Environmental Product Declaration

NRMCA MEMBER INDUSTRY-WIDE EPD FOR READY MIXED CONCRETE
NSF International Certified

This industry-wide or sector average environmental product declaration is in accordance with ISO 14025 and describes the environmental characteristics of 48 ready mixed concrete products. It is a certified declaration and all relevant environmental information is disclosed as per the governing product category rules. Attachment 1, included at the end of this EPD, is a list of plants that are eligible to claim participation in the NRMCA Industry Wide EPD for concrete.

| PROGRAM OPERATOR | NSF International  
|                  | 789 N. Dixboro  
|                  | Ann Arbor, MI 48105  
|                  | www.nsf.org |
| DECLARATION HOLDER | The National Ready Mixed Concrete Association (NRMCA)  
|                   | 900 Spring Street  
|                   | Silver Spring, MD 20910  
|                   | www.nrmca.org |
| DECLARATION NUMBER | EPD10046 |
| DECLARED PRODUCT | This industry wide EPD covers 48 ready mixed concrete products on a per cubic meter (cubic yard) basis |
| REFERENCE PCR | Product Category Rules (PCR) for ISO 14025 Type III Environmental Product Declarations (EPDs) for Concrete meeting the requirements of one of the following: ASTM C94, ASTM C90, CSA A23.1/A23.2, UNSPSC code 30111500, Version 1.1 dated December 4, 2013, The Carbon Leadership Forum; www.carbonleadershipforum.org |
| DATE OF ISSUE | October 10, 2014 |
| PERIOD OF VALIDITY | Until October 10, 2019 |
| CONTENTS OF THE DECLARATION | Declares a cradle-to-gate (A1 to A3) assessment of 48 ready mixed concrete products-capturing a significant spectrum of the industry’s production |

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December 4, 2013

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Description of Industry and Product

There are approximately 7,000 plants across the ready mixed concrete industry in the U.S. and Canada. NRMCA estimates that their membership represents 30% of all companies and 50% of all plants operating in 2012. A survey of NRMCA members as participating in this project (see Appendix A) revealed that the majority (>85%) of ready mixed concrete plants are of the truck-mixed type (sometimes called transit-mix) where concrete is batched at a fixed plant location and mixed in truck mixers. Over 95% of plants use supplementary cementitious materials (SCM) to portland cement in their ready mixed concrete products sometimes called mix designs, mixes, mixture compositions or mixture.

Each NRMCA member produces hundreds if not thousands of possible ready mixed concrete (RMC) products (mix designs), which ultimately balance the cost and performance of concrete for a wide variety of applications. For purposes of this NRMCA member Industry-Wide EPD, a conservative approach was taken to arrive at a workable list of 48 RMC products (mix designs) that could pragmatically capture a high proportion of the RMC produced by NRMCA members identified in this EPD.

The typical process for developing mix designs is 1) a design professional or purchaser of concrete states a specified compressive strength and other performance criteria for the concrete in contract documents, and 2) the concrete producer develops a mix design, or proportions, to meet the specified compressive strength and other performance criteria using an accepted mix proportioning methodology such as the ACI recommended practice 211.1, the most common method used in North America. For this EPD, the NRMCA provided mixture proportions using the ACI 211.1 process for 6 different specified compressive strengths and 8 different typical mixture compositions that would meet the specified compressive strength resulting in 48 products.

Declared Product Range Classification

Table 1 lists the 48 ready mixed products considered in the LCA and EPD. They have been purposely enumerated as having a range of mixture components and properties to cover a significant range of possible products and to conservatively estimate life cycle impact indicators; i.e., all product cradle-to-gate life cycle impact indicators and resource use metrics are calculated at the upper bound of the strength class range and lower bound of the indicated SCM percentage and thus, provide a conservative estimate of the life cycle impacts associated with each product. The product name is represented by the specified compressive strength and the quantity (%) of portland cement and SCMs (either fly ash or slag cement or both) used to estimate the life cycle impact indicators and resource use metrics.
Environmental Product Declaration

NRMCA
Ready-Mixed Concrete

According to ISO 14025

Environmental Product Declaration

How To Use This Table

NRMCA members participating in this project (see Attachment 1) may use Table 1 to claim compliance with this EPD.

Most products proposed for a project will likely not have the precise specified compressive strength and proportions listed in this EPD. One can use Table 1 to classify a proposed product to match one of the products listed in the EPD as follows:

**Step 1:** Identify the 28-day specified compressive strength of the proposed product and the percentage of fly ash and/or slag cement (e.g. 100 x fly ash quantity / total cementitious materials quantity)

**Step 2:** In Table 1 identify the specified compressive strength range that captures the specified compressive strength of the proposed product (Column 1).

**Step 3:** Within that specified compressive strength range row, identify the SCM percentage range that matches the SCM percentage of the proposed product (Column 2). For ternary mixes (mixes containing portland cement, fly ash and slag cement) between 20% and 49% SCM (fly ash plus slag percentage) take the largest percentage of either fly ash or slag cement and use that value to select the SCM range to use. For example, if the proposed mix has 15% fly ash and 40% slag cement, use the 40-49% slag range.

**Step 4:** In that row, move to Column 3 to identify the product name that can be used to look up the life cycle impacts listed in Tables 6 through 11a for either 1 cubic meter or 1 cubic yard of product. Reference this EPD and the “Product Name” listed in column 3 in any compliance statement/literature (e.g., weigh bill) accompanying the product.

