

ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804+A2

Owner of the Declaration	dormakaba International Holding GmbH
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Declaration number	EPD-DOR-20250124-CBA1-EN
Issue date	11.04.2025
Valid to	10.04.2030

Door closer TS 98 XEA
dormakaba

www.ibu-epd.com | <https://epd-online.com>



General Information

dormakaba

Programme holder

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

Declaration number

EPD-DOR-20250124-CBA1-EN

This declaration is based on the product category rules:

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

Issue date

11.04.2025

Valid to

10.04.2030



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Door closer TS 98 XEA

Owner of the declaration

dormakaba International Holding GmbH
DORMA Platz 1
58256 Ennepetal
Germany

Declared product / declared unit

1 piece of the product: TS 98 XEA incl. slide channel G-N consisting of the following items:

- Door closer TS 98 XEA
- Product packaging

Scope:

This Environmental Product Declaration refers to a specific TS 98 XEA manufactured by dormakaba. The production site is located in Ennepetal (Germany).

Green electricity with Guarantee of Origin (GoO) is being used at this production site.

The data represents the year 2024.

The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

The EPD was created according to the specifications of EN 15804+A2. In the following, the standard will be simplified as *EN 15804*.

Verification

The standard EN 15804 serves as the core PCR		
Independent verification of the declaration and data according to ISO 14025:2011		
<input type="checkbox"/>	internally	<input checked="" type="checkbox"/> externally



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

Product

Product description/Product definition

The dormakaba TS 98 XEA slide channel door closer features an attractive, high-grade XEA design and is also flexible and easy to install. The closer body with an overall installation height of just 60 mm can be installed in all four ways. Its additional SoftFlow closing range between 15° and 0° combined with a latching action between 7° and 0° provides whisper-quiet closing for all four installation types. The hydraulic functions and the closing force EN 1–6 can be set conveniently from the front. The selected closing force can be read from an optical display. Delayed closing and backcheck are available for all installation types.

For the TS 98 XEA the standards which can be applied are the following:

- EN 1154
- EN 1155
- EN 1158
- EN 14637
- DIN 18040

The CE-marking takes into account the proof of conformity with the respective harmonized standards based on the legal provisions above. ...

Application

The product can be universally used for one and two -leaf door applications and for fire and smoke control doors. Application on external doors, outward opening, as well as on standard doors is also possible.

Technical Data

The TS 98 XEA has following technical properties:

Name	Value	Unit
General doors, fire and smoke doors ≤	1400	mm
Exterior doors, opening outwards ≤	1400	mm
Same design for left- and right-handed doors		
Closing force continuously adjustable on front using a battery screwdriver		
Closing time continuously adjustable using valve		
Additional closing range for quiet closing	15–0	°
Latching action continuously adjustable using valve		
Backcheck (BC) adjustable using valve		
Delayed closing (DC) continuously adjustable using valve		
Compliance with the max. opening torque as per German Industrial Standard (DIN) 18040 up to a door width of	1250	mm

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

Base materials/Ancillary materials

The major material composition including the packaging of the product is listed below:

Name	Value	Unit
Steel	76	%
Aluminium	9	%
Packaging	7	%
Others	5	%
Plastics	2	%
Brass	1	%

The product includes partial articles which contain substances listed in the *Candidate List of REACH Regulation 1907/2006/EC* (date: 25.01.2025) exceeding 0.1 percentage by mass: yes

- Lead (Pb): 7439-92-1 (CAS-No.) is included in some of the alloys used. The concentration of lead in each individual alloy does not exceed 4% (by mass).

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

Reference service life

The reference service life of the TS 98 XEA is about 20 years, depending on the application and frequency of use. For repairs and renewals, suitable spare parts are available. The door closer is tested and certified to *EN 1154*, meaning they are designed to withstand a minimum of 500,000 cycles.

LCA: Calculation rules

Declared Unit

The declared unit is 1 piece of the product: TS 98 XEA incl. slide channel G--N including packaging

Name	Value	Unit
Declared unit	1	piece/product
Mass of declared Product without Packaging	4.32	kg
Mass of Packaging	0.35	kg
Total mass of declared product	4.67	kg

System boundary

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

Production - Module A1-A3

The product stage includes: — A1, raw material extraction, processing and mechanical treatments, processing of secondary material input (e.g. recycling processes), — A2, transport to the manufacturer, — A3, manufacturing and assembly including provision of all materials, products and

energy green electricity with Guarantee of Origin (GoO), as well as waste processing up to the end-of-waste state.

