

# ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

|                          |                                      |
|--------------------------|--------------------------------------|
| Owner of the Declaration | ASSA ABLOY Entrance Systems AB       |
| Publisher                | Institut Bauen und Umwelt e.V. (IBU) |
| Programme holder         | Institut Bauen und Umwelt e.V. (IBU) |
| Declaration number       | EPD-ASA-20260438-IBA1-EN             |
| Issue date               | 28.05.2026                           |
| Valid to                 | 29.01.2031                           |

## ASSA ABLOY HS7080 High-Performance Door ASSA ABLOY Entrance Systems AB

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1. General Information

ASSA ABLOY Entrance Systems AB

Programme holder

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

Declaration number

EPD-ASA-20260438-IBA1-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

28.05.2026

Valid to

29.01.2031



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



Dr. Martina Bender  
(Managing Director Institut Bauen und Umwelt e.V.)

ASSA ABLOY HS7080 High-Performance Door

Owner of the declaration

ASSA ABLOY Entrance Systems AB  
Lodjursgatan 10  
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Sweden

Declared product / declared unit

This declaration represents 1 High-Speed Roll-Up door ASSA ABLOY HS7080 High-Performance Door with electrical operation, 3600mm width and 3600 mm height, consisting of a galvanized steel structure and a roll-up curtain in PVC coated polyester textile.

Scope:

This declaration and its LCA study are relevant to the ASSA ABLOY HS7080 High-Performance Door. The production location is Moorsel, Belgium, and components are sourced from international tier one suppliers.

ASSA ABLOY HS7080 High-Performance Door size will vary according to project requirements; a standard door of 3600 mm width and 3600 mm height 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

**Product name:** ASSA ABLOY HS7080 High-Performance Door

Improve operational efficiency with the ASSA ABLOY HS7080 High-Performance Door, a high-speed roll-up door designed for industrial environments. Built with advanced gravity technology, this door features a self-reinserting flexible curtain and requires minimal maintenance, ensuring seamless operations.

Ideal for industrial and logistics settings, it facilitates the smooth flow of goods, materials, and personnel.

Committed to simplicity and excellence, the ASSA ABLOY HS7080 High-Performance Door prioritizes energy efficiency. It offers a strong seal against moderate winds, reducing energy costs and maintaining a comfortable working environment by keeping drafts, humidity, dust, and dirt out. Discover the durability, efficiency and user-friendly design of the ASSA ABLOY HS7080; the perfect solution for your exterior door needs.

Features that make the door safe are a soft bottom profile, a Level E light curtain and automatic release of the curtain from side guides if crashed into.

The curtain reintroduces itself after a crash to reduce downtime and maintenance.

Safe for personnel and equipment: the flexible curtain without any rigid elements avoids injuries and damage.

The door has 3 primary parts:

1. Top roll with door curtain
2. Side frames
3. Control system with drive system

The ASSA ABLOY HS7080 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 European Union/European Free Trade Association (EU/EFTA) (excluding 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.

**Harmonized European standards and associated updated editions, which have been applied:**

*EN 13241:2003+A2:2016*

Industrial, commercial, garage doors and gates - Product standard, performance characteristics

*EN 12604:2017+A1:2020*

Industrial, commercial, and garage doors and gates - Mechanical aspects - Requirements and test methods

*EN 12453:2017+A1:2022*

Industrial, commercial, and garage doors and gates - Safety in

use of power operated doors - Requirements and test methods

*EN 12978:2003+A1:2009*

Industrial, commercial, and garage doors and gates - Safety devices for power operated doors and gates - Requirements and test methods

*EN 61000-6-2: 2019*

Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity standard for industrial environments

*EN 61000-6-3: 2021*

Electromagnetic compatibility (EMC) - Part 6-3: Generic standards - Emission standard for equipment in residential environments

*EN 60335-*

*1:2012+A11:2014+A13:2017+A14:2019+A15:2021+A1:2019+A2:2019*  
Household and similar electrical appliances - Safety - Part 1: General requirements

