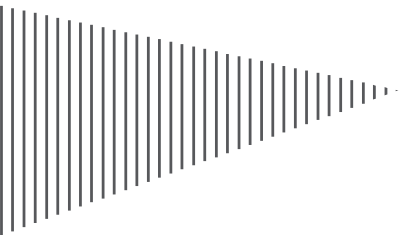


**Life Cycle Assessment of Newly  
Manufactured and Reconditioned  
Industrial Packaging**

**REVISED VERSION**

*October 2015*





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# 1. Introduction

For nearly three-quarters of a century, the Reusable Industrial Packaging Association (RIPA) has been the trade association representing North American reconditioners, manufacturers and distributors of reusable industrial packaging. RIPA represents over 90 % of the industrial packaging reconditioning industry in North America including many of the world's leading manufacturers of steel, plastic and fiber drums, as well as intermediate bulk containers. The RIPA membership also includes many of the leading suppliers of packaging parts and accessories.

As a condition of membership, all RIPA members agree to conform to a Code of Operating Practice, which sets forth specific guiding principles for operations, packaging reuse and recycling. These guidelines are intended to improve the industry's performance in the areas of regulatory compliance, environmental management, waste reduction and recycling.

RIPA is the industry's information clearinghouse. The association sponsors workshops and meetings that provide information about issues of importance to the industry's wellbeing and continued success. The group's Annual Conference, Technical Conference and compliance workshops help ensure that members understand key issues affecting their businesses, and can learn about technical and business developments. The association publishes an industry newsletter, "Reusable Packaging Today," and distributes Special Bulletins on issues of immediate concern to members.

RIPA has requested to analyze the environmental performance of industrial packaging. What are the ecological impact differences of reconditioning as compared with manufacturing a drum, IBC and Multitank from raw materials? This report presents the goal and scope of the study performed (chapter 2), the results (chapter 3) and conclusions of the study (chapter 4).

**This report is a revised version of the report that has been made in 2013. The changes can be summarized as follows:**

- **The drum made from post-consumer plastic is placed out of scope.**
- **Data modifications and improvements have been made in the input data for the LCA.**
- **Improvements are made with an update of data, recalculations in the SimaPro model and the LCA. The LCA calculation is improved, based on final data analysis October 2015.**

The details of the changes are described in Appendix D.

## 2. Goal and scope

This chapter of the report discusses the goal and scope of the study. The functional unit and the specific products are involved as well. It also discusses the choices concerning allocation, system boundaries and assessment method.

### 2.1 Goal

The primary goal of the study is a head to head comparison between a new packaging and a reconditioned packaging of similar technical specifications, resulting from a single trip and multi-trip industrial packaging solution.

### 2.2 Functional unit

The functional unit of the comparison are packaging units with capacities of 55, 105.7 and 275 or 330 gallons, which are used to transport chemicals or other substances. The packaging content of 55 gallons is used for drums, the packaging content of 105.7 gallons is used for Multitank and the packaging of 275 gallons and 330 gallons are used for IBCs. The production, transport to customer and the end of life are included in the functional unit. The functional flow is one unit of packaging.

### 2.3 The product systems

The following product systems are part of the scope of the project:

Packaging type	Content	New	Reconditioned
IBC	275 USGal 330 USGal	Steel pallet	Steel pallet
Steel drum	55 US Gal	Tight head Open head	Tight head Open head
Plastic drum	55 US Gal	Tight head (virgin plastic)	Tight head
Multitank	105.7 US Gal	(virgin plastic)	

#### IBC

An IBC has a 275 or 330 gallon volume polyethylene bottle which will contain the product during use. The bottle is inside a steel tube cage. The analyzed systems have a steel pallet.

#### Steel drum

A steel drum is completely made out of steel sheet, with an outside coating applied later in the process. The drum is manufactured as an open - or tight head. The top of the tight head is seamed to the body and only two small openings remain for filling and emptying the drum. The lid of the open head can be removed from the rest of the drum for filling. Lid and drum body are assembled with a bolt or clamp ring. Open head steel drums also utilize a plasticized gasket to facilitate proper closure.

#### Plastic drum

A plastic drum is made out of high density polyethylene (HDPE). The plastic used is a mix of virgin and recycled plastic. The tight head plastics drum is one piece blow molded. It has two small openings for filling and emptying the drum.

#### Multitank

Multitank is made out of high density polyethylene (HDPE). The plastic used is virgin plastic.

### Collection process

It is normal practice to collect drums and IBCs from users who have emptied the packaging. The drums and IBC's are collected by truck and transported to a reconditioning facility. There, they are reconditioned as explained above and sold to customers again.

## 2.4 System boundary

The system boundary determines the unit processes included or excluded in each life cycle of the product system. One life cycle has connections with other life cycles. This is for instance the case with the life cycle of a packaging and the life cycle of the content of the packaging. Another example is the use of recycled materials that originate from another life cycle. It is important to determine and show which processes will be included, how they are included and also which will be excluded. This is essential for the interpretation of the results and conclusions of the study.

Below a process flow diagram is presented, which provides an overview of the flow of the processes in the system. The boxes with the dotted lines are not included in the life cycles of the product systems.

### Upstream Processes

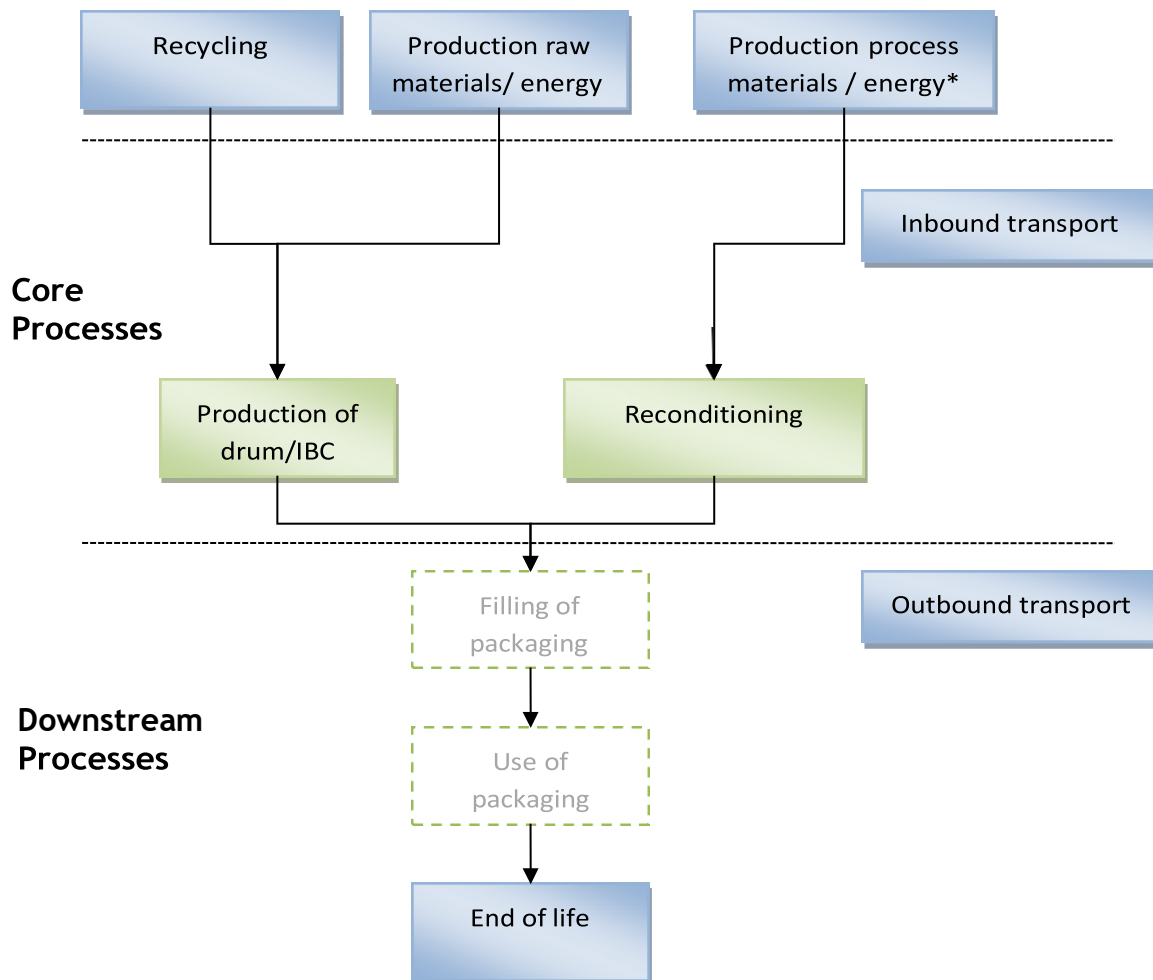


Figure 1 Schematic representation of the system boundary of the life cycle assessment

\* Upstream processes involved in the reconditioning only reflect materials needed for washing (like e.g. caustic soda) and nothing of the packaging materials themselves.

