

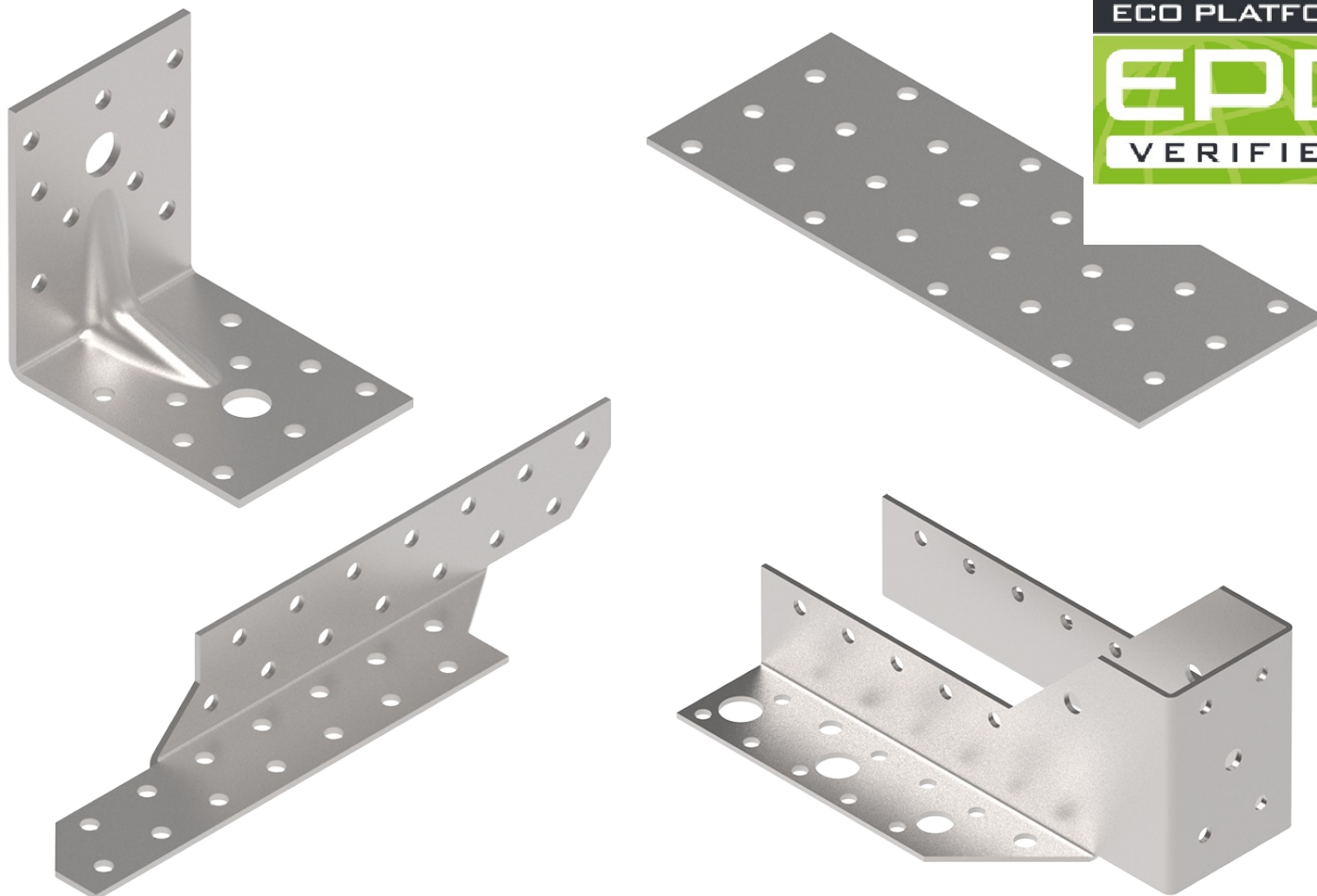
ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	EJOT SE & Co. KG
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-EJO-20250645-IBC1-EN
Issue date	30/01/2026
Valid to	29/01/2031

Metal connectors EJOT SE & Co. KG

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1. General Information

EJOT SE & Co. KG

Programme holder

IBU – Institut Bauen und Umwelt e.V.
Hegelplatz 1
10117 Berlin
Germany

Declaration number

EPD-EJO-20250645-IBC1-EN

This declaration is based on the product category rules:

Structural steels, 01/08/2021
(PCR checked and approved by the SVR)

Issue date

30/01/2026

Valid to

29/01/2031



Dipl.-Ing. Hans Peters
(Chairman of Institut Bauen und Umwelt e.V.)