### Table 1: Declared Product Range Classification

<table>
<thead>
<tr>
<th>Specified Compressive Strength range (Column 1)</th>
<th>SCM range (%) (Column 2)</th>
<th>Product Name (Column 3)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-2500 psi (0-17.24 MPa)</td>
<td>0-19% Fly Ash and/or Slag</td>
<td>2500-00-FA/SL</td>
</tr>
<tr>
<td></td>
<td>20-29% Fly Ash</td>
<td>2500-20-FA</td>
</tr>
<tr>
<td></td>
<td>30-39% Fly Ash</td>
<td>2500-30-FA</td>
</tr>
<tr>
<td></td>
<td>40-49% Fly Ash</td>
<td>2500-40-FA</td>
</tr>
<tr>
<td></td>
<td>30-39% Slag</td>
<td>2500-30-SL</td>
</tr>
<tr>
<td></td>
<td>40-49% Slag</td>
<td>2500-40-SL</td>
</tr>
<tr>
<td></td>
<td>≥ 50% Slag</td>
<td>2500-50-SL</td>
</tr>
<tr>
<td></td>
<td>≥ 20% Fly Ash and ≥ 30% Slag</td>
<td>2500-50-FA/SL</td>
</tr>
<tr>
<td>2501-3000 psi (17.25-20.68 MPa)</td>
<td>0-19% Fly Ash and/or Slag</td>
<td>3000-00-FA/SL</td>
</tr>
<tr>
<td></td>
<td>20-29% Fly Ash</td>
<td>3000-20-FA</td>
</tr>
<tr>
<td></td>
<td>30-39% Fly Ash</td>
<td>3000-30-FA</td>
</tr>
<tr>
<td></td>
<td>40-49% Fly Ash</td>
<td>3000-40-FA</td>
</tr>
<tr>
<td></td>
<td>30-39% Slag</td>
<td>3000-30-SL</td>
</tr>
<tr>
<td></td>
<td>40-49% Slag</td>
<td>3000-40-SL</td>
</tr>
<tr>
<td></td>
<td>≥ 50% Slag</td>
<td>3000-50-SL</td>
</tr>
<tr>
<td></td>
<td>≥ 20% Fly Ash and ≥ 30% Slag</td>
<td>3000-50-FA/SL</td>
</tr>
<tr>
<td>3001-4000 psi (20.69-27.58 MPa)</td>
<td>0-19% Fly Ash and/or Slag</td>
<td>4000-00-FA/SL</td>
</tr>
<tr>
<td></td>
<td>20-29% Fly Ash</td>
<td>4000-20-FA</td>
</tr>
<tr>
<td></td>
<td>30-39% Fly Ash</td>
<td>4000-30-FA</td>
</tr>
<tr>
<td></td>
<td>40-49% Fly Ash</td>
<td>4000-40-FA</td>
</tr>
<tr>
<td></td>
<td>30-39% Slag</td>
<td>4000-30-SL</td>
</tr>
<tr>
<td></td>
<td>40-49% Slag</td>
<td>4000-40-SL</td>
</tr>
<tr>
<td></td>
<td>≥ 50% Slag</td>
<td>4000-50-SL</td>
</tr>
<tr>
<td></td>
<td>≥ 20% Fly Ash and ≥ 30% Slag</td>
<td>4000-50-FA/SL</td>
</tr>
</tbody>
</table>
Table 1: Declared Product Range Classification Cont’d

<table>
<thead>
<tr>
<th>Strength Range</th>
<th>0-19% Fly Ash and/or Slag</th>
<th>20-29% Fly Ash</th>
<th>30-39% Fly Ash</th>
<th>40-49% Fly Ash</th>
<th>30-39% Slag</th>
<th>40-49% Slag</th>
<th>≥ 50% Slag</th>
<th>≥ 20% Fly Ash and ≥ 30% Slag</th>
</tr>
</thead>
<tbody>
<tr>
<td>(27.59-34.47 MPa)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5001-6000 psi</td>
<td>6000-00-FA/SL</td>
<td>6000-20-FA</td>
<td>6000-30-FA</td>
<td>6000-40-FA</td>
<td>6000-30-SL</td>
<td>6000-40-SL</td>
<td>6000-50-SL</td>
<td>6000-50-FA/SL</td>
</tr>
<tr>
<td>(34.48-41.37 MPa)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(41.38-55.16 MPa)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Product Standard

Products covered by this EPD satisfy general purpose concrete as used in residential, commercial and public works applications in the US and Canada. This EPD reports the impacts for a range of ready mixed concrete products in accordance with the following:

- ACI 211: Standard Practice for Selecting Proportions for Normal, Heavy-weight, and Mass Concrete
- ACI 318: Building Code Requirements for Structural Concrete
- ASTM C94: Standard Specification for Ready Mixed Concrete
- CSA A23.1-09/A23.2-09 (R2014): Concrete materials and methods of concrete construction/test methods and standard practices for concrete
- CSI MasterFormat Division 03-30-00: Cast-In-Place Concrete
- UNSPSC Code 30111500: Ready Mix Concrete
### Cradle-to-Gate Life Cycle of Concrete

#### Business-to-Business EPD and Cradle-to-Gate LCA

This EPD is intended for use in Business to Business (B-to-B) communication. The scope of this EPD is cradle-to-gate and considers the following life cycle stages.

- **A1 - Raw Material Supply (upstream processes):** Extraction, handling and processing of the raw materials used in the production of concrete: cement, supplementary cementitious materials, aggregate (coarse and fine), water, admixtures and other materials or chemicals used in concrete mixtures.
- **A2 - Transportation:** Transportation of these materials from the supplier to the ‘gate’ of the concrete producer.
- **A3 - Manufacturing (core processes):** The energy used to store, batch, mix and distribute the concrete and operate the facility (concrete plant). A3 also includes the water used in mixing and distributing concrete.

#### Figure 1: Cradle-to-gate product system for concrete

<table>
<thead>
<tr>
<th>A1 Raw Material Supply: Upstream Processes</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>NATURAL AGGREGATE</strong></td>
</tr>
<tr>
<td>Quarry Sort</td>
</tr>
<tr>
<td><strong>CRUSHED AGGREGATE</strong></td>
</tr>
<tr>
<td>Quarry Crush Sort</td>
</tr>
<tr>
<td><strong>CEMENT</strong></td>
</tr>
<tr>
<td>Material Input</td>
</tr>
<tr>
<td>Crush/Grind</td>
</tr>
<tr>
<td>Clinker production</td>
</tr>
<tr>
<td>&amp; handling</td>
</tr>
<tr>
<td>Grinding/ package</td>
</tr>
<tr>
<td><strong>SCM</strong></td>
</tr>
<tr>
<td>Secondary Material (waste)</td>
</tr>
<tr>
<td>Input Material Input</td>
</tr>
<tr>
<td>Process and Handling</td>
</tr>
<tr>
<td><strong>WATER</strong></td>
</tr>
<tr>
<td>Varies</td>
</tr>
<tr>
<td><strong>ADMIxTURES</strong></td>
</tr>
<tr>
<td>Varies</td>
</tr>
</tbody>
</table>

| A2 Transportation                        |

<table>
<thead>
<tr>
<th>A3 Manufacturing: Core Processes</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>PURCHASED ELECTRICITY</strong></td>
</tr>
<tr>
<td><strong>PURCHASED ELECTRICITY GREEN GRID</strong></td>
</tr>
<tr>
<td><strong>SITE GENERATED RENEWABLE ELECTRICITY</strong></td>
</tr>
<tr>
<td><strong>SITE GENERATED BIO BASED ELECTRICITY</strong></td>
</tr>
<tr>
<td><strong>NATURAL GAS</strong></td>
</tr>
<tr>
<td><strong>FUEL OIL</strong></td>
</tr>
<tr>
<td><strong>DIESEL</strong></td>
</tr>
<tr>
<td><strong>RECYCLED RETURNED CONCRETE</strong></td>
</tr>
<tr>
<td><strong>WASTE PROCESSES</strong></td>
</tr>
<tr>
<td><strong>WATER USE</strong></td>
</tr>
</tbody>
</table>
Methodology of Underlying LCA

Declared Unit

The declared units are 1 cubic meter and 1 cubic yard for 48 ready mixed concrete products. Key product variables include:

- **28-day Strength**: Six different specified compressive strengths are considered, 2,500 psi (17.3 MPa), 3,000 psi (20.7 MPa), 4,000 psi (27.6 MPa), 5,000 psi (34.5 MPa), 6,000 psi (41.3 MPa) and 8,000 psi (55.1 MPa);
- **Water to cementious materials ratio (w/cm)**: Varies, but lower for higher strength concrete mixtures in accordance with ACI 211.1;
- **SCM reactivity**: Assumes 75% reactivity for fly ash (FA) as compared to portland cement and 100% reactivity of slag cement (SL) as compared to portland cement based on NRMCA member feedback;
- **Admixtures use**: Products (mix designs) with specified compressive strengths less than or equal to 5,000 psi (34.5 MPa) included an air entraining admixture since many of these concretes would be exposed to freezing and thawing. Products with specified compressive strengths above 5,000 psi (34.5 MPa) did not include air entraining admixture since these higher strength concretes are rarely exposed to freezing and thawing; water reducing and accelerating admixtures were used across all mixes; high range water reducer admixtures were used in high strength mix designs (5,000psi (34.5 MPa) and above).

