

BMW  
GROUP



# VEHICLE FOOTPRINT.

Life cycle assessment of the MINI Cooper E with a validation by TÜV Rheinland and further information on its environmental and social impact. Data at the time of the start of production of the vehicle in November 2023.

# TABLE OF CONTENTS.



Page	Contents
03	1. Product information and technical data
04	2. Life cycle assessment
07	2.1. Materials used in the vehicle
08	2.2. CO <sub>2</sub> equivalents over the life cycle
09	2.3. CO <sub>2</sub> equivalents compared for different powertrains
10	2.4. Measures for reducing CO <sub>2</sub> equivalents
11	2.5. Further environmental impact categories
12	3. Production
13	4. Recycling options at the end of the life cycle
14	5. Evaluation and conclusion

# 1. PRODUCT INFORMATION AND TECHNICAL DATA.

Technical details	MINI Cooper E (Type 11GC, Left-hand drive)
Powertrain type	Electric
Transmission	1-speed automatic
Power in kW (hp)	135 (184)
Drive type	Front-wheel drive
Maximum speed in km/h	160
Energy consumption, combined WLTP in kWh/100 km (mIs/kWh) <sup>1,2</sup>	14.3 – 13.8 (4.3 – 4.5)
Electric range, WLTP in km (mIs) <sup>1,2</sup>	293 – 305 (182 – 190)
Battery capacity (gross/net) in kWh	40.7 / 36.6
Empty weight in kg <sup>3</sup>	1,615
CO <sub>2</sub> classification <sup>4</sup>	A
CO <sub>2</sub> emissions, combined WLTP in g/km	0

<sup>1</sup>The stated fuel consumption and CO<sub>2</sub> figures were determined according to the prescribed measuring procedure of the WLTP (Worldwide harmonised Light vehicles Test Procedure) cycle in accordance with Regulation (EC) No. 715/2007 and Regulation (EU) 2017/1151. The specifications always refer to a vehicle with basic equipment. Any added optional equipment that is supplied by the manufacturer to replace parts of the basic equipment may increase these values and therefore differ depending on the model and motorisation. In addition, retrofitted optional equipment and accessories can change relevant vehicle parameters such as weight, rolling resistance and aerodynamics, resulting in deviating consumption values and CO<sub>2</sub> emissions. Values other than the values stated here may therefore apply for the assessment of taxes and other vehicle-related duties (also) based on CO<sub>2</sub> emissions. The figures therefore do not refer to the specific vehicle, and do not form an integral part of the offer, but are provided solely for comparison purposes between the different types of vehicle. Further information on the WLTP measurement procedure can be found at: <https://www.bmw.com/en/innovation/wltp.html>.

A battery electric vehicle requires mains electricity for charging. Whilst we recommend the battery for this vehicle is charged to 80% to help optimise the health and life of your battery, the electric range figure shown is the WLTP figure after the battery had been fully charged to 100%. WLTP figures are shown for comparability purposes. Only compare fuel consumption, CO<sub>2</sub> and electric range figures with other cars tested to the same technical procedures. These figures may not reflect real life driving results, which will depend upon a number of factors including the starting charge of the battery, accessories fitted (post registration), variations in weather, driving styles and vehicle load.

<sup>2</sup>Range depends on various factors, in particular: personal driving style, route conditions, outside temperature, heating/climate control, pre-temperature setting.

<sup>3</sup>The EC unladen weight refers to a vehicle with standard equipment and does not include optional equipment. This unladen weight factors in a driver weighing 75 kg. Optional equipment can change the weight of the vehicle, the payload and, if it affects the aerodynamics, the maximum speed.

<sup>4</sup>According to the German Energy consumption labeling regulation (Pkw-EnVKV)

With the all-electric MINI Cooper, the MINI brand has reinvented an icon. With its typical MINI design, it underlines the brand's tradition while bringing it firmly into the future.

It is inspiring as a vehicle and as a role model. The high-voltage battery cells, for example, consist of approx. 10% secondary material (approx. 35% of which is secondary nickel and approx. 35% is secondary cobalt). These values have been calculated at the start of production of the new vehicle generation in 2023 based on specific supplier records and also include production residues.

Furthermore, the MINI Cooper E is the first MINI model to feature a completely leather-free interior as standard.



## 2. LIFE CYCLE ASSESSMENT.

---

Think long term and act with the customer in mind. These are the fundamental objectives of the BMW Group and firmly anchored in our corporate strategy. Part of our product responsibility includes: evaluating the environmental, economic and social impact of the BMW Group. With the help of a lifecycle assessment, we can look at the entire life cycle of a vehicle and its components.

### What is a Life Cycle assessment?

A Life Cycle assessment means looking at the three elements of the car:

- production of the vehicle
- the use phase, or driving phase
- the end of life, how the car can be recycled

This transparency means that in the development phase of a vehicle for example, potential measures to reduce the environmental impact can be identified and incorporated into product development decisions at an early stage.

