

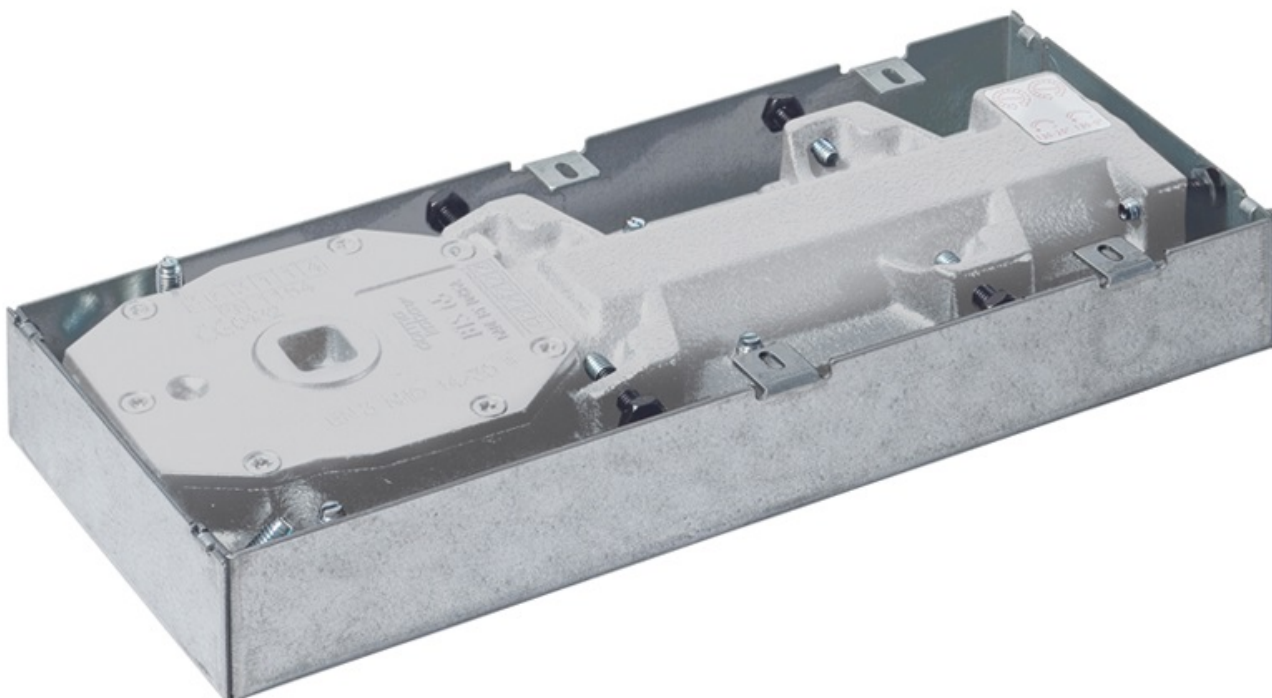
# ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	dormakaba International Holding GmbH
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-DOR-20220165-CBA1-EN
Issue date	30.06.2023
Valid to	29.06.2028

## Floor spring BTS 65 dormakaba

[www.ibu-epd.com](http://www.ibu-epd.com) | <https://epd-online.com>



## General Information

### dormakaba

#### Programme holder

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

#### Declaration number

EPD-DOR-20220165-CBA1-EN

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

Building Hardware products, 01.08.2021  
(PCR checked and approved by the SVR)

#### Issue date

30.06.2023

#### Valid to

29.06.2028



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



Dipl.-Ing. Hans Peters  
(Managing Director Institut Bauen und Umwelt e.V.)

### Floor spring BTS 65

#### Owner of the declaration

dormakaba International Holding GmbH  
DORMA Platz 1  
58256 Ennepetal  
Germany

#### Declared product / declared unit

1 piece of the product: Floor spring BTS 65, consisting of the following items:

- Floor spring
- Product packaging

#### Scope:

This Environmental Product Declaration refers to a specific floor spring manufactured by dormakaba. The production site is located in Suzhou (China).

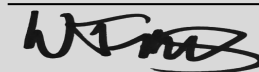
The data represents the year 2020.