Product (mix design) components include: portland cement, fly ash, slag cement, natural and crushed aggregates, admixtures and batch water.
Scope of LCA

The life cycle stages included in this EPD are limited to raw materials and component products used in the manufacture of ready mixed concrete (A1), the transportation of these materials and components to the concrete plant (A2) and the manufacture of ready mixed concrete (A3) ready for shipment at the plant gate.

Life cycle stages excluded from this EPD include:

- Transport to the construction site;
- On-site construction processes and components (reinforcement, forms and form work, placing and curing);
- Building (infrastructure) use and maintenance; and
- End of life effects.

In addition, the following cycle processes are excluded from this study:

- Production, manufacture and construction of buildings’ capital goods and infrastructure;
- Production and manufacture of concrete production equipment, concrete delivery vehicles, earthmoving equipment, and laboratory equipment;
- Personnel-related activities (travel, furniture, office supplies);
- Energy use related to company management and sales activities.

Cut-off Rules

The cut-off criteria for all activity stage flows considered within the system boundary conform with ISO14044:2006 and section 3.3 of the governing PCR. Specifically, the cut-off criteria were applied as follows:

- All inputs and outputs for which data are available are included in the calculated effects and no collected core process data are excluded.
- A one percent cut-off is considered for renewable and non-renewable primary energy consumption and the total mass of inputs within a unit process. The sum of the total neglected flows does not exceed 5% of all energy consumption and mass of inputs.
- All flows known to contribute a significant impact or to uncertainty (e.g., portland cement and admixtures) are included;
- The cut-off rules are not applied to hazardous and toxic material flows – all of which are included in the life cycle flow inventory.

Note: A significant portion (>85%) of North American concrete plants are truck-mixing plants where the concrete mixing occurs within mixer trucks after they are loaded at the project site; for these operations a portion of the delivery truck’s energy use that would typically be captured under “Construction and Process Stage” A4-Transportation (to site) is allocated to the mixing of concrete for truck-mixing plants and is captured in information module A3. This system boundary refinement addresses the difference between truck-mixing and central-mixing concrete plants where the latter plant type fully mixes the concrete prior to loading the concrete into delivery trucks.
Environmental Product Declaration

National Ready Mixed Concrete Association
Ready-Mixed Concrete According to ISO 14025

Allocation

The applied allocation procedures conform with ISO14044 clause 4.3.4.

Limitations

The limitations of this EPD include:

- This EPD does not report all of the environmental impacts due to manufacturing of the product, but rather reports the environmental impacts for those categories with established life-cycle assessment based methods to track and report. Unreported environmental impacts include (but are not limited to) factors attributable to human health, land use change, and habitat destruction.
- In order to assess the local impacts of product manufacturing, additional analysis is required.
- This EPD reports the results of an LCA or the ‘cradle-to-gate’ analysis. Thus, declarations themselves are not comparative assertions, defined as an environmental claim regarding the superiority or equivalence of one product versus a competing product that performs the same function. An EPD does not make any statements that the product covered by the EPD is better or worse than any other product.
- NRMCA members participating in the development of this EPD may participate in other sustainability or environmental best practice programs; however, no such additional environmental claim, declaration or claim is conveyed in this EPD.
- EPDs of concrete mixtures may not be comparable if they do not comply with this standard and data from this EPD. The data cannot be used to compare between concrete mixes, construction products or concrete mixtures used in different concrete products unless the data is integrated into a comprehensive LCA. For example, precast concrete, concrete masonry units and site cast concrete all have different manufacturing processes whose impacts are attributed to different LCA stages. This precludes direct comparison between mixtures used in these different products unless all life cycle phases are included.
- Life cycle impact assessment (LCIA) results are relative expressions and do not predict impacts on category endpoints, the exceeding of thresholds, safety margins or risks.
- This EPD does not cover any optional additional information specified in the PCR Section 3.2.
- This EPD is declared as an average environmental performance for a number of products. The range of results (the minimum, maximum, and individual mix results) are provided for each strength class.
- This EPD was created using industry average data for upstream materials. Variation can result from differences in supplier locations, manufacturing processes, manufacturing efficiency and fuel type used.

Data Sources and Data Quality Assessment

This EPD is based on foreground LCI data collected from a representative sample of 412 NRMCA ready mixed concrete production facilities located in the U.S. and Canada. These data, in combination with background datasets, were used to compile this EPD. All upstream material, resource and energy carrier inputs have been sourced from industry-average datasets and literature. Many of these datasets are defaulted to those specified for use in the CLF PCR. Care was taken to fill known data gaps (dummy processes) as recorded in the USLCI database profiles. Tables 2 to 4 describe each LCI data source for raw materials (A1), transportation by mode (A2), the RMC core manufacture process (A3 and A4), and descriptions of data quality for each data source.
### Table 2: A1 - Raw Material Supply

<table>
<thead>
<tr>
<th>Material/Unit</th>
<th>LCI data source [as per CLF PCR: 2013]</th>
<th>Geography</th>
<th>Year</th>
<th>Data Quality Assessment</th>
</tr>
</thead>
</table>
| Cement (lbs)           | MIT 2014 paper, Update of portland cement, at plant (USLCI). Modified to include upstream impacts of fuel and energy production | USA       | 2010 | • Technology: good  
Process represents average cement production in the U.S.  
• Time: Very good  
Data is within 4 years  
• Geography: very good  
• Completeness: good  
Data is based on an average of national production  
• Reliability: very good |
| Fly Ash (lbs)          | None, no incoming burden, only inbound transport was considered                                      | N/A       | N/A  | N/A                                                                                    |
| Silica Fume (lbs)      | None, no incoming burden, only inbound transport was considered                                      | N/A       | N/A  | N/A                                                                                    |
| Slag cement (lbs)      | LCI Slag Cement Manufacturing                                                                       | USA       | 2003 | • Technology: good  
Process models ground granulated blast furnace slag.  
• Time: fair  
Data is within eleven years.  
• Geography: very good  
• Completeness: good  
• Reliability: good |
| Crushed Aggregates (lbs) coarse and fine | ecoinvent process: “Gravel, crushed, at mine” ecoinvent 2.02, CLF PCR Default                  | EU        | 2004 | • Technology: good  
Processes represent aggregate, with and without crushing. Dust emissions are estimated from limestone mining.  
• Time: fair  
Data is within ten years.  
• Geography: fair  
Processes model Swiss production (no U.S. process in USLCI database).  
• Completeness: very good  
• Reliability: very good  
Data is verified by ecoinvent. |
### Table 2: A1 - Raw Material Supply Con't