### **Allocation and recycling**

System boundaries are also set in the life cycle to determine the allocation of burdens and benefits regarding recycling. For instance, scrap is the output from the life cycle of steel drums and is used in another life cycle of perhaps a steel clamp ring of a drum. The boundary between the two life cycles should be set and be consistent throughout the whole study. The benefit of recycling should not be claimed twice. This happens if a benefit is provided to the drum that is scrapped and to the clamp ring that uses the scrap. The system boundary is set before the use of the recycled material by products downstream that has been provided by the products in this study. The benefits of providing materials for recycling are therefore not deducted from the burdens but also the burdens of the recycling process (for instance the scrapping process) are not taken into account here.

The recycled content of steel is set at the amount of steel that is recycled at the end of life. The reason of this choice is that steel is a closed loop material: it is possible to recycle steel an indefinite number of times. The limit is the steel that is kept in the loop and is recycled in the end of life phase.

Some recycling plants, as in energy recovery facilities, generate electricity and heat. This benefit is included in the national electricity mixes. This benefit is therefore allocated to the use of electricity and not to the material and product generating the energy when incinerated.

### **Drums, Multitanks and IBCs for collection**

Each reconditioned drum, Multitank or IBC was once newly manufactured. The drums, Multitank and IBCs are collected after use by the reconditioning party. The impact of the newly manufactured drum is not included in any way in the life cycle of the reconditioned drum.

## **2.5 Impact assessment method**

The focus of the study is on the emission of greenhouse gasses (GHG), which influences global warming. There are many different gasses that have this potential for global warming, but this potential is different for each gas. To be able to add up all these potentials, the global warming potential (GWP) of a substance is related to the GWP of carbon dioxide. Methane, for instance has a 25 times higher GWP than carbon dioxide, its conversion factor is therefore 25. To add up 1 kg of methane and 1 kg of carbon dioxide the amount of methane emitted is multiplied with 25 and then added to the amount of carbon dioxide emitted. This results in a total GWP equivalent to 26 kg carbon dioxide or CO<sub>2</sub>e in this case.

Besides global warming there are other environment issues, for instance ozone depletion, toxicity, resource depletion. The results of this study will therefore be complemented with the results of several other impact categories as well. The impact potentials are calculated in these impact categories in a similar way as the GWP of the climate change calculated as explained above.

There are different impact assessment methods that have determined conversion factors for the impact categories. In this study the method Traci 2.1, version 1.02 with normalization and weighting set US-Canadian 2008 is used. This is a method that is developed specifically for the North American continent. More information about this method can be found in Appendix E. The impact categories in Table 1 are included in the analysis.

Table 1 Impact categories of Traci 2.1

Impact category	Unit
Climate change	Lbs CO2e
Ozone depletion	Lbs CFC-11e
Acidification	Lbs SO2e
Eutrophication	Lbs Ne
Smog	Lbs O3e
Carcinogenics	CTUh
Non carcinogenics	CTUh
Respiratory effects	Lbs PM 2.5e
Ecotoxicity	CTUe
Fossil fuel depletion	MJ surplus

The main focus is on climate change, the other impact categories are discussed more briefly.



### 3. Life cycle inventory

The inventory data can be divided in foreground and background data. The foreground data are the core processes of the figures in and concerns processes like energy use of production and material use. This data is collected using questionnaires send to members of RIPA.

The background data are the upstream and downstream processes of the figures in 3.4.1 and concerns processes like energy production, raw material production, resource extraction etc. A specific database for the US will be used: USLCI database<sup>1</sup>. This database contains processes specific for the production processes and circumstances in the USA. Data gaps are filled with data from the database Ecoinvent 3<sup>2</sup>, the most up-to-date and large LCA database available.

#### 3.1 Inbound transport

The raw materials and the drums and IBC to be reconditioned need to be transported to the manufacturing or reconditioning facility. The inbound transport is set at 200 miles, these materials are typically purchased within this distance from the facility. The transport of drums and IBCs to be reconditioned is dependent on the size of the packaging, the size of the truck, the distance to the client and the number of drums or IBCs to be delivered. The number of 55 gallon drums per truck load is set at 250, the number of 275 gallon IBCs per truckload is set at 60, the number of 330 gallon IBCs per truckload is set at 50 and the number of 105.7 gallon Multitanks per truckload is set at 360.

#### 3.2 Manufacturing

Ten manufacturers of drums and IBCs have responded to a request to provide data about the production of the manufacturing of both drums and IBCs. This resulted in data from sixteen different production lines, some manufacturers provided data of multiple lines. The database processes used and the assumptions used are presented in Appendix A. The inventory per manufacturer is confidential information, only the averages per packaging type are presented, see Appendix C

The main dimensions of the different packaging types are presented below.

##### Steel drum

Steel sheet thickness (mm) Top/body/bottom	Tight head Steel weight (lbs.)	Open head Steel weight (lbs.)
1.2/1.2/1.2	44.8	47.5
1.0/1.0/1.0	37.7	42.3
1.2/0.9/1.2	36.7	40.8
1.1/0.9/1.1	35.6	40.0
1.1/0.8/1.1	33.5	37.8
1.0/0.8/1.0	32.9	35.5
0.8/0.8/0.8	31.0	33.3

##### IBC - composite, steel pallet

IBC type	Steel weight (lbs.)	Virgin plastic weight (lbs.)	Recycled plastic weight (lbs.)
275 gallon IBC	80.4	41.8	5.3
330 gallon IBC	96.5	50.2	6.4

### Plastic drum - tight head

IBC type	plastic weight PE-mix (lbs.)
55 gallon plastic	21

### Multitank

Multitank	plastic weight PE (lbs.)
105.7 gallon plastic	70.5

The material PE-mix is based on an average use of 53% virgin and 47% recycled material.

## 3.3 Reconditioning

Sixteen reconditioning facilities responded to a request to provide data about the production of the reconditioning of both drums and IBCs. This resulted in data from nineteen different reconditioning lines, some reconditioners provided data of multiple lines. The aggregated data of the reconditioning is presented in Appendix B.

## 3.4 Outbound transport

The manufactured (both new and reconditioned) drums and IBC need to be transported to the client. The outbound transport is set at 200 miles, the truck load is set equal to the truckload of the inbound transport.

## 3.5 End of life

No direct data of the end of life statistics of industrial packaging is available. The statistics of Municipal solid waste (MSW) are used as proxy data. The recycling percentage of the plastic and steel is obtained from the EPA<sup>3</sup>. The remaining waste is either incinerated or landfilled. This ratio is also based on EPA as included in the end of life scenario of the USA.

Recycling percentage of Plastics: 12.9%<sup>a</sup>. Recycling percentage of steel: 72%<sup>b</sup>.

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<sup>a</sup> From MSW category: Total Plastics in Cont. & Packaging

<sup>b</sup> From MSW category: Containers and Pack aging – Total steel packaging

## 4. Results

This chapter presents the results of the life cycle assessment. The results of the analysis of the carbon footprint of the open head steel drum, tight head steel drum, tight head plastic drum, IBC and Multitank are discussed in the first four paragraphs and an overview of the results is presented in the fifth paragraph. The sixth paragraph discusses other impact categories like ozone depletion and ecotoxicity.

### 4.1 Carbon footprint: Open head steel drum

Figure 2 shows the head to head comparison of the life cycle of a newly manufactured drum and a reconditioned drum. The outbound transport and end of life of both systems is assumed to be the same. The differences are in the raw materials, inbound transport and the production/reconditioning process. The raw materials of the reconditioning process concern materials like steel shot that are used in the process but it also includes inner lining and coatings. The figure shows that the GHG-emissions of the life cycle of a reconditioned drum are almost one third of the GHG-emissions of a newly manufactured open head steel drum.

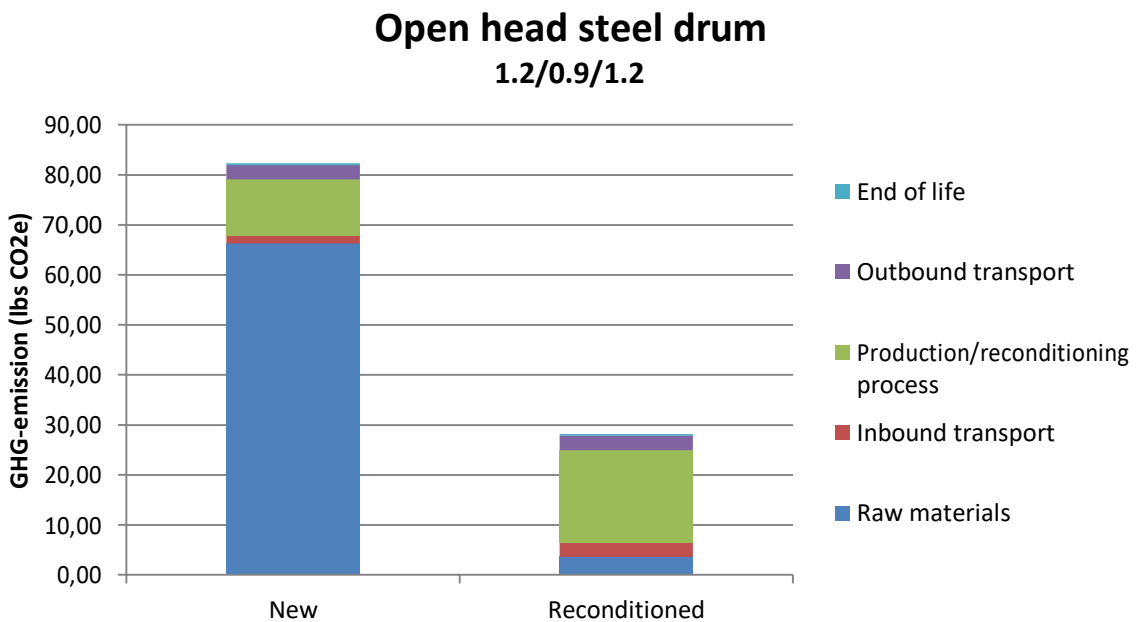


Figure 2 Comparison of carbon footprint between newly manufactured open head steel drum with the reconditioned open head steel drum

