

# ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	DYNACO Europe NV
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-DYN-20240627-IBC1-EN
Issue date	08.02.2022
Valid to	07.02.2027

## Dynaco R-741 Rigid high performance door DYNACO Europe NV

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## 1. General Information

### DYNACO Europe NV

#### Programme holder

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

#### Declaration number

EPD-DYN-20240627-IBC1-EN

#### This declaration is based on the product category rules:

Automatic doors, automatic gates, and revolving door systems,  
01.08.2021  
(PCR checked and approved by the SVR)

#### Issue date

08.02.2022

#### Valid to

07.02.2027



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



Florian Pronold  
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### Dynaco R-741 Rigid high performance door

#### Owner of the declaration

DYNACO Europe NV  
Waverstraat 21  
9310 Moorsel  
Belgium

#### Declared product / declared unit

This declaration represents 1 rapid roll door with electrical operation, 4000 mm width and 4000 mm height, consisting of panels filled with water blown CFC-free polyurethane foam, panel thickness 50 mm and panel height 200 mm

#### Scope:

This declaration and its LCA study are relevant to the Dynaco R-741 Rigid high-performance door. The production location is Plzen, Czech Republic and components are sourced from international tier one suppliers. Dynaco R-741 Rigid high-performance door size vary according to project requirements; a standard door 4000 mm width and 4000 mm height with insulated panels filled with CFC-free polyurethane, panel thickness 50 mm, panel height 200 mm is used in this declaration.

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	
<input type="checkbox"/>	internally
<input checked="" type="checkbox"/>	externally



Dr.-Ing. Wolfram Trinius,  
(Independent verifier)

## 2. Product

### 2.1 Product description/Product definition

The Dynaco R-741 Rigid high-performance door is suitable for all types of buildings, with regards to both function and appearance. High flexibility makes it possible to install this door in almost every type of building. The door rolls up on a roll above the lintel when opened, not needing excessive space around the door opening and leaving the door opening completely free.

The door is made of insulated panels. The panels are designed without a thermal bridge to provide minimal thermal transmittance, which reduces energy costs. The surface is made of micro profiling stucco steel. There is top, bottom and side seals and seals between door panels. The standard side frame is made of galvanized steel with ethylene-propylene-diene rubber (EPDM) insulation and a sliding guide.

The balancing system balances the door by applying a force nearly equal to the weight of the door blade if the door is half-opened. This allows the door blade to be moved up and down, and to stay in a half opening position if the emergency lever is used. The balancing system (springs in combination with belts) supports heavy forces. In case of a spring or belt break, its counterforce is lost. For that case, the drive system is designed to take the load of the door blade weight.

The door has 3 primary parts:

- 1) Top roll with door blade
- 2) Side frames with integrated balancing system
- 3) Electrical control system with drive system.

The Dynaco R-741 Rigid high-performance door has been designed to meet all operational and safety requirements in the European Directives and the standards issued by the European Standardization Committee (CEN). For the placing on the market in the EU/EFTA (excl. Switzerland), Switzerland and Turkey the Construction Products Regulation (CPR) (EU) No 305/2011 applies. The products need a Declaration of Performance and CE marking under consideration of the Construction Products Regulation and the harmonized standard EN 13241:2003+A2:2016 Industrial, commercial, garage doors and gates — Product standard — Part 1: performance characteristics. Products without fire resistance or smoke control characteristics.

Further standards that can be applied for RR5000 High-performance doors are:

- Wind load: EN12424  
Class 4 ( $W \leq 3500$  mm)  
Class 3 ( $3500\text{mm} < W \leq 5000$  mm)
- Thermal transmittance: EN12428  
0.79  $\text{W/m}^2\text{K}$  (panel door blade)  
1.28  $\text{W/m}^2\text{K}$  (Door without windows (maximum size 5000 x 4700 mm))
- Acoustic insulation: EN ISO 10140-2  
 $R_w=25$  dB (Door blade surface 3560 x 2900 mm)

The electrical unit as identified is in compliance with the following directives:

- 2006/42/EC Machinery Directive (MD)
- 2014/30/EU Electromagnetic Compatibility Directive (EMCD)
- 2011/65/EU RoHS
- 2015/863/EU RoHS