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)

## Product

### Product description/Product definition

The economic floor spring specially designed for double action doors. The BTS 65 offers a particularly shallow design and thus all the advantages of a reduced installation depth. With two closing ranges and a choice of models, the BTS 65 can fulfil virtually any application requirement while providing all the reliability associated with assured quality.

For the use and application of the product the respective national provisions at the place of use apply. The standards which can be applied are the following:

- EN 1154
- EN 1634-1

### Application

The practical clamp fixing system of the BTS 65 ensures a secure and high-precision fit in the cement box for double action doors, with hydraulic fully controlled closing from approx. 130°.

### Technical Data

The door closers have following technical properties:

Technical Data		BTS 65	
		EN 3	EN 4
Spring strength	Size		
Standard and external doors <sup>1) 2)</sup>	≤ 950 mm	●	–
	≤ 1100 mm	–	●
Max. door weight in kg		100	100
Closing speed variable by valve adjustment		●	●
Backcheck		–	–
Delayed action		–	–
Hold-open point 90°		○	○
Weight in kg, approx.		4.0	4.0
Dimensions in mm	Length	276	276
	Width	108	108
	Height	40	40
Door closer tested to EN 1154		●	●
CE mark for building products (products with factory-fitted hold-open do not carry a CE mark)		●	●

● Yes – No ○ Option

Performance data of the product with respect to its characteristics in accordance with the relevant technical provision which can be applied are mentioned above.

### Base materials/Ancillary materials

Name	Value	Unit
Steel	89	%
Zinc	5	%
Lubricant	3	%
Paper	2	%
Aluminium	1	%

The product includes partial articles which contain substances listed in the Candidate List of REACH Regulation 1907/2006/EC (date: 17.01.2022) exceeding 0.1 percentage by mass: yes

- Lead (Pb): 7439-92-1 (CAS-No.) is included in some of the alloys used. The concentration of lead in each individual alloy does not exceed 4.0% (by mass).

The Candidate List can be found on the ECHA website address: <https://echa.europa.eu/de/home>.

### Reference service life

The reference service life of the BTS 65 floor spring amounts to 20 years and depends on the application and frequency of use. For repairs or renewals, suitable spare parts are available. The floor springs are certified to EN 1154, meaning they are designed to withstand a minimum of 500.000 cycles.

## LCA: Calculation rules

### Declared Unit

The declared unit is 1 piece of the product including the packaging: BTS 65.

Name	Value	Unit
Declared unit	1	piece/product
Mass of declared Product	4.1	kg

For IBU core EPDs (where clause 3.6 is part of the EPD): for average EPDs, an estimate of the robustness of the LCA values must be made, e.g. concerning the variability of the production process, geographical representativeness and the influence of background data and preliminary products compared to the environmental impacts caused by the actual

production.

### System boundary

The type of EPD is: cradle to gate with options, modules C1–C4, and module D (A1–A3 + C + D and additional modules: A4 + A5)

### Production - Module A1-A3

The product stage includes:

- A1, raw material extraction, processing and mechanical treatments, processing of secondary material input (e.g. recycling processes),
- A2, transport to the manufacturer,

— A3, manufacturing and assembly including provision of all materials, products and energy, as well as waste processing up to the end-of waste state.

**Construction stage - Modules A4-A5**

The construction process stage includes:

- A4, transport to the building site;
  - A5, installation into the building;
- including provision of all materials, products and energy, as well as waste processing up to the end-of waste state or disposal of final residues during the construction process stage.

**End-of-life stage– Modules C1-C4 and D**

The end-of-life stage includes:

- C1, de-construction, demolition;
- C2, transport to waste processing;
- C3, waste processing for reuse, recovery and/or recycling;
- C4, disposal;

including provision and all transport, provision of all materials, products and related energy and water use. Module D (Benefits and loads beyond the system boundary) includes:

- D, recycling potentials, expressed as net impacts and benefits.

**Geographic Representativeness**

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

**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**

**Characteristic product properties of biogenic carbon**

The biogenic carbon content quantifies the amount of biogenic carbon in a construction product leaving the factory gate, and it shall be separately declared for the product and for any accompanying packaging. If the total mass of biogenic carbon containing materials is less than 5 % of the total mass of the product and accompanying packaging, the declaration of biogenic carbon content may be omitted. The mass of packaging containing biogenic carbon shall always be declared.