<table>
<thead>
<tr>
<th>Material</th>
<th>Supply Description</th>
<th>Location</th>
<th>Year</th>
<th>Technology Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>**Natural Aggregates (lbs)</td>
<td>coarse and fine</td>
<td>EU</td>
<td>2004</td>
<td>• Technology: good &lt;br&gt; Processes represent aggregate, with and without crushing. &lt;br&gt; Dust emissions are estimated from limestone mining. &lt;br&gt; • Time: fair &lt;br&gt; Data is within ten years. &lt;br&gt; • Geography: fair &lt;br&gt; Processes model Swiss production (no U.S. process in USLCI database). &lt;br&gt; • Completeness: very good &lt;br&gt; • Reliability: very good &lt;br&gt; Data is verified by ecoinvent.</td>
</tr>
<tr>
<td>**Admixtures (lbs)</td>
<td></td>
<td>EU</td>
<td>2005-2006</td>
<td>• Technology: very good &lt;br&gt; Processes represents admixture production for use in concrete &lt;br&gt; • Time: fair &lt;br&gt; Data is within ten years &lt;br&gt; • Geography: fair &lt;br&gt; • Completeness: good &lt;br&gt; Data from a federation of European admixture producers &lt;br&gt; • Reliability: good &lt;br&gt; Profiles have undergone an independent review process. Compliance with ISO standards (unknown)</td>
</tr>
<tr>
<td><strong>Concrete Batch and Wash Water (gallons)</strong></td>
<td>Primary &lt;br&gt; (Pre-consumer, burden of crushing is reported and included in module A3)</td>
<td>USA</td>
<td>2013</td>
<td>• Technology: very good &lt;br&gt; Primary data collected via industry survey &lt;br&gt; • Time: very good &lt;br&gt; Data is within two years &lt;br&gt; • Geography: very good &lt;br&gt; • Completeness: very good &lt;br&gt; Primary data from core processes survey &lt;br&gt; • Reliability: very good &lt;br&gt; Data based on specified use</td>
</tr>
<tr>
<td><strong>Crushed Demolition Concrete (lbs)</strong></td>
<td>LCI Slag Cement Manufacturing &lt;br&gt; (crushing data used as proxy)</td>
<td>USA</td>
<td>2003</td>
<td>• Technology: good &lt;br&gt; Process models crushing of blast furnace slag. &lt;br&gt; • Time: fair &lt;br&gt; Data is within eleven years. &lt;br&gt; • Geography: very good &lt;br&gt; • Completeness: fair &lt;br&gt; • Reliability: fair</td>
</tr>
</tbody>
</table>
### Table 2: A1 - Raw Material Supply Con’t

| Road Dust Control Chemicals (lbs) | ecoinvent 3.01, Calcium chloride used to control dust on gravel roadways CaCl₂, 35-38 wt. percent calcium chloride solution to the roadway | Europe | 2008 | • Technology: good  
Process models the manufacture of dust control chemical.  
• Time: good  
Data is within two years.  
• Geography: fair  
Processes model Swiss production  
• Completeness: very good  
• Reliability: very good  
Data is verified by ecoinvent. |
|---|---|---|---|---|
| Oil, Lubricants and Greases (lbs) | ecoinvent 3.01, Lubricating oil (US) | USA | 2008 | • Technology: good  
Process models the manufacture of lubricants  
• Time: good  
Data is within two years.  
• Geography: good  
Processes model US production  
• Completeness: very good  
• Reliability: very good  
Data is verified by ecoinvent. |
| Cleaning Chemicals (lbs) | ecoinvent 3.01, 50% ecoinvent “RustAway” modeled as 0.844 lb/gal of “Phosphoric acid, industrial grade, without water, in 85% solution state (GLO) | Global | 2008 | • Technology: good  
Processes model the manufacture of primary cleaning active ingredients  
• Time: good  
Data is within two years.  
• Geography: fair  
Global process model  
• Completeness: very good  
• Reliability: very good  
Data is verified by ecoinvent. |
# Table 3: A2 - Transportation

<table>
<thead>
<tr>
<th>Process</th>
<th>LCI Data Source</th>
<th>Geography</th>
<th>Year</th>
<th>Data Quality Assessment</th>
</tr>
</thead>
</table>
| Truck, rail, ocean freighter and barge (lbs*miles) | USLCI – single unit truck transport, diesel powered; rail transport, diesel powered; ocean freighter, average fuel mix; barge, average fuel mix | USA       | 2008 | • Technology: very good  
  - Process represents U.S. average transportation profiles  
  - Time: Fair  
  - Data is within 10 years  
  - Geography: fair  
  - Completeness good  
  - (all data place holders filled)  
  - Reliability: good |

# Table 4: A3 - Manufacturing

<table>
<thead>
<tr>
<th>Process</th>
<th>LCI Data Source</th>
<th>Geography</th>
<th>Year</th>
<th>Data Quality Assessment</th>
</tr>
</thead>
</table>
| Electricity (kWh)  | NRMCA purchased electricity grid mix-Electricity, medium voltage, at grid, US (ecoinvent v3.01) | USA       | 2008 | • Technology: very good  
  - Process represents production of electricity in the appropriate NERC regions. An average NRMCA electricity grid was developed based on total purchased electricity by surveyed plants weighted by RMC production in various NERC regions. (See % contribution by NERC grid region on page 16)  
  - Time: Fair  
  - Data is within ten years  
  - Geography: very good  
  - Completeness: good  
  - Data is representative of U.S. production  
  - Reliability: good  
  - ecoinvent has verified the data |
| Natural Gas (cu. ft.) | USLCI                                                                | USA       | 2008 | • Technology: very good  
  - Process represents combustion of natural gas in an industrial boiler.  
  - Time: Fair  
  - Data is within ten years  
  - Geography: fair  
  - Completeness: good  
  - Data is representative of U.S. conditions  
  - Reliability: good  
  - Data is from USLCI database |
### Table 4: A3 - Manufacturing Con’t