### Harmonized European standards, which have been applied:

EN 60204-1 Safety of machinery - Electrical equipment of machines - Part 1: General requirements  
EN 61000-6-2 Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments  
EN 61000-6-3 Electromagnetic compatibility (EMC) — Part 6-3: Generic standards — Emission standard for residential, commercial and light-industrial environments  
EN ISO 13849-1 Safety of machinery — Safety-related parts of control systems — Part 1: General principles for design  
Disposal of the product is subject to the Waste from Electrical and Electronical Equipment (WEEE)  
Directive within Europe, Directive 2012/19/EU

### Other standards or technical specifications, which have been applied:

For the application and use, the respective national provisions apply.

### 2.2 Application

The Dynaco R-741 Rigid high-performance door is suitable for all types of buildings, with regards to both function and appearance. It has a modern, clean design and meets high stability and insulation demands. Modularity makes it possible to install this door in almost every type of building allowing free space around the door.

### 2.3 Technical Data

The table presents the technical properties of the Dynaco R-741 Rigid high-performance door:

#### Constructional data

Name	Value	Unit
Max size: (W x H)	5000 x 4700	mm
Panel thickness	50	mm
Panel material	Waffled steel (RAL 9006)	-
Panel filling	CFC-free polyurethane	-
Panel weight	Steel: 13.5 kg/m <sup>2</sup>	-
Top roll or motor cover	Aluminium/Steel Optional: powder coated	-
Safety devices	light grid in side frame optional: safety edge and stationary photocell	-
Emergency-lever (optional):	on frontside optional on backside	-
Windows (optional)	window lamella (double paned)	-
Locking unit (optional):	mechanical lock	-
Electrical operation	MCC Frequency converter control system	-
Opening/ closing speed	Opening: 2.2 m/s Closing: 0.7 m/s	-

*\*Bold text and values are relevant for the product in this EPD*

### 2.4 Delivery status

Dynaco R-741 Rigid high-performance door unit with a door size of width 4000 mm and height 4000 mm is delivered in parts ready for installation.

### 2.5 Base materials/Ancillary materials

The average composition for Dynaco R-741 Rigid high performance door is as following:

Name	Value	Unit
Aluminium	3,545	%
Brass	0,011	%
Copper	0,180	%
Plastics	9,771	%
Stainless steel	0,020	%
Steel	83,883	%
Electronic	0,123	%
Electro mechanics	2,139	%
Paper	0,034	%
Others	0,294	%
Total	100	%

\*percentage in mass

## 2.6 Manufacture

The final manufacturing processes occur at the factory in Plzen, Czech Republic. The factory in Plzen, Czech Republic has a certification of quality management system in accordance with ISO 9001.

Offcuts and scraps during the manufacturing process are directed to a recycling unit. Waste is sent for disposal. Waste codes according to European Waste Catalogue and Hazardous Waste List -Valid from 1 January 2002.

EWC 12 01 01 Ferrous metal filings and turnings  
 EWC 12 01 03 Non-ferrous metal filings and turnings  
 EWC 17 02 03 plastic  
 EWC 17 04 01 copper, bronze, brass  
 EWC 17 04 02 aluminium  
 EWC 17 04 05 iron and steel  
 EWC 17 04 11 Cables with the exception of those outlined in 17 04 10

## 2.7 Environment and health during manufacturing

DYNACO Europe NV is committed to produce and distribute door opening solutions with minimal environmental impact, where health & safety is the primary focus for all employees and associates.

- Environmental operations, Greenhouse gases, energy, water, waste, Volatile Organic Compound (VOC), surface treatment and Health & Safety are being routinely monitored. Inspections, audits, and reviews are conducted periodically to ensure that applicable standards are met and environment management program effectiveness is evaluated.
- Code of Conduct covers human rights, labour practices and decent work. Management of DYNACO Europe NV is aware of their roles and responsibilities, providing appropriate training, supporting accountability and recognizing outstanding performance.
- Any waste metals during machining are separated and recycled.

## 2.8 Product processing/Installation

The high-performance door components are supplied ready for installation. The Dynaco R-741 Rigid High-performance door is shipped to site in pre-assembled components (top roll with door blade, side frames and control unit). The components are assembled using simple tools including drills and hand tools. The installation is performed by certified (or competent) installation technicians.

