

ENVIRONMENTAL PRODUCT DECLARATION

MILLIKEN CONTINUOUS DYED NYLON 6 BROADLOOM



Milliken

“At Milliken, sustainability is core to our culture. We believe a healthy enterprise and healthy earth are vitally linked. We care about and respect each other, our customers, and the world we share. While we hold ourselves accountable to the highest ethical standards, we derive our greatest satisfaction from creating innovations that help solve the world’s problems at a human level – adding value to people’s lives, improving health and safety, and making this world sustainable.”

Our products are scrutinized using Life Cycle Analysis before they make it past the drawing board. All Milliken products, globally, are third party certified carbon neutral using the Leonardo Academy’s “Cleaner and Greener” certification.

Four decades of worldwide site-based environmental management systems guarantee that we remain beyond compliance for safety and environmental impacts. All U.S. manufacturing facilities are certified as OSHA VPP STAR and ISO-14001 compliant.

For more information visit
www.milliken.com



ENVIRONMENTAL PRODUCT DECLARATION


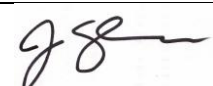


Milliken Carpet Americas
Continuous Dyed Nylon Type 6 Broadloom

According to ISO 14025

This declaration is an environmental product declaration in accordance with ISO 14025 that describes the environmental characteristics of the aforementioned product. It promotes the development and use of sustainable products. This is a certified declaration and all relevant environmental information is disclosed.



PROGRAM OPERATOR	UL Environment
DECLARATION HOLDER	Milliken
DECLARATION NUMBER	13CA02639.112.1
DECLARED PRODUCT	Continuous Dyed Nylon Type 6 Broadloom made by Milliken in LaGrange, GA 30240 USA
REFERENCE PCR	NSF PCR for Flooring (Carpet, Resilient, Laminate, Ceramic, and Wood)
DATE OF ISSUE	September 11, 2015
PERIOD OF VALIDITY	5 Years
CONTENTS OF THE DECLARATION	Product definition and information about building physics Information about basic material and the material's origin Description of the product's manufacture Indication of product processing Information about the in-use conditions Life cycle assessment results Testing results and verifications
The PCR review was conducted by:	NSF International
	Accepted by PCR Review Panel
	ncss@nsf.org
This declaration was independently verified in accordance with ISO 14025 by Underwriters Laboratories <input type="checkbox"/> INTERNAL <input checked="" type="checkbox"/> EXTERNAL	
	Wade Stout, UL Environment
This life cycle assessment was independently verified in accordance with ISO 14044 and the reference PCR by:	
	James Salazar, Athena





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Product Definition

Product Classification & Description

Continuous Dyed Nylon 6 Broadloom Carpet is the family of carpet included in this Environmental Product Declaration (EPD). This tufted carpet family is constructed with Continuous Dyed Nylon 6 face fiber, and a woven primary and secondary adhered with a SBR latex backing. The weight range of this carpet family is ±11%. This EPD represents an average performance.

This EPD includes a broad range of face fiber colors and patterns all with Nylon 6 yarn. The variation within this product group is in the face yarn style.

Layer	Component	Material	Weight (oz. / yd ²)	Weight (kg / m ²)
Tufted Face Fiber	Yarn	Continuous dyed nylon 6	40.0	0.68
Primary Backing	Woven Layer	Woven polypropylene with nylon 6	4.0	0.16
Primary Coating	Latex	Styrene butadiene	11	0.37
Secondary Backing	Woven Layer	Woven polypropylene with nylon 6,6	2.0	1.3
Secondary Coating	Latex	Styrene butadiene	12.0	0.07

Table 1 Product Construction Details



Figure 1: Product Construction Image





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Range of Applications

Milliken Continuous Dyed Broadloom Carpet is intended for moderate to heavy traffic use in residential, hospitality and commercial applications using test method ASTM D5252.