*EN 60335-2-103: 2015*

Household and similar electrical appliances - Safety - Part 2-103: Particular requirements for drives for gates, doors, and windows

Disposal of the product is subject to the Waste from Electrical and Electronic Equipment (WEEE) Directive within Europe, *Directive 2012/19/EU*

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

*2006/42/EC* Machinery Directive (MD)

*2014/30/EU* Electromagnetic Compatibility Directive (EMCD)

*2014/35/EU* Low Voltage Directive (LVD)

*2011/65/EU* Restriction of Hazardous Substances (RoHS)

*2015/863/EU* Restriction of Hazardous Substances (RoHS)

*UKSI 2008 No.1597* Supply of Machinery (Safety) Regulations 2008

*UKSI 2016 No.1091* Electromagnetic Compatibility Regulations 2016

*UKSI 2012 No.3032* The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment  
*UKSI 2016 No.1101* Electrical Equipment (Safety) Regulations 2016

Regulations 2012 (RoHS)

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

### 2.2 Application

The ASSA ABLOY HS7080 High-Performance Door is an ideal high-speed door suited for industrial and logistic activities. Its fast operating speed enables smooth traffic of goods, materials and personnel. The good wind load resistance makes the ASSA ABLOY HS7080 High-Performance Door the perfect solution for your exterior door needs.

## 2.3 Technical Data

The technical properties of the ASSA ABLOY HS7080 High-Performance Door are as follows:

- Max size (W x H): 4500 x 4500 [mm]
- Structure: Galvanised Steel
- Material sidepost covers and top roll covers: Galvanised Steel
- Material curtain: Technical textile 900 gr/m², Polyester fibers with PVC coating
- Thickness curtain: 0.8 [mm]
- Optional: fire retardant curtain (B-S2-d0)
- Optional: Windows PVC Window or PVC Mesh
- Safety devices: Light Curtain type E and Soft bottom edge
- Motor Power: 1.5 [kW]
- Electrical operation: Controller 52E with frequency inverter and numeric display
- Optional: DCC Frequency converter control system
- Opening/ closing speed: Opening: max 1.2 [m/s]  
Closing: 0.8 [m/s]
- Power input "Operation": 352 [W]
- Power input "Standby": 10 [W]

Detailed information on specifications, options and accessories is available on [www.assaabloyentrance.com](http://www.assaabloyentrance.com).

## Performance according EN13241-1 standards

### Constructional data ASSA ABLOY HS7080 High Performance Door

| Name                                              | Value          | Unit   |
|---------------------------------------------------|----------------|--------|
| Water permeability acc. to EN 12425, EN 12489     | PND            |        |
| Wind Load acc. to EN 12424, EN 12444              | Up to Class 4* |        |
| Air permeability acc. to EN 12426, EN 12427       | PND            |        |
| Safe openings acc. to EN 12453, EN 12445          | Pass           |        |
| Mechanical resistance acc. to EN 12604, EN 12605L | Pass           |        |
| Unintended movements acc. to EN 12604, EN 12605   | Pass           |        |
| Curtain thermal transmittance acc. to EN 12428    | 6.02           | W/m²K  |
| Durability acc. to EN 12604, EN 12605             | 1.000.000      | cycles |

\* size dependent

## 2.4 Delivery status

ASSA ABLOY HS7080 High-Performance Door units are delivered in pre-assembled parts ready for installation.

## 2.5 Base materials/Ancillary materials

The average composition for ASSA ABLOY HS7080 High-Performance Door is as following:

| Name              | Value | Unit |
|-------------------|-------|------|
| Aluminium         | 2.84  | %    |
| Brass             | 0.02  | %    |
| Copper            | 0.02  | %    |
| Stainless steel   | 0.02  | %    |
| Steel             | 74.75 | %    |
| Zinc              | 0.02  | %    |
| Electronic        | 0.81  | %    |
| Electro_mechanics | 7.05  | %    |
| Others            | 0.05  | %    |
| Plastics          | 14.42 | %    |
| Total             | 100.0 | %    |

## 2.6 Manufacture

The final manufacturing processes occur at the factory in Moorsel, Belgium. The factory has environmental management systems certified according to ISO 14001.

