ENVIRONMENTAL PRODUCT DECLARATION

as per ISO 14025 and EN 15804

Owner of the Declaration	ARGE; European Federation of Associations of Lock and Builders Hardware Manufacturers
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
Publisher	Institut Bauen und Umwelt e.V. (IBU)
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Valid to	13/09/2021

Panic exit devices

ARGE; European Federation of Associations of Lock and Builders Hardware Manufacturers

(This EPD is valid only for products supplied by an ARGE EPD licence holder)

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1. General Information

ARGE	Panic exit devices
Programme holder IBU - Institut Bauen und Umwelt e.V. Panoramastr. 1 10178 Berlin Germany	**Owner of the Declaration** ARGE; European Federation of Associations of Lock and Builders Hardware Manufacturers Offerstraße 12, 42551 Velbert Germany
Declaration number EPD-ARG-20160191-IBG1-EN	**Declared product / Declared unit** 1 kg of panic exit device
This Declaration is based on the Product Category Rules: Building Hardware products, 02.2016 (PCR tested and approved by the SVR)	**Scope:** This ARGE EPD covers exit devices used to enable rapid and easy egress from buildings. The reference product used to calculate the impact this product group has on the environment is a panic exit device composed primarily of steel, zinc-based alloy and aluminium, and has been selected for the LCA (Life Cycle Assessment) because it is the product with the highest impact for 1 kg of product. A validity scope analysis has also been carried out to determine the limiting factors for exit devices covered by this EPD. In a preliminary study (simplified LCA), it has been confirmed that this EPD represents the worst case condition and it can therefore be used to cover all exit devices manufactured in Europe by ARGE member companies. 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.
Issue date 14/09/2016	
Valid to 13/09/2021	**Verification** The CEN Norm /EN 15804/ serves as the core PCR Independent verification of the declaration according to /ISO 14025/ ☐ internally ☒ externally
Prof. Dr.-Ing. Horst J. Bossenmayer (President of Institut Bauen und Umwelt e.V.)	
Dr. Burkhart Lehmann (Managing Director IBU)	Dr. Frank Werner (Independent verifier appointed by SVR)

2. Product

2.1 Product description

This ARGE EPD covers exit devices used to allow rapid and easy egress from buildings. It covers panic and emergency exit devices

2.2 Application

These products are designed to be integrated into door assemblies of varying materials and applications. They may be used for either interior or exterior doors.

2.3 Technical Data

Ideally, products should comply with a suitable technical specification. /EN 179/ and /EN 1125/ are examples of such specifications and some products will comply with one or other of these. The relevant grading structure is shown in the following table.

Name	Value	Unit
Category of use	3	Grade
Durability	6, 7	Grade
Door mass	5, 6, 7	Grade
Suitability for use in fire resisting and/or smoke control doors	0, A, B	Grade
Safety	1	Grade
Corrosion resistance	3, 4	Grade
Security	2 - 5	Grade
Projection of operating element	1, 2	Grade
Type of operation	A, B	Grade
Field of door application	A, B, C, D	Grade

2.4 Application rules

For the placing on the market in the EU/EFTA (with the exception of Switzerland) the Regulation (EU) No 305/2011 “Construction products regulation” applies. Accordingly products shall be CE marked to harmonized standards /EN 179/ Emergency exit devices operated by a lever handle or push pad, for use on escape routes, or

/EN 1125/ Panic exit devices operated by a horizontal bar, for use on escape routes, and shall have a Declaration of Performance
For application and use, respective additional national provisions may also apply.

2.5 Delivery status
The products are sold by unit. Deliveries of a single unit might be possible but will be an exception. Regular deliveries will cover a larger amount of panic exit devices as they are put on the market as "B2B" product and not for a final customer.

2.6 Base materials / Ancillary materials

Composition of product analysed for this EPD:
The values are given in the table below are for the product analysed for this EPD. Ranges of values for other products covered by the validity scope analysis are shown in brackets

Name	Value	Unit
Steel (36.81% – 77.01%)	36.81	%
Zinc-based alloy (0.00% – 34.03%)	34.03	%
Aluminium (22.03% – 25.86%)	25.86	%
ABS (0.00% – 1.77%)	1.77	%
Nylon 6 (0.00% – 1.53%)	1.53	%
PVC (0.00% – 0.08%)	0	%
Brass (0.00% - 0.88%)	0	%

The product contains no substances cited on the REACH list of hazardous substances.