Florian Pronold
(Managing Director Institut Bauen und Umwelt e.V.)

Metal connectors

Owner of the declaration

EJOT SE & Co. KG
In der Stockwiese 35
57334 Bad Laasphe
Germany

Declared product / declared unit

1 kg metal connectors

Scope:

This EPD refers to 1 kg of metal connectors (for wood to wood/concrete/steel connections) manufactured at EJOT Baubefestigungen GmbH, Manufacturing Plant 52. It represents metal connectors made of carbon steel representative for that product group. The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

The EPD was created according to the specifications of EN 15804+A2. In the following, the standard will be simplified as *EN 15804*.

Verification

The standard EN 15804 serves as the core PCR		
Independent verification of the declaration and data according to ISO 14025:2011		
☐	internally	☒ externally



Mr Stephen Forson ,
(Independent verifier)

2. Product

2.1 Product description/Product definition

EJOT joist hangers, purlin anchors, angle brackets and nail plates are one-piece non-welded three-dimensional connectors, to be used in timber to timber connections as well as connections between a timber joist and a concrete structure or a steel member.

The connectors are made from pre-galvanized steel or from cold-rolled austenitic stainless steel plate. They are fastened to the timber members by anchor nails or screws.

For the placing of the product on the market in the European Union/European Free Trade Association/EU/EFTA) (with the exception of Switzerland) the *Regulation (EU) No. 305/2011 (CPR)* applies. The product needs a declaration of performance taking into consideration the respective ETA and the CE-marking. For the application and use the respective national provisions apply.

2.2 Application

EJOT connectors are intended for use in load bearing timber constructions, where the products are fixed to strength graded timber according to *EN 14081-1*, glulam according to *EN 14080*, softwood- or laminated logs, laminated veneer lumber (LVL) according to *EN 14374*, plywood according to *EN 13986*, cross laminated timber (CLT) with edge glued lamellas, or corresponding timber material.

2.3 Technical Data

Structural data for EJOT connectors can be found in the corresponding approvals and technical drawings, shown below as an example using an extract from valid ETAs based on *EAD 130186-00-0603*.

Constructional data

Name	Value	Unit
Usage category as per ETA	ETA-23/0169 and more	-
Minimum tensile strength Carbon steel	330	N/mm ²

Performance data of the product in accordance with the declaration of performance with respect to its essential characteristics according to:

- *ETA-23/0169*
- *ETA 22/0868*
- *ETA-23/0170*
- *ETA 22/0867*
- *EN 14545*

2.4 Delivery status

Depending on the type of project and customer requirements, the connectors are supplied as individual components or in packaging units of a range from 15 to 100 pieces.

The information on the product properties and quantity information are clearly visible on the outside of the packaging.

2.5 Base materials/Ancillary materials

EJOT connectors are usually made of the following materials: steel or stainless steel. Depending on the requirements and material, these are provided with a galvanic zinc coating. The declared unit is composed of 100 % cold rolled steel DX 51 D

hot dip galvanized Z275.

'This product/article/at least one partial article contains substances listed in the candidate list (date: 21.01.2025) exceeding 0.1 percentage by mass: no'

'This product/article/at least one partial article contains other carcinogenic, mutagenic, reprotoxic (CMR) substances in categories 1A or 1B which are not on the candidate list, exceeding 0.1 percentage by mass: no'

'Biocide products were added to this construction product or it has been treated with biocide products (this then concerns a treated product as defined by the (EU) *Ordinance on Biocide Products No. 528/2012*): no'

2.6 Manufacture

For the production of connectors, the following manufacturing process is mainly used nowadays:

The raw material is delivered as sheet metal coils that is uncoiled and straightened in the upstream equipment. The sheet metal is cut into smaller pieces, the holes and the perimeter are punched, and, if applicable, the connector gets its final form by one or more bending operations.