Product Standards and Approvals

Fire/ Static

Radiant Panel:	ASTM-E-648	≥ 0.45 (Class 1)
Smoke Density:	ASTM-E-662	≤ 450
Methenamine Pill Test:	ASTM-D-2859	Self-Extinguishing
Static Electricity:	AATCC-134	$\leq 3.5KV$, Permanent Conductive Fibers

Appearance

Atmospheric Fading	AATCC 129 & 164	≥ 4.5
Light Fastness:	AATCC 16 E	≥ 4.0 at 40 hrs.
Crocking:	AATCC 165	≥ 4.0 wet or dry
Dimensional Stability:	DIN Std 54318/ ASTM 7570/ISO 2551	$\leq 0.2\%$

Accreditations

- ISO 14001 Environmental Management System
- ISO 9001 Quality Management System
- OSHA VPP STAR Certified
- Cleaner and Greener® Certified manufacturer
- Carpet and Rug Institute (CRI) Green Label Plus Certification
- Gold and Platinum NSF 140 Sustainability Assessment for Carpet





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Delivery Status

Delivery Status	
Type of construction	Tufted textured loop, tufted cut and loop, tufted tip sheared, or tufted cut pile
Pile fiber	Continuous dyed nylon 6
Primary backing	Polypropylene and post-industrial polyethylene terephthalate with styrene butadiene latex
Secondary backing	Polypropylene and post-industrial polyethylene terephthalate with styrene butadiene latex
Face fiber weight	40 oz/sy or 1.35 kg/m ²
Total carpet weight	69 oz/sy or 2.34 kg/m ²

Table 2: Delivery Status

Material Content

Material Content of the Product

Material Content of Product					
Layers	Component	Material	Availability	Percent of total carpet mass, %	Origin
Face fiber	Yarn	Nylon 6	Fossil resource, limited	46.6%	US
Primary layer	Woven layer	Polypropylene	Fossil resource, limited	5.1%	US
		Nylon 6,6	Fossil resource, limited	1%	US
Primary coating	Latex	Styrene butadiene latex	Fossil resource, limited	3.50%	US
		Calcium carbonate	Mineral ore, abundant	26.60%	US
Secondary layer	Woven Layer	Recycled Polypropylene	Fossil resource, recycled content	13.80%	US
Secondary Coating	Latex	Styrene butadiene latex	Fossil resource, limited	1	US
		Calcium carbonate	Mineral ore, abundant	2.4%	US

Table 3: Material Content





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Production of Main Materials

