

ENVIRONMENTAL PRODUCT DECLARATION

according to ISO 14025 and EN 15804

Declaration owner	Hydro Building Systems Germany GmbH
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-K.068-22-R2.7.5.2022.12.37.07 PM
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**K/068-22-R3; 8:
WICSTYLE 65 evo door 2p.open out
WICSTYLE 65**



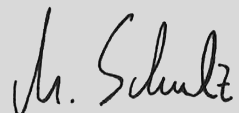
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WICONA[®]
TECHNIK FÜR IDEEN



1. General information

<p>Programme holder IBU - Institut Bauen und Umwelt e.V. Hegelplatz 1 10117 Berlin Deutschland</p>	<p>WICSTYLE 65</p> <p>Owner of the declaration Hydro Building Systems Germany GmbH Einsteinstrasse 61 89077 Ulm Deutschland</p>
<p>Declaration number EPD-K.068-22-R2.7.5.2022.12.37.07 PM-EN</p>	<p>Declared product/declared unit Door of the series WICSTYLE 65, with the dimensions (width x height) 1500 mm x 2200 mm.</p>
<p>This declaration is based on the product category rules: Windows and doors, 11.2017 (PCR tested and approved by the independent committee of experts)</p>	<p>Scope of application: This declaration is a company EPD and refers to the aluminium construction product described, which is manufactured using the profile system described in a given dimension and with standard glazing. The product declared is specified by the profile series, product name, product properties and view as shown in this EPD document. This EPD is based on software created by Hydro Building Systems Germany GmbH and provided to the creator via WICTOP. The data entry is performed by the creator responsible for the specifications described in this EPD and the manufacture of the door. The production location of the declared door is the location of the creator. The owner of the declaration is liable for the underlying information and proof, liability of IBU with regard to manufacturer information, LCA data and proof is excluded.</p>
<p>Date of issue 14/07/22</p>	<p>Verification The CEN standard /EN 15804/ serves as the core PCR Verification of the EPD by an independent third party according to /ISO 14025/ internal <input type="checkbox"/> external <input checked="" type="checkbox"/></p>
<p>Valid until 13.07.27</p>	<p> Prof. Dr.-Ing. Horst J. Bossenmayer (President of the Institut Bauen und Umwelt e.V.)</p>
<p> Hans Peters (Managing director IBU)</p>	<p> Matthias Schulz (Independent auditor appointed by the SVA)</p>

2. Product

2.1. Product description / product definition

Profile technology:

The aluminium door system of the WICSTYLE / WICSLIDE series is designed as an insulated multi-chamber composite system. The door system consists of construction depths from 50 mm to 85 mm and is characterised by the specification of the construction depth behind the series name WICSTYLE.

Frame connection by means of patented, mechanically secured and glued corner and butt joint technology ensures high component strength.

The surface treatment takes place optionally by means of anodizing, wet and powder coating.

Sealing concept:

Fitting, glazing and threshold stop seals are made of EPDM or EPDM foam and are used in the following variants:

- all round installation without impact in the corner area
- with formed corners, without gluing the joints

Fittings:

RAL tested doors with system matched fittings and door closing devices.

Available opening options are single and double leaf hinged doors, opening inwards and outwards, push-pull doors, finger protection doors, panic doors, all glass doors, doors with fixed and movable side parts, depending on function requirements and fitting application.

Heat protection:

The insulation area is constructed as a triple-chamber system. By means of continuous heat insulating strips made of fibre reinforced plastic
 U_d values up to 1.6 W/m²K depending on dimensions, glazing and panels used.

Infill thickness:

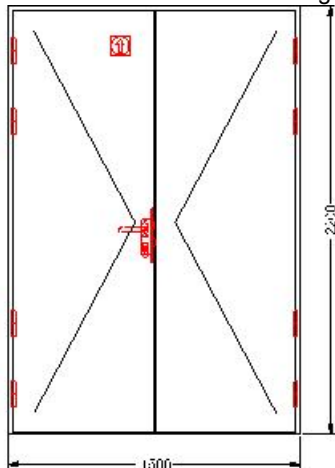
Infill thickness up to 60 mm

Burglar prevention:

Burglar prevention according to /DIN EN 1627/ up to RC3.

