ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	Häfele GmbH & Co KG
Publisher	Institut Bauen und Umwelt (IBU)
Programme Holder	Institut Bauen und Umwelt (IBU)
Declaration Number	EPD-HAE-20150058-IBG1-EN
Issue Date	23/09/2013
Valid To	22/09/2018

Stainless steel door fittings

Häfele GmbH & Co KG

www.bau-umwelt.com

Institut Bauen
und Umwelt e.V.

1 General Information

Häfele GmbH & Co KG

Programme Holder

IBU - Institut Bauen und Umwelt e.V.
Panoramastr. 1
D-10178 Berlin

Declaration Number

EPD-HAE-20150058-IBG1-EN

Thsi declaration is based on the product category regulations:

PCR Locks and Door Fittings, 07-2012
(PCR-tested and approved by the independent testing committee)

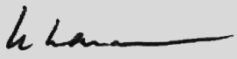
Issue Date

23/09/2013

Valid to

22/09/2018

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



Prof. Dr.-Ing. Hans-Wolf Reinhardt
(Chairman of SVA)

Stainless steel door fittings

Owner of the Declaration

Häfele GmbH & Co KG
Adolf-Häfele-Straße 1
72202 Nagold

Declared Product/Declared Unit

A stainless steel door fitting with an average weight of 0.5 kg

Scope of Validity:

This sample environmental declaration relates to an average stainless steel fitting assembly for doors. A weighted average according to the quantity sold was calculated from ten individual representative product samples.

The values determined to calculate the LCA originate from a member company selected by the Door Lock and Fittings Industry Federation. The average product is representative for the product group according to the federation. The production and installation location is Germany.

The owner of the declaration is liable for the fundamental information and verification; any liability by the IDU in relation to manufacturers' information, LCA data and verification is excluded.

Verification

CEN standard EN 15804 serves as the core PCR
Independent verification of the declaration and data according to ISO 14025
☐ internal ☒ external

Prof. Dr. Birgit Grahl
(Independent tester appointed by SVA)

2 Product

2.1 Product Description

These fittings mainly consist of various metal alloys in differing proportions. Product weights between 0.400 kg and 0.950 kg are normal depending on the version. The fittings open and close interior and exterior doors. They consist of the handle which serves to open and close the door manually, alternatively a knob and the backplate or escutcheon, normally with a keyhole for operating the built-in lock. In addition, accessory parts and fixing materials are also part of a door fitting.

The fittings can be used on wood, plastic or metal doors.

A weighted average according to the quantity sold was calculated from ten individual representative product samples according to the manufacturer.

2.2 Application

Operating the handle moves the built-in lock or the latch bolt from the closed to the open position and back again. The handle is responsible for the manual movement of the pivotable or slidable door leaf and together with the other components of the door ensures that building physics-related and possibly other properties such as burglar resistance, noise insulation and fire protection are reached safely. The fittings are normally installed in the door leaf by the door manufacturer, carpenters and furnishers.

2.3 Technical Data

Not relevant.

2.4 Placing on the market/Application rules

DIN EN 1906, DIN EN 179, DIN 18255

2.5 Delivery status

The door fitting sets shown here are supplied in standard formats and with standard openings with regard to combinations with mortise locks and usually fitted to the door leaf by the door manufacturer, carpenters and furnishers. They may also be offered individually by building suppliers.

The end customer receives the fitted door fitting.

2.6 Base materials/Ancillary materials

The declared fitting parts consist of various galvanised steels (20%), stainless steel (70%) and small amounts of plastics (10%).

Plant oil-based cooling agents may be used during cutting to size, punching and boring. These have no

effect on the material composition of the end product.

2.7 Manufacture

The fittings are manufactured at the factory in three steps:

Prefabrication (cutting to size and punching)

Prefitting of assemblies

Final assembly

2.8 Environment and health during manufacturing

No environmental interactions which must be especially taken into account occur during the manufacture of the fittings.