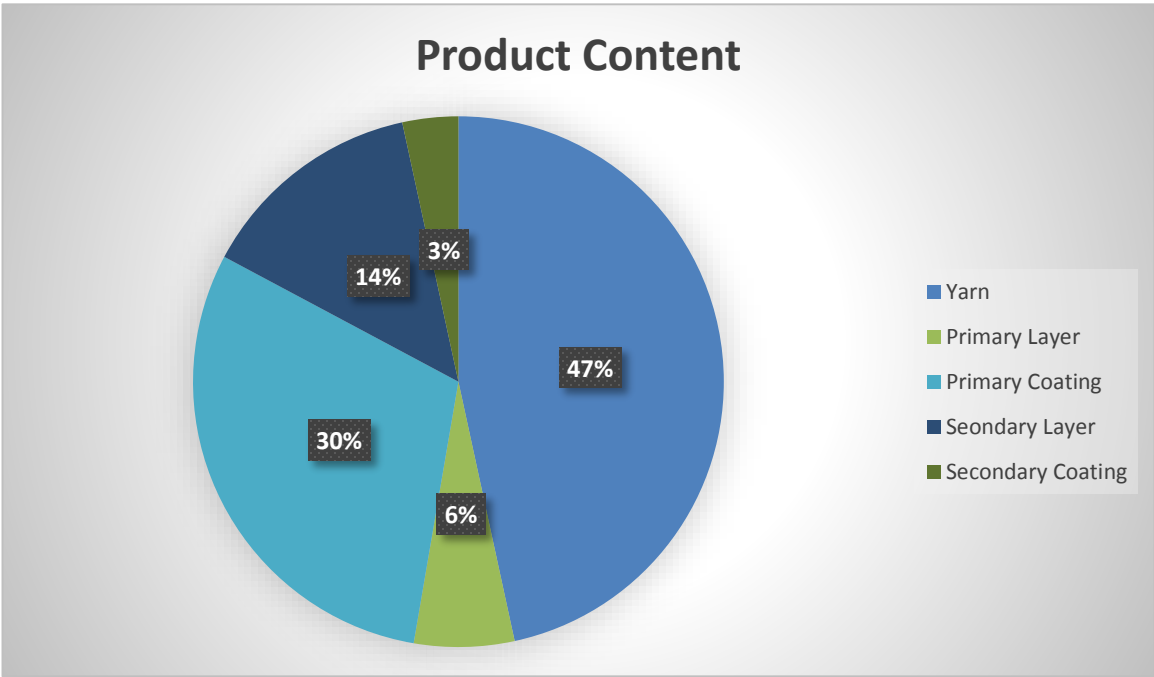


Figure 2: Product Content Graph

Description	Primary Materials	Production
Face Fabric	Nylon 6	Synthetic fiber material which is a polymerization of the Caprolactam monomer to Nylon 6, this synthetic material is extruded into fiber and twisted into bundles of fibers to form yarns. Post-consumer and postindustrial material is shaved from the face of used carpet, depolymerized and made back into Nylon 6 fiber.
Primary Backing/Substrate	Polyethylene terephthalate	Also known as Polyester, this is a synthetic fiber made of a copolymer of ethylene and terephthalic acid. The recycled fiber is often extruded from post-consumer plastic bottles. This fiber is made into a fabric form and might be woven, spun bonded, or needle punched.
Primary Adhesive	Styrene butadiene latex	Copolymer of styrene and 1,3 butadiene filled with calcium carbonate (limestone)
Secondary Backing/Substrate	Polyethylene terephthalate	Also known as Polyester, this is a synthetic fiber made of a copolymer of ethylene and terephthalic acid. The recycled fiber is often extruded from post-consumer plastic bottles. This fiber is made into a fabric form and might be woven, spun bonded, or needle punched.
Secondary Adhesive	Styrene butadiene latex	Copolymer of styrene and 1,3 butadiene filled with calcium carbonate (limestone)