2.7 Environment and health during manufacturing

The steels and production materials used for the manufacture of connectors are non-toxic and have no impact on humans and the environment or aquatic and terrestrial organisms. The vapours produced during the manufacturing process of the connectors are removed from the production sites by appropriate filter systems and ventilation systems and cleaned by filter systems. Strict safety regulations apply in the EJOT production sites, e.g. wearing suitable work clothing as well as hearing protection. These preventive measures serve to minimise risks and prevent occupational accidents. The EJOT Holding GmbH & Co. KG with its corporate units, including EJOT Baubefestigungen GmbH, has introduced an environmental management system and applies it to the development, production, testing and distribution of connectors.

2.8 Product processing/Installation

EJOT connectors are intended for use in making connections in load-bearing timber structures, as a connection between a beam and a purlin, where requirements for mechanical resistance and stability and safety in use shall be fulfilled. The connectors shall be fixed by anchor nails or screws according to *EN 14592*. A standard screwdriver with a suitable bit, or a hammer, is required for the installation.

For all connections it applies that only if the installation instructions given in the approval notice (if required) for the connectors are complied with, the characteristic values listed there may be expected.

2.9 Packaging

Cardboard/paper (0.021 kg/kg screws) (*EWK 15 01 01*) and multi-use pallets (0.076 kg/kg screws) are used for packaging. Waste products: Packaging materials can be recycled.

2.10 Condition of use

No material change is expected for the connectors during use.

2.11 Environment and health during use

No negative effects on the environment or human health are known from connectors in the installed state.

2.12 Reference service life

Due to the wide range of applications, no reference service life is given. The expected service life of connectors generally depends on their use. The prevailing external influences, particularly humidity and the level of corrosivity in the environment, can greatly affect the service life. According to the European Technical Assessment, the average service life is > 50 years. However, much longer service lives are also known. It should be noted that the connectors are used in accordance with the technical regulations.

2.13 Extraordinary effects

Fire

EJOT connectors meet the requirements of the fire resistance class A1 and may be classified in resistance class A1 and class A1fl without testing in accordance with *European Commission Decision 96/603/EC*. In the area of fire protection, the following building material class according to *EN 13501-1* is complied with:

Fire protection

Name	Value
Building material class	A1fl

Water

Water usually has no effect on the connectors, as these are made of a corrosion-resistant stainless steel or have a surface coating (galvanisation).

Mechanical destruction

The mechanical destruction of the connectors has no impact on the environment.

2.14 Re-use phase

EJOT connectors can generally be dismantled again from all applications and thus be fed into the recycling process. Direct reuse would also be possible if the connectors have not been damaged during use or removal.

2.15 Disposal

EJOT connectors can be disposed of separately (by appropriate dismantling) or directly with the installed elements during demolition. These are fed into the recycling process in accordance with the applicable disposal guidelines. The waste code for connectors made of corrosion-resistant stainless steel is 170407 and for connectors made of steel 170405 (EWC).

2.16 Further information

Further information can be found at www.ejot.com or in the approvals, standards and specialist rules and installation guidelines already mentioned.

3. LCA: Calculation rules

3.1 Declared Unit

The declared unit is 1 representative kg of metal connectors. Metal connectors from cold-rolled steel were selected as the representative product based on production volume.

Declared unit

Name	Value	Unit
Declared unit	1	kg
Gross density	7850	kg/m ³
Thickness	2-3	mm

3.2 System boundary

Type of the EPD: cradle to gate - with options

Module A1–A3

The product stage includes the provision of materials (steel and packaging materials) as well as the associated transportation to the manufacturing site. Furthermore, electric and thermal energy required for the manufacturing process as well as the treatment of production waste until the end-of-waste status is reached, are accounted for.

Module A5

Module A5 includes the treatment of packaging materials until end-of-waste status is reached. It is assumed that the associated impacts from installation are negligible, which means that no environmental impacts from the installation of the products are declared.

Modules C1–C4

Module C1 describes the expenses after the product's end of life for dismantling or demolition of the product from the building. It is assumed that the associated impacts are negligible, which means that no environmental impacts from the dismantling are declared. Transport to waste treatment is considered in module C2. Module C3 contains the necessary processes for waste treatment at the end of the product life cycle. Emissions for

waste sorting are assigned to module C3. End-of-waste for steel scrap is assumed after transportation to and sorting at a recycling plant. Resulting substitution potentials for a next product system are accounted for in module D. Module C4 describes the expenses for the disposal of the product or its components if material or energy recovery or reuse is not possible. Since material recycling is assumed, no processes are modelled in module C4.