Air: The compressed air (pneumatic cylinder) required for processing is produced in enclosed plants and cleaned with filter systems, those systems are subject to national law.

Water/Ground: Water and ground are not contaminated as no waster water is produced during the manufacturing process.

Cleaning agents: are not used in the manufacturing process.

Sound emissions: Regular sound emission tests at the production locations show that only the cutting and punching areas, which are labelled as a noise zone, are relevant as regards work protection laws Employees always wear ear protection and are subject to monitoring by the company doctor and / or national authorities.

2.9 Product processing/Installation

The fittings are either sent directly to the door manufacturer by the manufacturer, carpenters and furnishers or supplied ready-to-use to the building materials trade. Processing recommendations are provided. During final fitting of the door care must be taken that the fitting is fitted properly.

2.10 Packaging

The fitting sets are normally packaged in disposal packaging made of recyclable cardboard. There is no elaborate sales packaging if deliveries are made directly to the processor (door manufacturer). The packaging mainly serves as protection during transport.

2.11 Condition of use

The materials result from the raw materials described in Chapter 2.1. The automatic seals are maintenance-free and are not subject to wear under normal use.

2.12 Environment and health during manufacturing

Material-specific reactions or reciprocal reactions with the environment/the user's health are not expected.

2.13 Reference service life

The products are designed for permanent use and certified accordingly. The corresponding classifications are stated on the relevant product and meet the quality standard to / DIN EN 1906.

2.14 Extraordinary effects

Fire

Metal fittings are classified as not combustible. As regards their reaction to fire, they are allocated to Class A1 in accordance with DIN EN 13501-1.

Water

No negative effects for the environment and drinking water protection are to be expected from the effects of flooding. A new function test must be performed once the floods have subsided. Corrosion can lead to consequential damage.

Mechanical destruction

The mechanical destruction of door handle fittings is not expected in case of ordinary use. In practice, the fittings are only damaged if the entire door is destroyed and renewed.

2.15 Re-use phase

The materials used are high-quality raw materials which can be recycled at the end of the use phase. No environmental contamination occurs when the seals are dismantled. On the other hand, continued use of the fitting does not normally make economic sense.

2.16 Disposal

The seal is to be disposed of separately if a door is dismantled. The simple dismantling option means the fittings in the post-use phase can be completely given over to recycling.

Disposal is superfluous because it would be possible without special conditions or influencing of the environment stating the waste code 17.04.07 according to the European Waste Catalogue.

2.17 Further information

Stainless steel fittings are manufactured in various designs depending on the type and amount of stress on the door. Generally, the same fittings are suitable for both wooden and plastic surfaces. Especially matched materials are normally also used for fittings on aluminium doors. In addition, you can obtain further information on www.hafele.com.

3 LCA: Calculation rules

3.1 Declared unit

The declaration relates to an average of ten individual stainless steel fittings for doors, manufactured by a member company of the Door Lock and Fittings Industry Federation, This average product is representative for the product group. The toal weight of the declared average door fitting is 0.5 kg.

Specification of the declared unit

Designation	Value	Unit
Conversion factor to 1 kg	2	-
Declared unit	1	Piece/Product

3.2 System boundary

EPD type: Cradle to gate - with options.

The calculated LCA addresses the life cycle stage of product manufacture as well as a recycling scenario. Product manufacture includes modules A1 (raw materials provision), A2 (transport) and A3 (manufacture). The recycling scenario includes modules C2 8transport for disposal/recycling), C3 (waste recycling) and C4 (disposal). Credits from reuse, recovery and recycling potential are shown in module D in accordance with DIN EN 15804.

3.3 Estimates and assumptions

The declared average automatic door seal was calculated on the basis of production data from a member company of the Door Lock and Fittings Industry Federation. To calculate the values, an manufacturer of stainless steel door fittings was selected by the federation as being representative for further federation companies. The stainless steel door seals on which the calculation in this declaration is based were also deliberately chosen so that they best represent each product group. The manufacturing processes and raw materials are comparable due to the normative specifications and requirements.