Table 4: Production of main material details



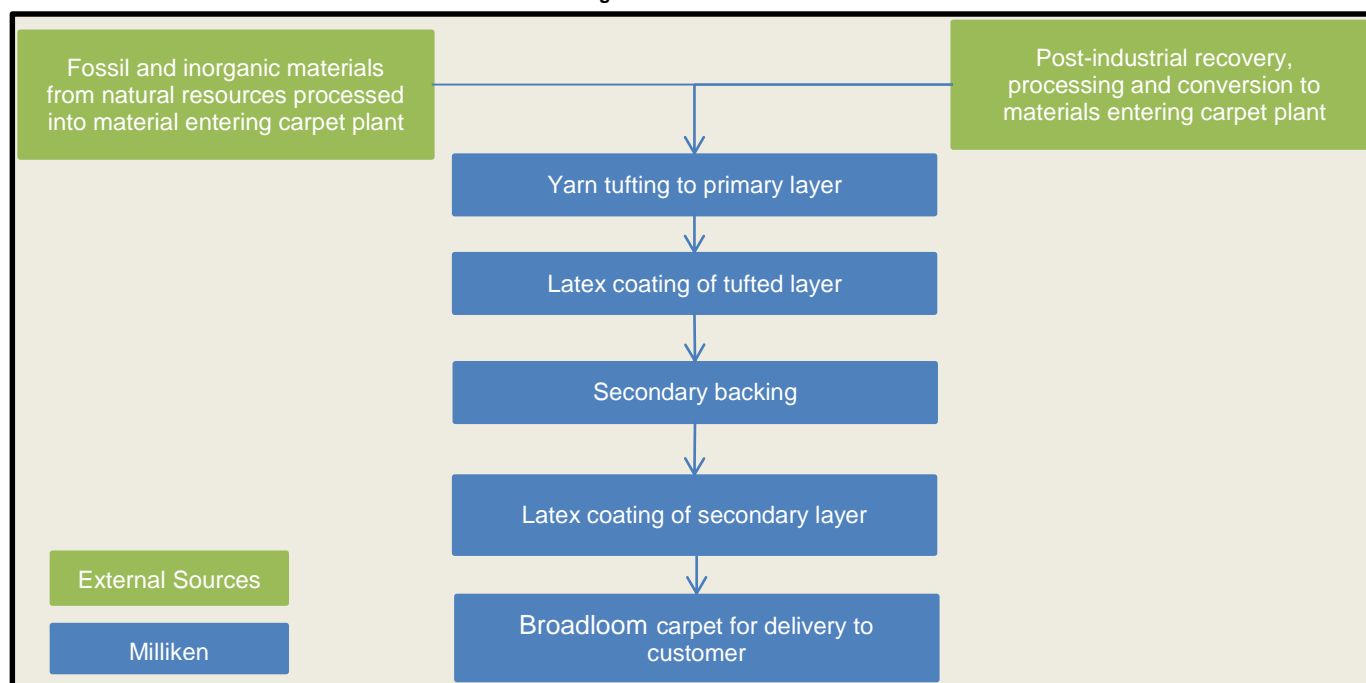


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Production of the Floor Covering

Figure 3: Production Process



Health, Safety, and Environmental Aspects During Production

- EPA's Landfill Methane Outreach Program Member
- EPA's Wastewise™ Member
- EPA's SmartWay Member
- ISO 14001 Certified
- OSHA VPP Star Certified
- Milliken Safety Way™ Compliant

Milliken has recycling programs set up for all recyclable waste streams and zero waste is sent to the landfill during our manufacturing process. The waste that cannot be recycled is used to make energy in certified Energy from Waste facilities. These certified facilities help reduce greenhouse gas emissions that would otherwise be created by landfills.

We minimize waste in our processes everywhere possible. We are able to reduce our manufacturing waste by monitoring our waste streams using six sigma statistical process control methodologies.



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Delivery and Installation of the Floor Covering

Delivery

Truck transport of the carpet is the dominant means of delivery. For the life cycle inventory, a truck is used with 50% utilization of payload. The average distance an order travels is 866 Miles.

Installation

Except where exceed or modified by Milliken Carpet Installation Instructions, Milliken recognizes the CRI Carpet Installation Standard 2011 as the minimum acceptable standard for the installation of its carpet products, for more information, visit our website, www.millikencarpet.com.

Health, Safety and Environmental Aspects during Installation

As a first preference, Milliken strongly recommends the use of a Milliken Certified installation Contractor to install our products. As an alternative source, Floor Covering Installation Board (FCIB) certified contractors as well as companies that can document that they employ installers certified at the C-2 level or higher by the International Certified Floor Covering Installers Associations (CFI) are also recognized as viable sources of quality installations.

Installation Waste

Excess carpet from installation is preferred to be recycled through Milliken Landfill Diversion Program. This program is accessed from our website. (www.millikencarpet.com/LandfillDiversion).

Packaging

The broadloom carpet is wrapped in a plastic wrap and labeled. This plastic wrap is LLDPE and is 100% recyclable.

Use Stage

The Milliken broadloom product is built to serve as a viable floor covering for the warranty life of the lifetime of the carpet. "Lifetime" is defined as the period of time that the original purchaser of the carpet chooses to keep the carpet on the floor at the original installation site. To include the use phase, one year of service life is used. The user may scale up the service life to meet their requirements.