<table>
<thead>
<tr>
<th>Fuel Oil other than diesel (gallon)</th>
<th>USLCI</th>
<th>USA</th>
<th>2008</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Technology: very good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Process represents combustion of RFO in an industrial boiler.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Time: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is within ten years</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Geography: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Completeness: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is representative of U.S. conditions</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Reliability: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is from USLCI database</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Diesel (gallon)</th>
<th>USLCI</th>
<th>USA</th>
<th>2008</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Technology: very good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Process represents combustion of diesel in industrial equipment.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Time: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is within ten years</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Geography: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Completeness: good</td>
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<td></td>
<td></td>
</tr>
<tr>
<td>Data is representative of U.S. conditions</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Reliability: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is from USLCI database</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Gasoline (gallon)</th>
<th>USLCI</th>
<th>USA</th>
<th>2008</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Technology: very good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Process represents combustion of gasoline in equipment.</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>• Time: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is within ten years</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Geography: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Completeness: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is representative of U.S. conditions</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Reliability: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is from USLCI database</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Liquefied Propane Gas (gallon)</th>
<th>USLCI</th>
<th>USA</th>
<th>2008</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Technology: very good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Process represents combustion of LPG in industrial boiler.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Time: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is within ten years</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Geography: fair</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Completeness: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is representative of U.S. conditions</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Reliability: good</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Data is from USLCI database</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### Table 4: A3 - Manufacturing Con’t

<table>
<thead>
<tr>
<th>Material Type</th>
<th>Database Information</th>
<th>Region</th>
<th>Year</th>
</tr>
</thead>
<tbody>
<tr>
<td>Secondary Fuels, Liquid (waste solvents, etc.) (lbs)</td>
<td>ecoinvent 3.01</td>
<td>EU</td>
<td>2008</td>
</tr>
<tr>
<td></td>
<td>• Technology: good combustion emissions only</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Time: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Geography: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Completeness: very good</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Reliability: very good</td>
<td></td>
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</tr>
<tr>
<td></td>
<td>Data is verified by ecoinvent.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Secondary Fuels, Solid (tires, etc.) (ton-short)</td>
<td>ecoinvent 3.01</td>
<td>EU</td>
<td>2008</td>
</tr>
<tr>
<td></td>
<td>• Technology: good combustion emissions only</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Time: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Geography: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Completeness: very good</td>
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<tr>
<td></td>
<td>• Reliability: very good</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Data is verified by ecoinvent.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Hazardous Solid Waste (lbs)</td>
<td>ecoinvent 3.01; Adjusted for U.S. electricity grid</td>
<td>EU</td>
<td>2008</td>
</tr>
<tr>
<td></td>
<td>• Technology: good combustion emissions only</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Time: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Geography: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Completeness: very good</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Reliability: very good</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Data is verified by ecoinvent.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Non-Hazardous Solid Waste (lbs)</td>
<td>ecoinvent 3.01; Adjusted for U.S. electricity grid</td>
<td>EU</td>
<td>2008</td>
</tr>
<tr>
<td></td>
<td>• Technology: good combustion emissions only</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Time: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Geography: fair</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Completeness: very good</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Reliability: very good</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Data is verified by ecoinvent.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### Table 4: A3 - Manufacturing Con’t

<table>
<thead>
<tr>
<th>NRMCA Purchased Electricity source grid mix (as modeled)</th>
<th>%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electricity, medium voltage (ASCC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (FRCC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (HICC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (MRO) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (NPCC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (RFC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (SERC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (SPP) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (TRE) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td>Electricity, medium voltage (WECC) market for</td>
<td>Alloc Def, U</td>
</tr>
<tr>
<td><strong>Total</strong></td>
<td><strong>100.00%</strong></td>
</tr>
</tbody>
</table>
Data Quality

Data quality/variability requirements, as specified in the CLF PCR: 2013, sections 3.5 and 3.6, are applied. This section describes the achieved data quality relative to the ISO 14044:2006 requirements. Data quality is judged on the basis of its precision (measured, calculated or estimated), completeness (e.g., unreported emissions), consistency (degree of uniformity of the methodology applied within a study serving as a data source) and representativeness (geographical, temporal, and technological).

**Precision:** The NRMCA participating member companies through measurement and calculation collected primary data on their annual production of RMC products. For accuracy the LCA team validated these plant gate-to-gate input and output data. A statistical analysis was completed and documented in a separate report – see Primary Data Sources section.

**Completeness:** All relevant, specific processes, including inputs (raw materials, energy and ancillary materials) and outputs (emissions and production volume) were considered and modeled to represent the specified and declared RMC products. The relevant background materials and processes were taken from the USLCI Database (adjusted for known data placeholders); U.S. system boundary adjusted ecoinvent v2.2 and v3.0 LCI databases and modeled in SimaPro software v.8.0.1, 2014.

**Consistency:** To ensure consistency, the LCI modeling of the production weighted input and output LCI data for the declared products used the same modeling structure across the respective product systems, which consisted of input raw and ancillary material, energy flows, water resource inputs, product and co-products outputs, returned and recovered concrete materials, emissions to air, water and soil, and waste recycling and treatment. The same background LCI datasets from the NRMCA SimaPro LCI database were used across all RMC product systems LCI modeling. Crosschecks concerning the plausibility of mass and energy flows were continuously conducted. The LCA team conducted mass and energy balances at the plant and selected process level to maintain a high level of consistency.

**Reproducibility:** Internal reproducibility is possible since the data and the models are stored and available in a database (NRMCA SimaPro LCI database, 2014). A considerable level of transparency is provided throughout the report as the specifications and material quantity make-up for the declared RMC products are presented and key primary and secondary LCI data sources are summarized in Tables 2, 3 and 4. The provision of more detailed data to allow full external reproducibility was not possible due to reasons of confidentiality.

**Representativeness:** The representativeness of the data is summarized as follows:

- Time related coverage of the NRMCA manufacturing processes- Primary collected data: 2013 (12 months).
- Upstream (background) LCI data: either the PCR specified default or more appropriate LCI datasets were used as found in the USLCI (adjusted) Database, US adjusted ecoinvent v.2.2 and v.3.0 database, 2014.
- Geographical coverage: the geographical coverage is the U.S. and Canada.
- Technological coverage: typical or average
Life Cycle Assessment Results

Environmental indicators and inventory metrics

As specified in the CLF PCR:2013, Section 8., the U.S. EPA Tool for the Reduction and Assessment of Chemical and Other Environmental Impacts (TRACI), version 2.1, 2012 impact categories was used to provide a North American context for the mandatory category indicators included in the EPD. Additionally, the PCR requires a set of inventory metrics to be reported with the LCIA indicators. Table 5 summarizes the 15 life cycle impact assessment indicators and inventory metrics. Tables 6 through 11 then report the LCA results for each product.

