



# Environmental Product Declaration

# ISKO™

*for NZ-287920 and NZ-286048 denim garment in accordance with ISO 14025*

## Programme

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

## Programme Operator

EPD International AB & EPD Turkey

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EPD Registration Number: S-P-03458

**Owner of the Declaration:** ISKO™ ISKO Division, Sanko Tekstil İşletmeleri San. ve Tic. A.Ş. Organize Sanayi Bölgesi 3.Cadde 16400 İnegöl/Bursa/Turkey

**Garment Manufacturer:** Cross Textiles – Şık Makas Giyim Sanayi ve Ticaret A.Ş. 15 Temmuz Mah, 1507 Sok No:5 Bağcılar/İstanbul/TURKEY

Programme Operator	EPD International AB, Box 210 60, SE-100 31 Stockholm, Sweden E-mail: info@environdec.com Regional Office: EPD Turkey, Nef 09 B Blok 7/15 Kağıthane/ Istanbul, Turkey www.epdturkey.org
Product Category Rules (PCR)	Jackets, coats and other similar outdoor garments 2019:04, version 1.02 UN CPC 282 General Program Instructions 3.01
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Third Party Verifier	Vladimír Kočí, PhD Šárecká 5, 16000 Prague 6, Czech Republic www.lcastudio.cz Approved by: The International EPD® System Technical Committee, supported by the Secretariat
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LCA Study & EPD Design Conducted By	Semtrio Sustainability Consulting BUDOTEK Teknopark, No 4/21, Umraniye / Istanbul Turkey www.semtrio.com

ISKO™ has the sole ownership, liability and responsibility of this EPD. For further information about this EPD or its content, please contact **Mrs. Ebru Ozkucuk Guler** at sustainability@isko.com.tr.

EPDs within the same product category but from different programmes may not be comparable.

## OUR DENIM

“Denim fabrics look at people, and we explore our denim world through their lifestyles.”



ISKO™, the leading ingredient brand on a global level, is the first denim producer in the world to be recognized with the Nordic Swan and EU Ecolabel certifications. It has a production capacity of 300 million meters of fabric per year, with 2000 state-of-the-art automatic looms. It creates the soul of jeans, the essence of the most popular fashion style that has become universal.

ISKO™'s vision is as international as the love for denim. It can adapt to different contexts and markets, becoming a point of reference for the most famous designers and inspiring new fashion trends.

## INNOVATION since 1904

With a global presence and offices in 35 countries, ISKO™ is part of SANKO TEKSTIL, the textile division of SANKO Group.

ISKO™'s route to textiles began in 1904 and in 1989 we opened our 300,000 m2 manufacturing plant, making ISKO™ the world's largest denim manufacturer under one roof.

## ISKO Philosophy



### PERFORMANCE

ISKO™ is the denim specialist, all fabrics are characterized by an advanced technology and the deeply-rooted care for quality, during all the integrated production from yarn to finishing processes.



### INNOVATION

ISKO™'s mission is to always keep in touch with the latest trends and also to anticipate times. ISKO™'s research center is certified by the Turkish government and it consists of more than 25 textile engineers, specialists in creating new denim products.