### What Criteria are we using?

The comparable presentation of results and process applications is particular challenging for complex products such as vehicles. We are using the WLTP (Worldwide harmonised Light Vehicles Test Procedure) which gives a representation of fuel consumption, electricity consumption and CO<sub>2</sub> figures for comparison purposes.

For the use phase of the vehicle WLTP consumption values are used over a total nominal distance covered of 200.000 km (approx. 125.000 mls).

Then, using LCA for experts 10 Software Programme and Database from Sphera, specific supplier records are added to quantify the environmental impact of the supply chain and vehicle production. Specific supplier records include the proportion of secondary raw materials and the use of renewable energies as at the start of production of the new vehicle generation. It's an industry standard system, and unless otherwise specified, all emission factors used are taken from the software.

### Who verifies this data?

External experts, TÜV Rheinland, have verified compliance with the ISO 14040/44 standard.

The CML-2001 method is used for the life cycle assessment of the MINI Cooper E, and this method was developed by the Institute of Environmental Sciences at Leiden University in the Netherlands in 2001. This method of impact assessment is used in many life cycle assessments in the automotive industry. It's aim is to quantitatively map as many material and energy flows as possible between the environment and the product system in the life cycle.



# VALIDATION OF THE LIFE CYCLE ASSESSMENT.



## Validation

TÜV Rheinland Energy and Environment GmbH confirms that a critical review of the life cycle assessment (LCA) study of **BMW AG, Petuelring 130, 80788 München** for the following passenger car:

### MINI Cooper E– 2023 model year

was performed.

Proof has been provided that the requirements of the international standards

- ISO 14040:2006 + A1:2020: Environmental management – life cycle assessment – principles and framework
- ISO 14044:2006 + A1:2018 + A2:2020: Environmental management – life cycle assessment – requirements and guidelines
- ISO/TS 14071:2014: Environmental management – life cycle assessment – critical review processes and reviewer competencies: additional requirements and guidelines to ISO 14044

are fulfilled.

#### Results:

- The LCA study was carried out according to the international standards ISO 14040:2006 + A1:2020 and ISO 14044:2006 + A1:2018 + A2:2020. The methods used and the modelling of the product system correspond to the state of the art. They are suitable to fulfill the goals stated in the study. The report is comprehensive and provides a transparent description of the framework of the LCA study.
- The assumptions used in the LCA study especially energy consumption based on the current WLTP (Worldwide harmonized Light vehicles Test Procedure) were verified and discussed.
- The assessed samples of data and environmental information included in the LCA study are plausible.

#### Review process and level of detail:

Verification of input data and environmental information as well as the check of the LCA process was performed in course of a critical data review. The data review considered the following aspects:

- Check of the applied methods and the product model,
- Inspection of technical documents (e.g. type approval documents, parts lists, supplier information, measurement results, etc.) and
- Check of LCA input data (e.g. weights, materials, energy consumption, emissions, etc.).

Cologne, 15<sup>th</sup> February 2024



Norbert Heidelmann  
Department Manager for Carbon and Energy Services

#### Responsibilities:

Sole liability for the content of the LCA rests with BMW AG. TÜV Rheinland Energy and Environment GmbH was commissioned to review said LCA study for compliance with the methodical requirements, and to verify and validate the correctness and credibility of the information included therein.