Bullet resistance:

Bullet resistance according to /DIN EN 1522/ up to FB4 S/FB4 NS and combinable burglar prevention.



Product: WICSTYLE 65

Opening type: npd

Area: 3.30 m²

Transparent area: 2.03 m²

Surface treatment: powder coating / anodized

For marketing in the EU/EFTA, /Regulation (EU) No 305/2011/. The product requires performance specifications taking into account the harmonised product standard /DIN EN 14351 -1/, window and external doors and the CE marking.

For use, the respective national regulations apply.

2.2. Application

The WICSTYLE door series is used as interior and exterior doors in residential and commercial buildings.

2.3. Technical data

Structural data

Designation	Value	Unit
Heat transfer coefficient glass according to /DIN EN 673/	1.10	W/(m ² K)
Total energy transmittance glass according to /DIN EN 410/	1.00	%
Heat transfer coefficient profile frame according to /DIN EN 10077-2/	2.10	W/(m ² K)
Heat transfer coefficient door according to /DIN EN 10077-1/	1.80	W/(m ² K)
Heat transfer coefficient panel according to /DIN EN 6946/	npd	W/(m ² K)
Joint permeability coefficient according to /DIN EN 1026/	-*)	m ³ /h
Driving rain proof according to /DIN EN 12208/	npd	Class
Sound insulation index against outside noise according to /DIN EN ISO10140/ and /DIN EN ISO717/	-*)	dB
Deflection due to wind loads according to /EN 12210/	npd	mm
Deflection due to vertical loads according to /EN 947/	-*)	mm
Fire resistance class for fire doors and windows according to /DIN	-*)	Class

EN 13501/		
Air permeability according to /DIN EN 12207/	npd	Class
Radiation properties according to /DIN EN 410/ Total energy transmittance g according /DIN EN 13363-1/ and /DIN EN 13363-2/	npd	%
Radiation properties according to /DIN EN 410/ Light transmission degree TI according /DIN EN 13363-1/ and /DIN EN 13363-2/	npd	%
Fittings type	-*)	-
Opening type	-*)	-
Sound insulation class (SSK1–SSK6)	-*)	Class
Sound reduction index, Rw (c, ctr)	-*)	dB
Burglar prevention class RC1 – RC4	-*)	Class

*) omitted, as not a mandated property according to product regulation /DIN EN 14351/.

Product according to /CPR with hEN/:

Performance values of the product according to the performance specifications with regard to its essential characteristics according to /DIN EN 14351-1/.

2.4. Delivery condition

All details about the present door series are order specific.

The balanced door element is delivered to the installation site ready for installation as described in chapter 2.1.

Number of pieces: 2 piece

Width: 1500 mm

Height: 2200 mm

2.5. Raw materials/auxiliary materials

The aluminium window considered consists of the following materials:

Designation	Value	Unit
Stainless steel screw	0.33	kg
EPDM foam	0.08	kg
Polyamid 66 GF	10.28	kg
Stainless steel	0.28	kg
Aluminium	0.01	kg
EPDM	4.76	kg
Polyamid 6	0.42	kg
Hardware components	13.46	kg
ABS	3.96	kg
CIRCAL 75	66.07	kg
Powder coating	1.63	kg
Glas, Float	177.51	kg
Anodizing	0.00	kg
REDUXA	1.56	kg
Total Weight	280.35	kg

The product/article/at least a partial product contains substances from the candidate list (15.01.2018) above 0.1 by mass-%: no.

The product/article/at least one partial product contains further CMR substances of category 1A or 1B

above 0.1 % by mass in at least one partial product which are not included in the candidate list: no

Biocidal products have been added to this construction product or it was treated with biocidal products (this is a treated product within the Biocidal Products Ordinance (EU) no. 528/2012): no

2.6. Manufacturing

The surface treatment of the extruded aluminium profiles takes place before the actual processing by anodizing or powder coating.