#### Open head steel drum - 1.2/0.9/1.2 - carbon footprint (lbs CO<sub>2</sub>e)

	Raw materials	Inbound transport	Production/reconditioning process	Outbound transport	End of life	Total (lbs CO <sub>2</sub> e)
New	66.26	1.59	11.22	2.91	0.35	<b>82.3</b>
Reconditioned	3.59	2.91	18.4	2.91	0.35	<b>28.2</b>

Open head steel drums are manufactured with steel sheet of different thicknesses, from 0.8 to 1.2 mm. Figure 3 shows an overview of the GHG-emission of the different open head steel drums.

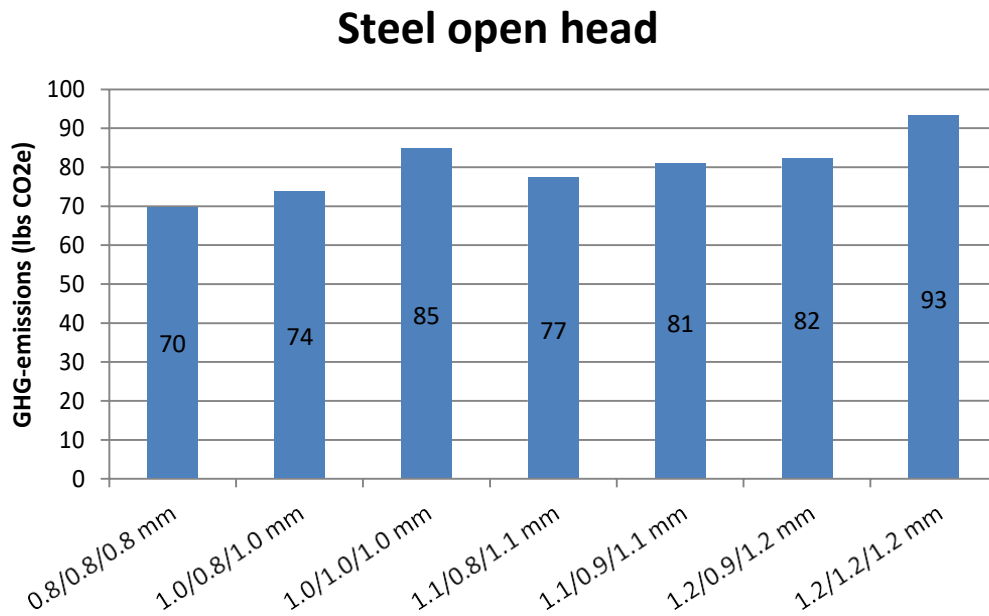


Figure 3 Comparison of the carbon footprint between open head steel drums with different thickness steel sheet. The codes refer to the thickness of the steel sheet: bottom/body/top

Figure 3 shows the expected results that the drums with the thinner sheet have lower GHG-emissions than the drums with thicker steel sheet. It should be stressed that the drums with thicker sheet can be reconditioned and can be reconditioned more often. The comparison with the reconditioned drum shows that the possibility of reconditioning the drums with thicker steel sheets outweighs the reduced impact of the drums with thinner steel sheet.

## 4.2 Carbon footprint: Tight head steel drum

Figure 4 shows a head to head comparison between a newly manufactured tight head drum (1.2/0.9/1.2 mm) and a reconditioned tight head drum.

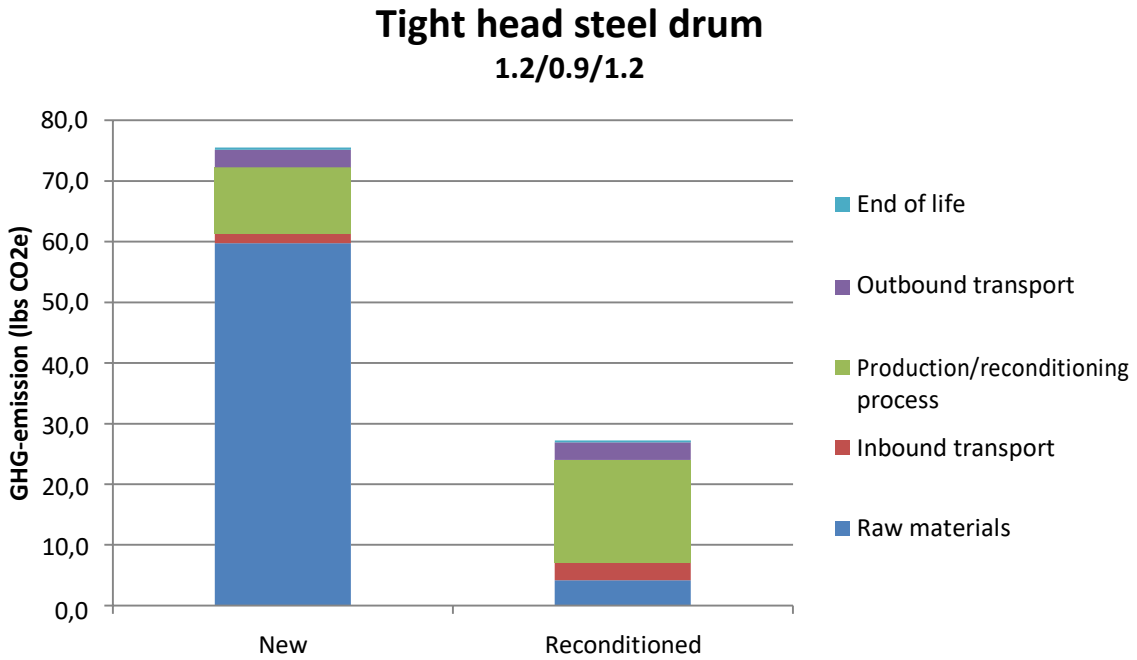


Figure 4 Comparison of carbon footprint between newly manufactured tight head steel drums with the reconditioned tight head steel drum.

### Tight head steel drum - 1.2/0.9/1.2 - carbon footprint (lbs CO<sub>2</sub>)

	Raw materials	Inbound transport	Production/reconditioning process	Outbound transport	End of life	Total (lbs CO <sub>2</sub> e)
New	59.8	1.57	10.95	2.91	0.33	75.5
Reconditioned	4.18	2.91	16.91	2.91	0.33	27.2

The above figure shows that the GHG-emissions of the reconditioned drum are about 36 % of the GHG-emissions of a newly manufactured drum. Figure 5 shows a comparison of tight head steel drums with different steel sheet thickness.

## Steel tight head

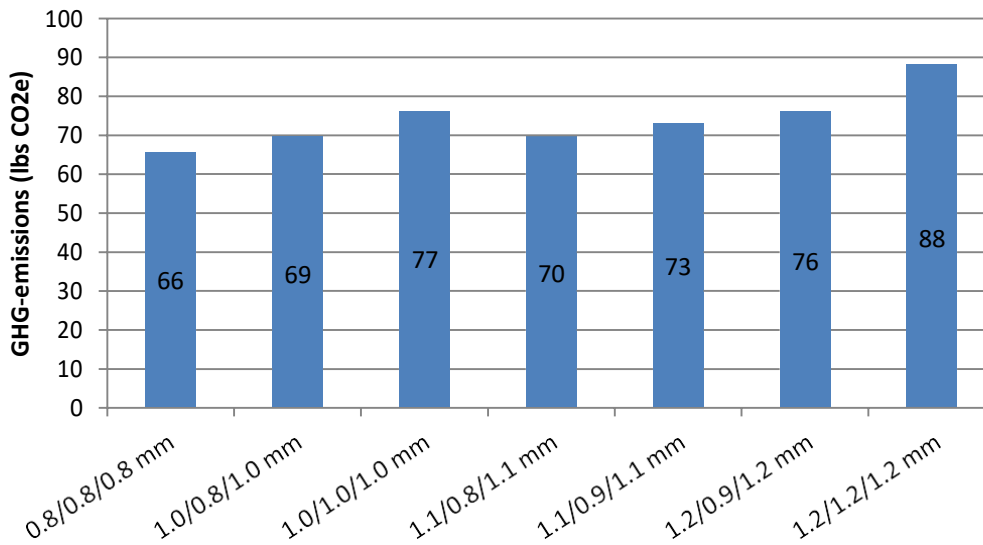


Figure 5 Comparison of the carbon footprint between tight head steel drums with different thickness steel sheet. The codes refer to the thickness of the steel sheet: bottom/body/top.

