ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	dormakaba International Holding GmbH
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
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Crane SS 2000/3000 - Manual Revolving Door

dormakaba

Institut Bauen und Umwelt e.V.

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General Information

dormakaba

Programme holder
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Germany

Declaration number
EPD-DOR-20160280-ICA1-EN

This Declaration is based on the Product Category Rules:
Automatic doors, automatic gates, and revolving door systems, 07.2014
(PCR tested and approved by the SVR)

Issue date
24.04.2017

Valid to
23.04.2023

Prof. Dr.-Ing. Horst J. Bossenmayer
(President of Institut Bauen und Umwelt e.V.)

Dr. Burkhart Lehmann
(Managing Director IBU)

Crane SS 2000/3000 - Manual Revolving Door

Owner of the Declaration
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DORMA Platz 1
58256 Ennepetal
Deutschland

Declared product / Declared unit
The declaration represents one manual revolving door, consisting of four (4) door leaves and with a diameter of 7 ft. (2130 mm) and a height of 7.5 ft. (2290 mm).

Scope:
The declaration and background LCA report represent DORMA's Crane SS 2000 / 3000 manual revolving doors. Raw materials and components are provided by suppliers and shipped to DORMA's facility in Illinois, USA, where doors are manufactured and assembled before being shipped to job sites.

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.

Verification

The CEN Norm /EN 15804/ serves as the core PCR
Independent verification of the declaration according to /ISO 14025/
☐ internally ☒ externally

Dr.-Ing. Wolfram Trinius
(Independent verifier appointed by SVR)

Product

Product description / Product definition
Revolving doors represent an alternative entrance option that minimizes airflow between the outside and inside while allowing for continuous traffic flow. A revolving door can also create a sealed barrier at the building envelope, reducing the load on HVAC systems and saving energy in the process.

The Crane SS series uses a fully formed and welded stainless steel canopy and enclosure. The 2000 series utilizes stainless steel clad construction over an aluminum sub frame for the door leaves. The 3000 series utilizes fully formed and welded stainless steel construction door leaves.

The heavy-duty hardware used in all Crane revolving doors complies with all state and federal requirements for providing emergency egress.

The Crane manual revolving door utilizes a fully adjustable mechanical speed control which meets governing building codes and requires no electrical connection.

All Crane revolving doors are furnished with factory-made seals, which provide a durable dynamic barrier between inside and outside environments.

Crane manual revolving doors can be manufactured in a range of 1.83 m (6 ft) to 3.05 m (10 ft) diameter, and can accommodate virtually any attachment plan that the architect has in their vision for the building.

For the use and application of the product, the respective national provisions at the place of use apply. In the United States, for example, this would be the relevant building codes and the corresponding national specifications.

Application
Revolving doors may be used to provide a comfortable entry and exit in many applications in the facade of or within a building.

Typical applications include:

- Hotels
- Healthcare settings

- Airports and transportation facilities
- Commercial office buildings
- Institutional and educational buildings
- Retail stores

Technical Data
The technical features for the Crane SS 2000/3000 manual revolving door are as follows:

Constructional data

Name	Value	Unit
Height range 2000	7-9	ft
Height range 3000	7+ with engineering approval	ft
Diameter range 2000/3000	6 ID to 12 OD	ft
Enclosure glass 2000	7/16" clear or tinted laminated	
Enclosure glass 3000	9/16" clear or tinted laminated	
Door leaf glass	1/4" tempered	
Emergency egress control	Crane adjustabl	
	e bookfold design	
Speed control	Crane mechanical design	

Base materials / Ancillary materials

The basic material composition of the door is given below. The door is primarily manufactured from stainless steel and glass.

Name	Value	Unit
Stainless steel	42	%
Glass	37	%
Steel	10	%
Bronze	6	%
Plastic	2	%
Chipboard	2	%
Other	1	%

Reference service life
The reference service lives of the revolving doors will ultimately depend on the traffic pattern and degree of usage of the doors. A reference service life of 30 years is assumed for calculation of the Use Stage impacts of the Crane SS 2000/3000 manual revolving door.

LCA: Calculation rules

Declared Unit
The declared unit for this analysis is one (1) revolving door system.

Declared unit

Name	Value	Unit
Declared unit for revolving door system*	4.9	m^2
Mass of the entire system	675	kg
Conversion factor to 1 kg	0.0015	-
Grammage of the components	138	kg/m^2
Dimensions for revolving door, diameter	2130	mm
Dimensions for revolving door, height	2290	mm

* Area represents the cross-sectional area of the door, which is designed to fit in an opening of 2130-mm wide by 2290-mm high (7 ft. by 7.5 ft.).

System boundary
Type of EPD: cradle-to-grave. The following modules were considered in this analysis:

Product stage
- Raw material supply (A1)
- Transport (A2)
- Manufacturing (A3)

Construction stage
- Transport to the building site (A4)
- Installation, including packaging disposal (A5)

Use stage
- Maintenance (B2)

End-of-life stage
- Transport to disposal (C2)
- Waste processing (C3)
- Disposal (C4)

Benefits and loads beyond the system boundary
- Reuse, recovery, and recycling potential (D)

Submodules that were not declared either do not apply and would therefore be zero, or are estimated to fall below the cut-off criteria.

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.
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LCA: Scenarios and additional technical information

Additional information is provided for the declared modules, including A4, A5, B2, C2, C4, and D. In order to represent DORMA's global distribution network, sales-weighted averages are used to model transport to the building sites.