Doors are made-to-measure for customer orders. For the side structure, metal and plastic profiles are cut to length and assembled together with stud welding and fasteners.

The rolling drum is made by cutting a tube profile to length and fitting it with a motor and axles. The header structure is assembled around the rolling drum.

The curtain material is cut to size and panels are joined together with hot air welding. Some smaller parts are attached with glue. The curtain is rolled into the header structure and the door, with all covers and accessories, is packed onto a pallet and covered with a sturdy cardboard/wood fiberboard structure.

Offcuts, scraps and waste packaging material generated during the manufacturing process are separated for recycling.

Industrial Waste is sent for disposal and recycling. Waste codes according to the European Waste Catalogue and Hazardous Waste List - Valid from 1 July 2015.

EWC 15 01 01 Paper and cardboard packaging  
EWC 15 01 02 Plastic packaging  
EWC 15 01 03 Wooden packaging  
EWC 17 02 01 Wood  
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 EWC 17 04 10

## 2.7 Environment and health during manufacturing

ASSA ABLOY Entrance Systems is committed to producing and distributing door opening solutions with minimal environmental impact, where health & safety are the primary focus for all employees and associates.

Environmental operations, Greenhouse gases, energy, water, waste, 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 ASSA ABLOY Entrance Systems is aware of their roles and responsibilities, providing appropriate training, supporting accountability and recognizing outstanding performance.

Any waste metals, plastics and packaging materials generated during manufacturing are separated and recycled.

## 2.8 Product processing/Installation

The ASSA ABLOY HS7080 High-Performance Door is shipped to site in pre-assembled components (header with top roll with door curtain, side frames and control unit). The components are assembled using simple tools, including drills and hand tools. The installation is performed by trained and qualified installation technicians.

## 2.9 Packaging

Packaging exists for the purpose of protection during transportation. ASSA ABLOY HS7080 High-Performance Door components are packaged on wooden pallets with wood particleboards and corrugated cardboard. All of these packaging components are standard industry types. The cardboard and wood are recyclable.

Packaging composition is following [percentage in mass]:

- Paper: 16.9%
- Wood 83.1%
- **Total 100.0%**

All materials incurred during installation can be collected for recycling.

Waste codes according to the *European Waste Catalogue and Hazardous Waste List* - Valid from 1 July 2015.

*EW C 15 01 01* Paper and cardboard packaging  
*EW C 15 01 03* Wooden packaging

## 2.10 Condition of use

Regular inspections by a trained and qualified person are recommended with a minimum of one visit per every six months or 50.000 cycles.

Examinations on a 3-months period by the user of the high performance door:

1. Clean the door leaf with a soft clean brush and mild detergent
2. If damage is found, contact the local service center 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 10 years standard daily use with the recommended maintenance and service program.  
For this EPD a lifetime of 10 years was considered.

## 2.13 Extraordinary effects

### Fire

#### Standard curtain material:

Burning behavior < 100 mm/min according to *ISO 3795 1989*

**Option Fire retardant curtain:** B-S2-d0 according to *EN 13501-1*

### 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, copper, zinc, electronics, electro-mechanics, stainless steel, steel, and aluminium).

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

Waste codes according to the *European Waste Catalogue and Hazardous Waste List* - Valid from 1 July 2015.

*EW C 16 02 14* Used devices with the exception of those outlined in *EW C 16 02 09* to *EW C 16 02 13*

*EW C 17 02 03* Plastic

*EW C 17 04 01* Copper, bronze, brass

*EW C 17 04 02* Aluminium

*EW C 17 04 05* Iron and steel

*EW C 17 04 11* Cables with the exception of those outlined in *EW C 17 04 10*

## 2.15 Disposal

The product can be mechanically disassembled to separate the different materials for recycling. The plastic components could be used for energy recovery in an incineration plant. No disposal is foreseen for the product nor for the corresponding packaging.