The extruded and thermally separated aluminium profiles are processed by sawing, milling, drilling and punching on corresponding semi or fully automatic machines. Scrap from processing (profile sections, chips) is collected sorted and recycled as secondary materials.

Subsequently, the profiles are fixed to frames.

The permanently elastic seals are matched to the respective receiving area in the aluminium profile and are removed automatically or by hand.

The fittings and other components are matched to the WICSTYLE and WICSLIDE product series. They are positively and/or frictionally connected to the profile system.

The glazing, panels or other fillings are used and secured depending on the overall construction (weight, dimensions, etc.) in the manufacturing of the metalwork shop or directly during assembly on the site.

2.7. Environment and health during production

Measures that go beyond national regulations for environmental protection and occupational safety are not required during the entire manufacturing process.

2.8. Product processing / installation

The bases for the processing and installation of the WICSTYLE and WICSLIDE product series are the currently applicable processing guidelines of Hydro Building Systems Germany GmbH and the notes detailed here. There are also recommendations for suitable aids contained therein.

In addition, standards and guidelines for the planning, execution and installation of windows and doors must be observed.

Particular attention is drawn to the /Guidelines for the design and installation of windows and entrance doors/ from RAL Gütegemeinschaft Fenster und Haustüren e.V. In this document explanations for training and the execution of the building connection are provided.

2.9. Packaging

The door elements are stacked on transport racks.

A proper securing of the elements is achieved by tie rods and straps. Elastic intermediate bearings between the individual elements prevent damage to the paintwork.

When transporting on an open loading surface, the transport unit can be wrapped with PE film to protect it from dirt and moisture.

PE foil, PE foam moulded parts, cardboard and spruce wood are used as packaging materials. These are taken to the regional waste sorting system or reused in the recycling process.

2.10. State of use

Doors of the WICSTYLE and WICSLIDE product range are installed in a thermally separated design as

a building closing component and are exposed to weather conditions.

As a thermally non-separate construction, the product can also be installed in the building interior.

Depending on the type of opening and the installed fitting or other attachments, the maintenance instructions of the hardware manufacturer must be observed.

Additional information can be found in the brochure /Maintenance and Operating Instructions/ from WICONA/Hydro Building Systems Germany GmbH.

Maintenance or care of the profile surface is not required.

2.11. Environment & health during use

The door element is stable in the wall opening to fasten or build in as a building closure.

According to research report /Emissions from building elements/, ift Rosenheim, there is no danger to the environment.

Under normal conditions of use and regular maintenance, there is no danger to the health of the user.

2.12. Reference service life

According to the /Sustainable Building Assessment System/ exterior doors comply with Code 334.211 with a service life of more than 50 years.

2.13. Exceptional influences

Fire

According to the /DIN EN 14351-1/ window and door product standard, doors are without properties regarding fire protection and smoke proofing.

If this product has properties, these are listed under chapter 2.3 Technical data.

A classification of the individual components according to /DIN EN 13501-1/ resulted in:

Fire protection

Designation	Value
Building material class	E
Burning dripping	d0
Smoke development	s1

Water

Due to the unforeseen effects of water no substances are released.

It is unlikely that there will be any impact on the environment.

Mechanical destruction

Mechanical destruction can cause sharp edges at the break points.

Negative impacts on the environment are not to be expected in case of unforeseen mechanical destruction.

2.14. End of life phase

The theoretical service life of the actual door frame exceeds the service life of, for example, the glazing or the permanently elastic seals. If individual components of the doors are renewed, the door frame can be used again according to the original purpose. This corresponds to a so-called "re-use" of the door frame.

The aluminium profiles are 100 % recyclable. Primary and secondary aluminium have identical product quality. Scrap from demolition, conversion or refurbishment can easily be separated and recycled (via the recycling industry). The process waste produced in the production and further processing of

the profile is completely recorded in the factory and processed into new input material in a recycling process in the re-melting plant. Press studs can be made with reused extruded profiles as the starting material.

