ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	DORMA Deutschland GmbH
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-DOR-20140191-CBD1-EN
Issue date	28.10.2014
Valid to	27.10.2019

BTS 75 V and RTS 87 Series Concealed Door Closers

DORMA

Institut Bauen und Umwelt e.V.

www.bau-umwelt.com / https://epd-online.com

General Information

DORMA

Programme holder
IBU - Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
Germany

Declaration number
EPD-DOR-20140191-CBD1-EN

This Declaration is based on the Product Category Rules:
Locks and fittings , 07.2014
(PCR tested and approved by the independent expert committee)

Issue date
28.10.2014

Valid to
27.10.2019

Prof. Dr.-Ing. Horst J. Bossenmayer
(President of Institut Bauen und Umwelt e.V.)

Dr. Burkhart Lehmann
(Managing Director IBU)

BTS 75 V and RTS 87 Series Concealed Door Closers

Owner of the Declaration
DORMA Deutschland GmbH
DORMA Platz 1
58256 Ennepetal
Germany

Declared product / Declared unit
The declaration represents one concealed door closer unit.

Scope:
The declaration and the background LCA represent DORMA's BTS 75 V and RTS 87 Series concealed door closers. Raw materials and components are provided by suppliers and shipped to DORMA, where the closers are manufactured and assembled at DORMA facilities in Singapore. The BTS 75 V and RTS 87 differ in how they are mounted to the door (floor versus frame), but are otherwise identical products. 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.

Verification

The CEN Norm EN 15804 serves as the core PCR
Independent verification of the declaration according to ISO 14025
☐ internally ☒ externally

Dr.-Ing. Wolfram Trinius
(Independent tester appointed by SVA)

Product

Product description
DORMA's BTS 75 V and RTS 87 Series concealed door closers are dependable and versatile for almost any application. Their compact bodies enable them to be used in applications where larger closers would be prohibitive. They can be installed a number of different configurations, including in standard, narrow or wide door frames, as well as with left-hand or right-hand single- or double-action mounting. The closers are designed for all types of doors and allow the necessary spring adjustments for both barrier-free and non-barrier free openings. A comprehensive selection of accessories ensures that they can be used successfully with a wide variety of door constructions and floor coverings. Product benefits include:

- *For the trade:* Reduced stock requirements because of adjustable closing force and separate, interchangeable spindles (BTS 75 V only), and slim product range offering all key functions.
- *For the installer:* Suitable for installation with left-hand or right-hand single and double action doors. Interchangeable spindles, as well as adjustable closing force, enable easy adaption to structural conditions—even when retrofitted (BTS 75 V only).
- *For the architect:* Concealed installation for maximum visual elegance. A wide range of applications allow architects a reliable and durable solution without compromising the aesthetics of an opening.
- *For the user:* A temperature-independent closing cycle and highly efficient mechanism gives maximum user convenience.

Application
The BTS 75 V and RTS 87 Series offer aesthetically pleasing solutions for both interior and exterior applications. The closers can be used in a variety of applications, including as closers for fire and smoke doors for the non hold-open versions.

Technical Data
The concealed door closers employ a cam and roller mechanism, and are capable of controlling interior or

exterior doors weighing up to 120 kg. They have an adjustable closing force from EN 1 to EN 4 and a mechanical backcheck at approximately 70°. Dual valve adjustment provides controlled closing speed from approximately 175° opening range, even in cold temperature conditions.

Certifications include /ISO 9001/, /ANSI A156.4/ for Grade 1, and /EN 1154/ (CE for non hold-open versions only).

Name	Value	Unit
Length	285	mm
Width	82	mm
Height	50	mm
Weight	2.9	kg
Test standards and methods	/EN 1154/	

Base materials / Ancillary materials

Name	Value	Unit
Steel	44	%
Aluminum	44	%
Zinc	6	%
Oil	5	%
Coatings	1	%

Reference service life
No use stage modules are reported; as such, declaration of the reference service life (RSL) is voluntary. The RSL is not reported for the BTS 75 V or RTS 87 Series closers.

LCA: Calculation rules

Declared Unit
The declared unit of this analysis is one concealed door closer.