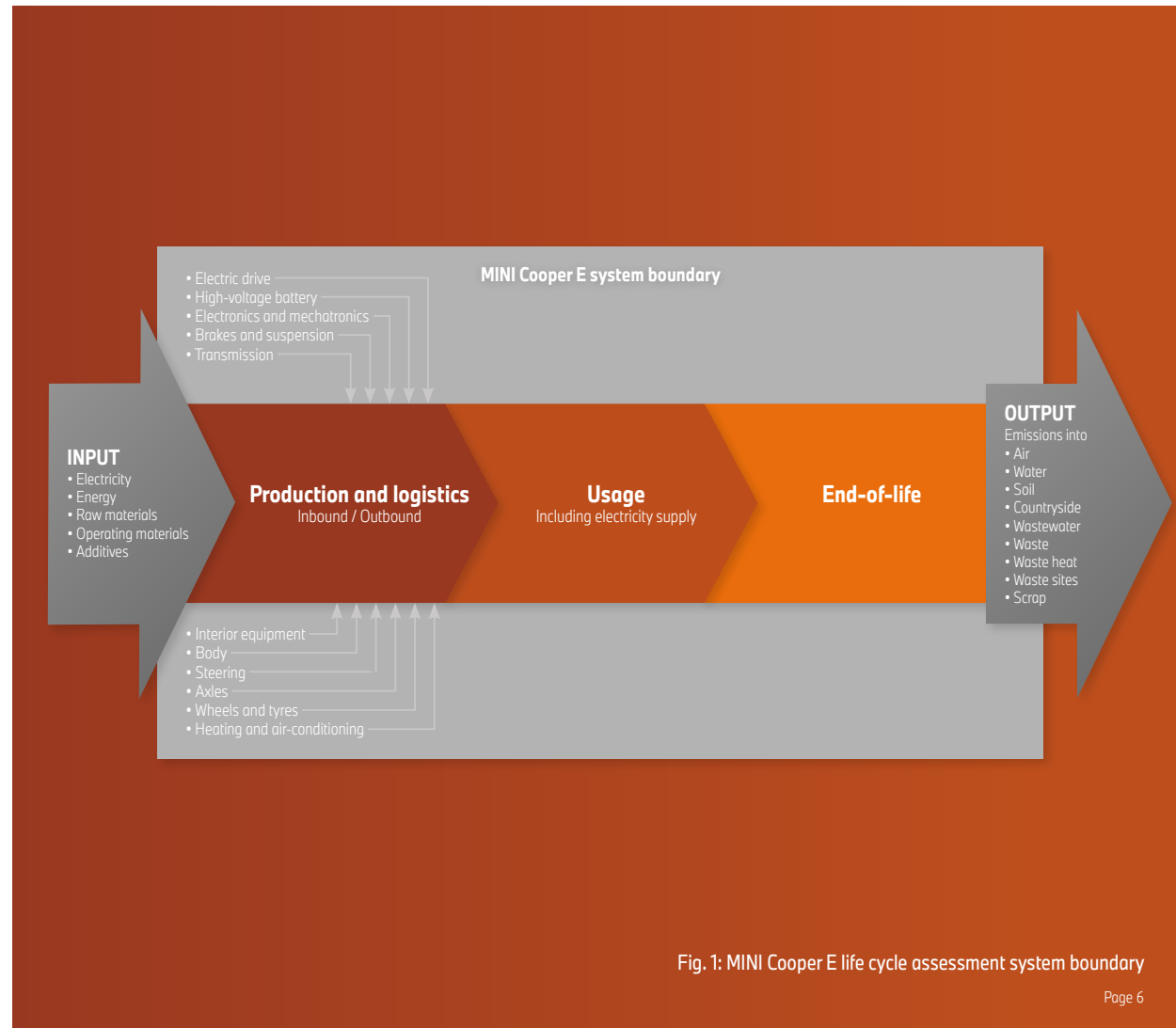
## 2. LIFE CYCLE ASSESSMENT.

The system boundary of the life cycle assessment (LCA) is shown in Figure 1 and ranges from the extraction of raw materials to the production of materials and components, logistics and the usage phase to recycling at the end of the vehicle's service life.

**Recyclable production** residues from manufacturing processes are kept in an internal cycle and are also taken into account. This includes, for example, the scrap from the production of steel and aluminium components. The impact of the manufacture of tools and the construction of production facilities are not included in this LCA.

**For the usage phase**, publicly available data records for EU-28 electricity mixes at the start of production of the new model generation are used for the electricity supply. The scope of the study does not include the maintenance, high-voltage battery replacement or any service of the vehicles.

**The recycling (end-of life)** is mapped as part of the LCA using the standard ISO processes of drying and disassembly in accordance with the End-of-Life vehicles directive, as well as the separation of metal in the shredding process and the energy recovery of non-metallic components (shredder light fraction). No eco-credits are issued for secondary materials produced and energy recovery through thermal recycling. Only the efforts and emissions of the recycling processes are taken into account. The dismantling of the component was set as the system boundary for the recycling of the high-voltage battery and no further credit was issued.



## 2.1. MATERIALS USED IN THE VEHICLE.

Product-related data, such as component and material specifications, piece quantities, manufacturing and logistics efforts, etc., is primary data collected by the BMW Group.

For the LCA, the weight is taken as the "mass in a drive-ready state without a driver or luggage plus artificial leather upholstery". This weight is mapped through a derivation of the vehicle's components and their material composition from a vehicle-specific parts list.

Figure 2 shows the material composition of the MINI Cooper E.

The weight of the MINI Cooper E is composed of 49.0% steel and ferrous metals and 14.0% light alloys, particularly aluminium. The material group of polymers also has a large share with 17.0%. The cells, including the electrolyte of the high-voltage battery, make up 10.0% of the weight. Their cell chemistry represents the latest generation of lithium-ion batteries. Other materials make up 3.2%. Non-ferrous metals are 3.5%. Process polymers account for 2.0%. Operating materials are around 1.3%. They are composed of oils, coolant and brake fluid, as well as refrigerant and washer water. Special metals such as tin have a share of well below 1%.