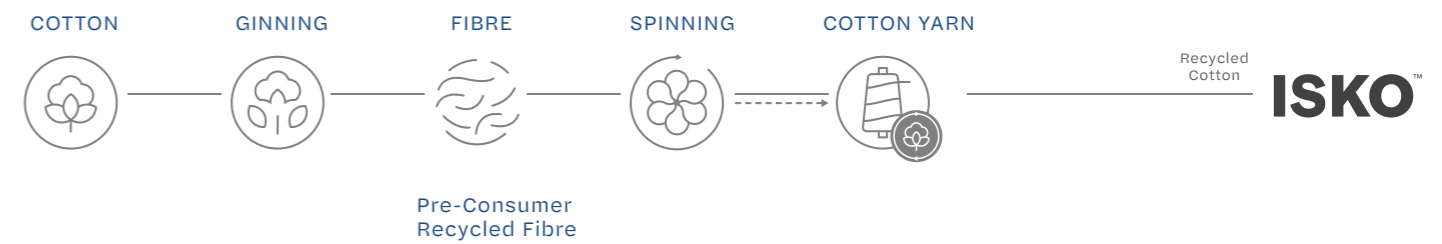


### SUSTAINABLE

Sustainability at ISKO™ we rethink our sourcing strategies and refuse to source more material than we need. Our waste management innovations reduce the environmental performance impact from yarn to fabric production, by using reused and recycled materials.

## OUR COMMITMENT

Sustainability is inherent to ISKO's DNA: every day we value responsibility and a 360-degree innovation. This is something we take seriously, and we are dedicated to doing this with beauty, heart, and creativity.



## CERTIFIED RECYCLED MATERIALS USAGE

At ISKO™ we blend certified recycled materials with the reused cotton. Producing recycled polyester uses less energy than making virgin polyester and lessens the dependence on petroleum as a raw material. Both factors reduce our overall carbon footprint.



## CREATING REUSED COTTON FROM LOSS

When raw cotton is processed into yarn, 10% of it is typically expected to be lost as waste. At this stage ISKO™ differentiates itself as we continually trace, track, and monitor this loss and reuse the cotton by adding it back into the spinning process.

*All our reused cotton is Content Claim Standard (CCS) certified.*



Product NZ-287920

Content Declaration



Materials in the Product	% in the product	Material Composition
Denim Fabric	> 90%	%60CO %20RUC %20PRE
Lining	< 2%	%74RCY PES %13RCY CO %13ORJ.CO
Fusing	< 1%	%100 PES
Paper Labels	1-1.5 %	%100 Paper
Metal Accessories	< 3%	100% Metal

- Packaging: PE packaging film is used to cover the end products.
- Classified as Distribution Packaging: designed for the purposes of transport, handling and/or distribution.
- Chemicals used in ISKO™ and Cross Textiles manufacturing comply with the Regulation (EC) No 1907/2006 of the European parliament and of the council of 18 December 2006 concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH).

Technical Specifications\*

Characteristics	Reference Standard	Units	Results
<b>Constructive Characteristics</b>			
Composition	Regulation EU No 1007/2001	%	60% CO 20% RUC 20% PRE
For woven materials: Weave	ISO 3572	-	3/1 RHT
Mass per unit area	(ASTM D3776)	g/m <sup>2</sup>	378
Width	(ASTM D3774)	cm	160
<b>Dyeing</b>			
Colour Index	-	-	-
<b>Performance Characteristics</b>			
For woven materials: Abrasion strength (Martindale)	ISO 12947-2	grade	-
For woven materials: Tear strength	ASTM D1424	grade	Warp: 4667 gr Weft: 4450 gr
For woven materials: Tensile strength	ASTM D5034	grade	Warp: 74.1 kg Weft: 45 kg
pH of water extract	EN ISO 3071	grade	7
<b>Colour Fastness</b>			
Colour fastness to artificial light: Xenon arc fading lamp test	EN ISO 105 B02	grade	-
Acid and alkaline perspiration	EN ISO 105 E04	grade	-
Dry and wet rubbing	AATCC 8	grade	Dry: 3 - Wet: 1