The figure above shows a difference of 25 % GHG-emission between the lightest and heaviest drum.

### 4.3 Carbon footprint: Tight head plastic drum

Figure 6 shows a comparison between the life cycle of a newly manufactured tight head plastic drum and a reconditioned drum. There is a small advantage of using a reconditioned drum. For reconditioning more energy is required in the processing, but this is compensated by the benefits of not using new plastic PE-mix.

#### Tight head plastic drum

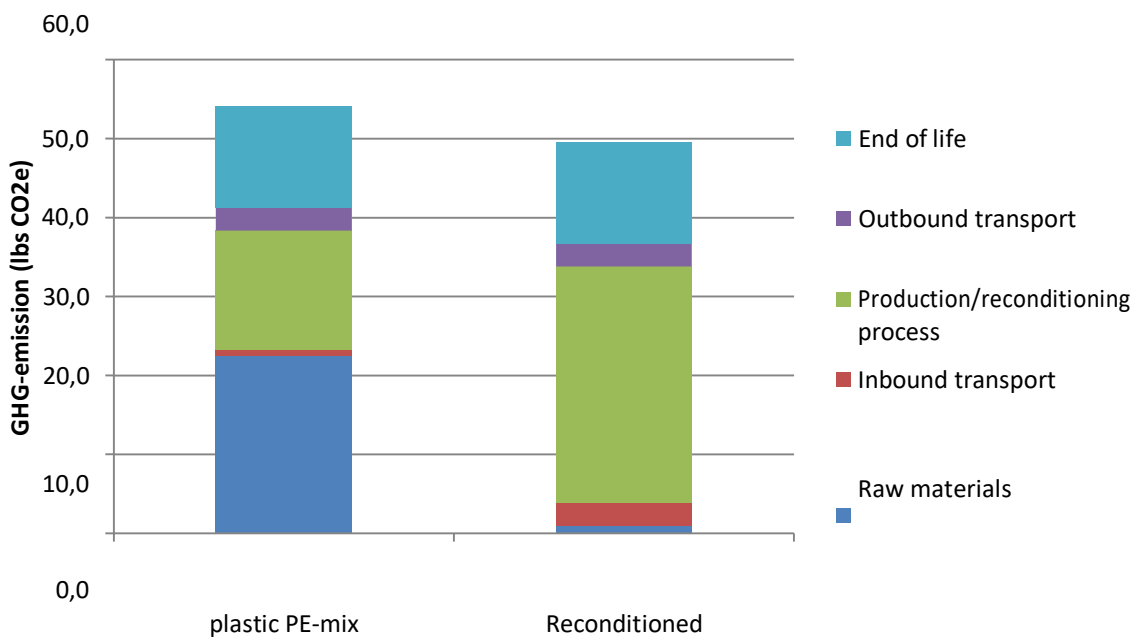


Figure 6 Comparison of carbon footprint between newly manufactured drums made from plastic PE-mix and the reconditioned drum

### Tight head plastic drum - carbon footprint (lbs CO<sub>2</sub>)

	Raw materials	Inbound transport	Production/reconditioning process	Outbound transport	End of life	Total (lbs CO <sub>2</sub> e)
Plastic PE-mix	22,4	0,8	15,1	2,9	12,8	<b>54,1</b>
Reconditioned	0,9	2,9	30,0	2,9	12,8	<b>49,5</b>

What would have happened if the plastic drum was not reconditioned? Would the plastic have been incinerated? Reconditioning avoid emissions that would have been caused by the disposal. These avoided emissions are not taken into account but are a benefit of reconditioning.

## 4.4 Carbon footprint: IBC

Figure 7 shows a comparison between the life cycles of newly manufactured IBCs and reconditioned IBCs. The benefit of reconditioning an IBC is substantial. The GHG-emissions of reconditioned IBCs are less than a third of the GHG-emissions of newly manufactured IBCs.

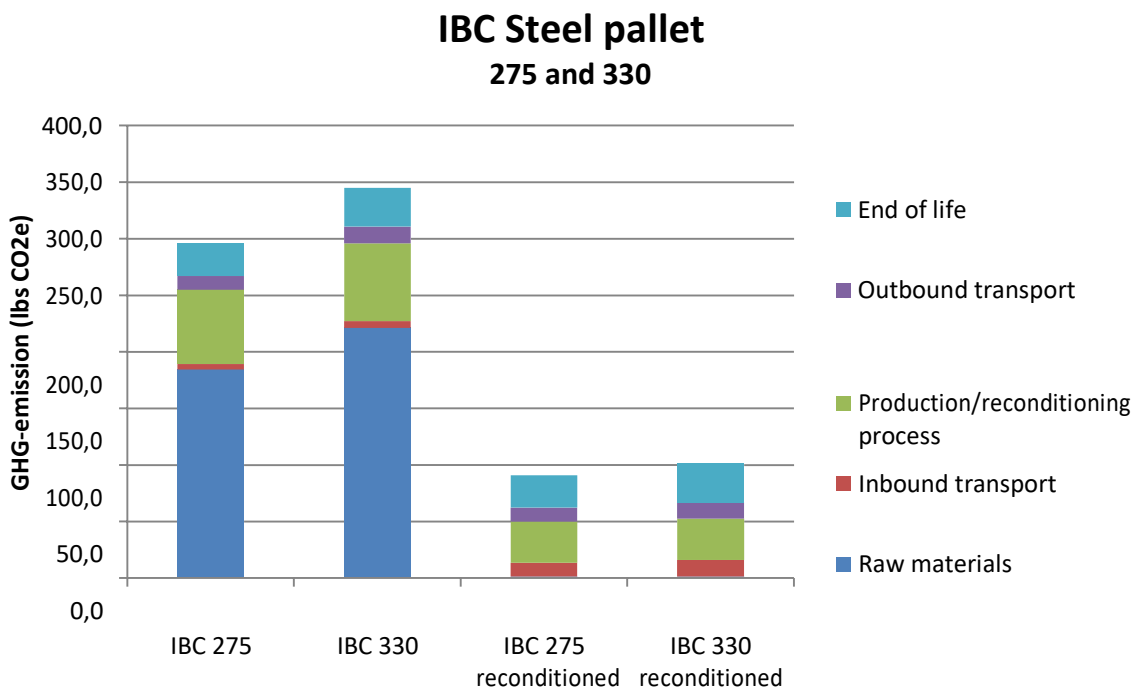


Figure 7 Comparison of carbon footprint between newly manufactured IBCs and the reconditioned IBCs with the sizes 275 and 330 lbs.

### Intermediate bulk container (IBC) - carbon footprint (lbs CO<sub>2</sub>)

	Raw materials	Inbound transport	Production/reconditioning process	Outbound transport	End of life	Total (lbs CO <sub>2</sub> e)
<b>IBC 275</b>	184,5	4,9	65,6	12,1	28,6	<b>295,8</b>
<b>IBC 330</b>	221,2	5,9	68,9	14,6	34,3	<b>345,0</b>
<b>IBC 275 reconditioned</b>	1,5	12,1	36,6	12,1	28,6	<b>91,0</b>
<b>IBC 330 reconditioned</b>	1,5	14,6	36,6	14,6	34,3	<b>101,6</b>

## 4.5 Carbon footprint: Multitank

Figure 8 shows a comparison between the life cycles of newly manufactured Multitank and reconditioned Multitank. The benefit of reconditioning a Multitank is substantial. The GHG-emissions of reconditioned Multitanks are less than a half of the GHG-emissions of newly manufactured Multitank.