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	30	l/100km
Transport distance	2500	km
Capacity utilisation (including empty runs)	75	%

Installation into the building (A5)

Name	Value	Unit
Packaging waste for disposal (wood)	209	kg
Packaging waste for disposal (other)	19	kg

Maintenance (B2)

Name	Value	Unit
Maintenance cycle	1	Number/ RSL
Replacement components	7	kg

Reference service life

Name	Value	Unit
Reference service life	30	a

End of life (C1-C4)

Name	Value	Unit
Collected separately	331	kg
Collected as mixed construction waste	343	kg
Recycling	331	kg
Landfilling	343	kg

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

Name	Value	Unit
Collection rate, aluminum	90	%
Collection rate, bronze	45	%
Collection rate, steel	81	%

LCA: Results

The table below summarizes which modules are declared and which are not declared. Environmental performance results are shown for one (1) piece of revolving door and represent the average of Crane SS 2000/3000 manual revolving doors produced at DORMA's facility.

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	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	X	MNR	MNR	MNR	MND	MND	MND	X	X	X	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: one revolving door system

Parameter	Unit	A1-A3	A4	A5	B2	C2	C3	C4	D
GWP	[kg CO_2-Eq.]	2.88E+3	3.58E+2	2.62E+2	1.06E+2	1.11E+1	0.00E+0	1.86E+1	-1.64E+2
ODP	[kg CFC11-Eq.]	2.37E-7	2.90E-9	2.26E-10	1.63E-8	8.96E-11	0.00E+0	3.15E-10	-4.98E-6
AP	[kg SO_2-Eq.]	2.84E+1	1.04E+0	5.28E-1	4.52E-1	3.10E-2	0.00E+0	7.58E-2	-1.65E+0
EP	[kg $(PO_4)^{3-}$-Eq.]	1.38E+0	2.61E-1	4.55E-1	3.68E-2	7.96E-3	0.00E+0	1.87E-2	-9.56E-2
POCP	[kg ethene-Eq.]	1.52E+0	1.28E-1	1.47E-1	3.96E-2	3.91E-3	0.00E+0	8.55E-3	-3.84E-2
ADPE	[kg Sb-Eq.]	2.48E-1	5.26E-5	4.46E-6	5.13E-3	1.63E-6	0.00E+0	6.31E-6	-3.76E-2
ADPF	[MJ]	3.63E+4	4.95E+3	2.06E+2	1.46E+3	1.53E+2	0.00E+0	2.49E+2	-2.03E+3

Caption	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

RESULTS OF THE LCA - RESOURCE USE: one revolving door system

Parameter	Unit	A1-A3	A4	A5	B2	C2	C3	C4	D
PERE	[MJ]	8.23E+3	8.20E+1	1.09E+1	1.44E+2	2.54E+0	0.00E+0	1.62E+1	-6.57E+2
PERM	[MJ]	2.00E+2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PERT	[MJ]	8.43E+3	8.20E+1	1.09E+1	1.44E+2	2.54E+0	0.00E+0	1.62E+1	-6.57E+2
PENRE	[MJ]	3.86E+4	4.97E+3	2.10E+2	1.55E+3	1.54E+2	0.00E+0	2.56E+2	-2.61E+3
PENRM	[MJ]	3.53E+2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PENRT	[MJ]	3.89E+4	4.97E+3	2.10E+2	1.55E+3	1.54E+2	0.00E+0	2.56E+2	-2.61E+3
SM	[kg]	3.43E+2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
RSF	[MJ]	4.16E-2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	-1.66E-2
NRSF	[MJ]	1.24E-1	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	-1.49E-1
FW	[m^3]	1.38E+1	1.00E+0	6.46E-2	6.66E-1	3.12E-2	0.00E+0	3.96E-2	-2.12E+0

Caption	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 – OUTPUT FLOWS AND WASTE CATEGORIES: one revolving door system

Parameter	Unit	A1-A3	A4	A5	B2	C2	C3	C4	D
HWD	[kg]	9.56E-2	6.31E-6	3.69E-7	5.96E-5	1.95E-7	0.00E+0	4.90E-7	-2.89E-3
NHWD	[kg]	3.11E+2	1.75E-1	1.51E+2	4.76E+0	5.41E-3	0.00E+0	3.68E+2	-7.75E+1
RWD	[kg]	1.04E+0	1.05E-2	1.72E-3	3.52E-2	3.24E-4	0.00E+0	2.60E-3	-2.11E-1
CRU	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
MFR	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	-1.71E+1	0.00E+0	0.00E+0
MER	[kg]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
EEE	[MJ]	0.00E+0	0.00E+0	7.32E+1	0.00E+0	0.00E+0	6.83E-1	0.00E+0	0.00E+0
EET	[MJ]	0.00E+0	0.00E+0	3.44E+1	0.00E+0	0.00E+0	3.21E-1	0.00E+0	0.00E+0

Caption	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; EEE = Exported thermal energy

The revolving door environmental footprint is primarily dominated by materials production (Module A1). Materials used during door maintenance also represent a non-negligible contribution to abiotic depletion potential of elements.

In order to capture DORMA's global sales network, the LCA assumes a sales-weighted distribution distance based on the countries and regions where Crane doors are sold. Finished products are primarily shipped within North America, but are also sent to South America.

Module D is associated with a comparatively large contribution to ozone depletion potential. This is driven by a difference in furnace technologies used to produce primary and secondary steel, combined with the amount of secondary material for steel production in Module A1 exceeding the amount of steel recovered at end-of-life (Module C3).

At the end-of-life, the metal components of the revolving door are modeled as being recycled. A portion of the steel and bronze are recovered and the remainder landfilled. Glass, however, is assumed to be sent entirely to landfill as recycling this material from demolished buildings is not considered common practice.

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