<table>
<thead>
<tr>
<th>#</th>
<th>LCIA Indicators</th>
<th>Abbreviations</th>
<th>Units</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Global Warming Potential (climate change)</td>
<td>GWP</td>
<td>kg CO2-eq</td>
</tr>
<tr>
<td>2</td>
<td>Ozone Depletion Potential</td>
<td>ODP</td>
<td>kg CFC-11-eq</td>
</tr>
<tr>
<td>3</td>
<td>Acidification Potential</td>
<td>AP</td>
<td>kg SO2-eq</td>
</tr>
<tr>
<td>4</td>
<td>Eutrophication Potential</td>
<td>EP</td>
<td>kg N-eq</td>
</tr>
<tr>
<td>5</td>
<td>Photochemical Ozone Creation/Smog Potential</td>
<td>POCP</td>
<td>kg O3-eq</td>
</tr>
<tr>
<td>6</td>
<td>Total primary energy consumption</td>
<td>PEC</td>
<td>MJ (HHV*)</td>
</tr>
<tr>
<td>7</td>
<td>Depletion of non-renewable energy resources</td>
<td>NRE</td>
<td>MJ (HHV*)</td>
</tr>
<tr>
<td>8</td>
<td>Use of renewable primary energy</td>
<td>RE</td>
<td>MJ (HHV*)</td>
</tr>
<tr>
<td>9</td>
<td>Depletion of non-renewable material resources</td>
<td>NRM</td>
<td>kg</td>
</tr>
<tr>
<td>10</td>
<td>Use of renewable material resources</td>
<td>RM</td>
<td>kg</td>
</tr>
<tr>
<td>11</td>
<td>Concrete batching water consumption</td>
<td>CBW</td>
<td>m3</td>
</tr>
<tr>
<td>12</td>
<td>Concrete washing water consumption</td>
<td>CWW</td>
<td>m3</td>
</tr>
<tr>
<td>13</td>
<td>Total water consumption</td>
<td>TW</td>
<td>m3</td>
</tr>
<tr>
<td>14</td>
<td>Concrete hazardous waste</td>
<td>CHW</td>
<td>kg</td>
</tr>
<tr>
<td>15</td>
<td>Concrete non-hazardous waste</td>
<td>CNHW</td>
<td>kg</td>
</tr>
</tbody>
</table>

*HHV, higher heating value (also called gross calorific value), is the heat of combustion of a given amount of fuel that includes the calorific value of condensing the water content of the fuel (the heat of vaporization). The lower heating value (LHV) excludes the heat of vaporization of the water content and thus the HHV is equal to the LHV plus the heat of vaporization.
### Impact Assessment Results

#### Table 6. Summary Results (A1-A3): 0-2500 psi (0-17.24 MPa) RMC product, per cubic meter

<table>
<thead>
<tr>
<th>Indicator/LCI Metric</th>
<th>GWP</th>
<th>ODP</th>
<th>AP</th>
<th>EP</th>
<th>POC P</th>
<th>PEC</th>
<th>NRE</th>
<th>RE</th>
<th>NRM</th>
<th>RM</th>
<th>CBW</th>
<th>CWW</th>
<th>TW</th>
<th>CHW</th>
<th>CNHW</th>
</tr>
</thead>
<tbody>
<tr>
<td>Unit (equivalent)</td>
<td>kg CO₂</td>
<td>kg CFC-11</td>
<td>kg SO₂</td>
<td>kg N</td>
<td>kg O₃</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
<td>kg</td>
<td>kg</td>
<td>m³</td>
<td>m³</td>
<td>m³</td>
<td>kg</td>
<td>kg</td>
</tr>
<tr>
<td>Minimum Indicator/</td>
<td>186.9</td>
<td>3.48E-6</td>
<td>1.02</td>
<td>0.12</td>
<td>14.47</td>
<td>1721</td>
<td>1707</td>
<td>13</td>
<td>2051</td>
<td>0.46</td>
<td>0.13</td>
<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
<td>2.67</td>
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<tr>
<td>Metric Value</td>
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</tr>
<tr>
<td>Maximum Indicator/</td>
<td>302.3</td>
<td>5.26E-6</td>
<td>1.36</td>
<td>0.15</td>
<td>17.66</td>
<td>2402</td>
<td>2384</td>
<td>17</td>
<td>2279</td>
<td>0.57</td>
<td>0.13</td>
<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
<td>2.67</td>
</tr>
<tr>
<td>Metric Value</td>
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<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>2500-00-FA/SL</td>
<td>302.3</td>
<td>5.26E-6</td>
<td>1.36</td>
<td>0.15</td>
<td>17.66</td>
<td>2402</td>
<td>2384</td>
<td>17</td>
<td>2279</td>
<td>0.57</td>
<td>0.13</td>
<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
<td>2.67</td>
</tr>
<tr>
<td>2500-20-FA</td>
<td>261.2</td>
<td>4.57E-6</td>
<td>1.20</td>
<td>0.14</td>
<td>16.14</td>
<td>2118</td>
<td>2103</td>
<td>15</td>
<td>2176</td>
<td>0.52</td>
<td>0.13</td>
<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
<td>2.67</td>
</tr>
<tr>
<td>2500-30-FA</td>
<td>239.0</td>
<td>4.20E-6</td>
<td>1.11</td>
<td>0.13</td>
<td>15.33</td>
<td>1966</td>
<td>1951</td>
<td>14</td>
<td>2120</td>
<td>0.49</td>
<td>0.13</td>
<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
<td>2.67</td>
</tr>
<tr>
<td>2500-40-FA</td>
<td>215.6</td>
<td>3.80E-6</td>
<td>1.02</td>
<td>0.12</td>
<td>14.47</td>
<td>1805</td>
<td>1792</td>
<td>13</td>
<td>2061</td>
<td>0.46</td>
<td>0.13</td>
<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
<td>2.67</td>
</tr>
<tr>
<td>2500-30-SL</td>
<td>233.0</td>
<td>4.23E-6</td>
<td>1.21</td>
<td>0.14</td>
<td>16.67</td>
<td>2022</td>
<td>2007</td>
<td>16</td>
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#### Table 6a. Summary Results (A1-A3): 0-2500 psi (0-17.24 MPa) RMC product, per cubic yard

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<td>kg N</td>
<td>kg O₃</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
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# Environmental Product Declaration

## National Ready Mixed Concrete Association

**Ready-Mixed Concrete According to ISO 14025**

**Environmental Product Declaration**

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**Table 7. Summary Results (A1-A3): 2501-3000 psi (17.25-20.68 MPa) RMC product, per cubic meter**

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<tr>
<th>Indicator/LCI Metric</th>
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<th>ODP</th>
<th>AP</th>
<th>EP</th>
<th>POCP</th>
<th>PEC</th>
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<td>kg CFC-11</td>
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<td>kg O₃</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
<td>kg</td>
<td>kg</td>
<td>m³</td>
<td>m³</td>
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**Table 7a. Summary Results (A1-A3): 2501-3000 psi (17.25-20.68 MPa) RMC product, per cubic yard**

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<th>AP</th>
<th>EP</th>
<th>POCP</th>
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<td>kg SO₂</td>
<td>kg N</td>
<td>kg O₃</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
<td>kg</td>
<td>kg</td>
<td>m³</td>
<td>m³</td>
<td>m³</td>
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<th>AP</th>
<th>EP</th>
<th>POC</th>
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<tr>
<td><strong>Unit (equivalent)</strong></td>
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<td>kg CFC-11</td>
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Table 8a. Summary Results (A1-A3): 3001-4000 psi (20.69-27.58 MPa) RMC product, per cubic yard