Product NZ-286048

Content Declaration

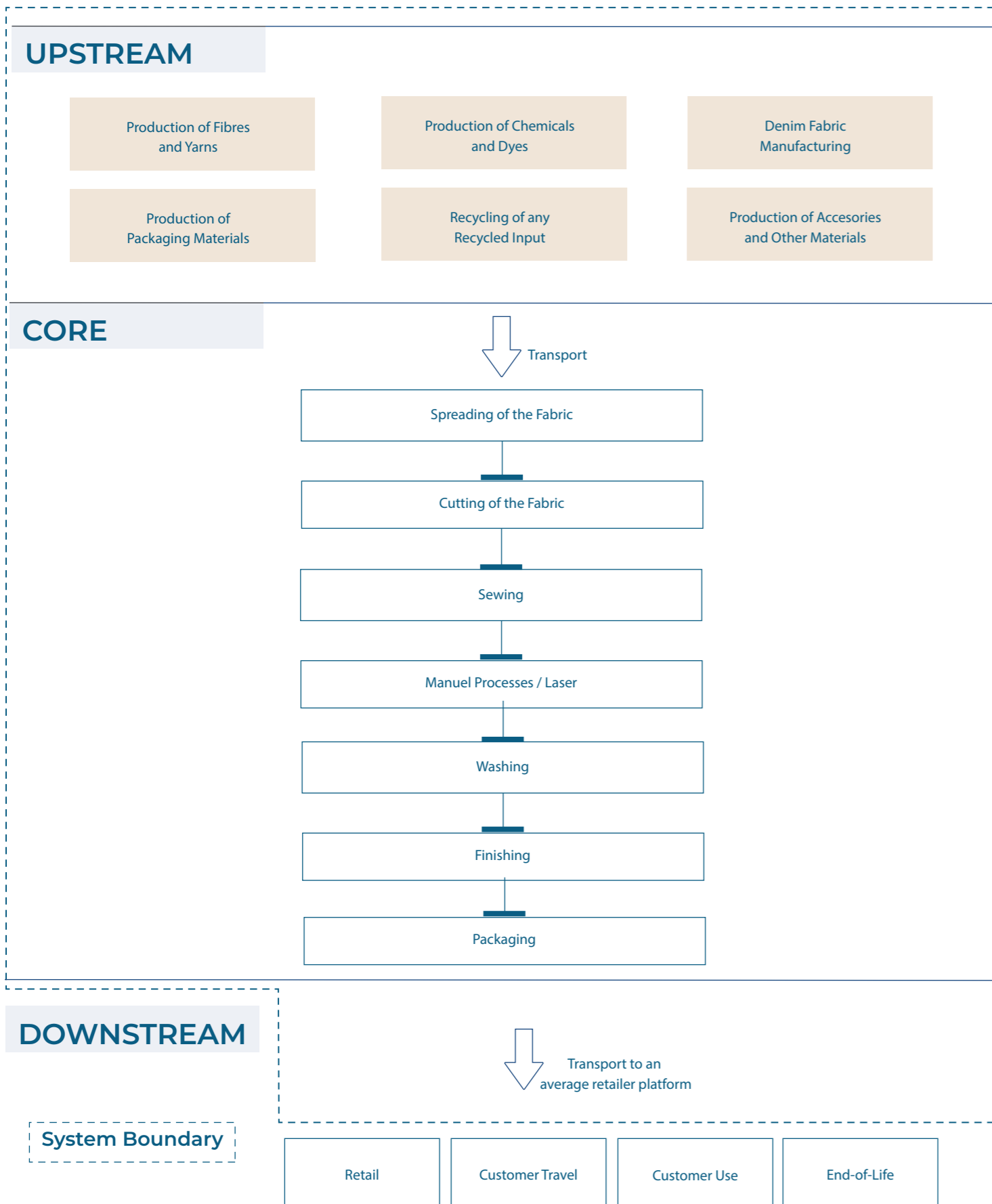


Materials in the Product	% in the product	Material Composition
Denim Fabric	> 90%	%60CO %20RUC %20RCO
Lining	0%	-
Fusing	< 4%	%100 PES
Paper Labels	< 1%	%100 Paper
Metal Accessories	< 5%	100% Metal

- Packaging: PE packaging film is used to cover the end products.
- Classified as Distribution Packaging: designed for the purposes of transport, handling and/or distribution.
- Chemicals used in ISKO™ and Cross Textiles manufacturing comply with the Regulation (EC) No 1907/2006 of the European parliament and of the council of 18 December 2006 concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH).

