

# ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	<b>Abloy Oy</b>
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-ASA-20130276-IBC1-EN
Issue date	21.02.2014
Valid to	20.02.2020

Door Closer - DC 330  
**ABLOY**




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



Institut Bauen  
und Umwelt e.V.



## 1. General Information

ABLOY	Door Closer – DC 330
<b>Programme holder</b> IBU - Institut Bauen und Umwelt e.V. Panoramastr. 1 10178 Berlin Germany	<b>Owner of the Declaration</b> Abloy Oy Wahlforssinkatu 20, 80100 Joensuu, Finland
<b>Declaration number</b> EPD-ASA-20130276-IBC1-EN	<b>Declared product / Declared unit</b> The declaration represents 1 Cam-Motion door closer DC 330 series, consisting of the following items: <ul style="list-style-type: none"> <li>- A closer body</li> <li>- A guide rail</li> <li>- Accessories</li> </ul>
<b>This Declaration is based on the Product Category Rules:</b> Locks and fittings , 07-2012 (PCR tested and approved by the independent expert committee)	<b>Scope:</b> This declaration and its LCA study is relevant to Abloy DC330 series door closer. The primary manufacturing processes are made by external suppliers and the final manufacturing processes and assembly for all door closer components occur at our manufacturing factory in Joensuu, Finland. 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.
<b>Issue date</b> 21.02.2014	<b>Verification</b> The CEN Norm EN 15804 serves as the core PCR Independent verification of the declaration and data according to ISO 14025 <input type="checkbox"/> internally <input checked="" type="checkbox"/> externally
<b>Valid to</b> 20.02.2020 	
Prof. Dr.-Ing. Horst J. Bossenmayer (President of Institut Bauen und Umwelt e.V.) 	Dr.-Ing. Wolfram Trinius (Independent tester appointed by SVA)
Dr. Burkhard Lehmann (Managing Director IBU)	

## 2. Product

### 2.1 Product description

The DC330 Cam-Motion® door closer is CE-marked and characterized by

- Cam-Motion® technology, which reduces counter-pressure when opening the door, making it easier to operate
- Fulfillment of barrier-free building requirements /Equality Act & CEN/TR15894
- Cam-Motion® Door Closers are suitable for installation in all four mounting positions
- Cam-Motion® Door Closers help to save energy in all seasons, optimizing the thermal efficiency of the door opening
- Height-adjustable pinion connection between door closer and arm
- A uniform attractive design across the entire product range gives buildings style and aesthetic Appeal throughout the building
- Variable adjustable closing force

- Adjustable back-check which offers optimum protection for doors, walls and users to pass through the door
- Adjustable delayed closing which is important for situations where extended closing time is needed for passing through a door
- Integrated, concealed mounting plate available
- Height-adjustable guide rail Option, for ease of installation
- Thermodynamic valves for consistent performance across a wide temperature range
- Wide range of accessories

### 2.2 Application

The ABLOY Cam-Motion® overhead door closer DC330 is ideal for a wide range of applications – from private to commercial and public sectors both light and heavy:

- Fire & smoke protection and standard doors
- For interior and exterior doors

- All four alternative mounting positions enabled on single leaf doors as standard, to frame or door leaf on hinge or non-hinge side

### 2.3 Technical Data

The information in the table below represents the technical properties for DC 330.

Adjustable closing force	EN1-4
Door width up to	1100mm
Fire and smoke protection	yes
DIN door swing directions	Left/right handed
Closing speed	Variable between 170°-10°
Latching speed	Variable between 10°-0°
Backcheck	Variable above 70°
Opening angle, hinge side	ca. 170°
Opening angle non-hinge side	ca. 120°
Weight	2,7kg
Height	64mm
Depth	57mm
Length	270mm
Certified in compliance with	EN1154
CE marking for building products	yes

### 2.4 Placing on the market / Application rules

For the marketing in the EU/EFTA the Regulation (EU) No 305/2011 dated from 9 March 2011 applies. The products need a Declaration of Performance taking into consideration /EN 1154:1996/A1:2002/AC:2006 / – Building hardware -Controlled door closing devices/ and the CE-marking.

Abloy DC330 and relevant accessories are certified according to these standards.

For the application and use the respective national provisions apply.

### 2.5 Delivery status

Door closer units and guide rail arms are delivered ready for installation in separate packages.

The door closer unit including the packaging has the following dimensions: 330mm x 80mm x 73mm.

The guide rail arm has the following dimensions: 540mm x 35mm x 45mm.

### 2.6 Base materials / Ancillary materials

The average composition of Abloy DC330, including the guide rail arm and packaging is as follows:

Component	Percentage in mass (%)
Aluminum	40.3
Steel	48.3
Plastic	3.6
Oil	3.2
Other	4.4
<b>Total</b>	<b>100.0</b>

### 2.7 Manufacture

The primary manufacturing processes are made by Tier 1 suppliers and the final manufacturing processes for door closer units occur at the factory in Joensuu, Finland.