## 2.16 Further information

ASSA ABLOY Entrance Systems AB  
Lodjursgatan 10  
SE-261 44 Landskrona  
Sweden

[www.assaabloyentrance.com](http://www.assaabloyentrance.com)

## 3. LCA: Calculation rules

### 3.1 Declared Unit

The declaration refers to the functional unit of 1 piece of ASSA ABLOY HS7080 High-Performance Door as specified in Part B requirements on the EPD IBU: PCR Automatic doors, automatic gates, and revolving door systems (door systems).

Functional unit for module B6: Use of 1 piece of ASSA ABLOY HS7080 High-Performance Door for 10 years.

#### Declared unit and mass reference

| Name                            | Value     | Unit   |
|---------------------------------|-----------|--------|
| Dimensions (WxH)                | 3600x3600 | mm     |
| Declared unit                   | 1         | pce    |
| Mass (without packaging)        | 243.27    | kg     |
| Mass packaging (paper and wood) | 71.00     | kg     |
| Mass reference                  | 243.27    | kg/pce |

### 3.2 System boundary

Type of the EPD: cradle to grave with module D (A+B+C+D).  
The following life cycle stages were considered:

#### Production stage:

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

- B6 – Operational energy use

#### End-of-life stage:

- C1 – De-construction/demolition,
- 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.

Use stage: For the use phase, it is assumed that one piece of ASSA ABLOY HS7080 High-Performance 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 1.22 hours in on-mode and 22.78 hours in stand by per day (260 days per year in use, 10 years lifetime); the power consumption throughout the whole life cycle is 1960.82 kWh. The remaining 105 days, the product is assumed to stay in stand-by mode.

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, zinc, 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, Sphera's Life Cycle for Expert (LCA FE) software is used. Sphera Managed Lifecycle Content (MLC) modelling database is used as the background database of the study.

### 3.6 Data quality

The requirements for data quality and background data correspond to the specifications of the IBU PCR Part A. Sphera 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 Sphera MLC database.

### 3.7 Period under review

The period under review is, 2024 (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: Europe

### 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 MLC 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. Sphera's Managed LCA Content CUP 2024.2

serves as background database for the calculation.

## 4. LCA: Scenarios and additional technical information

### Characteristic product properties of biogenic carbon

Characteristic product properties of biogenic carbon. 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).

### 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 | 34.66 | kg C |

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

### Transport to the building site (A4)

| Name                                        | Value | Unit    |
|---------------------------------------------|-------|---------|
| Litres of fuel                              | 27.5  | l/100km |
| Transport distance by truck                 | 984   | km      |
| Capacity utilisation (including empty runs) | 61    | %       |
| Transport distance by ship                  | 102   | km      |

### Installation into the building (A5)

| Name                                                                            | Value | Unit |
|---------------------------------------------------------------------------------|-------|------|
| Output substances following waste treatment on site (paper/cardboard packaging) | 12    | kg   |
| Output substances following waste treatment on site (wood packaging)            | 59    | kg   |

### Reference service life

| Name                                    | Value | Unit  |
|-----------------------------------------|-------|-------|
| Life Span according to the manufacturer | 10    | years |

### Operational energy use (B6)

| Name                                                                | Value   | Unit |
|---------------------------------------------------------------------|---------|------|
| Electricity consumption per RSL (260 days per year during 10 years) | 1960.82 | kWh  |
| Hours per day in on mode                                            | 1.22    | h    |
| Hours per day in stand-by mode                                      | 22.78   | h    |
| Power consumption – on mode                                         | 352     | W    |
| Power consumption – stand-by mode                                   | 10      | W    |

For the remaining days (105 days) the door is in stand-by mode.