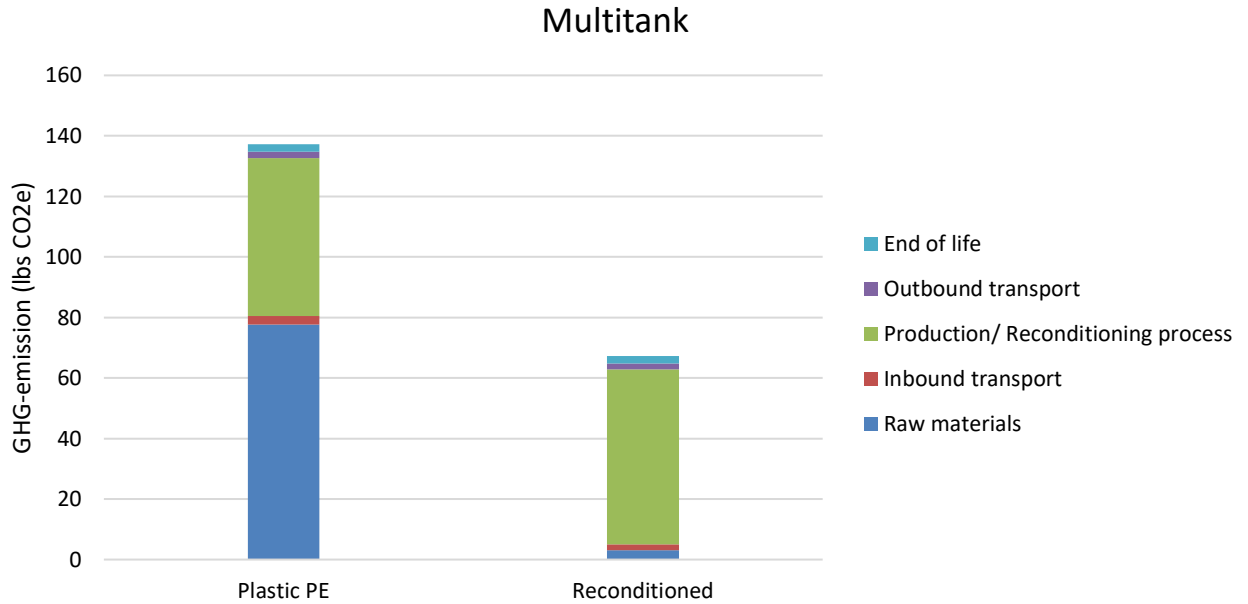


Figure 8 Comparison of carbon footprint between newly manufactured Multitanks made from plastic PE and the reconditioned Multitanks

### Multitank (lbs CO<sub>2</sub>)

	Raw materials	Inbound transport	Production/reconditioning process	Outbound transport	End of life	<b>Total (lbs CO<sub>2</sub>e)</b>
Plastic PE	75,2	2,7	50,7	2,0	43,0	<b>173,7</b>
Reconditioned	0.57	2,0	13,7	2,0	43,0	<b>61,3</b>

What would have happened if Multitank was not reconditioned? Would the plastic have been incinerated? Reconditioning avoids emissions that would have been caused by the disposal. These avoided emissions are not taken into account but are a benefit of reconditioning.



## 4.6 Carbon footprint - results overview

### Overview of carbon footprint results

Category	Type	New (lbs/Kg CO <sub>2</sub> )	Recon (lbs/kg CO <sub>2</sub> )	Kg CO <sub>2</sub> per 100 lt
	Open head	82.30 / 37.33	28.2 / 12.8	<b>17.0</b>
	Tight head	75.5 / 34.24	27.2 / 12.34	<b>17.0</b>
	Tight head Plastic PE- mix	54.1 / 24.54	49.5 / 22.45	<b>11.2</b>
	275 gallon	295.8 / 134.17	91.0 / 41.27	<b>13.4</b>
	330 gallon	345.0 / 156.5	101.6 / 46.08	<b>15.7</b>
	105.7 gallon	173.7 / 78.7	61.3 / 28.0	<b>2.13</b>

## 4.7 Environmental footprints

The emission of greenhouse gasses is not the only environmental issue. A comparison between newly manufactured industrial packaging and reconditioned packaging with more environmental topics are shown in the figures from

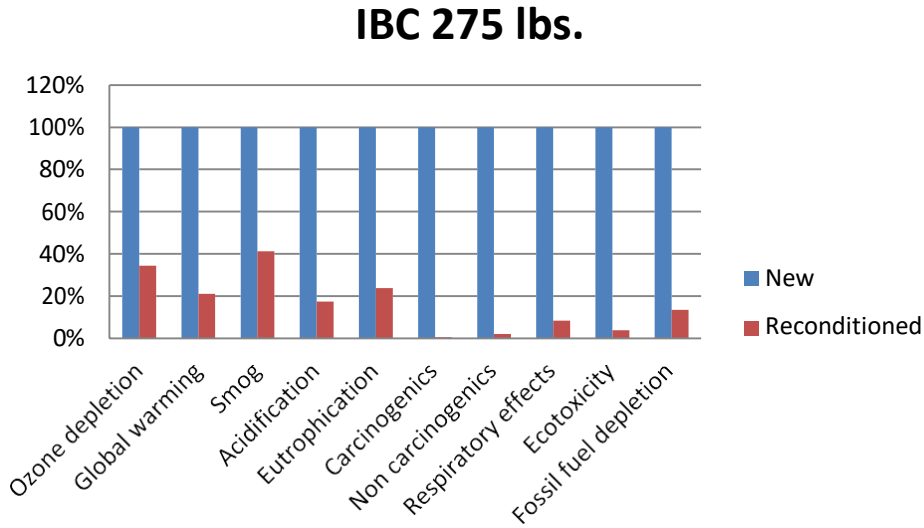


Figure 8 to Figure 12.

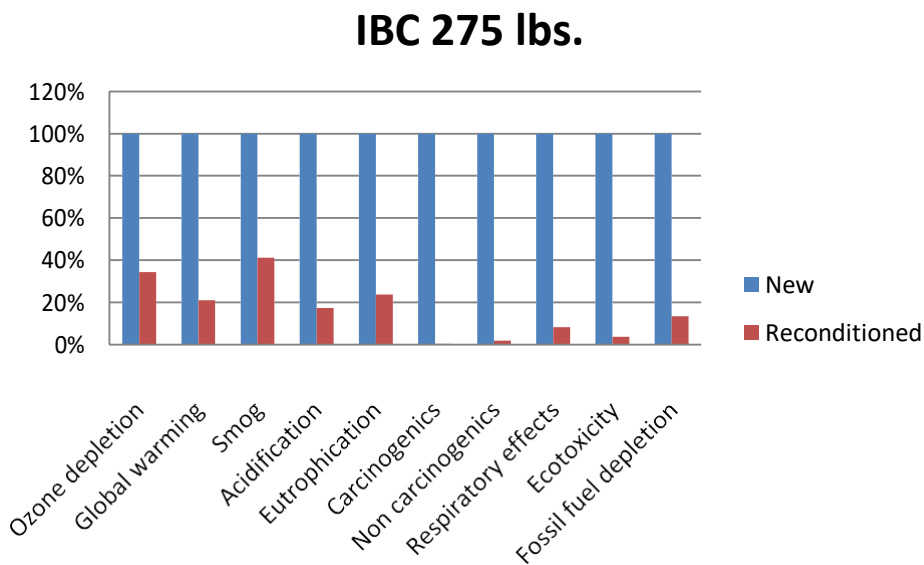


Figure 8 Comparison on multiple environmental issues between newly manufactured IBC and reconditioned IBC of 275 lbs.

## IBC 330 lbs.

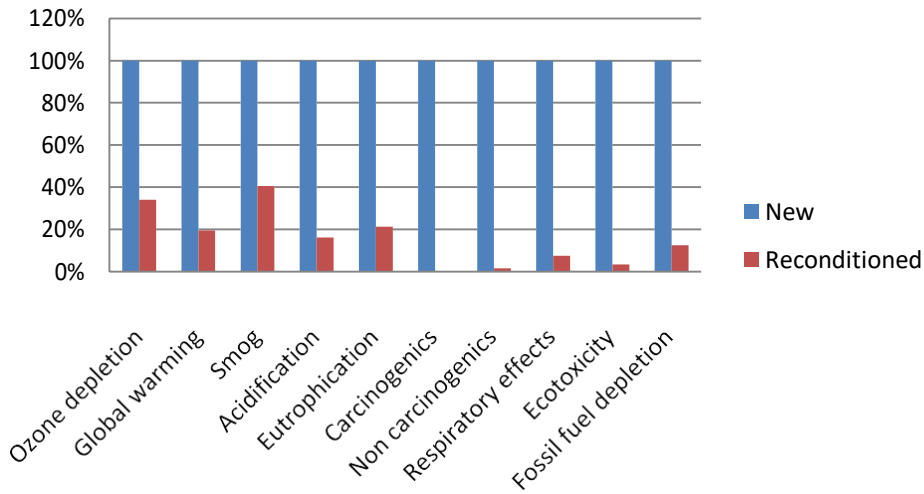
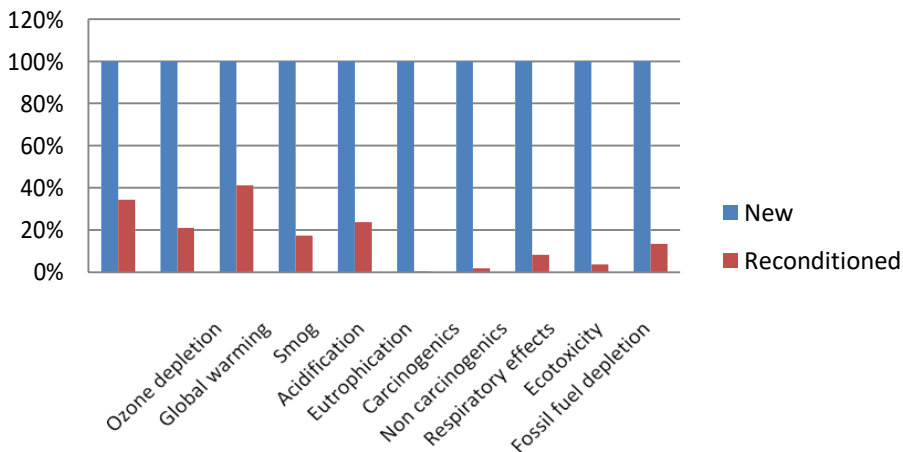