## 2.9 Packaging

Packaging exists for the purpose of protection during transportation. Dynaco R-741 Rigid high-performance door components are packaged in polystyrene plastic, on wooden

pallets and corrugated cardboard. All of these packaging components are standard industry types. The cardboard and wood are recyclable.

Material	Value (%)
Cardboard/paper	1.44
Wood	79.72
Steel	8.46
Plastics	10.38
<b>Total</b>	<b>100.0</b>

All materials incurred during installation are sent to a recycling unit (e.g. steel) and waste incineration plant (wood paper and plastic) for its energy recovery.

Waste codes according to European

Waste Catalogue and Hazardous Waste List -Valid from 1 January 2002.

EWC 15 01 01 paper and cardboard packaging

EWC 15 01 02 plastic packaging

EWC 15 01 03 wooden packaging. EWC 17 04 05 iron and steel

## 2.10 Condition of use

Regular inspections by a trained and qualified person are recommended a minimum of one visit per year or more. Depending on the maintenance plan in user manual examinations of the Dynaco R-741 Rigid high-performance door.

- 1) Make sure there are no loose screws, bolts or nuts on the door blade or the side frames.
- 2) If necessary, tighten all loose screws, bolts and nuts.
- 3) Examine the door blade and lifting belts for damage.
- 4) If damage is found, contact the local service centre for advice.
- 5) Examine the door cables for damage and corrosion.
- 6) If damage or corrosion is found, contact the local service centre for advice.

## 2.11 Environment and health during use

There is no harmful emissive potential. No damage to health or impairment is expected under normal use corresponding to the intended use of the product.

## 2.12 Reference service life

The product has a reference service life of more than 1.000.000 cycles or 17 years standard daily use with the recommended maintenance and service program. For this EPD a lifetime of 17 years was considered.

## 2.13 Extraordinary effects

### Fire

The door fulfils class B2 according to DIN4102.

### Water

Contains no substances that have any impact on water in case of a flood. Electric operation of the device will be influenced negatively.

### Mechanical destruction

No danger to the environment can be anticipated during mechanical destruction.

## 2.14 Re-use phase

The product is possible to be re-used during the reference service life and be moved from one opening to another.

All recyclable materials are directed to a recycling unit where



they are recycled (brass, electronics, electro-mechanics, stainless steel, steel, and aluminium).

On the other hand, the plastic components are sent to the waste incineration plant for its energy recovery.

Waste codes according to European Waste Catalogue and Hazardous Waste List -Valid from 1 January 2002.

EWC 16 02 14 Used devices with the exception of those outlined in 16 02 09 to 16 02 13  
EWC 17 02 03 plastic  
EWC 17 04 01 copper, bronze, brass  
EWC 17 04 02 aluminium  
EWC 17 04 05 iron and steel

EWC 17 04 11 Cables with the exception of those outlined in 17 04 10

### 2.15 Disposal

The product can be mechanically disassembled to separate the different materials. The majority, of components are steel and aluminium which will be recycled. The plastic components are used for energy recovery in an incineration plant. No disposal is foreseen for the product nor for the corresponding packaging.

### 2.16 Further information

DYNACO Europe NV  
Waverstraat 21BE-9310 Moorsel Belgium  
www.dynacodoor.com

## 3. LCA: Calculation rules

### 3.1 Declared Unit

The declaration refers to the functional unit of 1 piece of Dynaco R-741 Rigid high-performance door (width of 4000 mm and height 4000 mm) as specified in Part B requirements on the EPD IBU: PCR Automatic doors, automatic gates, and revolving door systems (door systems).

#### Declared unit and mass reference

Name	Value	Unit
Mass (without packaging)	816.14	kg
Mass packaging (paper wood, cooper and plastics)	210.91	kg
Declared unit	1	pce
Mass reference	816.14	kg/pce

### 3.2 System boundary

Type of the EPD: cradle to gate - with options  
The following life cycle stages were considered:

Production stage:

- A1 – Raw material extraction and processing
- A2 – Transport to the manufacturer and
- A3 – Manufacturing

Construction stage:

- A4 - Transport from the gate to the site
- A5 – Packaging waste processing

Use stage related to the operation of the building includes:  
B6 – Operational energy use

End-of-life stage:

- C1- Deconstruction/demolition at End-of-life stage
- C2 – Transport to waste processing,
- C3 – Waste processing for recycling and
- C4 – Disposal (landfill, waste for incineration).