The actual transport distances were used for the transport of the raw materials to the factory. A transport distance of 200 km was estimated for recycling.

3.4 Cut-off criteria

All production data collected was taken into account in the balance. Processes which contribute less than 1% by weight to the final result and in all impact categories have been ignored.

It can be assumed that the ignored processes would have contributed less than 5% respectively to the impact categories included.

Machines, plant and infrastructure needed for manufacture have been ignored. Transport for packaging has been ignored.

3.5 Background data

The **GaBi 6** software system for integrated balancing developed by PE INTERNATIONAL was used to model the life cycle for the manufacture of Stainless steel fittings.

The consistent data records in the GaBi 6 database are documented in the GaBi 6 online documentation. The basic data in the GaBi database was used for energy, transport and auxiliary materials. The LCA was produced for the reference area of Germany. This means that in addition to the production processes within these framework conditions, the preliminary stages relevant for Germany such as electricity or energy source provision were used. The electricity mix for Germany in relation to the year 2009 was used.

3.6 Data quality

All background data relevant for the LCA was taken from the GaBi 6 database. The last revision of the background data used for balancing was less than four years ago.

The corresponding member company made current primary data from production in 2011 available. This production data was checked for plausibility. According the the manufacturer's data, the representativeness of the declared product is excellent.

The database contained corresponding data records for all upstream products. The data quality can be regarded as being excellent.

3.7 Period under review

The data basis for this LCA is current data from a member company of the Door Lock and Fittings Industry Federation from 2011.

3.8 Allocation

No allocations were made as the door fittings are manufactured on independent production lines. All factory data relates exclusively to the declared products.

3.9 Comparability

Comparison or evaluation of EPD data is really only possible if all data records to be compared were produced in accordance with DIN EN 15804 and the building context and the product-specific technical features are taken into account.

4 LCA: Scenarios and additional technical information

The following technical information forms the basis of the declared modules or can be used for the development of specific scenarios in the context of a building assessment if modules are not declared (MND)

Transport to recycling (C2)

Transport distance	200 km
Capacity utilisation (including empty runs)	85%

Ende of life (C1-C4)

Collected separately	100%
Collected as mixed construction waste	0%
Re-use	0%
Recycling	81%
Energy recovery	9%
Landfilling	10%

5 LCA: Results

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 boundary
Raw material supply	Transport	Manufacture	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction / Demolition	Transport	Waste processing	Disposal	Re-use, recovery or recycling potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	X	X	X	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: Stainless steel door fittings [0.5 kg/product]

		Manufacture	Disposal			Credit
Parameter	**Unit**	**A1-A3**	**C2**	**C3**	**C4**	**D**
GWP	[kg SO_2-Eq.]	4.0E+00	5.0E-03	9.7E-02	2.9E-03	-2.0E+00
ODP	[kg CFC11-Eq.]	9.0E-08	1.0E-13	2,4E-12	5,4E-13	-5,9E-09
AP	[kg SO_2-Eq.]	3.1E-02	2.2E-05	1.7E-04	4.3E-06	-1.6E-02
EP	[kg PO_4^{3-}- Eq.]	1.8E-03	5.3E-06	4.4E-05	6.5E-07	-1.1E-03
POCP	[kg Ethen Eq.]	2.1E-03	-7.5E-06	1.0E-05	1.1E-06	-1.1E-03
ADPE	[kg Ethen Eq.]	1.0E-04	2,3E-10	1.0E-09	2.5E-10	-5.5E-05
ADPF	[MJ]	5.1E+01	6.8E-02	6.2E-02	9.8E-03	-2.4E+01
Key	GWP = Global Warming Potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidifcation potential of land and water; EP = Eutrophication potential; POCP Formation potential for tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources					

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: Stainless steel door fittings [0.5 kg/product]