Figure 9 Comparison on multiple environmental issues between newly manufactured IBC and reconditioned IBC of 330 lbs

### Intermediate bulk container (IBC)

	Unit	New IBC 275	New IBC 330	Reconditioned IBC 275	Reconditioned IBC 330
Ozone depletion	Lbs CFC-11 eq	1.47E-05	1.77E-05	5.07E-06	6.04E-06
Global warming	Lbs CO2 eq	2.96E+02	3.45E+02	6.24E+01	6.72E+01
Smog	Lbs O3 eq	1.83E+01	2.13E+01	7.53E+00	8.64E+00
Acidification	Lbs SO2 eq	2.61E+00	3.05E+00	4.57E-01	4.92E-01
Eutrophication	Lbs N eq	2.04E-01	2.44E-01	4.86E-02	5.20E-02
Carcinogenics	CTUh	2.52E-05	3.01E-05	9.89E-08	1.03E-07
Non carcinogenics	CTUh	7.80E-05	9.34E-05	1.53E-06	1.61E-06
Respiratory effects	Lbs PM2.5 eq	3.01E-01	3.57E-01	2.52E-02	2.73E-02
Ecotoxicity	CTUe	4.57E+02	5.47E+02	1.75E+01	1.86E+01
Fossil fuel depletion	MJ surplus	2.97E+02	3.53E+02	4.01E+01	4.46E+01

## IBC 275 lbs.



## Steel open head drum

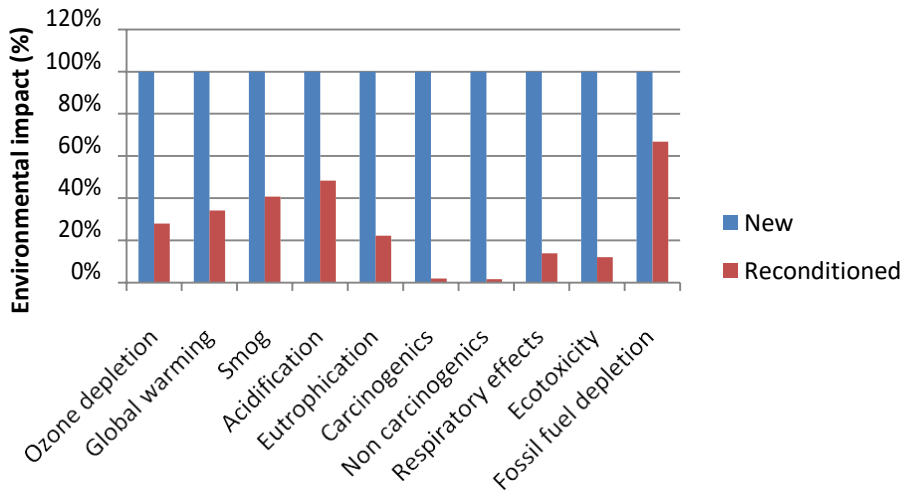


Figure 10 Comparison on multiple environmental issues between newly manufactured open head steel drum and the reconditioned drum.

### Steel drum open head - 1.2/0.9/1.2

	Unit	New drum	Reconditioned drum
Ozone depletion	Lbs CFC-11 eq	6.14E-06	1.72E-06
Global warming	Lbs CO2 eq	8.23E+01	2.82E+01
Smog	Lbs O3 eq	5.45E+00	2.23E+00
Acidification	Lbs SO2 eq	4.86E-01	2.35E-01
Eutrophication	Lbs N eq	9.14E-02	2.04E-02
Carcinogenics	CTUh	1.26E-05	2.43E-07
Non carcinogenics	CTUh	3.56E-05	5.86E-07
Respiratory effects	Lbs PM2.5 eq	1.06E-01	1.48E-02
Ecotoxicity	CTUe	1.61E+02	1.95E+01
Fossil fuel depletion	MJ surplus	4.00E+01	2.67E+01

Figure 10 shows that the reconditioned open head steel drum scores better on all analyzed environmental issues.

## Steel tight head drum

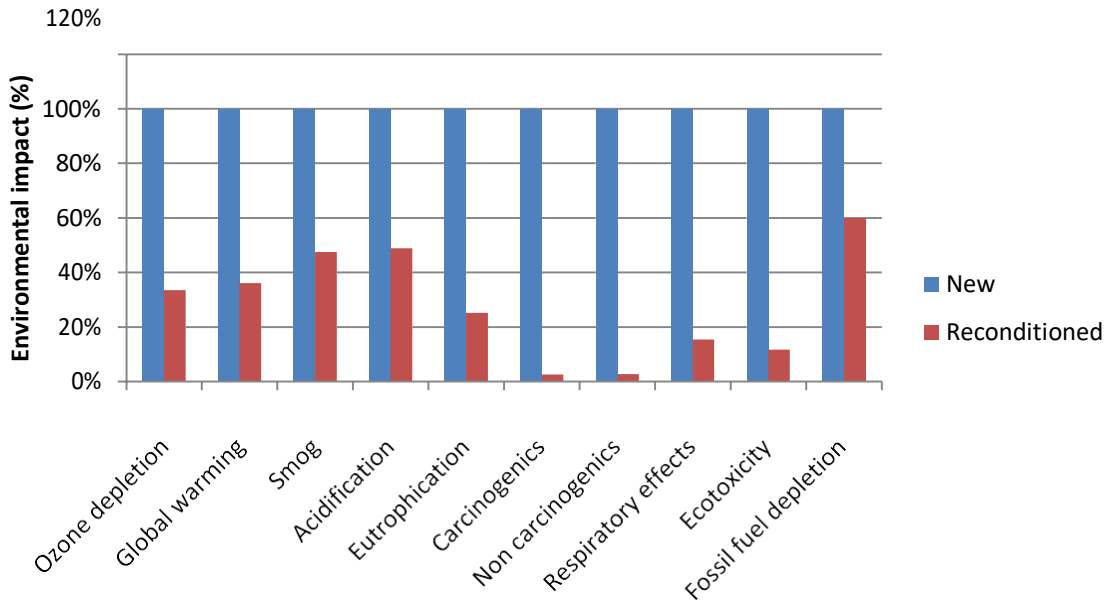


Figure 11 Comparison on multiple environmental issues between newly manufactured tight head steel drum and the reconditioned drum

### Steel drum tight head - 1.2/0.9/1.2

	Unit	New drum	Reconditioned drum
Ozone depletion	Lbs CFC-11 eq	3.46E-06	2.32E-06
Global warming	Lbs CO2 eq	7.16E+01	4.61E+01
Smog	Lbs O3 eq	4.88E+00	3.39E+00
Acidification	Lbs SO2 eq	4.29E-01	3.71E-01
Eutrophication	Lbs N eq	6.35E-02	4.86E-02
Carcinogenics	CTUh	1.14E-05	6.92E-07
Non carcinogenics	CTUh	3.19E-05	1.59E-06
Respiratory effects	Lbs PM2.5 eq	9.23E-02	2.61E-02
Ecotoxicity	CTUe	1.44E+02	3.55E+01
Fossil fuel depletion	MJ surplus	3.07E+01	3.20E+01

Figure 11 shows that the reconditioned tight head steel drum scores better on all analyses environmental issues.

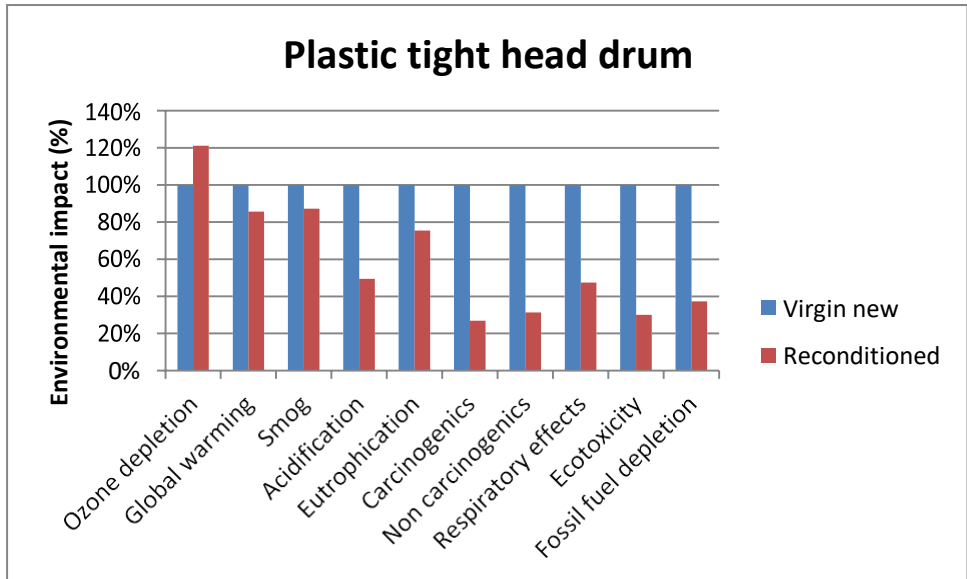


Figure 12 Comparison on multiple environmental issues between newly manufactured drums made from PE-mix plastic and the reconditioned drum

### Plastic drum tight head

	Unit	PE-mix new drum	Reconditioned drum
Ozone depletion	Lbs CFC-11 eq	1,01E-06	1,22E-06
Global warming	Lbs CO2 eq	5,41E+01	4,64E+01
Smog	Lbs O3 eq	3,09E+00	2,70E+00
Acidification	Lbs SO2 eq	5,68E-01	2,81E-01
Eutrophication	Lbs N eq	1,07E-02	8,06E-03
Carcinogenics	CTUh	1,98E-07	5,31E-08
Non carcinogenics	CTUh	2,23E-06	6,99E-07
Respiratory effects	Lbs PM2.5 eq	3,23E-02	1,53E-02
Ecotoxicity	CTUe	4,66E+01	1,40E+01
Fossil fuel depletion	MJ surplus	6,88E+01	2,56E+01

The reconditioned plastic drum scores lower on most environmental issues than the newly manufactured drum. The exception is ozone depletion, which is mainly caused by the higher inbound transport and the higher energy use for processing of the drums to be reconditioned.