This includes provision of all materials, products and energy, packaging processing and its transport, as well as waste processing up to the end-of-waste state or disposal of final residues.

Benefits and loads beyond the system boundaries: D –  
Declaration of all benefits and loads.

### 3.3 Estimates and assumptions

Transportation: Data on the mode of transport and distances, as reported by suppliers were used for those materials and parts contributing more than 2 % of the total product mass. In case of unknown transport distances for parts and materials, contributing less than 2 % to the total product mass, transport by road over an average distance of 500 km was assumed.

Use stage: For the use phase, it is assumed that the rapid roll door is used in the European Union, thus a European electricity grid mix is considered within this stage.

According to the most representative scenario, the operating hours of the product are accounted for 66.3 hours in on mode and finally 6053.7 hours in standby mode per year (255 days per year in use); the power consumption throughout the whole life cycle is 1313.85 kWh.

EoL: In the End-of-Life stage, for all the materials from the product which can be recycled (steel, aluminium, electronic parts, electro-mechanics, copper, stainless steel and brass), a recycling scenario with 100 % collection rate was assumed. The plastic components are sent for energy recovery within a waste incineration process.

EoL is assumed to happen within EU-28. Furthermore, a transport distance by truck of 100 km has been assumed in the model.

### 3.4 Cut-off criteria

In the assessment, all available data from the production process are considered, i.e. all raw materials used, auxiliary materials (e.g. lubricants), and electric power consumption - including material and energy flows contributing less than 1 % of mass or energy (if available). In case a specific flow contributing less than 1 % in mass or energy is not available, worst case assumption proxies are selected to represent the respective environmental impacts.

Impacts relating to the production of machines and facilities required during production are out of the scope of this assessment.

### 3.5 Background data

For life cycle modelling of the considered product, the GaBi 10 Software System for Life Cycle Engineering, developed by thinkstep AG, is used GaBi 10 2021a. The GaBi-database contains consistent and documented datasets which are documented in the online GaBi-documentation GaBi 10 2021b. To ensure comparability of results in the LCA, the basic data of GaBi database were used for energy, transportation and auxiliary materials.

### 3.6 Data quality

The requirements for data quality and background data correspond to the specifications of the IBU PCR Part A. Thinkstep performed a variety of tests and checks during the entire project to ensure a high quality of the completed project. This obviously includes an extensive review of project-specific LCA models as well as the background data used.

The technological background of the collected data reflects the physical reality of the declared products.  
The datasets are complete and conform to the system boundaries and the criteria for the exclusion of inputs and outputs.  
All relevant background datasets are taken from the GaBi 10 software database.

### 3.7 Period under review

The period under review is 2019 (12-month average).

### 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: Netherlands

### 3.9 Allocation

Regarding incineration, the software model for the waste incineration plant (WIP) is adapted according to the material composition and heating value of the combusted material. In

this EPD, the following specific life cycle inventories for the WIP are considered for:

- Waste incineration of paper
- Waste incineration of Plastic
- Waste incineration of Wood

Regarding the recycling material of metals, the metal parts in the EoL are declared as end-of-waste status. Thus, these materials are considered in module D. Specific information on allocation within the background data is given in the GaBi dataset documentation.

### 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. GaBi 10 2021b serves as background database for the calculation.

## 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	85.37	kg C

Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO<sub>2</sub>.