\*Total energy consumed during the whole product life was

calculated using following formula:

$$((W_{\text{active mode}} \cdot h_{\text{active mode}} + W_{\text{idle mode}} \cdot h_{\text{idle mode}} + W_{\text{standby mode}} \cdot h_{\text{standby mode}}) \cdot \text{Days\_years operational} \cdot \text{Lifespan}) + (W_{\text{idle mode}} \cdot h_{\text{idle mode}} \cdot \text{Days\_years idle} \cdot \text{Lifespan}) + (W_{\text{standby mode}} \cdot h_{\text{standby mode}} \cdot \text{Days\_years idle} \cdot \text{Lifespan}) \cdot 0.001$$

Where:

- W<sub>active mode</sub> - Energy consumption in active mode in W
- h<sub>active mode</sub> - Operation time in active mode in hours
- W<sub>idle mode</sub> - Energy consumption in idle mode in W
- h<sub>idle mode</sub> - Operation time in idle mode in hours
- W<sub>standby mode</sub> - Energy consumption in standby mode in W
- h<sub>standby mode</sub> - Operation time in Standby mode in hours
- Lifespan - Reference service life of product
- Days<sub>year operation</sub> - Operation days per year
- Days<sub>year idle</sub> - Only Idle days per year
- Days<sub>year standby</sub> - Only stand by days per year
- 0.001 - Conversion factor from Wh to kWh

### End of life (C1-C4)

| Name                                                                                                                                 | Value  | Unit |
|--------------------------------------------------------------------------------------------------------------------------------------|--------|------|
| Transport to EoL (C2)                                                                                                                | 100    | km   |
| Collected separately waste type (aluminium, steel, brass, plastics, stainless steel, copper, electronic, electro-mechanics and zinc) | 243.16 | kg   |
| Incineration of plastic parts                                                                                                        | 35.09  | kg   |
| Recycling (aluminium, zinc, steel, copper, electronic, electro-mechanics, stainless steel and brass)                                 | 208.07 | kg   |
| Landfill                                                                                                                             | 0.12   | kg   |

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

| Name                                                  | Value  | Unit |
|-------------------------------------------------------|--------|------|
| Collected separately waste type (including packaging) | 314.16 | kg   |
| Recycling aluminium                                   | 2.20   | %    |
| Recycling brass                                       | 0.02   | %    |
| Recycling copper                                      | 0.01   | %    |
| Recycling stainless steel                             | 0.01   | %    |
| Recycling steel                                       | 57.88  | %    |
| Recycling electronic                                  | 0.63   | %    |
| Recycling electro-mechanics                           | 5.46   | %    |
| Incineration of plastic parts                         | 11.17  | %    |
| Incineration of packaging (paper and wood) (from A5)  | 22.60  | %    |

## 5. LCA: Results

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 ASSA ABLOY HS7080 High Performance Door