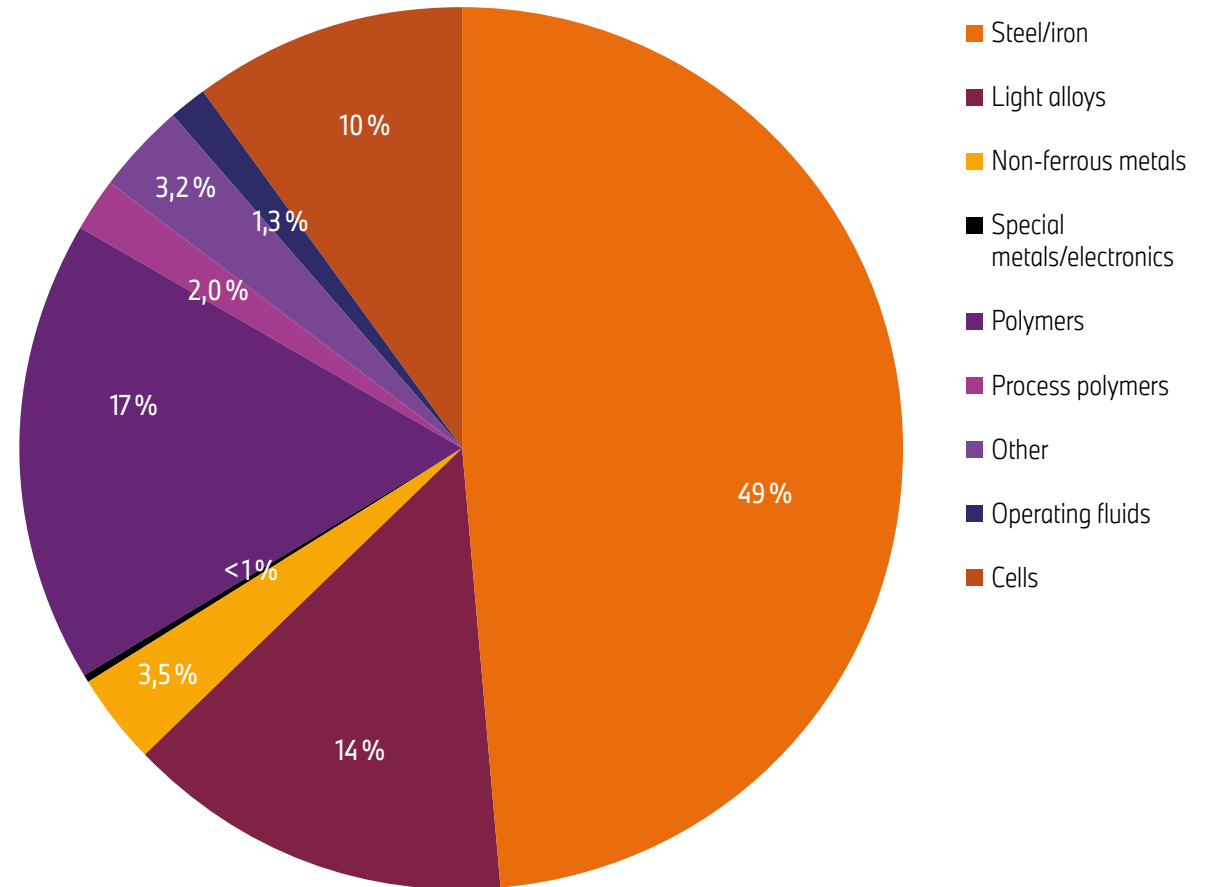


Fig. 2: Material composition of the MINI Cooper E at the start of production.  
The specified values may contain rounding differences.



## 2.2. CO<sub>2</sub> EQUIVALENTS OVER THE LIFE CYCLE.

### CO<sub>2</sub> equivalents [CO<sub>2</sub>e] of the MINI Cooper E over its life cycle

#### EU-28 electricity mix



#### Electricity from renewable energy sources



Fig. 3: The total amount of carbon dioxide (CO<sub>2</sub>) and other greenhouse gas emissions such as methane or nitrogen oxide are taken into account. CO<sub>2</sub> equivalents (CO<sub>2</sub>e) are a unit of measurement used to standardise the climate impact of different greenhouse gases. The crediting of electricity from renewable energy sources includes both electricity from renewable in-house-generation plants and direct supply contracts as well as certified guarantees of origin. Offsetting measures are not taken into account.

This life cycle assessment (LCA) considers the CO<sub>2</sub> equivalents of a product over its entire life cycle. In order to assess the climate impact, greenhouse gas emissions associated with the raw material supply chain, transport logistics and production, the usage and recycling or disposal of the product are included. The Global Warming Potential (GWP) evaluation is currently the main focus in the automotive sector.

Figure 3 shows the CO<sub>2</sub> equivalents of the MINI Cooper E over its life cycle and the impact of using 100% renewable energy in the usage phase.

The MINI Cooper tested for this life cycle assessment is handed over to customers with 13.6t CO<sub>2</sub>e. Inbound and outbound logistics account for 1t of this. Inbound logistics includes all transportation of goods from suppliers to the production sites and intra-plant transport. The outbound transport logistics from the factory to the global markets is determined on the basis of forecasted volume plans.

The usage phase for the MINI Cooper is based on WLTP consumption and a total distance covered of 200,000 km (approx. 125,000 mls).

How the electricity used is generated significantly influences the climate impact of the vehicle. Based on the generated European electricity (EU-28 mix, local or regional electricity mixes might differ), this amounts to 9.3t of CO<sub>2</sub>e. When the customer charges the vehicle with electricity from renewable sources, electricity generation contributes only 0.6t to the total life cycle emissions. Due to the inclusion of CO<sub>2</sub>e emissions for the production of the energy-generating plants, this value is not equal to zero.