Manufacturing of the door closer unit consists of machining, die casting, component manufacturing (springs, bearings, O-rings). Final manufacturing process includes assembly, testing, painting, and packing of the door closer. Guide rail arms are processed in profile extruding, cutting, welding, painting and assembly phases.

The factory of Joensuu has certification of Quality Management system in accordance with /ISO 9001:2008/

### 2.8 Environment and health during manufacturing

Abloy Oy is committed to producing and distributing door opening solutions with minimal environmental impact, where health & safety is the primary focus for all employees and associates.

- Routinely monitoring our environmental operations, Green House Gas (GHG), energy, water, waste, Volatile Organic Compound (VOC), surface treatment and Health&Safety (H&S). Conduct periodic inspections, audits, and reviews to ensure that we meet applicable standards and to evaluate our Environment Management program effectiveness.
- Code of Conduct covers human rights, labor practices and decent work. Personnel are aware of their environmental roles and responsibilities, providing appropriate training, supporting accountability and recognizing outstanding performance.
- The factory of Joensuu has certification of Environmental Management to /ISO 14001:2004/ and Occupational Health and Safety to /OHSAS 18001:2007/.
- Any waste metals during machining are separated and recycled. The waste from the water-based painting process is delivered to waste treatment plant.

### 2.9 Product processing/Installation

Abloy DC330 door closers are distributed through and installed by trained installation technicians, such as locksmiths, carpenters etc. adhering to local/national standards and requirements.

Door and frame preparations are made in door manufacturer's production sites.

### 2.10 Packaging

Abloy DC330 door closers are packed in cardboard packaging. Packaging includes two paper sheets (installation instruction and drilling template) – all of which are fully recyclable.

80% of carton is made from recycled material  
100% of paper documents are made from recycled material

### 2.11 Condition of use

Annual inspection is recommended in order to guarantee correct functionality of the product and the door leaf. The inspection includes: checking, fixing screws to ensure they are properly tight, correct adjustments (closing speeds, force), compliance with local legal inspection standards and greasing all the moving parts of the arm.

## 2.12 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.

## 2.13 Reference service life

Door closer units are normally installed by trained technicians. In any case the installation must be done in line with instructions provided by the manufacturer. Abloy DC330 was developed to comply with EN1154 standard and quality requirements. The typical life time of a DC330 is 15-20 years, dependent on frequency of cycles.

## 2.14 Extraordinary effects

### Fire

Abloy DC330 is tested for usage in fire and smoke protection doors according to /EN1634-1/.

### Water

Door closers include hydraulic oil and are designed for traditional locations and are not intended for flood protection. Unforeseeable flooding conditions will increase the potential for developing surface rust.

### Mechanical destruction

No impact on human health and environment is known or expected. Especially no hazardous substance can be anticipated in case of a mechanical destruction.

## 2.15 Re-use phase

It is possible to re-use the product during the reference service life and be moved from one door to another. The major materials, by weight, are aluminium alloy

and steel, which can both be recycled. The plastic components can be used for energy recovery within a waste incineration process.

## 2.16 Disposal

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

### Manufacturing:

/EWC 12 01 01/ Ferrous metal filings and turnings  
/EWC 12 01 03/ Non-ferrous metal filings and turnings

### Packaging:

All materials incurred during Installation on their end-of-life are directed to a recycling unit.  
/EWC 15 01 01/ paper and cardboard packaging  
/EWC 15 01 02/ plastic packaging

### End of life:

All materials on their end-of-life can be directed to a recycling unit.  
/EWC 16 02 14/ discarded Equipment other than those mentioned in 16 02 09 to 16 02 13.  
/EWC 16 02 16/ components removed from discarded equipment other than those mentioned in 16 02 15.  
/EWC 17 04 01/ copper, bronze, brass  
/EWC 17 04 02/ aluminium  
/EWC 17 04 05/ iron and steel.

## 2.17 Further information

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# 3. LCA: Calculation rules

## 3.1 Declared Unit

The declaration refers to the functional unit of 1 piece of door closer 300 (including packaging) as specified in Part B requirements on the EPD for Doors, windows, shutters, and related products/IBU PCR Part B/.

### Declared unit

Name	Value	Unit
Declared unit	1	piece
Mass (total system)	2.99	kg/piece
Conversion factor to 1 kg	0.33	

## 3.2 System boundary

Type of the EPD: cradle-to-gate - with options  
The following life cycle phases were considered for Door Closer:

### Production phase:

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

### Construction phase:

- A5 – Packaging waste processing

### End-of-life phase:

- C2 – Transport to waste processing
- C4 – Disposal (landfill)

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.