2.15. Disposal

Aluminium

Due to its high value, aluminium scrap is not disposed of as a raw material but is recycled in an established cycle for reuse or recycling.

Old aluminium doors are collected regionally, shredded in shredders and cleaned of foreign bodies. Recycling companies separate metals and non-metallic materials with specially developed processes, so that aluminium is sorted and separated from fractions such as stainless steel, iron, other non-ferrous metals, plastics and other materials. Separation methods used today guarantee that aluminium scrap can be returned to foundries all over Europe after appropriate processing

Al-Mg-Si-0.5 press studs can be remelted and pressed into profiles in press shops.

/EAK/ 170402 Aluminium

Metals

Low and high alloy steels and other non-ferrous metals are separated from the aluminium fraction by separation during recycling and are recycled separately.

/EAK/ 170403 lead

/EAK/ 170404 zinc

/EAK/ 170405 iron and steel

/EAK/ 170406 tin

/EAK/ 170407 mixed metals

Flat glass

Production scrap of flat glass during the production is directly taken for local recycling. When dismantling or renovating the doors, the glazing is removed from the frame on location at the construction site and taken separately to the glass industry return system/collection circuit. Architectural glass is collected, separated from foreign substances, granulated and reused or deposited in raw materials.

/EAK/ 170202 Glass

Plastics/permanent elastic sealants

Plastics and sealants can be recycled materially or thermally.

/EAK/ 170203

Insulation materials

Insulating materials made of panels or attachments are not soiled and can be recycled. Soiled insulation materials are deposited on a construction material landfill. For details on the current take back and recycling recommendations refer to the insulation industry.

/EAK/ 170604

2.16. Further information

On the WICONA homepage you will find more information about the products.

www.wicona.de

3. LCA: Calculation rules

3.1. Declared unit

The declared unit is a door WICSTYLE 65 in specific dimensions 1500 mm x 2200 mm with a frame proportion of 38.25 %

Declared unit

Designation	Value	Unit
Declared unit door 1500 mm x 2200 mm	2	Piece
Conversion factor to 1kg	1/280.35	-
Conversion factor to the reference door 1.23 m x 2.18 m	4.06E-01	-

3.2. System limit

This EPD is an EPD of the cradle-to-gate type - with options.

The stage of production (module A1-A3 raw material supply, transport to the factory and production), the stage of construction of the structure (module A4 transport to the construction site), parts of the end of life cycle (modules C3 and C4 waste treatment and disposal) are taken into account. In addition, the credits and charges are considered outside the system limits (module D).

3.3. Estimates and assumptions

For the transport of the raw materials to the factory (module A2) a distance of 500 km is assumed.

The packaging materials are not considered in this study due to their minor influence on the results.

For the disposal of metals, material recycling (module D) is modelled (e.g. aluminium profiles). If necessary, a collection rate of 96% is taken into account. For the remainder, landfill is accepted (module C4).

Plastic parts are thermally recycled (module C3), whereby energy is gained. Credits from the substitution or saved expenses for electricity and steam are allocated to module D.

For glass, a sink is modelled. It can be assumed that recycling takes place. However, this is not included in the LCA, as no data are available.

3.4. Truncation rules

All materials that are included in the parts list from WICTOP are taken into account in the calculation of the life cycle assessment. Packaging is neglected due to different options and the minimal effect on the results.

3.5. Background data

All background data are taken from the databases of /GaBi ts Software/. The version underlying this EPD is stated at the end of the bibliographic references. The consistent records contained in the GaBi ts database are documented in the online /GaBi-Documentation/.

For some precursors existing EPDs are used, if available, which were created in accordance with the current standard /DIN EN 15804/.

3.6. Data quality

The last revision of the GaBi ts background data was performed in 2018.

The quality and representativeness of data from WICTOP can be considered high.

3.7. The period under consideration

This declaration was created on 14.07.2022.

3.8. Allocation

The life cycle assessment takes into account the recycling potential of the metal parts used. Of the metal scrap produced in the system from the production and end of life of the metal parts, the required amount of secondary aluminium for the production is first returned or saturated ("closed loop"), followed by the awarding of a credit for the remaining net scrap quantity.