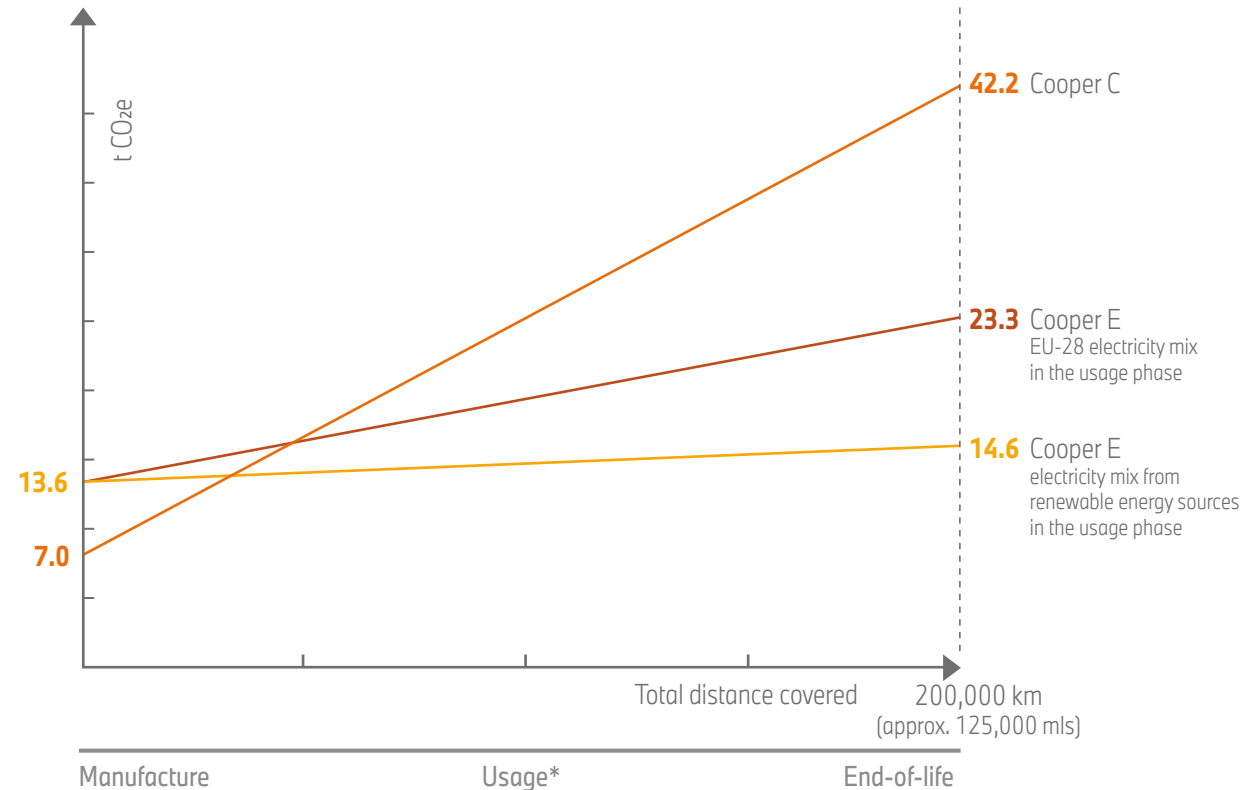


## 2.3. CO<sub>2</sub> EQUIVALENTS COMPARED FOR DIFFERENT POWERTRAINS.

The production of the MINI Cooper E causes 13.6t of CO<sub>2</sub>e. That is more than the MINI Cooper C with a combustion engine causes during production. The main reason is the energy-intensive production processes of the high-voltage battery.

However, besides production, consumption in the usage phase of both vehicles is key to their environmental impact. With a mileage of 200,000 km (approx. 125,000 mls), charged with an EU-28 electricity mix in the usage phase, the total emissions of the MINI Cooper E are 23.3t of CO<sub>2</sub>e: significantly lower than the 42.2t of CO<sub>2</sub>e, emitted by the MINI Cooper C.