| Parameter      | Unit                             | A1-A3     | A4       | A5       | B6       | C1 | C2       | C3       | C4 | D         |
|----------------|----------------------------------|-----------|----------|----------|----------|----|----------|----------|----|-----------|
| GWP-total      | kg CO <sub>2</sub> eq            | 6.18E+02  | 2.58E+01 | 1.26E+02 | 5.91E+02 | 0  | 2.02E+00 | 1.46E+02 | 0  | -6.29E+02 |
| GWP-fossil     | kg CO <sub>2</sub> eq            | 7.61E+02  | 2.53E+01 | 5.89E-01 | 5.86E+02 | 0  | 1.98E+00 | 1.46E+02 | 0  | -6.29E+02 |
| GWP-biogenic   | kg CO <sub>2</sub> eq            | -1.27E+02 | 5.93E-02 | 1.26E+02 | 5.27E+00 | 0  | 4.72E-03 | 2.23E-03 | 0  | 4.81E-02  |
| GWP-luluc      | kg CO <sub>2</sub> eq            | 5.93E-01  | 4.15E-01 | 3.27E-04 | 8.9E-02  | 0  | 3.32E-02 | 7.26E-03 | 0  | -2.43E-01 |
| ODP            | kg CFC11 eq                      | 5.03E-09  | 3.67E-12 | 3.33E-12 | 1.33E-08 | 0  | 2.91E-13 | 3.51E-11 | 0  | 2.83E-10  |
| AP             | mol H <sup>+</sup> eq            | 1.83E+00  | 5.56E-02 | 1.2E-01  | 1.13E+00 | 0  | 2.71E-03 | 2.02E-02 | 0  | -1.53E+00 |
| EP-freshwater  | kg P eq                          | 1.71E-03  | 1.05E-04 | 9.83E-07 | 2.43E-03 | 0  | 8.45E-06 | 8.6E-06  | 0  | -2.7E-04  |
| EP-marine      | kg N eq                          | 4.41E-01  | 1.74E-02 | 2.65E-02 | 2.83E-01 | 0  | 9.83E-04 | 5.92E-03 | 0  | -3.51E-01 |
| EP-terrestrial | mol N eq                         | 4.7E+00   | 2.02E-01 | 2.97E-01 | 2.96E+00 | 0  | 1.17E-02 | 9.43E-02 | 0  | -3.8E+00  |
| POCP           | kg NMVOC eq                      | 1.62E+00  | 4.83E-02 | 8.79E-02 | 7.48E-01 | 0  | 2.7E-03  | 1.68E-02 | 0  | -1.13E+00 |
| ADPE           | kg Sb eq                         | 1.17E-02  | 2.16E-06 | 3.48E-08 | 1.1E-04  | 0  | 1.72E-07 | 3.5E-07  | 0  | -1.8E-03  |
| ADPF           | MJ                               | 1.1E+04   | 3.31E+02 | 7.51E+00 | 1.23E+04 | 0  | 2.61E+01 | 6.86E+01 | 0  | -6.22E+03 |
| WDP            | m <sup>3</sup> world eq deprived | 3.98E+01  | 3.83E-01 | 5.92E+00 | 1.62E+02 | 0  | 3.06E-02 | 1.42E+01 | 0  | -4.18E+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 piece ASSA ABLOY HS7080 High Performance Door

| Parameter | Unit           | A1-A3    | A4       | A5        | B6       | C1 | C2       | C3        | C4 | D         |
|-----------|----------------|----------|----------|-----------|----------|----|----------|-----------|----|-----------|
| PERE      | MJ             | 2.9E+03  | 2.8E+01  | 1.33E+03  | 8.88E+03 | 0  | 2.24E+00 | 1.93E+01  | 0  | -5.32E+02 |
| PERM      | MJ             | 1.32E+03 | 0        | -1.32E+03 | 0        | 0  | 0        | 0         | 0  | 0         |
| PERT      | MJ             | 4.22E+03 | 2.8E+01  | 1.94E+00  | 8.88E+03 | 0  | 2.24E+00 | 1.93E+01  | 0  | -5.32E+02 |
| PENRE     | MJ             | 8.3E+03  | 3.31E+02 | 7.51E+00  | 1.23E+04 | 0  | 2.61E+01 | 2.73E+03  | 0  | -6.22E+03 |
| PENRM     | MJ             | 2.66E+03 | 0        | 0         | 0        | 0  | 0        | -2.66E+03 | 0  | 0         |
| PENRT     | MJ             | 1.1E+04  | 3.31E+02 | 7.51E+00  | 1.23E+04 | 0  | 2.61E+01 | 6.86E+01  | 0  | -6.22E+03 |
| SM        | kg             | 4.02E+01 | 0        | 0         | 0        | 0  | 0        | 0         | 0  | 0         |
| RSF       | MJ             | 0        | 0        | 0         | 0        | 0  | 0        | 0         | 0  | 0         |
| NRSF      | MJ             | 0        | 0        | 0         | 0        | 0  | 0        | 0         | 0  | 0         |
| FW        | m <sup>3</sup> | 2.03E+00 | 3.12E-02 | 1.39E-01  | 6.8E+00  | 0  | 2.5E-03  | 3.38E-01  | 0  | -1.8E+00  |