Module D

The output flows or secondary materials resulting from the waste treatment in A5 and C3, which can potentially serve as material input (recycling) for another product system, are declared in Module D.

3.3 Estimates and assumptions

For transport to waste processing (modules A3, A5 and C2), 100 km truck with 50 % utilisation was modelled. Wooden pallets were excluded from the model as their environmental impact was deemed negligible due to repeated reuse.

3.4 Cut-off criteria

All specific data collected was taken into account. Therefore, material flows with a mass fraction of less than one percent were also modelled.

It can be assumed that the cut-off criteria for considering the use of primary energy and mass according to *EN 15804+A2* (<1 % in each case, <5 % in total per declared module) were observed.

Capital goods are not considered.

3.5 Background data

For the background data, *Managed LCA Content* (Content Version 2024.2) was used.

3.6 Data quality

The primary data was provided by EJOT SE & Co. KG and checked for plausibility. The quality and representativeness of the foreground data collected can therefore be regarded as high.

The data quality of the background data used was rated as good in terms of technical, geographical and temporal representativeness. The majority of the background data used has the reference year 2023.

The potential environmental impacts result largely from the purchased materials and, therefore the background data. All metal connectors go through a similar production process. Therefore, little variability from the production process is to be expected.

3.7 Period under review

Data was collected for the year 2023.

3.8 Geographic Representativeness

Land or region, in which the declared product system is manufactured, used or handled at the end of the product's lifespan: Europe

3.9 Allocation

Allocation of energy, auxiliary and operating materials used for individual products in a factory

Material and inputs could be clearly assigned to the products under consideration. Energy inputs were assigned to the products based on mass.

Allocation of co-production processes

Steel scrap from production (modules A1-A3) is treated as a co-product and the economic value is set to 0. Therefore, all impacts from production are assigned to the declared unit.

Allocation in the use of recycled and/or secondary raw materials

For the input of secondary material, the cut-off method is applied. Therefore, secondary materials enter the system under consideration without any environmental loads. This applies to steel and waste paper for cardboard production in modules A1-A3.

Allocation method for re-use, recycling and recovery

Waste processing of materials flows is modelled until the end-of-waste status is reached. The loads of waste processing are accounted for in the module where the waste occurs (A1-A3, A5 and C3).

Substitution potentials are declared in modules D. For materials only the net flows are considered to ensure consistency with the cut-off method.

3.10 Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account. For the background data, *Managed LCA Content* (Content Version 2024.2) was used.

4. LCA: Scenarios and additional technical information

Characteristic product properties of biogenic carbon

Information on describing the biogenic carbon content at factory gate

Name	Value	Unit
Biogenic carbon content in product	-	kg C
Biogenic carbon content in accompanying packaging	0.043	kg C

Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO₂.

Installation into the building (A5)

Name	Value	Unit
Output substances following waste treatment on site	0.097	kg

End of life (C1-C4)

Name	Value	Unit
Collected separately waste type steel	1	kg
Recycling	1	kg

Reuse, recovery and/or recycling potentials (D), relevant scenario information

Name	Value	Unit
Net scrap	0.81	kg

5. LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE OR INDICATOR NOT DECLARED; MNR = MODULE NOT RELEVANT)

Product stage			Construction process stage		Use stage							End of life stage				Benefits and loads beyond the system boundaries
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	X	MND	MND	MNR	MNR	MNR	MND	MND	X	X	X	X	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 kg metal connector