Steel is produced by combining iron with carbon as well as other elements depending on the desired characteristics. The sub-components made of steel are formed by turning from solid bar.
Zinc-based alloy is an alloy of four separate metals: zinc, aluminium, magnesium and copper. Sub-components of the product, which are made from zinc-based alloy are diecast.
Aluminium is a non-ferrous metal produced from bauxite by the Bayer process. Sub-components made of aluminium are made by die casting.
ABS is a thermoplastic polymer produced from propylene and ammonia. Sub-components made of ABS are made by injection moulding.
Nylon 6 is a polymer synthesized by ring-opening polymerization of caprolactam. Sub-components made of Nylon 6 are made by injection moulding.

2.7 Manufacture
The production of a panic exit device normally follows a 3 step procedure:
1. Prefabrication of the semi-finished products. This step might include a surface treatment on factory site or by external manufacturers.
2. Preassembly of assembly modules (onsite factory)
3. Final assembly (onsite factory)

2.8 Environment and health during manufacturing
Regular measurements of air quality and noise levels are performed by ARGE member manufacturers. The results shall be within the compulsory safety levels. In areas where employees are exposed to chemical products, prescribed safety clothes and technical safety devices shall be provided. Regular health checks are mandatory for employees on production sites.

2.9 Product processing/Installation
The installation of the product could vary depending on the type of door and the specific situation but products shall not require energy consumption for installation.

2.10 Packaging
Normally each single product is packaged in paper. The products are then packed by batch in a cardboard box and stacked on wooden pallets for transport to the customer.
Waste from product packaging is collected separately for waste disposal (including recycling).

2.11 Condition of use
Once installed, the products shall require no servicing during their expected service lives. There shall be no consumption of water or energy linked to their use, and they shall not cause any emissions.

2.12 Environment and health during use
No environmental damage or health risks are to be expected during normal conditions of use.

2.13 Reference service life
The Reference Service Life is 30 years under normal working conditions. This corresponds to passing a mechanical endurance test of 200.000 cycles as specified in /EN 179/ and EN/1125/. The Reference Service Life is dependent on the actual frequency of use and environmental conditions. It is required that installation, as well as maintenance of the product, must be done in line with instructions provided by the manufacturer.

2.14 Extraordinary effects

Fire
Both types of product are suitable for use in fire resisting and/or smoke control door sets according to one of the classes 0,A,B in /EN 179/ and /EN 1125).

Water
The declared product is intended to be used in buildings under normal conditions (indoor or outdoor) They shall emit hazardous substances in the event of flooding.

Mechanical destruction
Mechanical destruction of the declared product shall not materially alter its composition or have any adverse effect on the environment.

2.15 Re-use phase
Removal of the panic or emergency device (for re-use or re-cycling) shall have no adverse effect on the environment.

2.16 Disposal
Panic and emergency exit components should be re-cycled wherever possible, providing that there is no adverse effect on the environment. The waste code in accordance with the /European Waste Code/ is 17 04 07.

2.17 Further information
Details of all types and variants to be shown on the

manufacturers' websites listed on http://arge.org/members/members-directory.html

3. LCA: Calculation rules

3.1 Declared Unit

The declared unit for all products covered by ARGE EPD is 1 kg (of product). Since individual products will rarely weigh exactly 1 kg it is necessary to establish the exact weight of the product then use this as a correction factor to determine the true values for 1 kg of product in the tables (Section 5).
A total of 2 typical products (based on sales figures) have been evaluated, and the worst case results are used in the tables.

Correction factor

Name	Value	Unit
Declared unit	1	kg
Mass of declared product	1.95	kg
Correction factor	Divide by 1,95	

3.2 System boundary

This type of the EPD covers "cradle-to-grave" requirements.
The analysis of the product life cycle includes the production and transport of the raw materials, manufacture of the product and the packaging materials, which are declared in modules A1-A3. Losses during production are considered as waste and are sent for recycling. No recycling processes are taken into account except transport and an electricity consumption for grinding the metals. When recycled metals are used as raw material, only their transformation process is taken into account and not the extraction of the raw material.
A4 module represents the transport of the finished product to the installation site.
There is no waste associated with the installation of the product. The A5 module therefore represents only the disposal of the product packaging.
For the RSL considered for this study, there are no inputs or outputs for the stages B1-B7.
The End-of-Life (EoL) stages are also considered. The transportation to the EoL disposal site is taken into account in module C2. Module C4 covers the disposal of the panic exit device. Module C3 covers the recycling of the individual elements according to European averages, with the remaining waste divided between incineration and landfill. The same assumption as for waste to recycling in A3 is used here.
For end-of-life modules (C1 to C4) the system boundaries from the /XP P01-064/CN/ standard have been followed, see annex H.2 and H.6 of this standard document for figures and further details.

