DIN EN 18066:2025-08 (E)

Plastics - Design for recycling of PVC based profiles for construction products

Contents

Page

European foreword 3

Introduction 4

1 Scope 5

2 Normative references 6

3 Terms and definitions 6
3.1 Material definitions 6
3.2 General definitions 7

4 Design for recycling 8
4.1 General 8
4.2 Assessment scheme for the design process considering the recyclability of the profile 9
4.2.1 Process of assessment 9
4.2.2 Choice of material concerning the recyclability 11
4.2.3 Separability into recyclable components 11

5 Requirements for use of rPVC-U 12
5.1 General 12
5.2 Materials used for manufacturing of profiles 14
5.3 Extrusion: Process conditions and tool design 14
5.4 Interaction of components and rPVC-U containing profiles 14

6 Determination of recycled content 14
6.1 Determination for a company or production site by means of mass balance 14
6.2 Determination for a profile 14

7 Summary: Design process regarding recyclability and use of recyclate 15

8 Reporting 16

Annex A (informative) Circular-ready attributed groups, rationale, and objectives - applicability to M/584 17

Annex B (informative) State-of-the-art recycling technologies 21

Annex C (normative) Assessment of design for recycling 22

C.1 Non-exhaustive list of properties and supporting questions for the assessment of design for recycling 22
C.1.1 Ability to disassemble 22
C.1.2 Separability/Sorting of materials for recycling 22
C.1.3 Recyclability of the profile 23
C.1.4 Optimization of use of rPVC-U 23

Annex D (informative) Typical rPVC-U allocation 25

Bibliography 28