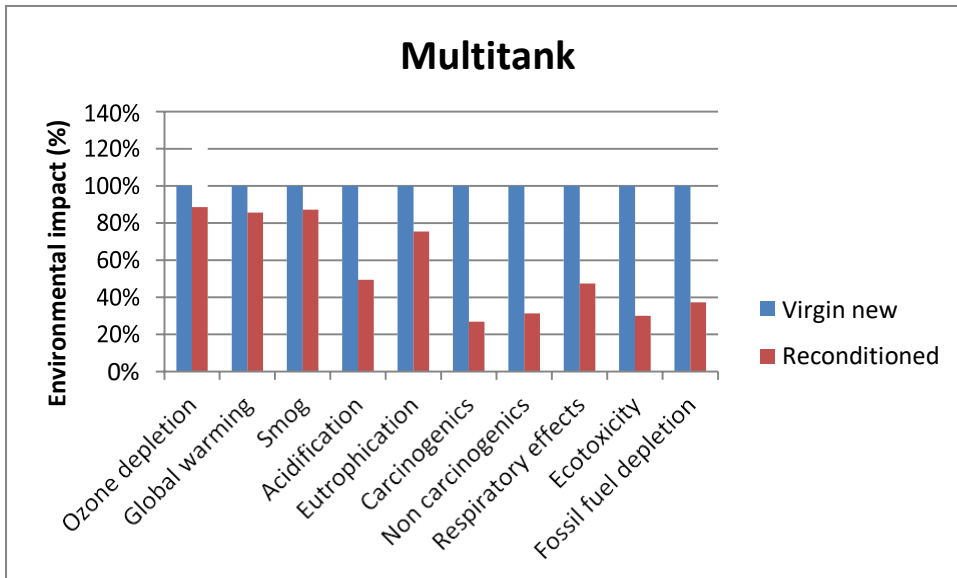


Figure 13 Comparison on multiple environmental issues between newly manufactured Multitanks made from PE virgin plastic and the reconditioned Multitank

### Multitank

	Unit	PE-mix new drum	Reconditioned drum
Ozone depletion	Lbs CFC-11 eq	3.49E-06	2.34E-06
Global warming	Lbs CO2 eq	18.71E+01	8.90E+01
Smog	Lbs O3 eq	10.9E+00	5.18E+00
Acidification	Lbs SO2 eq	19.65E-01	5.39E-01
Eutrophication	Lbs N eq	3.70E-02	15.47E-03
Carcinogenics	CTUh	6.85E-07	10.19E-08
Non carcinogenics	CTUh	7.71E-06	13.42E-07
Respiratory effects	Lbs PM2.5 eq	11.17E-02	2.93E-02
Ecotoxicity	CTUe	16.12E+01	2.68E+01
Fossil fuel depletion	MJ surplus	23.80E+01	4.91E+01

The reconditioned Multitank scores lower on all environmental issues than the newly manufactured Multitank.

## 5. Conclusions

Reconditioning industrial packaging has environmental benefits compared with newly manufactured ones. The conclusions are discussed per packaging type below.

### **Open head steel drum**

Reconditioning an open head steel drum instead of newly manufacturing it lowers the carbon footprint by a factor three. The impact of energy during the reconditioning process is the main contributor to the carbon footprint. Also all the other impact categories have a lower score for reconditioned drums than newly manufactured drums.

### **Tight head steel drum**

For tight head steel drum we see the same benefit of reconditioning as we see for the open head steel drum. It brings the carbon footprint down to almost a third. Also all the other impact categories have a lower score for reconditioned drums than newly manufactured drums.

### **Tight head plastic drum**

Reconditioning a tight head plastic drum reduces the carbon footprint about 15 % compared with a newly manufactured plastic drum. A reconditioned drum scores about three to four times better than a newly manufactured drum on several impact categories. The exception is ozone depletion because of the higher inbound transport and the higher energy use for processing of a reconditioned drum.

### **IBC**

Reconditioning an IBC has a substantial benefit on the carbon footprint, it is brought back to 30 % of the carbon footprint of a new IBC. Reconditioning has also a clear benefit on all the other analyzed impact categories.

### **Multitank**

Reconditioning a Multitank reduces the carbon footprint by 49% if compared with a newly manufactured Multitank. A reconditioned Multitank scores about three to four times better than a newly manufactured Multitank on almost all impact categories.

### **Reduction**

The environmental burden of the reconditioning process can be further reduced by energy reduction programs as the use of energy is the main contributor to the scores of the different impact categories analyzed. The depletion of fossil fuel of the reconditioned drum is higher than of a newly manufactured tight plastic drum.

### **Green Packaging Calculator**

The inventory data is integrated in an Excel based calculator. The Green Packaging Calculator offers a three-step process by which the environmental impact of industrial packaging solutions, expressed in carbon dioxide (CO<sub>2</sub>) equivalents, may be determined. Calculated impacts enables RIPA members to select containers and understand the impact on the environment of such selections.



# Appendix A Inventory data

Table XX: Comparable companies' XYZ			
Process	Database	Database process	Notes
Carbon steel bars	Ecoinvent 3	<ul style="list-style-type: none"> <li>Steel, low-alloyed {RoW}  steel production, electric, low-alloyed   Alloc Def, S</li> <li>Steel, low-alloyed {RoW}  steel production,converter, low-alloyed   Alloc Def, S</li> <li>Section bar rolling, steel {RoW}  processing   Alloc Def, S</li> </ul>	72 is assumed to be from electric steel and 28 is assumed to be from converter steel.
Carbon steel sheet	Ecoinvent 3	<ul style="list-style-type: none"> <li>Steel, low-alloyed {RoW}  steel production, electric, low-alloyed   Alloc Def, S</li> <li>Steel, low-alloyed {RoW}  steel production,converter, low-alloyed   Alloc Def, S</li> <li>Hot rolling, steel {RoW}  processing   Alloc Def, S</li> </ul>	72 is assumed to be from electric steel and 28 is assumed to be from converter steel.
EPDM gaskets	Ecoinvent 3	<ul style="list-style-type: none"> <li>Synthetic rubber {RoW}  production   Alloc Def, S</li> <li>Injection moulding {RoW}  processing   Alloc Def, S</li> </ul>	
Virgin HDPE - injection moulded	USLCI Ecoinvent 3	<ul style="list-style-type: none"> <li>High density polyethylene resin, at plant/RNA</li> <li>Injection moulding {RoW}  processing   Alloc Def, S</li> </ul>	Dummy processes of USLCI replaced with Ecoinvent 3 processes
Virgin HDPE pellets	USLCI	<ul style="list-style-type: none"> <li>High density polyethylene resin, at plant/RNA</li> </ul>	Dummy processes of USLCI replaced with Ecoinvent 3 processes
Paint solvent	Ecoinvent 3	<ul style="list-style-type: none"> <li>Chemical, organic {GLO}  production   Alloc Def, S</li> </ul>	
Acetone	Ecoinvent 3	<ul style="list-style-type: none"> <li>Acetone, liquid {RER}  production   Alloc Def, S</li> </ul>	
MEK	Ecoinvent 3	<ul style="list-style-type: none"> <li>Methyl ethyl ketone {GLO}  market for   Alloc Def, S</li> </ul>	
Aromatic solvents	Ecoinvent 3	<ul style="list-style-type: none"> <li>Toluene, liquid {RER}  production   Alloc Def, S</li> </ul>	
HCl	Ecoinvent 3	<ul style="list-style-type: none"> <li>Hydrochloric acid, without water, in 30 solution state {RER}  market for   Alloc Def, S</li> </ul>	
Sodium hydroxide pellets	USLCI	<ul style="list-style-type: none"> <li>Sodium hydroxide, production mix, at plant/kg/RNA</li> </ul>	
Sodium nitrite	Ecoinvent 3	<ul style="list-style-type: none"> <li>Chemical, inorganic {GLO}  production   Alloc Def, S</li> </ul>	
Steel shot	Ecoinvent 3	<ul style="list-style-type: none"> <li>Steel, low-alloyed, hot rolled {RER}  production   Alloc Def, S</li> <li>Metal working, average for metal product manufacturing {RER}  processing   Alloc Def, S</li> </ul>	
Exterior coating	Ecoinvent 3	<ul style="list-style-type: none"> <li>Alkyd paint, white, without water, in 60 solution state {RER}  alkyd paint production, white, water-based, product in 60 solution state</li> </ul>	