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

**Information on describing the biogenic Carbon Content at factory gate**

Name	Value	Unit
Biogenic carbon content in accompanying packaging	0.03	kg C

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

Name	Value	Unit
Litres of fuel truck (per piece)	0.00276	l/100km
Transport distance via truck (for scaling)	100	km
Capacity utilisation (including empty runs) average	55	%
Transport distance via ship	10000	km

The product is transported via truck and ship. The main distribution regions are China, UAE and India. In order to allow

scaling to a specific point of installation, 100 km are declared.

**Installation into the building (A5)**

Name	Value	Unit
Output substances following waste treatment on site (packaging)	0.075	kg

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

C1: The product dismantling from the building is done manually without environmental burden.  
C2: Transport to waste treatment at end of life is 50 km.

Name	Value	Unit
Collected separately waste type	4.02	kg
Recycling	3.89	kg
Energy recovery	0.005	kg
Final disposal	0,13	kg

The product is disassembled in a recycling process. Material recycling is then assumed for the metals. The plastic components are assumed to be incinerated with energy recovery. Minor proportions of residues arising from the recycling process are landfilled. Region for the End of Life is: Global.

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

Name	Value	Unit
Recycling	100	%

Collection rate is 100%.

## LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; ND = 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	MND	MND	X	X	X	X	X

### RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 door closer

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO <sub>2</sub> eq	1.18E+01	1.7E-01	1.06E-01	0	1.76E-02	1.19E-02	1.98E-03	-4.01E+00
GWP-fossil	kg CO <sub>2</sub> eq	1.19E+01	1.68E-01	2.66E-03	0	1.68E-02	1.19E-02	1.97E-03	-4.01E+00
GWP-biogenic	kg CO <sub>2</sub> eq	-9.65E-02	1.76E-03	1.04E-01	0	7.76E-04	2.78E-07	6.72E-06	-7.03E-03
GWP-luluc	kg CO <sub>2</sub> eq	8.16E-03	3.58E-06	1.75E-06	0	4E-07	6.75E-07	5.66E-06	-3.72E-04
ODP	kg CFC11 eq	1.02E-12	1.63E-17	1.92E-17	0	1.77E-18	6.02E-18	7.29E-18	-1.08E-12
AP	mol H <sup>+</sup> eq	3.58E-02	4.97E-03	2.98E-05	0	1.68E-05	2.13E-06	1.41E-05	-1.09E-02
EP-freshwater	kg P eq	1.79E-05	3.75E-08	3.75E-09	0	3.59E-09	9.61E-10	3.38E-09	-3.94E-06
EP-marine	kg N eq	7.31E-03	1.31E-03	1.08E-05	0	5.35E-06	4.8E-07	3.63E-06	-1.81E-03
EP-terrestrial	mol N eq	7.88E-02	1.44E-02	1.34E-04	0	5.94E-05	9.69E-06	3.99E-05	-1.86E-02
POCP	kg NMVOC eq	2.29E-02	3.67E-03	2.85E-05	0	1.51E-05	1.33E-06	1.1E-05	-7.18E-03
ADPE	kg Sb eq	1E-03	4.47E-09	3.03E-10	0	5.03E-10	8.26E-11	1.77E-10	-3.46E-04
ADPF	MJ	1.34E+02	2.11E+00	3.36E-02	0	2.38E-01	5.54E-03	2.58E-02	-3.84E+01
WDP	m <sup>3</sup> world eq deprived	1.66E+00	3.08E-04	1.32E-02	0	3.29E-05	1.22E-03	2.06E-04	-3.89E-01