- D - Declaration of all benefits or recycling potential from EOL and A5

## 3.3 Estimates and assumptions

### Transport:

Real-world data on mode of transport and distances, as reported by suppliers, have been considered for parts and materials contributing more than 2% tot the total product mass. For parts and materials contributing less than 2% to the total product mass, transport by road over an average distance of 500km has been assumed.

### EOL:

In the End-of-Life phase a recycling scenario with 100% collection rate was assumed.

### 3.4 Cut-off criteria

In the assessment, all available data from production process were considered, i.e. all raw materials used, auxiliary materials (e.g. lubricants), thermal energy consumption and electric power consumption - including material and energy flows contributing less than 1% of mass or energy (if available).

For raw materials, contributing more than 2% to the total product mass, means of transportation and distances were modeled in more detail to better reflect reality; for materials or product parts, contributing less than 2% of total product mass, average distances and traditional means of transport were assumed. Average distance assumptions were based on following thoughts:

- within one country – max. transport distance of 500 km;
- between two countries/regions – average distance between these countries/regions.
- Several supplier countries – weighted average distances.

The overall contribution from these assumptions does not exceed 5% to the impact categories under consideration. 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 modeling of the considered products, the /GaBi 6/ Software System for Life Cycle Engineering, developed by PE INTERNATIONAL AG, is used /GaBi 6 2013/. The GaBi-database contains consistent and documented datasets which are documented in the online

GaBi-documentation /GaBi 6 2013D/.

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/.

PE INTERNATIONAL performed a variety of tests and checks during the entire project to ensure 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 6/ software database. The last revision of the used background data has taken place not longer than 10 years ago.

### 3.7 Period under review

The period under review is 2012/13 (12 month average).

### 3.8 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 plastic from packaging
- Waste incineration of paper from packaging

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 each background dataset is available in the corresponding GaBi dataset documentation.

### 3.9 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.

## 4. LCA: Scenarios and additional technical information

In the EPD scenarios and/or technical information for modules A5, C1-C4 and D are given.

#### Installation into the building (A5)

Name	Value	Unit
Output substances following waste treatment on site packaging (paper)	0.3	kg

#### Reference service life

Name	Value	Unit
Reference service life	15	a

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

Name	Value	Unit
Water consumption	0	m <sup>3</sup>
Electricity consumption	0	kWh

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

Name	Value	Unit
Collected separately aluminium, brass, stainless steel, steel	2.9	kg

Collected as mixed construction waste	0.09	kg
construction waste for landfilling		
Recycling steel, stainless steel, aluminium	2.6	kg
Landfilling construction waste	0.09	kg

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

Name	Value	Unit
Collected separately waste type Door closer (including packaging)	2.99	kg
Recycling secondary aluminium	43	%
Recycling brass	1	%
Recycling steel	43	%
Reuse paper packaging (from A5)	6	%
Reuse plastic packaging (from A5)	4	%
Construction waste going to landfill	3	%



## 5. LCA: Results

The Table below shows the LCA results for the declared unit - 1 piece of door closer DC 330 Abloy.

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 BOUNDARIES
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement <sup>1)</sup>	Refurbishment <sup>1)</sup>	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	MND	X	MND	MND	MNR	MNR	MNR	MND	MND	MND	X	MND	X	X

### RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 piece of door closer DC 330 Abloy

Parameter	Unit	A1-A3	A5	C2	C4	D
Global warming potential	[kg CO <sub>2</sub> -Eq.]	1.49E+1	2.58E-1	7.08E-2	3.05E-1	-3.30E+0
Depletion potential of the stratospheric ozone layer	[kg CFC11-Eq.]	3.49E-9	7.06E-12	1.24E-12	4.99E-12	-3.08E-10
Acidification potential of land and water	[kg SO <sub>2</sub> -Eq.]	8.43E-2	6.65E-5	3.21E-4	7.81E-5	-1.59E-2
Eutrophication potential	[kg (PO <sub>4</sub> ) <sup>3-</sup> -Eq.]	6.58E-3	1.09E-5	7.41E-5	6.46E-6	-1.10E-3
Formation potential of tropospheric ozone photochemical oxidants	[kg Ethen Eq.]	5.69E-3	6.72E-6	-1.05E-4	5.45E-6	-1.42E-3
Abiotic depletion potential for non fossil resources	[kg Sb Eq.]	1.01E-3	5.71E-9	2.64E-9	4.35E-8	-1.93E-4
Abiotic depletion potential for fossil resources	[MJ]	1.67E+2	1.69E-1	9.79E-1	1.53E-1	-3.46E+1