		Alloc Def, S	
Interior Lining	USLCI	<ul style="list-style-type: none"> <li>High density polyethylene resin, at plant/RNA</li> </ul>	Dummy processes of USLCI replaced with Ecoinvent 3 processes
Natural gas	USLCI	<ul style="list-style-type: none"> <li>Natural gas, combusted in industrial boiler/US</li> </ul>	
Diesel	USLCI	<ul style="list-style-type: none"> <li>Diesel, combusted in industrial equipment/US</li> </ul>	
Propane gas	USLCI	<ul style="list-style-type: none"> <li>Liquefied petroleum gas, combusted in industrial boiler/US</li> </ul>	
Tap water	USLCI	<ul style="list-style-type: none"> <li>Tap water, at user/RER S</li> </ul>	
Electricity	USLCI	<ul style="list-style-type: none"> <li>Electricity, at grid, US/US</li> </ul>	Dummy processes of USLCI replaced with Ecoinvent 3 processes
Truck transport per mile	Ecoinvent 2.2	<ul style="list-style-type: none"> <li>Operation, lorry &gt;16t, fleet average/RER S</li> </ul>	
Truck transport per lbs*mile	Ecoinvent 2.2	<ul style="list-style-type: none"> <li>Transport, lorry &gt;16t, fleet average/RER S</li> </ul>	
Injection moulding	Ecoinvent 3	<ul style="list-style-type: none"> <li>Injection moulding {RoW}  processing   Alloc Def, S</li> </ul>	
Welding	Ecoinvent 3	<ul style="list-style-type: none"> <li>Welding, arc, steel {RoW}  processing   Alloc Def, U without energy</li> </ul>	
Waste water	Ecoinvent 3	<ul style="list-style-type: none"> <li>Wastewater, average {RoW}  treatment of, capacity 5E9l/year   Alloc Def, S</li> </ul>	
Other waste	Ecoinvent 3	<ul style="list-style-type: none"> <li>Municipal solid waste (waste treatment) {GLO}  market for municipal solid waste   Alloc Def, S</li> </ul>	
Paint waste	Ecoinvent 3	<ul style="list-style-type: none"> <li>Waste paint {RoW}  treatment of waste paint, municipal incineration   Alloc Def, S</li> </ul>	
Furnace ash	Ecoinvent 3	<ul style="list-style-type: none"> <li>Ash from deinking sludge {RoW}  treatment of, residual material landfill   Alloc Def, S</li> </ul>	
Sludge	Ecoinvent 3	<ul style="list-style-type: none"> <li>Inert waste {RoW}  treatment of, sanitary landfill   Alloc Def, S</li> </ul>	
Solid waste	Ecoinvent 3	<ul style="list-style-type: none"> <li>Municipal solid waste {RoW}  market for   Alloc Def, S</li> </ul>	
Trash	Ecoinvent 3	<ul style="list-style-type: none"> <li>Municipal solid waste {RoW}  market for   Alloc Def, S</li> </ul>	
Remaining waste	SimaPro 8	<ul style="list-style-type: none"> <li>Curb side collection (waste scenario) {US}  treatment of waste   Alloc Def, S</li> </ul>	

## Appendix B Data overview reconditioning

		Average IBC	Average OH steel	Average TH steel	Average poly	Multitank
Electricity	kWh	14.04	2.91	3.61	8.56	16.43
Natural gas	cuft	43.69	89.70	68.93	80.71	154.96
Diesel	gallon			0.0096		
Water	gal	32.97	1.08	6.86	13.91	26.70
NaOH Pellets	lbs	0.27		0.20	0.23	0.44
HCl 100	lb			0.30		
Sodium nitrite	Lbs			0.0065		
Steel shot	ton		0.000046	0.00018		
Weight exterior coating	lb		0.47	0.36	0.00022	0.00042
Weight lining	lb		0.32			
Paint usage solvent	gallon		0.0029	0.00129		
Weight acetone	lbs	0.49	0.0090		0.28	0.5376
Weight aromatic solvents	lbs				0.0053	0.010
Waste water	gal	61.73	0.25	0.95	12.38	23.76
Sludge	ton	0.017		0.000038	0.02	0.038
Furnace ash	ton		0.000053			
Solid waste generated	ton	0.00407	0.00100	0.000498	0.00138	0.00264
Trash generated	ton	0.00117	0.00074	0.0002973	0.00123	0.00236
Shot dust	ton		0.000082	0.0001209		
Paint Waste	Lbs		0.00371	0.0486		
Scrap steel	Lbs	23.01	4.67	0.534		
Scrap plastic	Lbs	39.98		0.22	17.95	34.46
Other	Lbs			0.19		

## Appendix C Data overview newly manufactured packaging

		IBC 275	OH steel 1.2/0.9/1.2	TH steel 1.2/0.9/1.2	Plastic tight head	Multitank
Electricity	kWh	28.1	2.35	2.33	8.69	30.06
Natural gas	Cuft	0.325	43.6	43.1	1.1	3.08
Propane gas	Lbs.	0.081	0.0123	0.00617	0.00248	0.0085
Tap water	Gal	0.667	5.12	5.12		
Aceton – MEK	gal		0.0197	0.00987		
HCl solution 50	Gal		0.000011	0.000011		
Caustic solution 50	Gal		0.000027	0.000027		
Injection moulded PE	Oz				6	20.76
EPDM gasket	Oz				1	3.46
Welding	inch	37	36	36		
Exterior coating	Lbs.		0.3025	0.3025		
Virgin PE	Lbs.	41.8				
PCR	Lbs.	5.33				
PE-mix	Lbs				21	72.66
Carbon steel sheet	Lbs.		43,6	40.2		
Carbon steel bars	Lbs.	80.4				

## Appendix D Data changes

In this study, the following changes have been made in comparison with the 2013 study titled 'Life Cycle Assessment of Newly Manufactured and Reconditioned Industrial Packaging' © January 2014 by Eelco Rietveld and Sander Hegger:

1. All information on the use of 100 % recycled plastic is removed. The references to the comparison between the single trip reconditioned drum versus the single trip recycled plastic drum is removed.
2. It appeared that the companies use a mix of recycled and virgin plastic to create a new drum. The average mix is calculated, which leads to a material PE-mix, consisting of 53% virgin and 47 % recycled material.
3. Where LDPE was chosen in the first study, now HDPE is used.
4. For all products inbound transport is set at 200 mile
5. For *New TH steel drums* the 'units sold' of facility 2 and 3 is included in the data calculations. This causes a lower average use of energy, natural gas and water and results in a lower environmental impact.
6. The redundancy in the data for *new OH and TH steel drums* is removed. In detail this means that for TH steel drums the data of 'Manufacturing of 55-Gallon Tight Head Steel Drums-COI' is removed and for OH steel drums the data of 'Manufacturing of 55-Gallon Open Head Steel Drums GSD' is removed. This results in a slightly higher energy use, which leads to a slightly higher environmental impact compared to the former study.
7. Some background processes for the waste treatment were not updated in SimaPro. We had to choose new processes. The effect on the environmental impact is small.

## Appendix E Traci 2.1

The Tool for the Reduction and Assessment of Chemical and other environmental Impacts (TRACI), a stand-alone computer program developed by the U.S. Environmental Protection Agency specifically for the US using input parameters consistent with US locations. Site specificity is available for many of the impact categories, but in all cases a US average value exists when the location is undetermined. TRACI facilitates the Characterization of environmental stressors that have potential effects, including ozone depletion, global warming, acidification, eutrophication, tropospheric ozone (smog) formation, ecotoxicity, human health criteria– related effects, human health cancer effects, human health non-cancer effects, fossil fuel depletion, and land-use effects. TRACI was originally designed for use with life-cycle assessment (LCA), but it is expected to find wider application in the future.

TRACI is a midpoint oriented life cycle impact assessment methodology, consistently with EPA's decision not to aggregate between environmental impact categories. It includes classification, characterization and normalization.

### Characterization

Impact categories were characterized at the midpoint level for reasons including a higher level of societal consensus concerning the certainties of modelling at this point in the cause-effect chain. Research in the impact categories was conducted to construct methodologies for representing potential effects in the United States.

TRACI is a midpoint oriented LCIA method including the following impact categories:

- Ozone depletion
- Global warming
- Smog
- Acidification
- Eutrophication
- Carcinogenics
- Non carcinogenics
- Respiratory effects
- Ecotoxicity
- Fossil fuel depletion

### Normalization

Morten Rybert from the Technical University of Denmark calculated normalization factors for the US and US + Canada. Data from 2008 and 2005 combined with 2008 was used for these reference geographies, respectively. A manuscript is now being prepared for publication at the International Journal of LCA.

### References

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