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<tr>
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<th>EP</th>
<th>POC</th>
<th>PEC</th>
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<th>RE</th>
<th>NRM</th>
<th>RM</th>
<th>CBW</th>
<th>CW</th>
<th>TW</th>
<th>CH</th>
<th>CNHW</th>
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<tbody>
<tr>
<td><strong>Unit (equivalent)</strong></td>
<td>kg CO₂</td>
<td>kg CFC-11</td>
<td>kg SO₂</td>
<td>kg N</td>
<td>kg O₃</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
<td>kg</td>
<td>kg</td>
<td>m3</td>
<td>m3</td>
<td>m3</td>
<td>kg</td>
<td>kg</td>
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<td>1676</td>
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<td>0.10</td>
<td>0.09</td>
<td>0.19</td>
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<td>2.04</td>
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**Environmental Product Declaration**

National Ready Mixed Concrete Association

Ready-Mixed Concrete According to ISO 14025

Environmental Product Declaration

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### Table 9. Summary Results (A1-A3): 4001-5000 psi (27.59-34.47 MPa) RMC product, per cubic meter

<table>
<thead>
<tr>
<th>Indicator/LCI Metric</th>
<th>GWP</th>
<th>ODP</th>
<th>AP</th>
<th>EP</th>
<th>POPC</th>
<th>PEC</th>
<th>NRE</th>
<th>RE</th>
<th>NRM</th>
<th>RM</th>
<th>CBW</th>
<th>CWW</th>
<th>TW</th>
<th>CHW</th>
<th>CNHW</th>
</tr>
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<td>2592</td>
<td>19</td>
<td>1995</td>
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#### Table 9a. Summary Results (A1-A3): 4001-5000 psi (27.59-34.47 MPa) RMC product, per cubic yard

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<th>EP</th>
<th>POPC</th>
<th>PEC</th>
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<th>RE</th>
<th>NRM</th>
<th>RM</th>
<th>CBW</th>
<th>CWW</th>
<th>TW</th>
<th>CHW</th>
<th>CNHW</th>
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<td>1997</td>
<td>1982</td>
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<td>2.04</td>
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<td>25.83</td>
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Environmental Product Declaration

Table 10. Summary Results (A1-A3): 5001-6000 psi (34.48-41.37 MPa) RMC product, per cubic meter

<table>
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<th>Indicator/LCI Metric</th>
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<th>AP</th>
<th>EP</th>
<th>POCPO</th>
<th>PEC</th>
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<th>RE</th>
<th>NRM</th>
<th>RM</th>
<th>CBW</th>
<th>CWW</th>
<th>TW</th>
<th>CHW</th>
<th>CNHW</th>
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</thead>
<tbody>
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<td>Unit (equivalent)</td>
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<td>kg CFC-11</td>
<td>kg SO2</td>
<td>kg N</td>
<td>kg O3</td>
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<td>MJ</td>
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<td>m3</td>
<td>m3</td>
<td>m3</td>
<td>kg</td>
<td>kg</td>
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<td>0.12</td>
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<td>0.41</td>
<td>2.67</td>
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<td>2463</td>
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<td>0.12</td>
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Table 10a. Summary Results (A1-A3): 5001-6000 psi (34.48-41.37 MPa) RMC product, per cubic yard

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<th>EP</th>
<th>POCPO</th>
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<th>RE</th>
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<th>TW</th>
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<td>kg O3</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
<td>kg</td>
<td>kg</td>
<td>m3</td>
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<td>m3</td>
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### Table 11. Summary Results (A1-A3): 6001-8000 psi (41.38-55.16 MPa) RMC product, per cubic meter

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<th>AP</th>
<th>EP</th>
<th>POC</th>
<th>PEC</th>
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<th>RE</th>
<th>NRM</th>
<th>RM</th>
<th>CBW</th>
<th>CW</th>
<th>TW</th>
<th>CHW</th>
<th>CNHW</th>
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<td>kg CFC-11</td>
<td>kg SO2</td>
<td>kg N</td>
<td>kg O3</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
<td>kg</td>
<td>kg</td>
<td>m3</td>
<td>m3</td>
<td>m3</td>
<td>kg</td>
<td>kg</td>
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<td>3115</td>
<td>3091</td>
<td>23</td>
<td>2009</td>
<td>0.67</td>
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<td>0.12</td>
<td>0.25</td>
<td>0.41</td>
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<td>4605</td>
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<td>2516</td>
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### Table 11a. Summary Results (A1-A3): 6001-8000 psi (41.38-55.16 MPa) RMC product, per cubic yard

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<th>Indicator/LCI Metric</th>
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<th>EP</th>
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<th>CHW</th>
<th>CNHW</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum Indicator/</td>
<td>kg CO2</td>
<td>kg CFC-11</td>
<td>kg SO2</td>
<td>kg N</td>
<td>kg O3</td>
<td>MJ</td>
<td>MJ</td>
<td>MJ</td>
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<td>m3</td>
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<td>0.31</td>
<td>2.04</td>
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<td>0.19</td>
<td>0.31</td>
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References

American Concrete Institute (ACI) 211: Standard Practice for Selecting Proportions for Normal, Heavyweight, and Mass Concrete

American Concrete Institute (ACI) 318: Building Code Requirements for Structural Concrete


Canadian Standards Association (CSA) A23.1-09/A23.2-09 (R2014): Concrete materials and methods of concrete construction/Test methods and standard practices for concrete

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Carbon Leadership Forum (2013). Product Category Rules (PCR) for ISO 14025 Type III Environmental Product Declarations (EPDs) of Concrete v1.1.

EN 15804:2012 Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products.


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Attachment 1: NRMCA Industry Wide EPD-Participating Plants

The following table is a preliminary list of plants that are eligible to claim participation in the NRMCA Industry Wide EPD for concrete.

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Environmental Product Declaration

National Ready Mixed Concrete Association
Ready-Mixed Concrete According to ISO 14025
Environmental Product Declaration

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According to ISO 14025

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# Environmental Product Declaration

**National Ready Mixed Concrete Association**  
**Ready-Mixed Concrete According to ISO 14025**  
**Environmental Product Declaration**

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### Environmental Product Declaration

**National Ready Mixed Concrete Association**  
**Ready-Mixed Concrete According to ISO 14025**

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**Anoka**  
**Minnesota**  

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![NSF Certified Environmental Product Declaration](www.nsf.org)
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Environmental Product Declaration

National Ready Mixed Concrete Association
Ready-Mixed Concrete According to ISO 14025