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 door closer

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PERE	MJ	2.54E+01	6.85E-03	9.06E-01	0	7.51E-04	1.41E-01	3.38E-03	-7.97E-01
PERM	MJ	1.04E+00	0	-9E-01	0	0	-1.39E-01	0	0
PERT	MJ	2.65E+01	6.85E-03	6.1E-03	0	7.51E-04	1.44E-03	3.38E-03	-7.97E-01
PENRE	MJ	1.34E+02	2.11E+00	3.36E-02	0	2.38E-01	1.25E-01	2.58E-02	-3.84E+01
PENRM	MJ	1.19E-01	0	0	0	0	-1.19E-01	0	0
PENRT	MJ	1.35E+02	2.11E+00	3.36E-02	0	2.38E-01	5.54E-03	2.58E-02	-3.84E+01
SM	kg	2.04E+00	0	0	0	0	0	0	0
RSF	MJ	0	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0	0
FW	m <sup>3</sup>	5.48E-02	1.24E-05	3.1E-04	0	1.35E-06	2.92E-05	6.51E-06	-1.19E-02

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 door closer

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
HWD	kg	1.5E-07	2.07E-10	4.95E-11	0	2.31E-11	2.11E-11	3.93E-10	-3.77E-06
NHWD	kg	3.18E-01	2.16E-04	3.33E-03	0	2.44E-05	1.24E-03	1.3E-01	3.13E-01
RWD	kg	4.67E-03	2.33E-06	1.76E-06	0	2.56E-07	2.06E-07	2.94E-07	-7.21E-04
CRU	kg	0	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	3.88E+00	0	0
MER	kg	0	0	0	0	0	0	0	0
EEE	MJ	0	0	1.61E-01	0	0	0	0	0
EET	MJ	0	0	2.92E-01	0	0	0	0	0

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

## RESULTS OF THE LCA – additional impact categories according to EN 15804+A2-optional: 1 door closer

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PM	Disease incidence	5.09E-07	8.45E-08	1.65E-10	0	8.83E-11	2.71E-11	1.75E-10	-1.57E-07
IR	kBq U235 eq	5.59E-01	3.35E-04	2.73E-04	0	3.65E-05	1.85E-05	3.02E-05	-4.34E-02
ETP-fw	CTUe	4.54E+01	1.49E+00	1.59E-02	0	1.69E-01	2.08E-03	1.47E-02	-4.94E+00
HTP-c	CTUh	9.1E-09	2.81E-11	8.43E-13	0	3.17E-12	1.8E-13	2.18E-12	3.76E-09
HTP-nc	CTUh	2.22E-07	1.3E-09	3.65E-11	0	1.36E-10	1.82E-11	2.41E-10	2.94E-07
SQP	SQP	3.47E+01	5.56E-03	8.9E-03	0	6.12E-04	1.66E-03	5.38E-03	1.54E-01

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 or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, 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 as there is limited experience with the indicator.

This EPD was created using a software tool.

## References

### EN 1154

EN 1154-2003;  
Building hardware - Controlled door closing devices - Requirements and test methods

### EN 1634-1

EN 1634-1:2018; Fire resistance and smoke control tests for door and shutter assemblies, openable windows and elements of building hardware - Part 1: Fire resistance test for door and shutter assemblies and openable windows

### EN 15804+A2

EN 15804:2019+A2 (in press), Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products

### REACH Regulation 1907/2006/EC

Regulation (EC) No 1907/2006 of the European Parliament and of the Council on the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH)

### Further References

#### 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)

#### GaBi

Sphera Solutions GmbH  
Gabi Software System and Database for Life Cycle Engineering 1992-2020  
Version 10.0.0.71  
University of Stuttgart  
Leinfelden-Echterdingen

#### GaBi ts documentation

GaBi life cycle  
inventory data documentation  
(<https://www.gabi-software.com/support/gabi/gabidatabase-2020-lci-documentation/>)

#### LCA-tool dormakaba

LCA-tool, IBU-DOR-202104-LT1-EN, 2021, developed by Sphera Solutions GmbH

#### PCR Part A

PCR – Part A: Calculation Rules for the Life Cycle Assessment and Requirements on the Project Report according to EN 15804+A2:2019, Version 1.0, 2020, Institut Bauen und Umwelt e.V., [www.ibu-epd.com](http://www.ibu-epd.com)

#### PCR Part B

PCR – Part B: Requirements on the EPD for Building Hardware product, version 1.2, Institut Bauen und Umwelt e.V., [www.ibu-epd.com](http://www.ibu-epd.com), 2017



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