In practice the-end- of life has been modelled as follows:
- When material is sent for recycling, generic transport and electric consumption of a shredder is taken into account (corresponding to the process "Grinding, metals"). Only then is the material considered to have attained the "end-of-waste" state.
- Each type of waste is modelled as transport to the treatment site over a distance of 30 km (source: /FD P01-015/). Parts sent for recycling include an electricity consumption (grinding) and a flow ("Materials for recycling, unspecified").

Four scenarios for the end-of-life of the products have been declared for this EPD:
1. 100% of the product going to landfill
2. 100% of the product going to incineration
3. 100% of the product going to recycling
4. mixed scenario consisting of the previous three scenarios, with values depending on the amount of waste going to recycling.

Module D has not been declared.

3.3 Estimates and assumptions

The LCA data of the declared panic exit device has been calculated from the production data of one ARGE member company, representing 2 different kinds of product. This company was chosen by ARGE as being representative by means of its production process and its market share. The product chosen as representative for this calculation follows the "worst case" principle as explained in section 6. LCA interpretation.

3.4 Cut-off criteria

The cut -off criteria considered are 1% of renewable and non-renewable primary energy usage and 1% of the total mass of that unit process. The total neglected input flows per module shall be a maximum of 5% of energy usage and mass.
For this study, all input and output flows have been considered at 100%, including raw materials as per the product composition provided by the manufacturer and packaging of raw materials as well as the final product. Energy and water consumptions have also been considered at 100% according to the data provided.
With the approach chosen, no significant environmental impacts are known to have been cut-off.

3.5 Background data

For life cycle modelling of the considered product, all relevant background datasets are taken from the ecoinvent 3.1 – Alloc Rec database. The life cycle analysis software used is SimaPro (V8.0.5), developed by PRé Consulting.

3.6 Data quality

The time factor, the life cycle inventory data used comes from:
Data collected specifically for this study on the ARGE manufacturer's site. Data sets are based on 1-year averaged data (time period: January 2013 to December 2013).
In the absence of collected data, generic data from the /ecoinvent V3/ database is obtained. This is updated regularly and is representative of current processes (the entire database having been updated in 2014).

3.7 Period under review

The data of the LCA is based on the annual production data of an ARGE member company from 2013.
Other values e.g. for the processing of the base materials, are taken from the /ecoinvent v3/1 Alloc Rec where the dataset age varies for each dataset, see ecoinvent documentation for more information.

3.8 Allocation

The products covered by this EPD are produced on one production site. All data was provided by the

manufacturer of the products per unit and then divided by the mass of the product to give a value per kg of product produced.
The assumptions relating to the EoL of the product are described in the section System Boundaries.
Metal losses during production (stage A3) are considered as waste.

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. The used background database has to be mentioned.

4. LCA: Scenarios and additional technical information

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 for Modules Not Declared (MND).

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	0.0045	l/100km
Transport distance	3500	km
Capacity utilisation (including empty runs)	36	%

Installation into the building (A5)

Name	Value	Unit
Material loss	0.144	kg

Reference service life

Name	Value	Unit
Reference service life (condition of use: see §2.13)	30	a

End of life (C1-C4)

Name	Value	Unit
Collected separately (All scenarii)	1	kg
Recycling (Mixed scenario)	0.475	kg
Energy recovery (Mixed scenario)	0.242	kg
Landfilling (Mixed scenario)	0.284	kg
Incineration (100% incineration scenario) Scenario 1	1	kg
Landfilling (Landfill scenario) Scenario 2	1	kg
Recycling (100% recycling scenario) Scenario 3	1	kg

It is assumed that a 16-32 ton truck is used to transport the product over the (up to) 30 km distance between the dismantling site and the next treatment site. (source: FD P01-015).

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

As Module D has not been declared, materials destined for recycling have been accounted for in the indicator “Materials for recycling” however no benefit has been allocated.

5. LCA: Results

In Table 1 "Description of the system boundary", the declared modules are indicated with an "X"; all modules that are not declared within the EPD but where additional data are available are indicated with "MND". Those data can also be used for building assessment scenarios. The values are declared with three valid digits in exponential form.