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 ASSA ABLOY HS7080 High Performance Door

| Parameter | Unit | A1-A3    | A4       | A5       | B6       | C1 | C2       | C3       | C4 | D         |
|-----------|------|----------|----------|----------|----------|----|----------|----------|----|-----------|
| HWD       | kg   | 1.67E-04 | 1.26E-08 | 3.2E-09  | 1.78E-05 | 0  | 9.98E-10 | 4.16E-08 | 0  | -1.09E-06 |
| NHWD      | kg   | 2.88E+01 | 5.36E-02 | 1.09E+00 | 1.01E+01 | 0  | 4.26E-03 | 1.36E+01 | 0  | -3.33E+01 |
| RWD       | kg   | 5.11E-01 | 5.99E-04 | 3.16E-04 | 1.97E+00 | 0  | 4.75E-05 | 2.56E-03 | 0  | -1.43E-01 |
| CRU       | kg   | 0        | 0        | 0        | 0        | 0  | 0        | 0        | 0  | 0         |
| MFR       | kg   | 0        | 0        | 0        | 0        | 0  | 0        | 2.31E+02 | 0  | 0         |
| MER       | kg   | 0        | 0        | 0        | 0        | 0  | 0        | 0        | 0  | 0         |
| EEE       | MJ   | 4.42E+00 | 0        | 3.24E+02 | 0        | 0  | 0        | 2.64E+02 | 0  | 0         |
| EET       | MJ   | 1.02E+01 | 0        | 4.41E+02 | 0        | 0  | 0        | 4.75E+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 ASSA ABLOY HS7080 High Performance Door

| Parameter | Unit              | A1-A3    | A4       | A5       | B6       | C1 | C2       | C3       | C4 | D         |
|-----------|-------------------|----------|----------|----------|----------|----|----------|----------|----|-----------|
| PM        | Disease incidence | 2.3E-05  | 7.2E-07  | 5.5E-07  | 9.46E-06 | 0  | 2.71E-08 | 2.45E-07 | 0  | -2.25E-05 |
| IR        | kBq U235 eq       | 4.85E+01 | 8.68E-02 | 4.72E-02 | 3.24E+02 | 0  | 6.89E-03 | 3.58E-01 | 0  | -2.43E+01 |
| ETP-fw    | CTUe              | 3.01E+03 | 2.46E+02 | 4.99E+00 | 3.56E+03 | 0  | 1.93E+01 | 4.39E+01 | 0  | -1.04E+03 |
| HTP-c     | CTUh              | 6.67E-07 | 4.95E-09 | 9.29E-09 | 2E-07    | 0  | 3.91E-10 | 2.28E-09 | 0  | -8.16E-07 |
| HTP-nc    | CTUh              | 4.8E-06  | 2.21E-07 | 3.23E-07 | 3.07E-06 | 0  | 1.75E-08 | 1.78E-07 | 0  | -4.71E-07 |
| SQP       | SQP               | 1.66E+04 | 1.6E+02  | 1.99E+00 | 5.18E+03 | 0  | 1.28E+01 | 1.84E+01 | 0  | -1.44E+02 |

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.

## 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 24% and 99% to the overall results for all core environmental impact assessment categories.

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. 70% 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) in 10 years of service life, the energy consumption was included, and it has a relevant contribution for all core impact assessment categories considered - between 1% and 43%, except for ADPF (56%), EP-Freshwater (60%), WDP (75%), and ODP (76%). This is a result of 1.22 hours of operation in on-mode and 22.78 hours in stand-by mode per day and per 260 days in a year. For the remaining 105 days, the door is in stand-by mode.