Cleaning and Maintenance

The maintenance of carpet is evaluated for medium use. Cleaning is more frequent in areas with greater use. The cleaning includes both routine vacuuming and deep cleaning with different annual frequencies assigned to both. Deep cleaning is less frequent and more intense. The use of chemicals/water and the energies for vacuuming and deep cleaning were developed from the typical equipment used. This was done for a) hot water extraction (HWE) cleaning



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and b) low moisture encapsulation (LM).

An annual schedule of maintenance and cleaning was defined, with the largest segment being vacuum cleaning. We recommend MilliCare® Textile and Carpet Care. This dry polymer technology not only cleans better than wet systems, but is also environmentally sustainable and removes dirt, dust and allergens without the use of toxic chemicals. Plus, MilliCare meets CRI criteria as an effective deep-extraction method of cleaning, which means fibers stay cleaner longer and your investment lasts longer. (www.millicare.com)

Prevention of Structural Damage

Milliken recognizes the CRI Carpet Installation Standard 2011 as the minimum acceptable standard for the installation of its carpet products. Milliken flooring products should not be installed until any and all structural damage has been adequately repaired and determined to be code compliant.

For more information on floor preparation and installation instruction, visit our website, www.millikencarpet.com.

End-of-Life

Recycling or Reuse

Landfill Diversion Program: The Milliken broadloom carpets are designed to achieve Milliken's commitment to enhance recycle and reuse. After removal, the carpet should be entered into the Milliken Landfill Diversion program (www.millikencarpet.com/LandfillDiversion). If landfill diversion is not a feasible option, then disposal in municipal landfill should follow local regulations. Similar regulations governing incineration facilities should be followed if this technology is selected.

Disposal

Milliken recommends the use of our Landfill Diversion Program as the proper disposal method for all carpet products.

Life Cycle Assessment

The following environmental data are the result of an ISO14040 compliant cradle-to-grave life cycle assessment (LCA). As is required for public disclosure, the LCA was peer reviewed by external third parties.

Description of the Declared or Functional Unit

To serve as an effective unit for users of the Milliken broadloom, the basis of the life cycle information is one square meter of carpet in a commercial building. To include the use phase, one year of service life is used. The user may scale up the service life to meet their requirements.



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Cut-off Criteria

Excluded materials met the following criteria:

- Less than 1% of total mass of the final product
- Less than 1% of total energy flows
- Total excluded materials must not exceed 5% of final product.

Materials that fell below the stated 1% thresholds were also evaluated to ensure they did not contribute disproportionately high environmental impacts.

Allocation

Background data used in the LCA model may contain some allocation. Gate-to-gate Primary manufacturing data for Milliken carpet production was not allocated.

Background Data

The LCA was modeled using the GaBi 6 software platform. Life cycle inventory background data was typically sourced from PE International datasets, although some data from PlasticsEurope and the USLCI databases were utilized when the PE datasets were either not available or less representative of actual conditions.

Data Quality

Time Related Coverage: All gate-to-gate manufacturing data was sourced from Milliken's most recent fiscal year. The time coverage of background data is adopted from the specific datasets utilized in the model. No background data is more than 10 years old.

Geographical Coverage: All gate-to-gate manufacturing data are specific to Milliken locations within the US. For background data, domestic data was preferred; however the absence of US specific data required some international data to be utilized.

Technology coverage: Gate-to-gate data represents Milliken specific processes and technologies. Technological coverage related to cradle-to-gate processes is specific to the GaBi datasets. These datasets were evaluated and found to be representative of the technology used within Milliken's supply chain.