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	MND	MND	MND	MND	MND	MND	X	X	X	X	MND

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT: 1 kg of panic exit devices

Parameter	Unit	A1-A3	A4	A5	C1	C2	C2/1	C2/2	C2/3	C3	C3/1	C3/2	C3/3	C4	C4/1	C4/2	C4/3
GWP	[kg CO_2-Eq.]	6.42E+0	5.89E-1	1.36E-2	0.00E+0	5.05E-3	5.05E-3	5.05E-3	5.05E-3	4.80E-3	0.00E+0	0.00E+0	8.66E-3	1.68E-2	5.23E-1	4.97E-1	0.00E+0
ODP	[kg CFC11-Eq.]	4.78E-7	1.08E-7	3.60E-10	0.00E+0	9.26E-10	9.26E-10	9.26E-10	9.26E-10	5.15E-10	0.00E+0	0.00E+0	9.30E-10	1.22E-10	4.02E-9	3.43E-9	0.00E+0
AP	[kg SO_2-Eq.]	5.03E-2	2.39E-3	1.41E-5	0.00E+0	2.05E-5	2.05E-5	2.05E-5	2.05E-5	1.99E-5	0.00E+0	0.00E+0	3.60E-5	6.13E-6	2.58E-4	1.24E-4	0.00E+0
EP	[kg $(PO_4)^{3-}$-Eq.]	6.62E-3	4.06E-4	6.29E-6	0.00E+0	3.48E-6	3.48E-6	3.48E-6	3.48E-6	2.24E-6	0.00E+0	0.00E+0	4.04E-6	1.17E-5	7.52E-5	5.94E-4	0.00E+0
POCP	[kg ethene-Eq.]	4.47E-3	2.68E-4	3.22E-6	0.00E+0	2.30E-6	2.30E-6	2.30E-6	2.30E-6	1.10E-6	0.00E+0	0.00E+0	1.98E-6	2.74E-6	1.60E-5	1.41E-4	0.00E+0
ADPE	[kg Sb-Eq.]	2.50E-3	1.95E-6	4.10E-9	0.00E+0	1.67E-8	1.67E-8	1.67E-8	1.67E-8	1.95E-9	0.00E+0	0.00E+0	3.53E-9	1.15E-9	4.69E-8	2.47E-8	0.00E+0
ADPF	[MJ]	8.41E+1	8.97E+0	3.31E-2	0.00E+0	7.69E-2	7.69E-2	7.69E-2	7.69E-2	7.36E-2	0.00E+0	0.00E+0	1.33E-1	1.06E-2	3.73E-1	2.80E-1	0.00E+0

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: 1 kg of panic exit devices

Parameter	Unit	A1-A3	A4	A5	C1	C2	C2/1	C2/2	C2/3	C3	C3/1	C3/2	C3/3	C4	C4/1	C4/2	C4/3
PERE	[MJ]	1.50E+1	1.12E-1	2.06E-3	0.00E+0	9.61E-4	9.61E-4	9.61E-4	9.61E-4	9.51E-3	0.00E+0	0.00E+0	1.72E-2	5.48E-4	1.14E-2	2.11E-2	0.00E+0
PERM	[MJ]	2.21E+0	0.00E+0	-1.40E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PERT	[MJ]	1.72E+1	1.12E-1	-1.40E+0	0.00E+0	9.61E-4	9.61E-4	9.61E-4	9.61E-4	9.51E-3	0.00E+0	0.00E+0	1.72E-2	5.48E-4	1.14E-2	2.11E-2	0.00E+0
PENRE	[MJ]	9.43E+1	9.13E+0	3.95E-2	0.00E+0	7.82E-2	7.82E-2	7.82E-2	7.82E-2	1.08E-1	0.00E+0	0.00E+0	1.95E-1	1.21E-2	3.86E-1	3.53E-1	0.00E+0
PENRM	[MJ]	1.31E+0	0.00E+0	-6.97E-2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
PENRT	[MJ]	9.56E+1	9.13E+0	-3.02E-2	0.00E+0	7.82E-2	7.82E-2	7.82E-2	7.82E-2	1.08E-1	0.00E+0	0.00E+0	1.95E-1	1.21E-2	3.86E-1	3.53E-1	0.00E+0
SM	[kg]	4.82E-1	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
RSF	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
NRSF	[MJ]	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0
FW	[m^3]	9.02E-2	1.72E-3	2.77E-5	0.00E+0	1.48E-5	1.48E-5	1.48E-5	1.48E-5	3.62E-5	0.00E+0	0.00E+0	6.54E-5	2.38E-5	1.17E-3	3.42E-4	0.00E+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: 1 kg of panic exit devices