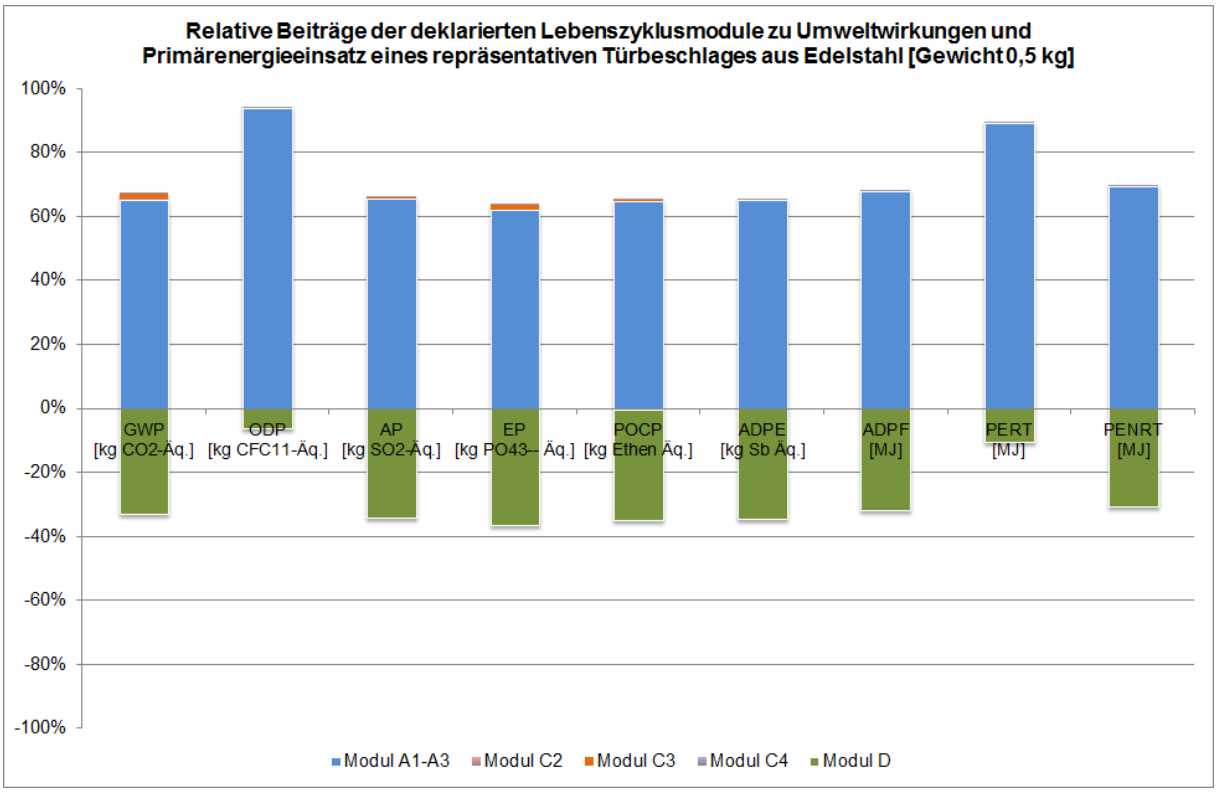
		Manufacture	Disposal			Credit
Parameter	**Unit**	**A1-A3**	**C2**	**C3**	**C4**	**D**
PERE	[MJ]	7.1E+00	4.0E-03	2.5E-03	7.3E-04	-8.4E-01
PERM	[MJ]	0.0E+00	-	-	-	-
PERT	[MJ]	7.1E+00	4.0E-03	2.5E-03	7.3E-04	-8.4E-01
PENRE	[MJ]	5.5E+01	6.8E-02	6.6E-02	9.8E-03	-2.5E+01
PENRM	[MJ]	2.0E+00	-	-	-	-
PENRT	[MJ]	5.7E+01	6.8E-02	6.6E-02	9.8E-03	-2.5E+01
SM	[kg]	0.0E+00	-	-	-	-
RSF	[MJ]	4.3E-04	5.1E-07	8.6E-07	1.9E-05	-9.3E-06
NRSF	[MJ]	4.5E-03	5.3E-06	9.0E-06	4.1E-05	-9.7E-05
FW	[m^3]	*	*	*	*	*
Key	PERE = Renewable primary energy as energy source; PERM = Renewable primary energy resources as material utilisation; PERT = Total use of renewable primary energy resources; PENRE = Non-renewable primary energy as energy source; PENRM = Non-renewable primary energy as material utilisation; 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 - ENVIRONMENTAL IMPACT: Stainless steel door fittings [0.5 kg/product]