Declared unit

Name	Value	Unit
Declared unit (1 closer)	1	1 piece/product
Mass of system (without packaging)	2.9	kg
Conversion factor to 1 kg	0.34	-

System boundary
Type of EPD: cradle-to-gate - with options. The following modules were considered in the analysis:

Product stage:
- Raw material supply (A1)
- Inbound transport (A2)
- Manufacturing (A3)

Construction process stage:
- Distribution (A4)
- Installation (A5)

End-of-life stage:
- Disposal (C4)

Beyond system boundaries:
- Reuse, recovery, recycling potential (D)

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.

LCA: Scenarios and additional technical information

Additional information is provided for declared modules, including A4, A5, C4, and D. In order to represent DORMA's global distribution network, a sales-weighted average is used to model transport to the building site. The table for Module A4 shows both weighted average transportation distance (given regional concealed closer sales), which is used in the analysis, along with the variation in that distance. Additionally, estimated global average recycling rates are used to represent product disposal.

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel (truck)	31	l/100km
Transport distance	2400 - 22800	km
Average transport distance (SI)	13300	km
Capacity utilisation (including empty runs)	85	%

Installation into the building (A5)

Name	Value	Unit
Output substances following waste treatment on site (packaging)	0.41	kg

End of life (C1-C4)

Name	Value	Unit
Recycling	2.2	kg
Landfilling	0.7	kg

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

Name	Value	Unit
Recycling rate, aluminum	60	%
Recycling rate, brass	52	%
Recycling rate, paper	90	%
Recycling rate, plastics	14	%
Recycling rate, steel	88	%
Recycling rate, zinc	52	%

LCA: Results

The table below summarizes which modules are declared (as indicated by an "X"), and which are not declared (as indicated with "MND"). Environmental performance results are shown for one (1) surface door closer.

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

PRODUCT STAGE			CONSTRUCTION PROCESS STAGE		USE STAGE							END OF LIFE STAGE				BENEFITS AND LOADS BEYOND THE SYSTEM BOUNDARYS
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement[1)]	Refurbishment[1)]	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	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	X	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 closer (2.9kg)*

Parameter	Unit	A1 - A3	A4	A5	C4	D
Global warming potential	[kg CO_2-Eq.]	2.024E+1	7.610E-1	1.570E-1	3.010E-2	-3.870E+0
Depletion potential of the stratospheric ozone layer	[kg CFC11-Eq.]	1.952E-8	3.390E-12	1.540E-13	7.990E-14	6.600E-8
Acidification potential of land and water	[kg SO_2-Eq.]	1.106E-1	1.810E-2	2.060E-5	4.440E-5	-1.600E-2
Eutrophication potential	[kg $(PO_4)^{3-}$- Eq.]	6.961E-3	1.940E-3	2.930E-5	6.870E-6	-6.170E-4
Formation potential of tropospheric ozone photochemical oxidants	[kg Ethen Eq.]	8.108E-3	7.420E-4	2.130E-5	1.060E-5	-1.620E-3
Abiotic depletion potential for non fossil resources	[kg Sb Eq.]	1.280E-3	2.260E-8	8.070E-10	2.690E-9	-7.990E-6
Abiotic depletion potential for fossil resources	[MJ]	2.351E+2	9.490E+0	5.750E-2	9.250E-2	-3.860E+1

RESULTS OF THE LCA - RESOURCE USE: 1 closer (2.9kg)*

Parameter	Unit	A1 - A3	A4	A5	C4	D
Renewable primary energy as energy carrier	[MJ]	6.235E+1	1.180E-1	3.040E-3	7.860E-3	-6.510E+0
Renewable primary energy resources as material utilization	[MJ]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Total use of renewable primary energy resources	[MJ]	6.235E+1	1.180E-1	3.040E-3	7.860E-3	-6.510E+0
Non renewable primary energy as energy carrier	[MJ]	2.803E+2	1.020E+1	6.560E-2	1.040E-1	-4.160E+1
Non renewable primary energy as material utilization	[MJ]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Total use of non renewable primary energy resources	[MJ]	2.803E+2	1.020E+1	6.560E-2	1.040E-1	-4.160E+1
Use of secondary material	[kg]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Use of renewable secondary fuels	[MJ]	2.174E-3	6.100E-5	4.470E-5	1.770E-4	-6.590E-4
Use of non renewable secondary fuels	[MJ]	1.751E-2	6.410E-4	9.940E-5	3.820E-4	-6.230E-3
Use of net fresh water	[m^3]	1.221E+2	1.210E-1	-4.440E-2	-2.860E-1	-1.670E+1

RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES: 1 closer (2.9kg)*

Parameter	Unit	A1 - A3	A4	A5	C4	D
Hazardous waste disposed	[kg]	2.254E-2	1.550E-5	2.000E-6	4.250E-6	-2.330E-3
Non hazardous waste disposed	[kg]	1.911E+0	3.610E-4	3.910E-2	5.240E-1	-2.520E-1
Radioactive waste disposed	[kg]	1.082E-2	1.380E-5	1.060E-6	1.630E-6	-7.500E-4
Components for re-use	[kg]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Materials for recycling	[kg]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Materials for energy recovery	[kg]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Exported electrical energy	[MJ]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0
Exported thermal energy	[MJ]	0.000E+0	0.000E+0	0.000E+0	0.000E+0	0.000E+0

* 1kg = 2.204 lbs.

Concealed closer environmental impacts are dominated by the product stage (A1-A3) for all impact categories. The production of raw materials such as aluminum, steel and zinc, in particular, are key drivers of environmental performance. The one exception is ozone depletion potential, for which Module D accounts for a significant portion of environmental impact. This is due to differences in primary versus secondary steel production routes, the latter typically leading to higher ozone-depleting emissions from electricity use in electric arc furnaces.

Distribution also accounts for a relevant contribution in a few impact categories. Compared to the product stage, however, distribution is a smaller fraction of closer environmental impact. Distribution is modeled assuming a sales-weighted average based on the countries and regions in which closers are sold. Finished products are shipped from DORMA's facility in Singapore to various locations in Europe, Asia, and the Americas. While the results represent DORMA's specific situation as of 2013, they can be reevaluated for a specific country or region.

At the end-of-life, DORMA's closers are modeled as being recycled. A portion of each material type is recovered and the remainder landfilled. In this case, proxy data are used as often, global average or even regional specific data are not available. Waste disposal (Module C4) is consistently a minor contributor to environmental impact so dataset choice is not anticipated to affect conclusions.

References

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GaBi 6
PE INTERNATIONAL; GaBi 6: Software-System and Database for Life Cycle Engineering. Copyright, TM. Stuttgart, Echterdingen, 1992-2013.

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PCR Part A
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PCR Part B
PCR Guidance-Texts for Building-Related Products and Services. From the range of Environmental Product Declarations of Institute Construction and Environment e.V. (IBU). Part B: Requirements on the EPD for Locks and fittings. 2012. www.bau-umwelt.com

Publisher
Institut Bauen und Umwelt e.V.
Panoramastr. 1
10178 Berlin
Germany

Tel +49 (0)30 3087748- 0
Fax +49 (0)30 3087748- 29
Mail info@bau-umwelt.com
Web **www.bau-umwelt.com**

Programme holder
Institut Bauen und Umwelt e.V.
Panoramastr 1
10178 Berlin
Germany

Tel +49 (0)30 - 3087748- 0
Fax +49 (0)30 – 3087748 - 29
Mail info@bau-umwelt.com
Web **www.bau-umwelt.com**

Author of the Life Cycle Assessment
PE INTERNATIONAL, Inc.
Milk St. 170
02109 Boston, MA
USA

Tel +1 617-247-4477
Fax +1 303-447-0909
Mail consulting@pe-international.com
Web **www.pe-international.com**

Owner of the Declaration
DORMA
DORMA Platz 1
58256 Ennepetal
Germany

Tel +49 (0)2333 793-0
Fax +49 (0)2333 793-4950
Mail dorma-deutschland@dorma.com
Web **www.dorma.com**