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
GWP-total	kg CO ₂ eq	3.03E+00	1.58E-01	0	1.07E-02	1.46E-02	0	-1.41E+00
GWP-fossil	kg CO ₂ eq	3.18E+00	1.49E-03	0	1.05E-02	1.44E-02	0	-1.41E+00
GWP-biogenic	kg CO ₂ eq	-1.53E-01	1.56E-01	0	3.24E-05	1.09E-04	0	2.99E-04
GWP-luluc	kg CO ₂ eq	8E-03	2.14E-05	0	1.71E-04	9.02E-05	0	-1.87E-04
ODP	kg CFC11 eq	3.26E-12	4.45E-15	0	1.5E-15	2.04E-13	0	1.89E-12
AP	mol H ⁺ eq	9.59E-03	5.91E-06	0	4.34E-05	4.58E-05	0	-3.44E-03
EP-freshwater	kg P eq	4.24E-06	6.21E-09	0	4.35E-08	5.98E-08	0	-3.28E-07
EP-marine	kg N eq	3.07E-03	2.72E-06	0	2.06E-05	1.81E-05	0	-5.53E-04
EP-terrestrial	mol N eq	3.35E-02	3.03E-05	0	2.3E-04	1.99E-04	0	-4.95E-03
POCP	kg NMVOC eq	8.04E-03	5.55E-06	0	4.12E-05	4.1E-05	0	-2.25E-03
ADPE	kg Sb eq	6.87E-05	1.46E-10	0	8.88E-10	2.14E-09	0	-7.97E-06
ADPF	MJ	3.17E+01	2.07E-02	0	1.34E-01	2.58E-01	0	-1.4E+01
WDP	m ³ world eq deprived	9.59E-02	7.17E-05	0	1.58E-04	2.56E-03	0	-9.49E-02

GWP = Global warming potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential of land and water; EP = Eutrophication potential; POCP = Formation potential of tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources; WDP = Water (user) deprivation potential

RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: 1 kg metal connector

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
PERE	MJ	2.07E+00	1.18E+00	0	1.16E-02	1.42E-01	0	5.52E-01
PERM	MJ	1.18E+00	-1.18E+00	0	0	0	0	0
PERT	MJ	3.25E+00	4.3E-03	0	1.16E-02	1.42E-01	0	5.52E-01
PENRE	MJ	3.17E+01	2.07E-02	0	1.34E-01	2.58E-01	0	-1.4E+01
PENRM	MJ	0	0	0	0	0	0	0
PENRT	MJ	3.17E+01	2.07E-02	0	1.34E-01	2.58E-01	0	-1.4E+01
SM	kg	2.09E-01	0	0	0	0	0	8.1E-01
RSF	MJ	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0
FW	m ³	3.82E-03	3.79E-06	0	1.29E-05	1.11E-04	0	-1.42E-01

PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water

RESULTS OF THE LCA - WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 kg metal connector

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
HWD	kg	8.74E-07	6.35E-12	0	5.14E-12	2.74E-10	0	-1.05E-07
NHWD	kg	1.27E-01	5.99E-06	0	2.19E-05	1.66E-04	0	1.69E-01
RWD	kg	2.9E-04	6.62E-07	0	2.45E-07	3.02E-05	0	1.53E-06
CRU	kg	0	7.6E-02	0	0	0	0	0
MFR	kg	0	2.1E-02	0	0	1E+00	0	0
MER	kg	0	0	0	0	0	0	0
EEE	MJ	0	0	0	0	0	0	0
EET	MJ	0	0	0	0	0	0	0

HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported electrical energy; EET = Exported thermal energy

RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional:

1 kg metal connector

Parameter	Unit	A1-A3	A5	C1	C2	C3	C4	D
PM	Disease incidence	ND	ND	ND	ND	ND	ND	ND
IR	kBq U235 eq	ND	ND	ND	ND	ND	ND	ND
ETP-fw	CTUe	ND	ND	ND	ND	ND	ND	ND
HTP-c	CTUh	ND	ND	ND	ND	ND	ND	ND
HTP-nc	CTUh	ND	ND	ND	ND	ND	ND	ND
SQP	SQP	ND	ND	ND	ND	ND	ND	ND

PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index

Disclaimer – for the indicators 'abiotic depletion potential for non-fossil resources', 'abiotic depletion potential for fossil resources', 'water (user) deprivation potential, deprivation-weighted water consumption'. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high as there is limited experience with the indicator.

Note: The results for the optional additional impact categories according to EN 15804+A2 are not declared since uncertainties on these results are high.

6. LCA: Interpretation

Dominance analysis



The figure above shows the dominance analysis across the declared modules. It can be seen that the production phase (modules A1-A3) are dominant for most of the declared indicators.