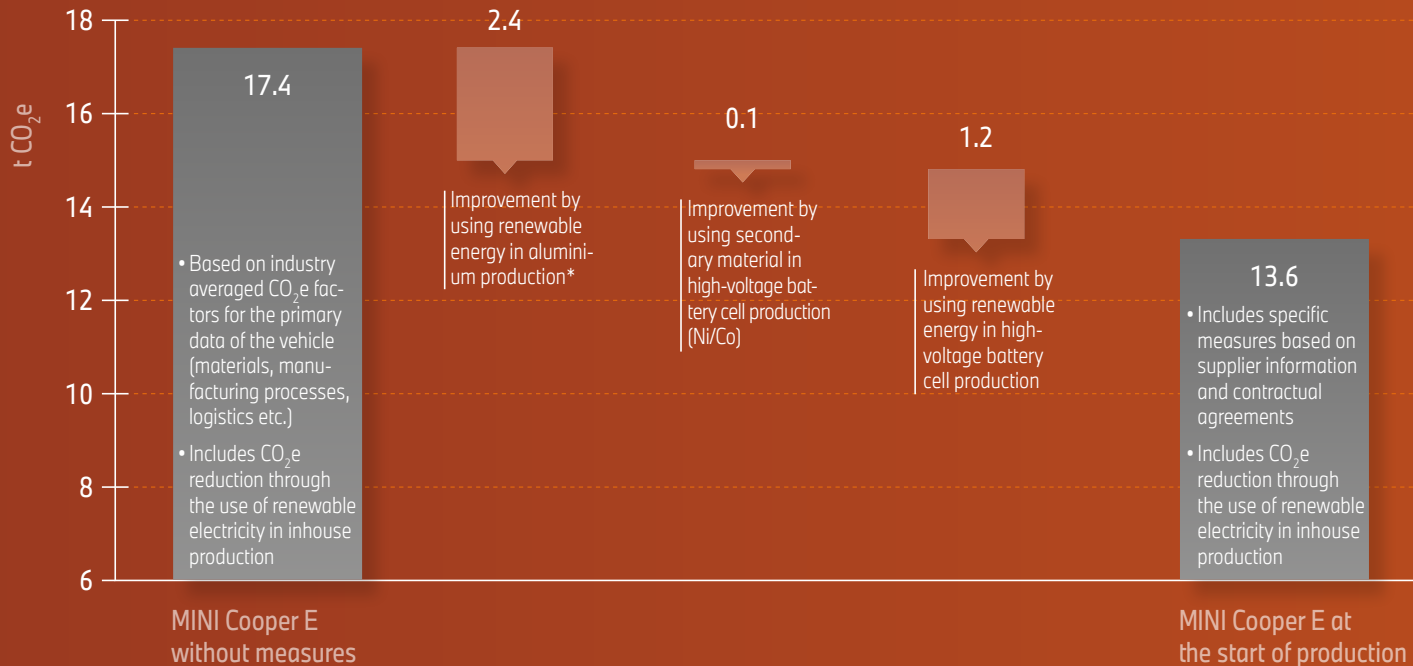
Charging with electricity from renewable energy sources can reduce CO<sub>2</sub>e in the usage phase of an electric vehicle from 9.3t to 0.6t.



\*Consumption data according to type test (mean value of the WLTP range)

Fig. 4: Comparison of the CO<sub>2</sub> equivalents of the MINI Cooper E in relation to the MINI Cooper C

## 2.4. MEASURES FOR REDUCING CO<sub>2</sub> EQUIVALENTS.



In order to achieve internal sustainability targets, various measures were implemented during the production phase of the MINI Cooper E.

Figure 5 shows the measures that contribute to reducing CO<sub>2</sub> equivalents in the manufacturing phase by around 21% compared to the industry averages according to LCA for Experts 10 Software and Database. The use of renewable energy sources in in-house production was not reported separately as a measure and is already included in the 17.4t of CO<sub>2</sub>e.

The inclusion of the measures result in a CO<sub>2</sub>e value of 13.6t when the vehicle is handed over to the customer.

\* Drive bearings, wheels, brake calipers, body, high-voltage battery housing, etc.