System Boundaries

The LCA of 1 M2 of Milliken carpet includes:

- Sourcing/extraction Stage
- Manufacturing Stage
- Delivery and installation Stage
- Use Stage
- End of Life Stage



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Notes on use stage

Carpet manufactured by Milliken carries a limited lifetime warranty. While the actual life time of the carpet is related to several factors, including changing style preference and building traffic, Milliken has adopted a 15-year service life in the LCA model. Results are presented for a single year of use, as well as for a 60-year reference service life of a building, as directed by the PCR.

Results of the Assessment

Results are uniformly provided in units of natural resource energy (MJ/m² carpet). The natural resource energy is calculated from the process energy of each manufacturing plant by first including the high heat value (HHV) of fuel combusted per unit of energy transferred to the process (efficiency) plus secondly the energy used to deliver fuel to the point of use in the energy production plant (often known as pre-combustion or delivered energy).

In the multi stage system for the life cycle of the family of Continuous Dyed Nylon 6 broadloom carpet, the natural resource energy is given in Table 5.

Natural Resources [MJ]	24 oz.	42 oz.	65 oz.
Total	565	699	868

Table 5: Natural resource energy for 1 m² of the Continuous Dyed Nylon 6 Broadloom Carpet

Life Cycle Inventory Analysis

Resources [kg]	24 oz.	42 oz.	65 oz.
Non-Renewable Material Resources	543	673	838
Wastes [kg]			
Hazardous Waste	0	0	0
Non-Hazardous Waste	16	20	26

Table 8: Non-Renewable energy and Waste use for Continuous Dyed Nylon 6 Broadloom Carpet

Life Cycle Impact Assessment

Translating the life cycle inventory data into life cycle impact categories provides additional information for the family of Milliken broadloom. As found with the life cycle inventory, the substantial majority of these environmental impacts are attributable to the supply chain and manufacturing of these carpets. Landfill waste, as an impact category showed a different result because the actual broadloom is landfilled.

The following tables present the LCIA results and contribution analysis based on CML 2001-November 2010.



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Relative Contribution to CML Life Cycle Impacts for 1 year of Use - Light Weight Product (24 oz)						
	Production	Sourcing/ Extraction	Delivery & Installation	Use (1 yr)	End of Life	Total
Abiotic Depletion (ADP elements) [kg Sb-Equiv.]	8.66E-07	5.70E-06	7.46E-06	1.29E-08	-1.56E-07	1.39E-05
Acidification Potential (AP) [kg SO ₂ -Equiv.]	9.91E-03	2.64E-02	1.82E-02	1.29E-08	1.95E-03	5.65E-02
Eutrophication Potential (EP) [kg Phosphate - Equiv.]	1.05E-03	3.50E-03	2.54E-03	1.29E-08	9.55E-04	8.05E-03
Global Warming Potential (GWP 100 years) [kg CO ₂ -Equiv.]	2.47E+00	1.20E+01	1.17E+01	1.29E-08	5.30E-01	2.67E+01
Ozone Layer Depletion Potential (ODP, steady state) [kg R11-Equiv.]	7.33E-09	5.81E-09	4.35E-10	1.29E-08	2.02E-09	2.85E-08
Photochem. Ozone Creation Potential (POCP) [kg Ethene-Equiv.]	7.05E-04	3.15E-03	3.41E-03	1.29E-08	5.58E-04	7.82E-03

Relative Contribution to CML Life Cycle Impacts for 60 years of Use - Light Weight Product (24 oz)						
	Production	Sourcing/ Extraction	Delivery & Installation	Use (60 yr)	End of Life	Total
Abiotic Depletion (ADP elements) [kg Sb-Equiv.]	3.46E-06	2.28E-05	2.98E-05	7.76E-07	-6.25E-07	5.62E-05
Acidification Potential (AP) [kg SO ₂ -Equiv.]	3.97E-02	1.06E-01	7.28E-02	7.76E-07	7.79E-03	2.26E-01
Eutrophication Potential (EP) [kg Phosphate - Equiv.]	4.20E-03	1.40E-02	1.02E-02	7.76E-07	3.82E-03	3.22E-02
Global Warming Potential (GWP 100 years) [kg CO ₂ -Equiv.]	9.88E+00	4.79E+01	4.68E+01	7.76E-07	2.12E+00	1.07E+02
Ozone Layer Depletion Potential (ODP, steady state) [kg R11-Equiv.]	2.93E-08	2.33E-08	1.74E-09	7.76E-07	8.09E-09	8.38E-07
Photochem. Ozone Creation Potential (POCP) [kg Ethene-Equiv.]	2.82E-03	1.26E-02	1.36E-02	7.76E-07	2.23E-03	3.13E-02