Environmental impacts of combustion of plastic parts in the EoL scenario are attributed to module C3; resulting credits for thermal and electrical energy are declared in module D.

The credits are based on European average data for the environmental burden of the production of electrical energy and thermal energy from natural gas.

3.9. Comparability

In principle, a comparison or evaluation of EPD data is only possible if all records to be compared were compiled in accordance with /DIN EN 15804/ and the building context or product specific specifications are taken into account.

4. LCA: Scenarios and other technical information

The following technical information is the basis for 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 construction site (A4)

Designation	Value	Unit
Liters of fuel		
Train (electric)	0.01158	l / 100 km
Plane (kerosine)	0.42164	l / 100 km
40 t truck (Diesel)	0.00165	l / 100 km
7,5 t truck (Diesel)	0.00591	l / 100 km
22 t truck (Diesel)	0.00231	l / 100 km
Ship (heavy heating oil)	0.00040	l / 100 km
Transport distance		
Train	0.00	km
Plane	0.00	km
40 t truck	120.00	km
7,5 t truck	0.00	km
22 t truck	0.00	km
Ship	4300.00	km
Utilisation (including empty runs)		
Train	51	%
Plane	61	%
40 t truck	55	%
7,5 t truck	40	%
22 t truck	66	%
Ship	48	%
Volume utilisation factor	1	-

Reference useful life

Designation	Value	Unit
Reference service life	50	a

End of life (C1-C4)

Designation	Value	Unit
Separately collected waste type	212.72	kg
Collected as mixed construction waste	64.92	kg
For reuse	0.00	kg
For recycling (D)	254.23	kg
For energy recovery (C3)	21.77	kg
For landfilling (C4)	4.34	kg
For thermal utilisation (C4)	0.00	kg

5. LCA: Results

In the following, the results of the indicators of the impact assessment, resource use as well as waste and other output flows related to 2 piece door WICSTYLE 65 in specific dimension 1500 mm x 2200 mm are shown.

For the conversion to the unit declared see chapter 3.1

LCA results are based on the characterisation method CML

SPECIFICATION OF THE SYSTEM LIMITS (X = INCLUDED IN LIFE CYCLE ASSESSMENT, MND = MODULE NOT DECLARED)

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 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	MND	MND	MND	MND	MND	MND	MND	MND	MND	MND	X	X	X

RESULTS OF THE LIFE CYCLE ASSESSMENT ENVIRONMENTAL IMPACT:

WICSTYLE 65 1500 mm x 2200 mm

Parameter	Parameter	Unit	A1-A3	A4	C3	C4	D
GWP	Global warming potential	[kg CO ₂ -Eq.]	561.54	19.19	56.68	2.73E-03	-110.27
ODP	Depleting the stratospheric ozone layer	[kg CFC ₁₁ -Eq.]	8.84E-06	4.26E-13	6.57E-07	6.24E-16	-3.91E-06
AP	Acidification potential of soil and water	[kg SO ₂ -Eq.]	3.40	5.21E-01	7.93E-02	1.62E-05	-5.21E-01
EP	Eutrophication	[kg (PO ₄) ³ -Eq.]	3.18E-01	5.40E-02	1.82E-02	2.24E-06	-3.14E-02
POCP	Forming potential for tropospheric ozone	[kg Ethen-Eq.]	-7.56E-02	2.62E-02	3.80E-03	1.26E-06	-3.85E-02
ADPE	Potential for the abiotic degradation of non-fossil resources	[kg Sb-Eq.]	3.01E-02	6.09E-07	1.13E-04	1.05E-09	-2.44E-02
ADPF	Potential for the abiotic degradation of fossil fuels	[MJ]	8792.54	236.20	104.86	3.54E-02	-1211.78

RESULTS OF THE LIFE CYCLE ASSESSMENT RESOURCE ACCOUNT:

WICSTYLE 65 1500 mm x 2200 mm

Parameter	Parameter	Unit	A1-A3	A4	C3	C4	D
PERE	Renewable primary energy as an energy source	[MJ]	1202.60	2.07	11.70	0.00	-220.03
PERM	Renewable primary energy to the material use	[MJ]	0.00	0.00	0.00	0.00	0.00
PERT	Total renewable primary energy	[MJ]	1202.60	2.07	13.48	4.55E-03	-507.24
PENRE	Non-renewable primary energy as an energy source	[MJ]	7085.13	236.26	721.97	0.00	-548.70
PENRM	Non-renewable primary energy to the material use	[MJ]	602.04	0.00	-602.04	0.00	0.00
PENRT	Total non-renewable primary energy	[MJ]	7686.93	236.26	119.93	3.67E-02	-1530.65
SM	Use of secondary materials	[kg]	101.00	0.00	0.00	0.00	0.00
RSF	Renewable secondary fuels	[MJ]	0.00	0.00	0.00	0.00	0.00
NRSF	Non-renewable secondary fuels	[MJ]	0.00	0.00	0.00	0.00	0.00
FW	Use of freshwater resources	[m ³]	2.86	3.96E-03	1.55E-01	7.02E-06	-1.06

RESULTS OF LIFE CYCLE ASSESSMENT OUTPUT RIVERS AND WASTE CATEGORIES:

WICSTYLE 65 1500 mm x 2200 mm

Parameter	Parameter	Unit	A1-A3	A4	C3	C4	D
HWD	Hazardous waste for landfill	[kg]	1.07E-01	1.56E-06	4.17E-01	6.32E-10	4.70E-02
NHWD	Discarded non-hazardous waste	[kg]	103.23	3.51E-03	81.17	2.88	-29.66
RWD	Discarded radioactive waste	[kg]	1.76E-01	2.88E-04	9.43E-04	5.34E-07	-9.10E-02
CRU	Components for reuse	[kg]	0.00	0.00	0.00	0.00	0.00
MFR	Materials for recycling	[kg]	0.00	0.00	63.10	0.00	195.08
MER	Materials for the energy recovery	[kg]	0.00	0.00	1.83	0.00	0.00
EEE	Exported electrical energy	[MJ]	0.00	0.00	80.09	0.00	0.00
EET	Exported thermal energy	[MJ]	0.00	0.00	144.87	0.00	0.00

6. LCA: Interpretation

The LCA results in the production phase (modules A1-A3) are dominated by the materials used. The two main drivers are the material fractions of aluminium and glass. Other materials such as plastics or other metal components are less relevant in terms of mass as well as life cycle assessment. Transport (module A2) plays a significantly subordinate role compared to the materials used.

In Module C3, the costs of thermal utilisation of the plastics used are to be considered as a low contribution.

The recycling of aluminium is shown in Module D and includes both the costs of the remelting process and the credits for the expenses saved (substitution of primary aluminium). The credits are higher than the charges, which leads to negative LCA results in module D. The recycled aluminium, as well as the other metal parts used in the product, can be re-used in the next product system.

7. Proof

Proof regarding formaldehyde and MDI emissions, toxicity of the combustion gases, as well as the testing for pretreatment of the input materials (wood preservatives, heavy metals, etc.) are not relevant for the declared product, since no wood based materials are used.

The proof regarding VOC emissions is also classified as not relevant with reference to the final report/emissions from construction elements/, ift

Rosenheim and therefore is not declared. In the above mentioned independent study, representative metal components (e.g. metal windows) were tested for VOC emissions. The chamber test was terminated after 7 days due to a clear shortfall of the termination criteria, i.e. the decision criteria of the AgBB scheme were fulfilled.

8. Bibliographic references

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Candidate list from 15.01.2018

/Maintenance and operating Instructions/
Hydro Building Systems Germany GmbH

/CPR with hEN/
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/EAK/
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/DIN EN 673/

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/DIN EN 717/

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/DIN EN 10077-1/

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/DIN EN 12207/

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LCA-Indikatoren Liste Version 1.3
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