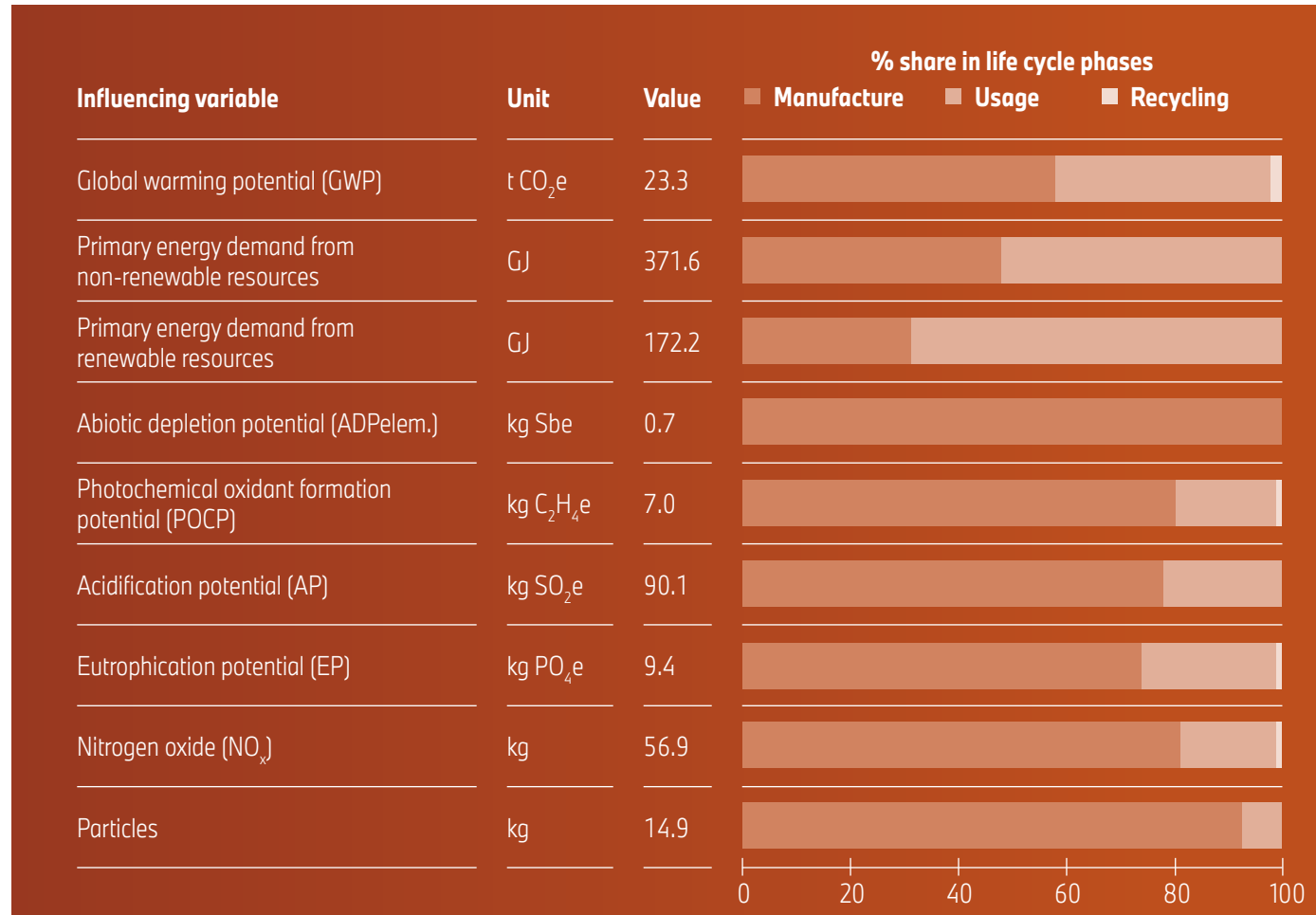
Fig. 5: Influence of development targets on the CO<sub>2</sub> equivalents in the manufacturing phase of the MINI Cooper E

The specified values may contain rounding differences

## 2.5. FURTHER ENVIRONMENTAL IMPACT CATEGORIES.

Table 1 shows the CO<sub>2</sub> equivalents of the MINI Cooper E, which is expressed in CO<sub>2</sub>e as well as other significant environmental impact categories with percentage contributions in the life cycle phases:

- The primary energy demand from renewable and non-renewable resources. In other words, the primary energy (e.g. coal, solar radiation) required to generate usable energy and to produce materials.
- Abiotic – i.e. non-living – resource consumption measures the scarcity of resources. The scarcer an element and the higher the consumption, the higher the contribution to Abiotic depletion potential (ADPelem.).
- The photochemical oxidant formation potential (POCP) measures ground-level ozone formation (e.g. summer smog) by emissions.
- The acidification potential (AP) quantifies and evaluates the acidifying effect of specific emissions.
- The eutrophication potential (EP) describes the undesirable introduction of nutrients into water bodies or soils (eutrophication).
- Nitrogen oxides (NO<sub>x</sub>) contribute, among other things, to the formation of particulate matter and ozone. NO<sub>2</sub>, for example, is an irritant gas.
- Emitted particles combine particles of different sizes.



Tab. 1: Environmental impact categories with percentage contributions in the life cycle phases of the MINI Cooper E