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

### EN 12604

EN 12604:2017+A1:2020 Industrial, commercial and garage doors and gates - Mechanical aspects - Requirements and test methods

### EN 12978

EN 12978:2003+A1:2009 Industrial, commercial and garage doors and gates - Safety devices for power operated doors and gates - Requirements and test methods

### EN 60335

EN 60335-1:2012+A11:2014+A13:2017+A14:2019+A15:2021+A1:2019+A2:2019 Household and similar electrical appliances - Safety - Part 1: General requirements

### EN 60335

EN 60335-2-103: 2015 Household and similar electrical appliances - Safety - Part 2-103: Particular requirements for drives for gates, doors and windows

### CPR

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

### EN 12424 Class 3

EN 12424:2000 Class 3, Industrial, commercial and garage doors and gates - Resistance to wind load - Classification; German version EN 12424:2000

## EN 12425 Class 3

EN 12425:2000 Class 3, Industrial, commercial and garage doors and gates - Resistance to water penetration - Classification; German version EN 12425:2000

## EN 12426 Class 3

EN 12424:2000 Class 3, Industrial, commercial and garage doors and gates. Air permeability. Classification; German version EN 12424:2000

## EN 12428

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

## EN 12453

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

## EN 12604:2017+A1:2020

EN 12604:2017+A1:2020, Industrial, commercial and garage doors and gates – Mechanical aspects – Requirements and test methods

## EN 12978:2003+A1:2009

EN 12978:2003+A1:2009, Industrial, commercial and garage doors and gates - Safety devices for power operated doors and gates - Requirements and test methods

## EN 13241-1

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

## EN 15804

EN 15804:2012+A2:2019+AC:2021, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products.

## EN 16034:2014

EN 16034:2014, Pedestrian door sets, industrial, commercial, garage doors and openable windows – Product standard, performance characteristics – Fire resisting and/or smoke control characteristics

## EN 60335

EN 60335-1:2012+A11:2014+A13:2017+A14:2019+A15:2021+A1:2019+A2:2019, Household and similar electrical appliances - Safety - Part 1: General requirements

## EN 60335-2-103

EN 60335-2-103, Household and similar electrical appliances - Safety - Part 2-103: Particular requirements for drives for gates, doors and windows

## 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

## 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 ISO 13849-1

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

## EN ISO 14025

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

## EWC

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

## EN ISO 14001:2015

EN ISO 14001:2015, Environmental management systems – Requirements with guidance for use (ISO 14001:2015)

## 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 harmonization 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 (RoHS directive)

## UKSI 2008 No.1597

UKSI 2008 No.1597 Supply of Machinery (Safety) Regulations 2008 for the Great Britain market

## UKSI 2016 No.1091

UKSI 2016 No.1091 Electromagnetic Compatibility Regulations 2016 for the Great Britain market

## UKSI 2012 No.3032

UKSI 2012 No.3032 The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment for the Great Britain market

## UKSI 2016 No.1101

UKSI 2016 No.1101 Electrical Equipment (Safety) Regulations 2016 for the Great Britain market

## RoHS

European Directive on Restriction of Hazardous Substances in

Electrical and Electronic Equipment (RoHS) 2012

## **Sphera Managed Lifecycle Content (MLC)**

Sphera Solutions, Managed LCA content dataset documentation, Sphera Solutions, Chicago, US, 2023. Retrieved from <https://lcadatabase.sphera.com/>

## **Sphera's Life Cycle for Expert (LCA FE) software**

Sphera Solutions, 'Life Cycle Assessment for Expert software', Sphera Solutions, Chicago, US, 2023. Retrieved from <https://sphera.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)

## **IBU PCR Part A**

Institut Bauen und Umwelt e.V., Berlin (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 1.4 04-2024 [www.ibu-epd.de](http://www.ibu-epd.de)

## **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: Part B: PCR for Automatic doors, automatic gates, and revolving door systems, Version v8 (08. 2024) [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

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