Table 7: Life cycle impact results for 1 year and 60 years of use for light weight product



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Relative Contribution to CML Life Cycle Impacts for 1 year of Use - Mid Weight Product (42 oz)						
	Production	Sourcing/ Extraction	Delivery & Installation	Use (1 yr)	End of Life	Total
Abiotic Depletion (ADP elements) [kg Sb-Equiv.]	1.00E-06	8.99E-06	7.46E-06	1.29E-08	-2.08E-07	1.72E-05
Acidification Potential (AP) [kg SO ₂ -Equiv.]	1.12E-02	4.37E-02	1.82E-02	3.31E-04	2.59E-03	7.60E-02
Eutrophication Potential (EP) [kg Phosphate - Equiv.]	1.13E-03	5.79E-03	2.55E-03	1.77E-05	1.27E-03	1.07E-02
Global Warming Potential (GWP 100 years) [kg CO ₂ -Equiv.]	2.96E+00	1.95E+01	1.17E+01	9.80E-02	7.05E-01	3.50E+01
Ozone Layer Depletion Potential (ODP, steady state) [kg R11-Equiv.]	7.47E-09	6.42E-09	4.36E-10	3.39E-11	2.69E-09	1.70E-08
Photochem. Ozone Creation Potential (POCP) [kg Ethene-Equiv.]	7.96E-04	5.06E-03	3.41E-03	2.02E-05	7.43E-04	1.00E-02

Relative Contribution to CML Life Cycle Impacts for 60 years of Use - Mid Weight Product (42oz)						
	Production	Sourcing/ Extraction	Delivery & Installation	Use (60 yr)	End of Life	Total
Abiotic Depletion (ADP elements) [kg Sb-Equiv.]	4.02E-06	3.60E-05	2.98E-05	7.76E-07	-8.32E-07	6.98E-05
Acidification Potential (AP) [kg SO ₂ -Equiv.]	4.48E-02	1.75E-01	7.29E-02	1.99E-02	1.04E-02	3.23E-01
Eutrophication Potential (EP) [kg Phosphate - Equiv.]	4.51E-03	2.32E-02	1.02E-02	1.06E-03	5.08E-03	4.40E-02
Global Warming Potential (GWP 100 years) [kg CO ₂ -Equiv.]	1.18E+01	7.82E+01	4.69E+01	5.88E+00	2.82E+00	1.46E+02
Ozone Layer Depletion Potential (ODP, steady state) [kg R11-Equiv.]	2.99E-08	2.57E-08	1.74E-09	2.03E-09	1.08E-08	7.01E-08
Photochem. Ozone Creation Potential (POCP) [kg Ethene-Equiv.]	3.19E-03	2.02E-02	1.37E-02	1.21E-03	2.97E-03	4.13E-02

Table 8: Life cycle impact results for 1 year and 60 years of use for middle weight product