Technical Specifications\*

Characteristics	Reference Standard	Units	Results
<b>Constructive Characteristics</b>			
Composition	Regulation EU No 1007/2001	%	60% CO 20% RUC 20% RCO
For woven materials: Weave	ISO 3572	-	3/1 RHT
Mass per unit area	(ASTM D3776)	g/m <sup>2</sup>	370
Width	(ASTM D3774)	cm	160
<b>Dyeing</b>			
Colour Index	-	-	-
<b>Performance Characteristics</b>			
For woven materials: Abrasion strength (Martindale)	ISO 12947-2	grade	-
For woven materials: Tear strength	ASTM D1424	grade	Warp: 5573 gr Weft: 4750 gr
For woven materials: Tensile strength	ASTM D5034	grade	Warp: 78.6 kg Weft: 54.3 kg
pH of water extract	EN ISO 3071	grade	7.4
<b>Colour Fastness</b>			
Colour fastness to artificial light: Xenon arc fading lamp test	EN ISO 105 B02	grade	-
Acid and alkaline perspiration	EN ISO 105 E04	grade	-
Dry and wet rubbing	AATCC 8	grade	Dry: 4 - Wet: 1



**Time representativeness:** The production data in the LCA study represents the period from 1<sup>st</sup> January 2021 and 31<sup>st</sup> January 2021

**Database and LCA software used:** SimaPro v9.1 software with Ecoinvent v3.6 database

**Excluded lifecycle stages:** Retail, Customer Travel, Customer Use and End-of-life stages have been excluded in the system boundary and not taken into account in the LCA study.

<b>Geographical scope of the EPD</b>	Worldwide
<b>Functional Unit</b>	1 pair of jeans delivered to an average retailer platform
<b>EPD Type (System Boundary)</b>	Cradle-to-gate with options
<b>Data Quality and Data Collection</b>	Site specific data is collected for the core and upstream processes from Cross Textiles and ISKO™ for the period between 1 <sup>st</sup> January to 31 <sup>st</sup> January 2021. Samples are produced for both products. Specific energy and chemical consumption values are collected from the manufacturing per load per machine. Selected generic data is used for upstream processes and obtained from Ecoinvent v3.6. Specific and selected generic data achieve the ISO 14044 data quality requirements and time representatives. Denim fabric makes the main component of the jeans and impacts caused by denim fabric manufacturing is solely depending on the denim mill. Denim fabric data is collected from the denim mill per individual product.
<b>Allocation</b>	Allocation was avoided by dividing the unit process into two or more sub-processes and collecting the environmental data related to these sub-processes. There has been no allocation conducted for the LCA study.
<b>Calculation Methods</b>	All resource use values are calculated from Cumulative Energy Demand V1.11; net use of fresh water has been calculated from SimaPro Inventory result outputs. Potential environmental impacts are calculated with the CML-IA baseline V 3.06; ReCiPe 2016 Midpoint (H) v 1.04; Formation potential of tropospheric ozone (POCP) from LOTOS-EUROS as applied in ReCiPe Midpoint (H) v 1.13, 2008; IPCC 2013 GWP 100a V1.03 and USEtox 2 (recommended + interim) v.1.0 and Water Scarcity indicator from Pfister et al 2009 v1.02 methods in SimaPro software.
<b>Cut-off Rules</b>	Life Cycle Inventory data for a minimum of 99 % of total inflows to the three life cycle stages have been included. Waste generated from core presses have been excluded due to the cut-off rule. Impacts caused by treatment operations have been calculated lower than 1% environmental relevance. Regarding material and chemical inputs, no cut-off rule has been applied.

More information regarding to ISKO™ and its products is available on [www.isko.com.tr](http://www.isko.com.tr).