		Manufacture	Disposal			Credit
Parameter	**Unit**	**A1-A3**	**C2**	**C3**	**C4**	**D**
HWD	[kg]	*	*	*	*	*
NHWD	[kg]	*	*	*	*	*
RWD	[kg]	2.0E-03	9.8E-08	1.6E-06	1.7E-07	-1.2E-04
CRU	[kg]	-	-	-		0.0E+00
MFR	[kg]	-	-	-		4.3E-01
MER	[kg]	-	-	-		1.6E-01
EE [elec.]	[MJ]	-	-	-		1.3E-01
EE [ther.]	[MJ]	-	-	-		3.1E-01
Key	HWD = Hazardous waste disposal; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed; CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EE = Exported thermal energy					

** The indicators cannot be identified (SVA resolution dated 07/01/2013).*

6 LCA: Interpretation



The largest contribution to **Global Warming Potential (GWP, 100 years)** comes from preliminary product provision (93%) - mainly from the manufacture of continuous aluminium casting and the silicone seals. 7% of global warming gas emissions are caused by the manufacturing process itself. A total of 50 % of all GWP emissions are credited; the dominant contribution comes from recycling the aluminium (91%).

98% of the **Ozone Depletion Potential (ODP)** comes from upstream chains. The manufacture of the aluminium extrusions (94%) and the galvanised steel (4%) contribute especially to the total ODP. Halogenated organic emissions (R 114, dichlorotetrafluoroethane) are released by the use of nuclear power in the manufacturing processes of the preliminary products. These can in turn be attributed to the CFCs used for cooling in nuclear power stations. The credit is 7% in total. The reason is that mainly electricity is used as an energy form when manufacturing secondary steel unlike the manufacture of primary steel in which coal is used as the energy source.

The **Acidification Potential (AP)** is dominated by 99% in the production stage by the provision of raw materials (module A1). The greatest effects therefore result from the manufacture of stainless steel (95%). Above all sulphur dioxide (85%) and nitrogen oxide (13%) dominate the AP. A credit of 50% is offset mainly by recycling the steel.

The largest contribution to **eutrophication potential (EP)** comes from preliminary product provision (94%), mainly the stainless steel (88%). The EP is dominated by nitrogen oxide emissions due to the energy provider implementation. A total of 58% of the total emissions are credited.

The **Abiotic Depletion Potential (ADPE non-fossil)** is mainly caused by the manufacturing stage (module A1-A3). The upstream chains (A1) (95%) contribute mainly to the total ADP. The disposal stage (C2 and C3) has no significant influence. The credit is 48% in total.

The **Abiotic Depletion Potential (ADP fossil)** results mainly from the contribution of the upstream chains in module A1 (88%). The use of stainless steel (65%) and polyamide (18%) makes a particularly large contribution to the ADPF. A credit of 48% is offset mainly by recycling the steel.

The **ozone smog potential (POCP)** is triggered by the provision of the pre-products. Modules A2 and A3 (0%) can be ignored compared to A1 (99%). Especially the MNVOC group, sulphur dioxide and nitrogen oxide contribute to POCP. The credit here is 52%.

The **entire primary energy requirement** is divided between 84% from non-renewable energy sources and 16% from renewable sources.