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Relative Contribution to CML Life Cycle Impacts for 1 years of Use - Heavy Weight Product (65 oz)						
	Production	Sourcing/ Extraction	Delivery & Installation	Use (1 yr)	End of Life	Total
Abiotic Depletion (ADP elements) [kg Sb-Equiv.]	1.18E-06	1.32E-05	7.46E-06	1.29E-08	-2.74E-07	2.16E-05
Acidification Potential (AP) [kg SO ₂ -Equiv.]	1.29E-02	6.58E-02	1.83E-02	3.31E-04	3.42E-03	1.00E-01
Eutrophication Potential (EP) [kg Phosphate - Equiv.]	1.23E-03	8.73E-03	2.55E-03	1.77E-05	1.67E-03	1.42E-02
Global Warming Potential (GWP 100 years) [kg CO ₂ -Equiv.]	3.58E+00	2.92E+01	1.17E+01	9.80E-02	9.28E-01	4.55E+01
Ozone Layer Depletion Potential (ODP, steady state) [kg R11-Equiv.]	7.64E-09	7.20E-09	4.36E-10	3.39E-11	3.55E-09	1.88E-08
Photochem. Ozone Creation Potential (POCP) [kg Ethene-Equiv.]	9.14E-04	7.49E-03	3.42E-03	2.02E-05	9.79E-04	1.28E-02

Relative Contribution to CML Life Cycle Impacts for 60 years of Use – Heavy Weight Product (65 oz)						
	Production	Sourcing/ Extraction	Delivery & Installation	Use (60 yr)	End of Life	Total
Abiotic Depletion (ADP elements) [kg Sb-Equiv.]	4.73E-06	5.28E-05	2.98E-05	7.76E-07	-1.10E-06	8.70E-05
Acidification Potential (AP) [kg SO ₂ -Equiv.]	5.15E-02	2.63E-01	7.31E-02	1.99E-02	1.37E-02	4.21E-01
Eutrophication Potential (EP) [kg Phosphate - Equiv.]	4.90E-03	3.49E-02	1.02E-02	1.06E-03	6.70E-03	5.78E-02
Global Warming Potential (GWP 100 years) [kg CO ₂ -Equiv.]	1.43E+01	1.17E+02	4.69E+01	5.88E+00	3.71E+00	1.88E+02
Ozone Layer Depletion Potential (ODP, steady state) [kg R11-Equiv.]	3.06E-08	2.88E-08	1.74E-09	2.03E-09	1.42E-08	7.73E-08
Photochem. Ozone Creation Potential (POCP) [kg Ethene-Equiv.]	3.66E-03	3.00E-02	1.37E-02	1.21E-03	3.91E-03	5.24E-02

Table 9: Life cycle impact results for 1 year and 60 years of use for heavy weight product

Interpretation

The use of energy in the supply chain and the carpet manufacturing plant to produce the Milliken broadloom of floor coverings is the dominant contributor to the life cycle energy and impacts. Generally, the supply chain and manufacture phase comprise about 98% of the environmental footprint of these carpets. The use phase is the second largest impact stage and is evaluated for a one year period, since the actual frequency of replacement is unknown. Because of the polymeric nature of the carpet composition, the end-of-life impact is negligible, except for the consumption of landfill volume. As recycling of carpet grows (based on the Milliken Landfill Diversion Program), the contribution to landfill volume will decrease even further.

The information in the EPD is provided to demonstrate that Milliken has a commitment to understand the complete life cycle of the Milliken broadloom products for our customers. That understanding is the mechanism by which Milliken will continue to improve the sustainability of these products for our customers.



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Additional Information, Evidence, and Test Results

- NSF – 140-2007 Sustainable Carpet Assessment Standard
- MTS / SMaRT Consensus Sustainable Product Standard – Platinum
- Carbon Neutral Certified – Leonardo Academy
- Carpet and Rug Institute (CRI) Green Label Plus & Green Label Certified

References

ISO 14025 Environmental labels and declarations-Type III Environmental Declarations –Principals and Procedures

ISO 14040 Life Cycle Assessment- Principles and Framework

ISO 14044 Life Cycle Assessment- Requirements and Guidelines

ISO 21930 Sustainability in Building Construction-Environmental Declaration of Building Products

Federal Trade Commission (FTC) Environmental Guidelines