Construction stage - Modules A4-A5

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

End-of-life stage— Modules C1-C4 and D

The end-of-life stage includes: — C1, de-construction, demolition; — C2, transport to waste processing; — C3, waste processing for reuse, recovery and/or recycling; — C4, disposal; including provision and all transport, provision of all materials, products and related energy and water use. Module

D (Benefits and loads beyond the system boundary) includes: — D, recycling potentials, expressed as net impacts and benefits.

Geographic Representativeness

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

Comparability

Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account. Background database: GaBi, SP40.

LCA: Scenarios and additional technical information

Characteristic product properties of biogenic carbon

Name	Value	Unit
Biogenic carbon content in product	0.02	kg C
Biogenic carbon content in accompanying packaging	0.13	kg C

Ennepetal (Germany) is considered for A3.

Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO₂.

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	0.00276	l/100km
Transport distance	100	km
Capacity utilisation (including empty runs)	55	%

The product is transported via truck. The product is stored in the dormakaba logistic center in Ennepetal. The main distribution region is Europe. In order to allow scaling to a specific point of installation 100 km are declared.

Installation into the building (A5)

Name	Value	Unit
Waste packaging (paper)	0.35	kg

Reference service life

Name	Value	Unit
Life Span according to the manufacturer	20	a

End of life (C1-C4)

C1: The product dismantling from the building is done manually without environmental burden.

C2: Transport to waste management is 50 km.

Name	Value	Unit
Collected separately waste type	4.32	kg
Recycling	4.22	kg
Energy recovery	0.1	kg

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

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

Name	Value	Unit
Recycling	100	%

The collection rate is 100 %.

LCA: Results

EF Version: 3.0

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	MND	MND	X	X	X	X	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 piece TS 98 XEA incl. slide channel G-N

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO ₂ eq	9.54E+00	4.08E-02	4.91E-01	0	1.89E-02	6.69E-01	0	-3.73E+00
GWP-fossil	kg CO ₂ eq	1.01E+01	3.9E-02	1.23E-02	0	1.8E-02	5.71E-01	0	-3.72E+00
GWP-biogenic	kg CO ₂ eq	-6.19E-01	1.8E-03	4.78E-01	0	8.34E-04	9.86E-02	0	-1.05E-02
GWP-luluc	kg CO ₂ eq	9.51E-03	9.29E-07	8.07E-06	0	4.29E-07	3.31E-05	0	-6.63E-04
ODP	kg CFC11 eq	9.35E-11	4.12E-18	8.84E-17	0	1.9E-18	2.99E-16	0	-2.13E-11
AP	mol H ⁺ eq	3.73E-02	3.9E-05	1.37E-04	0	1.81E-05	1.16E-04	0	-1.19E-02
EP-freshwater	kg P eq	2.57E-05	8.35E-09	1.73E-08	0	3.86E-09	4.76E-08	0	-2.2E-06
EP-marine	kg N eq	6.29E-03	1.24E-05	4.96E-05	0	5.75E-06	2.75E-05	0	-1.72E-03
EP-terrestrial	mol N eq	6.72E-02	1.38E-04	6.18E-04	0	6.39E-05	5.29E-04	0	-1.84E-02
POCP	kg NMVOC eq	1.99E-02	3.51E-05	1.31E-04	0	1.62E-05	7.59E-05	0	-5.63E-03
ADPE	kg Sb eq	3.06E-04	1.17E-09	1.4E-09	0	5.41E-10	4.13E-09	0	-3.27E-06
ADPF	MJ	1.36E+02	5.53E-01	1.55E-01	0	2.56E-01	2.85E-01	0	-5.08E+01
WDP	m ³ world eq deprived	1.69E+00	7.64E-05	6.08E-02	0	3.54E-05	6.85E-02	0	-2.05E-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 TS 98 XEA incl. slide channel G-N

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PERE	MJ	7.58E+01	1.74E-03	4.18E+00	0	8.07E-04	7.33E-01	0	-1.92E+01
PERM	MJ	4.81E+00	0	-4.15E+00	0	0	-6.6E-01	0	0
PERT	MJ	8.06E+01	1.74E-03	2.81E-02	0	8.07E-04	7.26E-02	0	-1.92E+01
PENRE	MJ	1.33E+02	5.54E-01	1.55E-01	0	2.56E-01	3.3E+00	0	-5.08E+01
PENRM	MJ	3.01E+00	0	0	0	0	-3.01E+00	0	0
PENRT	MJ	1.36E+02	5.54E-01	1.55E-01	0	2.56E-01	2.85E-01	0	-5.08E+01
SM	kg	3.45E+00	0	0	0	0	0	0	0
RSF	MJ	0	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0	0
FW	m ³	9.6E-02	3.13E-06	1.43E-03	0	1.45E-06	1.64E-03	0	-3.44E-02

PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water

RESULTS OF THE LCA - WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 piece TS 98 XEA incl. slide channel G-N

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
HWD	kg	9.86E-07	5.37E-11	2.28E-10	0	2.48E-11	1.02E-09	0	-7.76E-07
NHWD	kg	1.29E+00	5.66E-05	1.54E-02	0	2.62E-05	5.98E-02	0	-6.44E-01
RWD	kg	6.77E-03	5.94E-07	8.14E-06	0	2.75E-07	1.1E-05	0	-4.82E-03
CRU	kg	0	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	4.04E+00	0	0
MER	kg	0	0	0	0	0	0	0	0
EEE	MJ	0	0	7.42E-01	0	0	1.2E+00	0	0
EET	MJ	0	0	1.35E+00	0	0	2.68E+00	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 TS 98 XEA incl. slide channel G-N

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PM	Disease incidence	4.55E-07	2.05E-10	7.61E-10	0	9.49E-11	1.37E-09	0	-1.88E-07
IR	kBq U235 eq	1.09E+00	8.49E-05	1.26E-03	0	3.93E-05	1.08E-03	0	-9.45E-01
ETP-fw	CTUe	5.06E+01	3.92E-01	7.35E-02	0	1.81E-01	1.08E-01	0	-1.57E+01
HTP-c	CTUh	6.93E-09	7.38E-12	3.89E-12	0	3.41E-12	9.2E-12	0	-5.51E-10
HTP-nc	CTUh	1.69E-07	3.15E-10	1.68E-10	0	1.46E-10	8.9E-10	0	-2.79E-08
SQP	SQP	9.55E+01	1.42E-03	4.11E-02	0	6.58E-04	8.5E-02	0	-1.99E+00

PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index

Disclaimer 1 – for the indicator “Potential Human exposure efficiency relative to U235”. This impact category deals mainly with the eventual impact of low-dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, radon and from some construction materials is also not measured by this indicator.

Disclaimer 2 – for the indicators “abiotic depletion potential for non-fossil resources”, “abiotic depletion potential for fossil resources”, “water (user) deprivation potential, deprivation-weighted water consumption”, “potential comparative toxic unit for ecosystems”, “potential comparative toxic unit for humans – cancerogenic”, “Potential comparative toxic unit for humans - not cancerogenic”, “potential soil quality index”. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high as there is limited experience with the indicator.

This EPD was created using a software tool.

References

EN 1154

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

EN 1155

EN 1155 - 2003-04;
Building hardware – Electrically -powered hold -open devices for swing doors Requirements and test methods (includes amendment A1:2002); German version /EN 1155:1997 +A1:2002

EN 1158

EN 1158 - 2003--04;
Building hardware – Door coordinator devices –Requirements and test methods (includes amendment A1:2002); German version /EN 1158:1997 + A1:2002

DIN EN 14637

DIN EN 14637:2008-01
Building hardware - Electrically controlled hold-open systems for fire/smoke door assemblies - Requirements, test methods, application and maintenance; German version EN 14637:2008-01

DIN 18040

DIN 18040-1 (2010):
Construction of accessible buildings - Design principles

EN 15804

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

ISO 14025

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

ECHA

European Chemical Agency

REACH

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

RoHS

2011/65/EU, Directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment

Further References

IBU 2021

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

GaBi

Sphera Solutions GmbH
Gabi Software System and Database for Life Cycle Engineering 19922020
Version 10.0.0.71
University of Stuttgart
Leinfelden-Echterdingen

GaBi ts documentation

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

LCA-tool dormakaba

Tool No.: IBU-DOR-202104-LT1-EN
Developed by Sphera Solutions GmbH

PCR Part A

PCR – Part A: Calculation Rules for the Life Cycle Assessment

and Requirements on the Project Re-port according to EN 15804+A2:2019, Version 1.0, 2020, Institut Bauen und Umwelt e.V., www.ibu-epd.com.

PCR Part B

PCR – Part B: Requirements on the EPD for Building Hardware product, version 08/2021, Institut Bauen und Umwelt e.V., www.ibu-epd.com.



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