52% of the **entire renewable primary energy requirement (PERT)** results from the pre-product manufacture upstream chains (module A1). The influence of the manufacture of the stainless steel is particularly apparent at 90% and the polyamide at 8%. The production process (A3) supplies 48%. The credit (module D) totals 12%, of which the largest part is attributable to metallic pre-production recycling.

With regard to the **entire non-renewable primary energy requirement (PENRT)** the pre-product manufacture upstream chains contribute 88% (largely from stainless steel manufacture). The production of the door fitting itself contributes 12 %. A total of 43% is credited which comes mainly from recycling the metallic steel.

7 Requisite evidence

No further evidence is required according to the PCR for locks and fittings.

8 References

Institut Bauen und Umwelt 2011

Published by Institut Bauen und Umwelt (IBU) Generation of Environmental Product Declarations (EPDS)

General principles

For the Institut Bauen und Umwelt e.V. (IBU)'s EPD range, 2011-09, www.bau-umwelt.de

PCR 2012, Part A

Calculation rules for the LCA and requirements of the background report, Institut Bauen und Umwelt e.V., September 2012, www.bau-umwelt.de

PCR 2012, Part B

Instructions for building-related products and services, Part B: Requirements of the EPD for PCR Door locks and fittings, Institut Bauen und Umwelt e.V., www.bau-umwelt.de, July 2012, Version 1.0

ISO 14025

ISO 14025:2007-10, Environmental labels and declarations - Type III Environmental declarations - Principles and procedures (ISO 14025:2006);

DIN EN 15804

DIN EN 15804:2012-04: Sustainability of construction works - Environmental product declarations - Core rules for the product category of construction

AVV

European Waste Catalogue dated 10th December 2001 (Federal Legal Gazette p. 3379) last modified by Article 5 Paragraph 22 of the law dated 24th February 2012 (Federal Legal Gazette p. 212).

GaBi 6

GaBi 6 Software and database for Life Cycle Engineering, JKP (Institute for Polymer Testing and Polymer Science) University of Stuttgart and PE Europe AG, Leinfeld-Echterdingen, 2012

GaBi 6

GaBi 6 Documentation of GaBi 6 data records in the integrated balancing database. LBP, University of Stuttgart and PE International, 2011
http://documentation.gabi-software.com/,

DIN EN 179

DIN EN 179:2008-04: Building hardware - Emergency exit devices operated by a lever handle or push pad, for use on escape routes - Requirements and test methods

DIN EN 1906

DIN EN 1906:2012-12: Building hardware - Lever handles and knob furniture - Requirements and test methods

DIN EN 13501-1

DIN EN -1:2010-01: Fire classification of construction products and building elements - Part 1: Classification using data from reaction to fire tests

DIN EN 18255

DIN EN 18255:2002-05: Building hardware -Door lever handles, backplates and escutcheons - Definitions, dimensions, requirements and marking

VHBH Directive

VHBH, 2009-11: Fittings for windows and French windows - requirements/instructions on the product and product liability.

VHBE Directive

VHBE, 2009-11: Fittings for windows and French doors - requirements/instructions for end users.

Publisher
Institut Bauen und Umwelt (IBU)
Panoramastr. 1
10178 Berlin
Germany

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

Programme Holder
Institut Bauen und Umwelt (IBU)
Panoramastr. 1
10178 Berlin
Germany

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

HÄFELE

Owner of the Declaration
Häfele GmbH & Co KG.
Adolf-Häfele-Straße 1,
72202
Germany

Tel.: +49 (0)74 52 / 95 - 0
Fax: +49 (0)74 52 / 95 - 2 00
E-Mail: info@haefele.de
Web: **www.haefele.de**

PE INTERNATIONAL

Author of the Life Cycle Assessment
PE INTERNATIONAL AG
Hauptstraße 111 - 113
70771 Leinfelden-Echterdingen
Germany

Tel.: +49 (0) 711 34 18 17-0
Fax: +49 (0)711 341817-25
Email: info@pe-international.com
Web:**www.pe-international.com**