Resource Use for NZ-287920

Resource Use							
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total	
Primary Energy Resources Renewable	Use as energy carrier	MJ, net calorific value	14.481	0.65	0.763	0.280	16.171
	Use as raw materials	MJ, net calorific value	0	0	0	0	0
	TOTAL	MJ, net calorific value	14.481	0.65	0.763	0.280	16.171
Primary Energy Resources Nonrenewable	Use as energy carrier	MJ, net calorific value	39.676	3.1	5.7	10.3	58.794
	Use as raw materials	MJ, net calorific value	0	0	0	0	0
	TOTAL	MJ, net calorific value	39.676	3.1	5.7	10.3	58.794
Secondary Material	kg	0.270	0.0053	0	0	0.277	
Renewable Secondary Fuels	MJ, net calorific value	0	0	0	0	0	
Nonrenewable Secondary Fuels	MJ, net calorific value	0	0	0	0	0	
Net use of Fresh Water	m <sup>3</sup>	0.270	0.004	0.015	0.002	0.290	

Waste Production for NZ-287920

Waste Production						
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total
Hazardous Waste	kg	0.000468	INA	0.011	0	0.0115
Non-hazardous Waste	kg	0.003463	INA	0.15	0	0.1570
Radioactive Waste	kg	0	INA	INA	0	0

INA=Indicator Not Available

Potential Environmental Impacts for NZ-287920

Environmental Impacts							
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total	
Global Warming Potential (GWP100a)	Fossil	kg CO <sub>2</sub> eq	2.761	0.19	0.332	0.64	3.92
	Biogenic	kg CO <sub>2</sub> eq	0.067	0.028	0.004	0.008	0.11
	Land Use and Land Transformation	kg CO <sub>2</sub> eq	0.187	0.001	1.01E-04	4.95E-04	0.19
	TOTAL	kg CO <sub>2</sub> eq	3.015	0.218	0.336	0.652	4.22
Acidification Potential (AP)	kg SO <sub>2</sub> eq	0.0114	0.010	0.001	0.003	0.03	
Eutrophication Potential (EP)	kg PO <sub>4</sub> <sup>3-</sup> -eq	0.0089	0.000	0.002	0.000	0.01	
Photochemical oxidant formation potential (POFP)	kg NMVOC eq	0.0079	0.002	0.001	0.004	0.01	
Abiotic Depletion Potential-Elements	kg Sb eq	2.64E-05	1.07E-05	6.36E-07	0.004	0.00	
Abiotic Depletion Potential-Fossil Fuels	MJ, net calorific value	35.318	2.6	4.9	9.2	51.97	
Water Scarcity Potential	m <sup>3</sup> eq	11.602	0.1	0.765	0.048	12.55	

Output Flows for NZ-287920

Output Flows						
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total
Components For Reuse	kg	0	INA	0	0	0
Material For Recycling	kg	0.0172	INA	0.041	0	0.0586
Materials For Energy Recovery	kg	0	INA	0	0	0
Exported energy, Electricity	MJ	0	INA	0	0	0
Exported energy, Thermal	MJ	0	INA	0	0	0

INA=Indicator Not Available

Resource Use for NZ-286048

RESOURCE USE							
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total	
Primary Energy Resources Renewable	Use as energy carrier	MJ, net calorific value	15.157	0.76	0.884	0.325	17.12
	Use as raw materials	MJ, net calorific value	0	0	0	0	0
	TOTAL	MJ, net calorific value	15.157	0.76	0.884	0.325	17.12
Primary Energy Resources Nonrenewable	Use as energy carrier	MJ, net calorific value	42.774	4.2	6.9	11.9	65.74
	Use as raw materials	MJ, net calorific value	0	0	0	0	0
	TOTAL	MJ, net calorific value	42.774	4.2	6.9	11.9	65.74
Secondary Material	kg	0.255	0	0	0	0.26	
Renewable Secondary Fuels	MJ, net calorific value	0	0	0	0	0	
Nonrenewable Secondary Fuels	MJ, net calorific value	0	0	0	0	0	
Net use of Fresh Water	m <sup>3</sup>	0.286	0.005	0.017	0.002	0.31	