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

#### Transport to the building site (A4)

Name	Value	Unit
Kg of fuel diesel with maximum load (27t payload)	27.505	kg/100km
Transport distance truck (primary target market is EU 28)	842	km
Capacity utilization (incl.empty runs) of truck	61	%
Transport by ship	2	km

#### Installation into the building (A5)

Name	Value	Unit
Output substances following waste treatment on site (paper/cardboard packaging)	3.04	kg
Output substances following waste treatment on site (steel packaging)	17.850	kg
Output substances following waste treatment on site (wood packaging)	168.130	kg
Output substances following waste treatment on site (plastic packaging)	21.890	kg

#### Reference service life

Name	Value	Unit
Reference service life	17	a

#### Operational energy use (B6) and Operational water use (B7)

Name	Value	Unit
Electricity consumption per RSL (17 years, 255 days per year)	1313.85	kWh
Hours per day in on mode	0.26	h
Hours per day in stand-by mode	23.74	h
Hours per day in idle mode	0	h
Power consumption – on mode	70	W
Power consumption – stand-by mode	12	W
Power consumption – idle mode	0	W

For the remaining days (110 days) the power is being switched off.

Total energy consumed during the whole product life was calculated using following formula:

$$(W_{\text{active\_mode}} \cdot h_{\text{active\_mode}} + W_{\text{idle\_mode}} \cdot h_{\text{idle\_mode}} + W_{\text{stand\_by\_mode}} \cdot h_{\text{stand\_by\_mode}}) \cdot \text{Life\_span} \cdot \text{days\_year} \cdot 0.001$$

Where:

- $W_{\text{active\_mode}}$  - Energy consumption in active mode in W
- $h_{\text{active\_mode}}$  - Operation time in active mode in hours
- $W_{\text{idle\_mode}}$  - Energy consumption in idle mode in W
- $h_{\text{idle\_mode}}$  - Operation time in idle mode in hours
- $W_{\text{stand\_by\_mode}}$  - Energy consumption in stand-by mode in W
- $h_{\text{stand\_by\_mode}}$  - Operation time in stand-by mode in hours
- $\text{Life\_span}$  - Reference service life of product
- $\text{days\_year}$  - Operation days per year
- 0.001 - Conversion factor from Wh to kWh.

#### End of life (C1-C4)

Name	Value	Unit
Collected separately aluminium, steel, brass, plastics, stainless steel, copper, electronic, electromechanics etc.	816.140	kg
Incineration of plastic parts	79.75	kg
Incineration of paper	0.28	kg
Recycling aluminium, steel, copper, electronic, electro-mechanics, stainless steel and brass	733.71	kg
Landfill	2.40	kg

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

Name	Value	Unit
Collected separately waste type (including packaging)	1024.65	kg
Recycling aluminium	2.824	%
Recycling brass	0.009	%
Recycling copper	0.143	%
Recycling stainless steel	0.016	%
Recycling steel	66.813	%
Recycling electronic	0.098	%
Recycling electro mechanics	1.703	%
Incineration of plastic parts	7.783	%
Incineration of paper	0.027	%
Incineration of packaging (paper, wood and plastic) (from A5)	18.842	%
Recycling of steel packaging	1.742	%

## 5. LCA: Results

Results shown are calculated according to EN 15804+A2.

Note:

EP-freshwater: This indicator has been calculated as 'kg P eq' as required in the characterization model (EUTREND model, Struijs et al., 2009b, as implemented in ReCiPe; <http://eplca.jrc.ec.europa.eu/LCDN/developerEF.xhtml>).

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	X	X	MND	MND	MNR	MNR	MNR	X	MND	X	X	X	X	X

### RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 piece Dynaco R-741 Rigid high-performance door

Parameter	Unit	A1-A3	A4	A5	B6	C1	C2	C3	C4	D
GWP-total	kg CO <sub>2</sub> eq	2.29E+03	5.22E+01	3.21E+02	5.31E+02	0	6.19E+00	1.8E+02	-2.1E+02	-3.97E+03
GWP-fossil	kg CO <sub>2</sub> eq	2.55E+03	5.18E+01	6.63E+00	5.29E+02	0	6.15E+00	1.79E+02	-2.1E+02	-3.97E+03
GWP-biogenic	kg CO <sub>2</sub> eq	-2.67E+02	-8.86E-02	3.15E+02	1.76E+00	0	-1.05E-02	3.23E-01	-2.96E-02	2.24E+00
GWP-luluc	kg CO <sub>2</sub> eq	1.57E+00	4.2E-01	7.57E-04	7.66E-01	0	4.99E-02	-1.68E-02	-2.02E-02	-3.11E+00
ODP	kg CFC11 eq	1.08E-07	6.24E-15	6.28E-15	1.16E-11	0	7.41E-16	-3.03E-13	-2.34E-13	5.12E-11
AP	mol H <sup>+</sup> eq	7.18E+00	5.43E-02	3.68E-01	1.17E+00	0	6.32E-03	-1.01E-02	-1.43E-01	-4.71E+01
EP-freshwater	kg P eq	3.62E-03	1.58E-04	1.24E-06	1.41E-03	0	1.87E-05	-3.41E-05	-5.11E-05	-1.75E-03
EP-marine	kg N eq	1.48E+00	1.58E-02	9.07E-02	2.59E-01	0	1.84E-03	-9.57E-04	-6.85E-02	-4.69E+00
EP-terrestrial	mol N eq	1.6E+01	1.9E-01	1E+00	2.72E+00	0	2.22E-02	3.23E-02	-8.12E-01	-5.1E+01
POCP	kg NMVOC eq	5.24E+00	4.38E-02	2.95E-01	7.11E-01	0	5.12E-03	-1.73E-03	-1.76E-01	-1.5E+01
ADPE	kg Sb eq	3.08E+04	6.91E+02	9.22E+00	9.3E+03	0	8.21E+01	-2.11E+02	-1.94E+02	-3.92E+04
ADPF	MJ	3.11E-02	3.72E-06	1.02E-07	1.53E-04	0	4.42E-07	-3.9E-06	-2.52E-06	-2.07E+00
WDP	m <sup>3</sup> world eq deprived	2.12E+01	4.64E-01	1.15E+01	1.15E+02	0	5.51E-02	1.69E+01	-4.55E+01	-9.44E+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 piece Dynaco R-741 Rigid high-performance door

Parameter	Unit	A1-A3	A4	A5	B6	C1	C2	C3	C4	D
PERE	MJ	3.77E+03	0	3.35E+03	0	0	0	-1.12E+02	0	0
PERM	MJ	3.34E+03	0	-3.34E+03	0	0	0	0	0	0
PERT	MJ	7.11E+03	3.88E+01	1.61E+00	4.12E+03	0	4.61E+00	-1.12E+02	-5.32E+01	-4.03E+03
PENRE	MJ	2.66E+04	0	7.86E+02	0	0	0	3.34E+03	0	0
PENRM	MJ	4.33E+03	0	-7.77E+02	0	0	0	-3.55E+03	0	0
PENRT	MJ	3.09E+04	6.92E+02	9.23E+00	9.3E+03	0	8.22E+01	-2.12E+02	-1.93E+02	-3.93E+04
SM	kg	2.15E+02	0	0	0	0	0	0	0	0
RSF	MJ	5.47E-24	0	0	0	0	0	0	0	0
NRSF	MJ	6.43E-23	0	0	0	0	0	0	0	0
FW	m <sup>3</sup>	8.2E+00	4.5E-02	2.66E-01	4.77E+00	0	5.34E-03	3.37E-01	-1.08E+00	-2.24E+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 piece Dynaco R-741 Rigid high-performance door

Parameter	Unit	A1-A3	A4	A5	B6	C1	C2	C3	C4	D
HWD	kg	5.73E-05	3.22E-05	2.5E-08	3.85E-06	0	3.82E-06	1.39E-07	-9.57E-07	-9.24E-05
NHWD	kg	1.17E+02	1.06E-01	2.19E+00	6.6E+00	0	1.26E-02	1.87E+01	-4.73E+01	-4.98E+02
RWD	kg	6.6E-01	8.57E-04	2.95E-04	1.41E+00	0	1.02E-04	-4.05E-02	-7.75E-03	-5.15E-01



CRU	kg	0	0	0	0	0	0	0	0	0
MFR	kg	0	0	1.71E+02	0	0	0	7.38E+02	0	0
MER	kg	0	0	0	0	0	0	0	0	0
EEE	MJ	0	0	8.51E+02	0	0	0	4.34E+02	0	0
EET	MJ	0	0	1.21E+03	0	0	0	7.82E+02	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 piece Dynaco R-741 Rigid high-performance door

