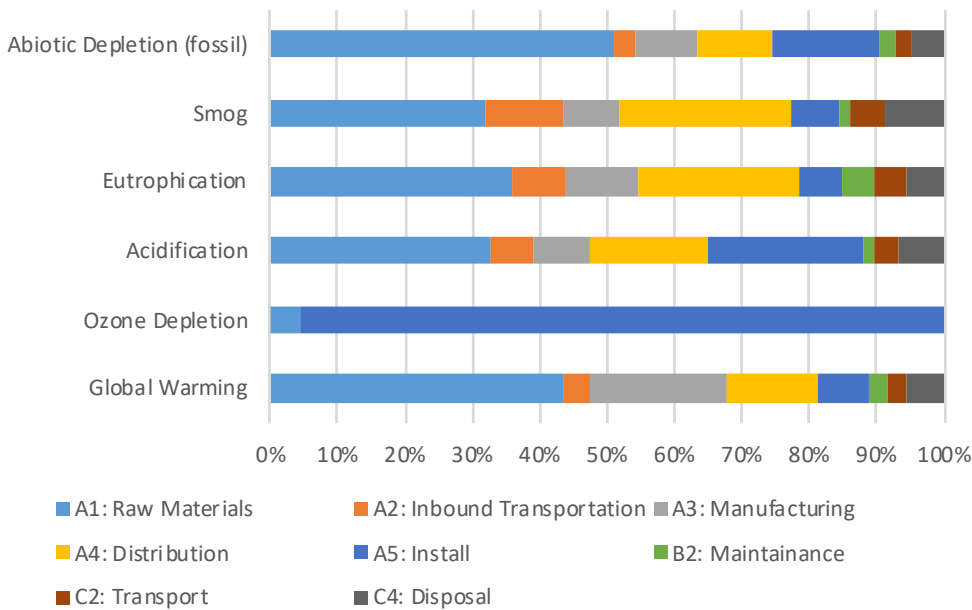
**Table 15: Outflows and Waste Categories for 1 m<sup>2</sup> of VCT**

VCT	Outflows and Waste Categories	Harardous Waste Disposed (HWD)	Non-Harardous Waste Disposed (NHWD)	High Level Radioactive Waste Disposed (HLRW)	Intermediate Low Level Radioactive Waste (ILLRW)	Exported Energy, Electrical	Exported Energy, Thermal
	Units	kg	kg	kg	kg	[MJ, LHV]	[MJ, LHV]
Production	A1-A3	1.35E-04	3.67E-01	-3.31E-06	-2.69E-03	0	0
Transport	A4	8.20E-08	3.81E-04	-2.70E-08	-2.19E-05	0	0
Install	A5	7.27E-09	4.27E-01	-4.22E-08	-3.43E-05	1.08E-04	5.07E-05
Maintain	B2	5.85E-09	1.03E-02	-2.03E-07	-1.66E-04	0	0
Replace	B4	2.70E-03	1.47E+01	-7.28E-06	-5.92E-03	2.16E-04	1.01E-04
Transport	C2	1.69E-08	7.88E-05	-5.59E-09	-4.53E-06	0	0
Disposal	C4	1.61E-08	6.75E+00	-5.59E-08	-4.36E-05	0	0
Recycling	D	0	0	0	0	0	0
<b>Total</b>	<b>1 Year</b>	1.35E-04	7.37E+00	-3.64E-06	-2.69E-03	1.08E-04	5.07E-05
<b>Total</b>	<b>75 Years</b>	4.05E-04	2.29E+01	-2.60E-05	-2.11E-02	3.42E-04	1.52E-04

### 5.0 LCA Interpretation

Under the 75-year building service life assumption, product manufacturing (A1-A3) and recommended maintenance (B2) are the largest contributors to most impacts categories considered. The production of raw materials as shown in Figure 4, represents a substantial fraction of potential impact, even over the life of a building. The potential impact of floor maintenance adds up over time and are relevant contributors to the life cycle. Transportation of the flooring product from the manufacturing facility to the installation site (A4) is a relatively minor contributor to all impact categories. Replacement (B4) is a key contributor, because it represents the production (A1-A3), installation (A5) and disposal of replacement products (B4) needed to satisfy the 75-year building service. The PCR assumes that all flooring product have the same durability, however more durable products will have lower impact.

**Figure 3. One-Year Life Cycle Impacts for VCT**



## 6.0 Additional Environmental Information

The PCR assumes that all flooring product have the same durability, however more durable products will have lower impact.

### 6.1 Environment and Health During Manufacturing

All Armstrong Flooring™ manufacturing plants maintain an Environmental Management System (EMS) in accordance with ISO 14001 which includes continuous environmental performance targets.

Additionally, Armstrong Flooring™ has a robust internal Quality Assurance process that is based on industry-accepted best practices and is led by a team of quality professionals who have been certified by the American Society for Quality. The process involves several hundred different measures made throughout the manufacturing processes.

### 6.2 Environment and Health During Installation and Use.

All Armstrong Flooring™ products are tested and certified by FloorScore® to comply with the requirements of the California Department of Public Health Standard for the Testing and Evaluation of VOC emissions (CDPH v1.2).

## 7.0 References

Armstrong Flooring™ Installation Instructions found at [ArmstrongFlooring.com](https://www.armstrongflooring.com).

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