Module A5 has a significant impact on the indicator GWP-biogenic since the biogenic carbon that is stored in the cardboard packaging is leaving the system in this module.

Within module A1-A3, the production of steel as raw material

dominates the results of all of the environmental impact indicators. Transportation is relevant for the indicator GWP-luluc.

Considering the high influence of steel raw material production, variations for metal connectors made from stainless steel are to be expected. In general, stainless steel is associated with higher potential environmental impacts than carbon steel; however, the relative difference is strongly dependent on the recycled-content assumptions and the underlying steel production datasets used for modelling.

7. Requisite evidence

Not relevant

8. References

Standards

EN 13986

EN 13986:2004+A1:2015, Wood-based panels for use in construction — Characteristics, evaluation of conformity and marking.

EN 14080

EN 14080:2013, Timber structures — Glued laminated timber and glued solid timber — Requirements

EN 14081-1

EN 14081-1:2016+A1:2019, Timber structures — Strength graded structural timber with rectangular cross section — Part 1: General requirements.

EN 14374

EN 14374:2004, Timber structures — Structural laminated veneer lumber — Requirements.

EN 14545

EN 14545:2008, Timber structures — Connectors — Requirements.

EN 14592

EN 14592:2022, Timber structures — Dowel-type fasteners — Requirements.

EN 15804

EN 15804:2012+A2:2019+AC:2021, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products.

ISO 14025

EN ISO 14025:2011, Environmental labels and declarations — Type III environmental declarations — Principles and procedures.

ISO 14040

ISO 14040:2006, Environmental management — Life cycle assessment — Principles and framework.

ISO 14044

ISO 14044:2006, Environmental management — Life cycle assessment — Requirements and guidelines.

EAD 130186

EAD 130186-00-0603 for three-dimensional nailing plates

Further references

Managed LCA Content

Managed LCA Content. Content Version 2024.2. Leinfelden-Echterdingen: Sphera Solutions GmbH.

EWC

European Waste Catalogue, Waste Catalogue Ordinance of 10 December 2001 (Federal Law Gazette I page 3379), which was last amended by Article 3 of the Ordinance of 17 July 2017

(Federal Law Gazette I page 2644).

IBU 2022

Institut Bauen und Umwelt e.V.: General Instructions for the EPD programme of Institut Bauen und Umwelt e.V., Version 2.1. Berlin: Institut Bauen und Umwelt e.V., 2021. www.ibu-epd.com

PCR Part A

Product Category Rules for Building-Related Products and Services. Part A: Calculation rules for the life cycle assessment and requirements for the project report, Version 1.4. Berlin: Institut Bauen und Umwelt e.V. (ed.), 15.04.2024.

PCR: Structural steels

PCR guidance texts for building-related products and services. Part B: Requirements on the EPD for Structural Steels. Berlin: Institut Bauen und Umwelt e.V. (ed.), PCR v4, 12.07.2023.

Candidate List

Candidate List of Substances of Very High Concern for Authorisation (ECHA Candidate List), dated 21.01.2025, published in accordance with Article 59(10) of the REACH Regulation. Helsinki: European Chemicals Agency.

ETA 22/0867

ETA 22/0867: Three dimensional nailing plates

ETA 22/0868

ETA 22/0868: Three-dimensional nailing plates

ETA-23/0169

ETA-23/0169: Three-dimensional nailing plate (Joist hanger for wood to wood connections and wood to concrete or steel connections)

ETA-23/0170

ETA-23/0170: Three-dimensional nailing plate (Angle brackets for timber-to-timber, timber-to-steel or timber-to-concrete connections)

European Commission Decision 96/603/EC

European Commission Decision 96/603/EC of 4 October 1996 establishing the list of products belonging to Classes A 'No contribution to fire' provided for in the decision 94/611/EC.

Regulation (EU) No. 305/2011 (CPR)

Regulation (EU) No 305/2011 of the European Parliament and of the Council of 9 March 2011 laying down harmonised conditions for the marketing of construction products and repealing Council Directive 89/106/EEC Text with EEA relevance

Regulation (EU) Ordinance on Biocide Products No. 528/2012

Regulation (EU) No 528/2012 of the European Parliament and of the Council of 22 May 2012 concerning the making available on the market and use of biocidal products Text with EEA relevance



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