Parameter	Unit	A1-A3	A4	A5	B6	C1	C2	C3	C4	D
PM	Disease incidence	8.24E-05	3.35E-07	1.59E-06	9.79E-06	0	3.76E-08	6.03E-08	-1.6E-06	-4.08E-04
IR	kBq U235 eq	8.55E+01	1.24E-01	3.61E-02	2.32E+02	0	1.47E-02	-6.76E+00	-7.02E-01	-7.82E+01
ETP-fw	CTUe	1.08E+04	4.89E+02	9.57E+00	3.98E+03	0	5.8E+01	-6.81E+01	-8.78E+01	-1.66E+04
HTP-c	CTUh	2.76E-06	1.02E-08	2.19E-08	1.1E-07	0	1.22E-09	-4.45E-10	-1.23E-08	-3.09E-06
HTP-nc	CTUh	4.32E-05	5.28E-07	1.9E-06	4.05E-06	0	6.27E-08	1.93E-07	-8.01E-07	-8.83E-05
SQP	SQP	3.26E+04	2.42E+02	1.84E+00	2.96E+03	0	2.88E+01	-7.27E+01	-6.53E+01	-1.22E+04

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 1 – for the indicator 'Potential Human exposure efficiency relative to U235'.*

*This impact category deals mainly with the eventual impact of low dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.*

*Disclaimer 2 – for the indicators 'abiotic depletion potential for non-fossil resources', 'abiotic depletion potential for fossil resources', 'water (user) deprivation potential, deprivation-weighted water consumption', 'potential comparative toxic unit for ecosystems', 'potential comparative toxic unit for humans – cancerogenic', 'Potential comparative toxic unit for humans - not cancerogenic', 'potential soil quality index'.*

*The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator.*

This EPD was created using a software tool.

## 6. LCA: Interpretation

This chapter contains an interpretation of the Life Cycle Impact Assessment categories. Stated percentages in the whole interpretation are related to the overall life cycle, excluding credits (module D).

The production stage (modules A1-A3) contributes between 70.67 % and 85.66 % to the overall results for all the environmental impact assessment categories hereby considered, except for the abiotic depletion potential (ADPE), for which the contribution from the production stage accounts for approx. 76 % - this impact category describes the reduction of the global amount of non-renewable raw materials, therefore, as expected, it is mainly related to the extraction of raw materials (A1). The ozone depletion potential (ODP), for which the contribution from the production stage accounts for approx. 99.99 %.

Within the production stage, the main contribution for all the impact categories is the production of steel and aluminium

mainly due to the energy consumption of these processes. These two materials account for approx. 87% to the overall mass of the product, therefore, the impacts are in line with the mass composition of the product. The environmental impacts for the transport (A2) have a negligible impact within this stage.

To reflect the use stage (module B6), the energy consumption was included, and it has a major contribution for all the impact assessment categories considered - between 16.75 % and 27.66 %, with the exception of ODP (0.1%). This is a result of 0.26 hours of operation in on mode and 23.74 hours in stand-by mode per day and per 255 days in a year.

In the end-of-life stage, there are loads and benefits (module D, negative values) considered. The benefits are considered beyond the system boundaries and are declared for the recycling potential of the metals and for the credits from the incineration process (energy substitution).

## 7. Requisite evidence

Not applicable in this EPD.

## 8. References

Standards, norms, directives:

### CPR

Regulation (EU) No. 305/2011, Construction Product Regulation (CPR)- laying down harmonised conditions for the marketing of construction products and repealing Council Directive 89/106/EEC

### DIN EN ISO 10140-2

DIN EN ISO 10140-2:2010, Acoustics - Laboratory measurement of sound insulation of building elements - Part 2: Measurement of airborne sound insulation (ISO 10140-2:2010); German version EN ISO 10140-2:2010

### DIN EN ISO 13849-1

DIN EN ISO 13849-1:2016, Safety of machinery - Safety-related parts of control systems - Part 1: General principles for design

### DIN 4102

DIN 4102-1 B2:1998, Reaction to fire tests - Ignitability of building products subjected to direct impingement of flame.