### RESULTS OF THE LCA - RESOURCE USE: 1 piece of door closer DC 330 Abloy

Parameter	Unit	A1-A3	A5	C2	C4	D
Renewable primary energy as energy carrier	[MJ]	5.77E+1	IND	IND	IND	IND
Renewable primary energy resources as material utilization	[MJ]	0.00E+0	IND	IND	IND	IND
Total use of renewable primary energy resources	[MJ]	5.77E+1	1.05E-2	3.85E-2	1.44E-2	-7.45E+0
Non renewable primary energy as energy carrier	[MJ]	1.88E+2	IND	IND	IND	IND
Non renewable primary energy as material utilization	[MJ]	0.00E+0	IND	IND	IND	IND
Total use of non renewable primary energy resources	[MJ]	1.88E+2	1.87E-1	9.82E-1	1.72E-1	-3.69E+1
Use of secondary material	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	IND
Use of renewable secondary fuels	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of non renewable secondary fuels	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
Use of net fresh water	[m <sup>3</sup> ]	1.31E+2	7.58E-1	4.27E-2	7.20E-1	-1.87E+1

### RESULTS OF THE LCA – OUTPUT FLOWS AND WASTE CATEGORIES: 1 piece of door closer DC 330 Abloy

Parameter	Unit	A1-A3	A5	C2	C4	D
Hazardous waste disposed	[kg]	5.88E-3	3.31E-3	0.00E+0	3.04E-2	-6.16E-4
Non hazardous waste disposed	[kg]	3.05E+0	2.62E-3	1.27E-4	5.92E-2	-3.74E-1
Radioactive waste disposed	[kg]	8.67E-3	7.68E-6	1.37E-6	7.97E-6	-9.32E-4
Components for re-use	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	IND
Materials for recycling	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	IND
Materials for energy recovery	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	IND
Exported electrical energy	[MJ]	0.00E+0	8.92E-1	0.00E+0	0.00E+0	IND
Exported thermal energy	[MJ]	0.00E+0	2.48E+0	0.00E+0	0.00E+0	IND

## 6. LCA: Interpretation

This chapter contains an interpretation of the Life Cycle Impact Assessment categories. When expressed as a percentage, the impact refers to its magnitude expressed as a percentage of total product impact across all modules, with the exception of module D.

Production phase (module A1-A3) contributes between 96 and 100% to total impact assessment. This stage is dominated by upstream emissions associated with

steel- and secondary aluminium making processes. The environmental impacts for the transport (A2) have a negligible impact within this stage.

In module D the benefits (negative values) and loads beyond the system boundary are declared for the recycling potential of the metals and for the credits from the incineration process (energy substitution) within A5.

## 7. Requisite evidence

Not applicable in this EPD.

## 8. References

### **Institut Bauen und Umwelt**

Institut Bauen und Umwelt e.V., Berlin (pub.):  
Generation of Environmental Product Declarations  
(EPDs);

### **General principles**

for the EPD range of Institut Bauen und Umwelt e.V.  
(IBU), 2013-04  
[www.bau-umwelt.de](http://www.bau-umwelt.de)

### **PCR Part A**

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. April 2013  
[www.bau-umwelt.de](http://www.bau-umwelt.de)

### **ISO 14025**

DIN EN ISO 14025:2011-10: Environmental labels and  
declarations — Type III environmental declarations —  
Principles and procedures

### **EN 15804**

EN 15804:2012-04: Sustainability of construction  
works — Environmental Product Declarations — Core  
rules for the product category of construction products

### **DIN EN 1154**

EN 1154:1996/A1:2002/AC:2006 Building hardware -  
Controlled door closing devices - Requirements and  
test methods EN 1154:1996/A1:2002/AC:2006  
Building hardware - Controlled door closing devices -  
Requirements and test methods

### **OHSAS 18001**

Arbeits- und Gesundheitsschutz-Managementsysteme  
- Leitfaden für die Implementierung von OHSAS 18001

### **DIN EN ISO 14001**

Environmental management systems - Requirements  
with guidance for use (ISO 14001:2004 + Cor. 1:2009)

### **CEN/TR 15894:2009**

Building hardware - Door fittings for use by children,  
elderly and disabled people in domestic and public  
buildings - A guide for specifiers; German version  
CEN/TR 15894:2009

### **ISO 9001:2008**

Quality management systems - Requirements (ISO  
9001:2008).

### **DIN EN 1634-1:2012-07**

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;  
German version FprEN 1634-1:2012

### **GABI 6 2013**

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

### **GaBi 6 2013D**

GaBi 6 2013D: GaBi 6: Documentation of GaBi 6:  
Software-System and Database for Life Cycle  
Engineering. Copyright, TM. Stuttgart, Leinfelden-  
Echterdingen, 1992-2013. <http://documentation.gabi-software.com/>

### **IBU PCR Part B**

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 Locks and fittings.  
[www.bau-umwelt.com](http://www.bau-umwelt.com)



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