<p>| CalPortland Company                      | Everett Ready Mix Plant | Everett | Washington |
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| CalPortland Company                      | Longview Ready Mix Plant | Longview | Washington |
| CalPortland Company                      | Morton Ready Mix Plant  | Morton   | Washington |
| CalPortland Company                      | Skagit Ready Mix Plant  | Mount Vernon | Washington |
| CalPortland Company                      | Poulsbo Ready Mix Plant | Poulsbo | Washington |
| CalPortland Company                      | Duwamish Ready Mix Plant | Seattle | Washington |
| CalPortland Company                      | Snoqualmie Ready Mix Plant | Snoqualmie | Washington |
| CalPortland Company                      | Taylor Way Ready Mix Plant | Tacoma | Washington |
| CalPortland Company                      | Tumwater Ready Mix Plant | Tumwater | Washington |
| CalPortland Company                      | East Vancouver Ready Mix Plant | Vancouver | Washington |
| CalPortland Company                      | West Vancouver Ready Mix Plant | Vancouver | Washington |
| CalPortland Company                      | Woodland Ready Mix Plant | Woodland | Washington |
| CalPortland Company                      | Yelm Ready Mix Plant    | Yelm    | Washington |
| Carew Concrete &amp; Supply Co., Inc.        | Algoma, Plant 14         | Algoma   | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Appleton, Plant 1        | Appleton | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Cooperstown, Plant 13    | Denmark | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Fond du Lac, Plant 4     | Fond du Lac | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Green Bay, Plant 6       | Green Bay | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Green Lake, Plant 7      | Green Lake | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Horizon, Plant 15        | Horizon  | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | New London, Plant 11     | Hortonville | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Green Bay West, Plant 9  | Howard   | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Kiel, Plant 12           | Kiel     | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Manitowoc, Plant 16      | Manitowoc | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Oshkosh, Plant 3         | Oshkosh  | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Portage, Plant 8         | Portage  | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Waupaca, Plant 10        | Waupaca  | Wisconsin |
| Carew Concrete &amp; Supply Co., Inc.        | Waupun, Plant 5          | Waupun   | Wisconsin |
| CEMEX Inc.                               | Alabaster - Pelham       | Alabaster | Alabama |
| CEMEX Inc.                               | Alexander City           | Alexander City | Alabama |
| CEMEX Inc.                               | Andalusia                | Andalusia | Alabama |
| CEMEX Inc.                               | Anniston                 | Anniston  | Alabama |
| CEMEX Inc.                               | Arley - Smith Lake       | Arley    | Alabama |
| CEMEX Inc.                               | Athens                    | Athens   | Alabama |
| CEMEX Inc.                               | Atmore                    | Atmore   | Alabama |
| CEMEX Inc.                               | Bay Minette               | Bay Minette | Alabama |
| CEMEX Inc.                               | Birminghame              | Birminghame | Alabama |
| CEMEX Inc.                               | Lakeshore (Dual) / Lafarge | Birminghame | Alabama |
| CEMEX Inc.                               | North Birmingham - Tarrant (Lafarge) | Birminghame | Alabama |
| CEMEX Inc.                               | Brevton                   | Brevton  | Alabama |
| CEMEX Inc.                               | Cottontale                | Cottontale | Alabama |
| CEMEX Inc.                               | Cullman                   | Cullman  | Alabama |
| CEMEX Inc.                               | Daphne                    | Daphne   | Alabama |
| CEMEX Inc.                               | Decatur - Main (Dual)     | Decatur  | Alabama |
| CEMEX Inc.                               | Decatur - Ross Plant      | Decatur  | Alabama |
| CEMEX Inc.                               | Demopolis                 | Demopolis | Alabama |
| CEMEX Inc.                               | Dothan                    | Dothan   | Alabama |
| CEMEX Inc.                               | Foley                     | Foley   | Alabama |
| CEMEX Inc.                               | Florence - Industrial     | Florence | Alabama |
| CEMEX Inc.                               | FLORENCE - RIVER          | Florence | Alabama |
| CEMEX Inc.                               | McDuffie Rd               | Foley   | Alabama |</p>
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Environmental Product Declaration

According to ISO 14025

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## Environmental Product Declaration

National Ready Mixed Concrete Association
Ready-Mixed Concrete According to ISO 14025
Environmental Product Declaration

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## Environmental Product Declaration

### National Ready Mixed Concrete Association

According to ISO 14025

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**National Ready Mixed Concrete Association**

**Ready-Mixed Concrete According to ISO 14025**

**Environmental Product Declaration**

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### Environmental Product Declaration

**National Ready Mixed Concrete Association**

**Ready-Mixed Concrete According to ISO 14025**

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# Environmental Product Declaration

According to ISO 14025

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## Environmental Product Declaration

### National Ready Mixed Concrete Association

**Ready-Mixed Concrete According to ISO 14025**

### Environmental Product Declaration

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National Ready Mixed Concrete Association
Ready-Mixed Concrete According to ISO 14025

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- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #12
  - Delaware, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #13
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- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #16
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- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
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- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #8
  - Lockbourne, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #14
  - Marion, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #11
  - Marysville, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #1
  - Newark, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #6
  - Reynoldsburg, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #17
  - Upper Sandusky, Ohio

- **Shelly Ready Mix-Buckeye Ready Mix, LLC**
  - BRM Plant #18
  - West Jefferson, Ohio

- **Shelly Ready Mix-Smith Concrete**
  - Smith Concrete - Athens, OH (453)
  - Athens, Ohio

- **Shelly Ready Mix-Smith Concrete**
  - Smith Concrete - Belpre, OH (450)
  - Belpre, Ohio

- **Shelly Ready Mix-Smith Concrete**
  - Smith Concrete - Cadiz (461)
  - Cadiz, Ohio

- **Shelly Ready Mix-Smith Concrete**
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- **Staker Parson**
  - Ina
  - Tucson, Arizona

- **Staker Parson**
  - Poorman
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- **United Companies**
  - Powers
  - Carbondale, Colorado

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  - Delta
  - Delta, Colorado

- **United Companies**
  - River Rd
  - Grand Junction, Colorado

- **United Companies**
  - Gunnison
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- **United Companies**
  - Gypsum
  - Gypsum, Colorado

- **United Companies**
  - Minturn
  - Minturn, Colorado

- **United Companies**
  - Montrose
  - Montrose, Colorado

- **United Companies**
  - Paonia
  - Paonia, Colorado

- **United Companies**
  - Rifle
  - Rifle, Colorado

- **United Companies**
  - Steamboat
  - Steamboat Springs, Colorado

- **United Companies**
  - Telluride
  - Telluride, Colorado

- **United Companies**
  - Woody Creek
  - Woody Creek, Colorado

- **Baylor**
  - Tower Rd
  - Albuquerque, New Mexico

- **Baylor**
  - Santa Fe
  - Santa Fe, New Mexico

- **Western Rock**
  - Page #597
  - Page, Arizona

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  - Cedar City #681
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- **Western Rock**
  - Kanab #686
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- **Western Rock**
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Environmental Product Declaration  
National Ready Mixed Concrete Association  
Ready-Mixed Concrete According to ISO 14025  

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Environmental Product Declaration

National Ready Mixed Concrete Association
Ready-Mixed Concrete According to ISO 14025
Environmental Product Declaration

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### Environmental Product Declaration

**National Ready Mixed Concrete Association**

**Ready-Mixed Concrete According to ISO 14025**

![NRMCA Logo](image)

**Environmental Product Declaration**

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