### 3. PRODUCTION.

---

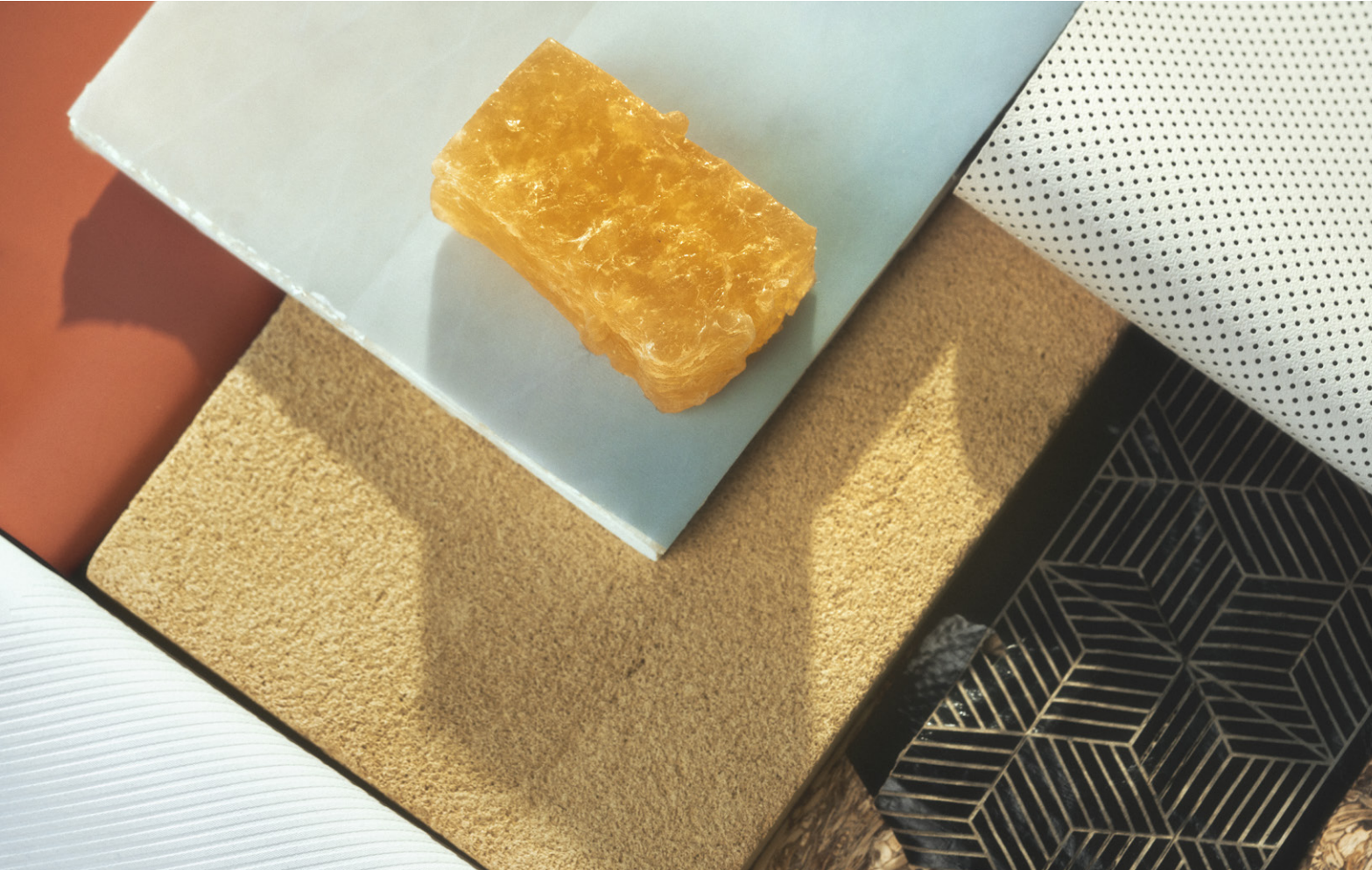
The entire vehicle assembly, including the electric drive unit of the MINI Cooper E, takes place at the joint plant of the "Spotlight Automotive Limited" joint venture between the BMW Group and Great Wall Motor in Zhangjiagang. The central components are the combination of electric motor, power electronics and transmission, as well as the high-voltage battery, which is installed in the underbody of the vehicle.

The BMW Group's corporate goal of supplying its own sites entirely with electricity generated from renewable sources also applies to the BMW joint venture site in Zhangjiagang. It has therefore been contractually agreed with Spotlight / GWM that only Energy Attribute Certificates (EACs; green electricity certificates) from renewable energies, either via International Renewable Energy Certificates (IRECs) or via China Green Electricity Certificates (GECs), will be procured. The systematics of these EAC-systems is based on seamless tracking of the amount of electricity generated and the corresponding certificates issued, meaning that the risk of double-counting can be categorised as very low. The heat requirement is covered by natural gas.





## 4. RECYCLING OPTIONS AT THE END OF THE LIFE CYCLE.



MINI considers the impact on the environment over the entire life cycle of a new vehicle. From production to usage, servicing and recycling. Efficient recycling is planned as early as in the development and production stages. "Designed for recycling" is applied and ensures efficient recycling of end-of-life vehicles. One example is the complete and simple removal of the operating fluids (e.g. refrigerant).

It goes without saying that MINI automobiles worldwide meet the legal requirements for the recycling of end-of-life vehicles, components and materials. In relation to the entire vehicle, at least 85% of materials are recycled and, including thermal utilisation, at least 95% as stipulated by legal requirements (European End-of-Life Vehicles Directive ELV 2000/53/EC).

End-of-life vehicles are recycled in recognised disassembly facilities. The BMW Group and its national sales companies have established a network recycling at more than 2,800 collection points in 30 countries worldwide. The four stages of recycling include controlled return, pre-treatment, disassembly and recycling of the remaining vehicle.

The statements and specifications on this page do not form part of the LCA.

# 5. EVALUATION AND CONCLUSION.

The new, all-electric MINI Cooper is modern, digital and unique. With the new MINI family, the brand is advancing into a future of all-electric driving pleasure, a digital user experience and a responsible attitude.

The independent TÜV Rheinland Energy validated a life cycle assessment of the MINI Cooper E showing the measures taken to reduce its environmental impact.