### DIN EN 12424

DIN EN 12424:2000, Industrial, commercial and garage doors and gates - Resistance to wind load - Classification; German version EN 12424:2000

### DIN EN 12426

DIN EN 12424:2000, Industrial, commercial and garage doors and gates. Air permeability. Classification; German version EN 12424:2000

### DIN EN 12428

DIN EN 12428:2013, Industrial, commercial and garage doors - Thermal transmittance - Requirements for the calculation; German version EN 12428:2013

### DIN EN ISO 14025

DIN EN ISO 14025:2010, Environmental labels and declarations - Type III environmental declarations - Principles and procedures

### EN ISO 10140-2

EN ISO 10140-2:2010, Acoustics - Laboratory measurement of sound insulation of building elements - Part 2: Measurement of airborne sound insulation (ISO 10140-2:2010); German version EN ISO 10140-2:2010

### EN 12425

EN 12425:2000, Industrial, commercial and garage doors and gates - Resistance to water penetration - Classification; German version EN 12425:2000

### EN 12453

EN 12453:2017, Industrial, commercial and garage doors and gates – Safety in use of power operated doors – Requirements and test methods

### EN 13241-1

EN 13241:2003+A2:2016, Industrial, commercial, garage doors and gates - Product standard, performance characteristics

### EN 15804+A2

EN 15804:2014+A2:2020, Sustainability of construction works

— Environmental Product Declarations — Core rules for the product category of construction products

### EN 61000-6-2

EN 61000-6-2:2005, Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments

### EN 61000-6-3

EN 61000-6-3:2007: Electromagnetic compatibility (EMC) - Part 6-3: Generic Standards - Emission standard for residential, commercial and light-industrial environments

### EWC

European Waste Catalogue established by Commission Decision 2000/532/EC

### ISO 9001

ISO 9001:2015, Quality management systems - Requirements with guidance for use

Regulation (EU) No 305/2011

Regulation of the European parliament and the council laying down harmonised conditions for the marketing of construction products and repealing Council Directive 89/106/EEC

### 2006/42/EC

European directive on machinery, and amending Directive 95/16/EC (recast)

### 2011/65/EC

European directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment, and its amendment directives including 2015/863/EC (RoHS directive)

### 2012/19/EU

European directive on waste electrical and electronic equipment (WEEE)

### 2014/30/EU

European directive on the harmonisation of the laws of the Member States relating to electromagnetic compatibility (recast)

### 2015/863/EU

European directive amending Annex II to Directive 2011/65/EU of the European Parliament and of the Council as regards the list of restricted substances

Other sources:

### GaBi 10 2021a

GaBi 10 2021: Software-System and Database for Life Cycle Engineering. Copyright, TM. Stuttgart, thinkstep AG, Echterdingen, 1992-2018.

### GaBi 10 2021b

GaBi 10 2021b: Documentation of GaBi 8: Software-System and Database for Life Cycle Engineering. Copyright, TM. Stuttgart, thinkstep AG, Echterdingen, 1992-2021. <https://gabi.sphera.com/international-support-gabi>

### IBU PCR Part A:2019

Institut Bauen und Umwelt e.V., Königswinter (pub.): Product Category Rules for Construction Products from the range of Environmental Product Declarations of Institut Bauen und

Umwelt (IBU), Part A: Calculation Rules for the Life Cycle Assessment and Requirements on the Background Report.  
Version 1.8 April 2019  
[www.ibu-epd.de](http://www.ibu-epd.de)

**IBU PCR Part B: 2017**

IBU 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 Automatic doors, automatic gates and revolving door systems Version 1.6 (11. 2017) [www.ibu-epd.com](http://www.ibu-epd.com)

**IBU 2021**

General Instructions for the EPD programme of Institut Bauen und Umwelt e.V. Version 2.0, Berlin: Institut Bauen und Umwelt e.V., 2021.  
[www.ibu-epd.com](http://www.ibu-epd.com)

**TRACI Methodology**

Tool for the Reduction and Assessment of Chemical and Other Environmental Impacts (TRACI), EPA/600/R-12/554 2012  
The literature referred to in the Environmental Product Declaration must be listed in full. Standards already fully quoted in the EPD do not need to be listed here again.  
The current version of PCR Part A and PCR Part B of the PCR document on which they are based must be referenced.

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