Waste Production for NZ-286048

Waste Production						
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total
Hazardous Waste	kg	3.85E-04	0	0.013	0	0.013
Non-hazardous Waste	kg	2.85E-03	0	0.18	0	0.180
Radioactive Waste	kg	0	INA	INA	0	0

INA=Indicator Not Available

Potential Environmental Impacts for NZ-286048

Environmental Impacts							
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total	
Global Warming Potential (GWP100a)	Fossil	kg CO <sub>2</sub> eq	2.932	0.26	0.396	0.75	4.33
	Biogenic	kg CO <sub>2</sub> eq	0.0713	0.029	0.005	0.010	0.12
	Land Use and Land Transformation	kg CO <sub>2</sub> eq	0.195	0.001	1.17E-04	5.74E-04	0.20
	TOTAL	kg CO <sub>2</sub> eq	3.198	0.287	0.401	0.756	4.64
Acidification Potential (AP)	kg SO <sub>2</sub> eq	0.0122	0.018	0.001	0.004	0.03	
Eutrophication Potential (EP)	kg PO <sub>4</sub> <sup>3-</sup> eq	0.0093	0	0.002	0.001	0.01	
Photochemical oxidant formation potential (POFP)	kg NMVOC eq	0.0085	0.003	0.001	0.005	0.02	
Abiotic Depletion Potential-Elements	kg Sb eq	2.81E-05	1.69E-05	7.37E-07	1.73E-05	0	
Abiotic Depletion Potential-Fossil Fuels	MJ, net calorific value	38.073	3.5	5.8	10.6	58.08	
Water Scarcity Potential	m <sup>3</sup> eq	12.137	0.163	0.886	0.055	13.24	

Output Flows for NZ-286048

Output Flows						
Parameter	Unit	Upstream-Denim Fabric	Upstream-Garment Maker	Core	Downstream	Total
Components For Reuse	kg	0	INA	0	0	0
Material For Recycling	kg	0.0142	INA	0.048	0	0.062
Materials For Energy Recovery	kg	0	INA	0	0	0
Exported energy, Electricity	MJ	0	INA	0	0	0
Exported energy, Thermal	MJ	0	INA	0	0	0

INA=Indicator Not Available

ISO 14040: 2006 Environmental management | Life cycle assessment | Principles and framework

ISO 14044: 2006 Environmental management | Life cycle assessment | Requirements and guidelines

ISO 14025: 2006 Environmental labels and declarations | Type III environmental declarations | Principles and procedures

ISO 14020: 2000 Environmental labels and declarations — General principles

The International EPD® System | [www.environdec.com](http://www.environdec.com)

The International EPD® System | The General Programme Instructions  
<http://www.environdec.com/tr/The-International-EPD-System/General-Programme-Instructions/>

The International EPD® System | Jackets, coats and other similar outdoor garments 2019:04, version 1.02 UN CPC 282

Ecoinvent 3.6 database | <http://www.ecoinvent.org>

SimaPro LCA Software | <https://simapro.com>

ISKO™ | <http://www.isko.com.tr>

GaBi database | Cotton fiber (organic) (at gin gate) <http://www.gabi-software.com/in>

Van der Velden, N.M., Patel, M.T., Vogtlander, J.G., 2014 / LCA benchmarking study on textiles made of cotton, polyester, nylon, acryl, or elastane. | International Journal of Life Cycle Assessment 19, 331 - 356.

Environmental Improvement Potential of textiles (IMPRO Textiles) | <https://publications.europa.eu/en/publication-detail/-/publication/f8d0def8-4fd5-4d84-a308-1dfa5cf2e823/language-en>

### Third Party Verifier

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Accredited or approved by: The International EPD® System



### Owner of the Declaration

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More information about ISKO™'s approach to sustainability and its corporate social responsibility initiatives available via the CSR Team at [sustainability@isko.com.tr](mailto:sustainability@isko.com.tr)



# ISKO™

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