Parameter	Unit	A1-A3	A4	A5	C1	C2	C2/1	C2/2	C2/3	C3	C3/1	C3/2	C3/3	C4	C4/1	C4/2	C4/3
HWD	[kg]	1.03E+0	5.64E-3	3.13E-4	0.00E+0	4.83E-5	4.83E-5	4.83E-5	4.83E-5	3.40E-4	0.00E+0	0.00E+0	6.14E-4	4.05E-3	2.66E-1	1.24E-3	0.00E+0
NHWD	[kg]	4.76E+0	4.68E-1	2.54E-2	0.00E+0	4.01E-3	4.01E-3	4.01E-3	4.01E-3	1.53E-3	0.00E+0	0.00E+0	2.77E-3	1.81E-2	1.45E-2	1.00E+0	0.00E+0
RWD	[kg]	3.02E-4	6.13E-5	2.23E-7	0.00E+0	5.25E-7	5.25E-7	5.25E-7	5.25E-7	5.83E-7	0.00E+0	0.00E+0	1.05E-6	6.76E-8	1.35E-6	2.65E-6	0.00E+0
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	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]	3.54E-1	0.00E+0	9.94E-2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	5.54E-1	0.00E+0	0.00E+0	1.00E+0	0.00E+0	0.00E+0	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	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	3.28E-2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	2.11E-2	1.39E+0	0.00E+0	0.00E+0
EET	[MJ]	0.00E+0	0.00E+0	6.82E-2	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	0.00E+0	4.32E-2	2.85E+0	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

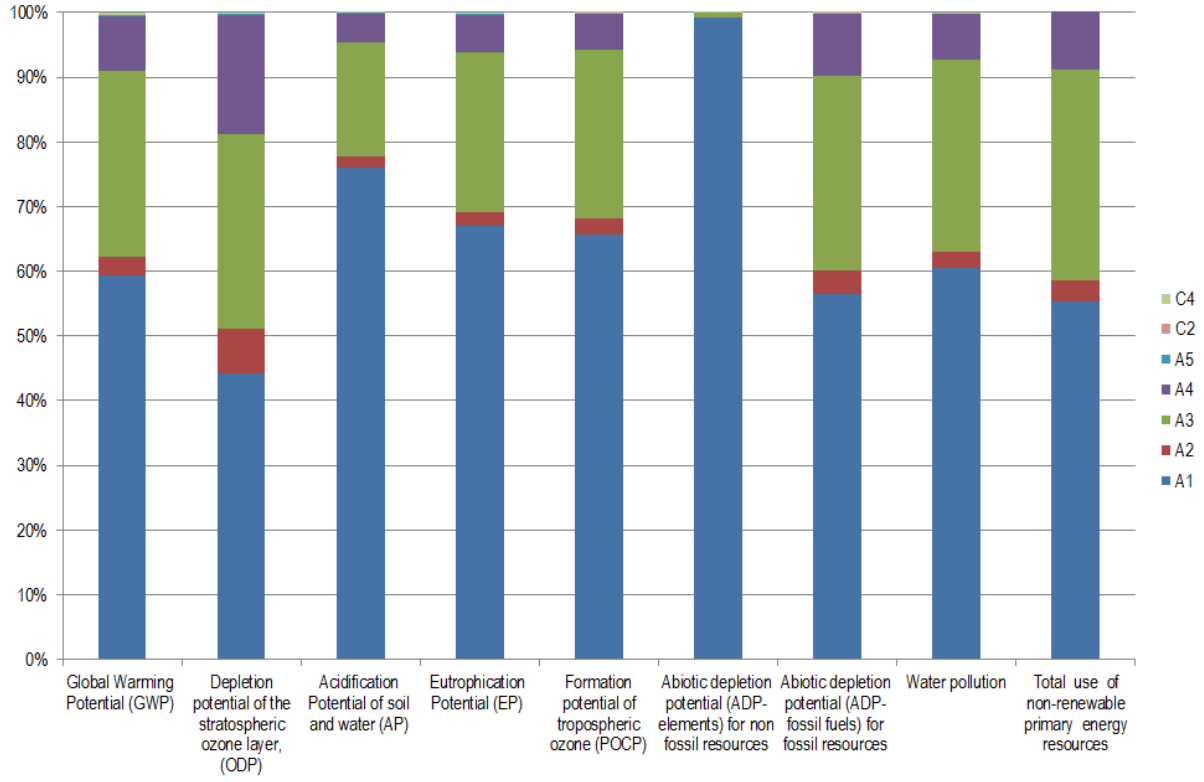
Other end-of-life scenarios have been calculated in order to build specific end-of-life scenario at the building level:

- scenario 1: the product is considered to be 100% incinerated
- scenario 2: the product is considered to be 100% landfilled
- scenario 3: the product is considered to be 100% recycled

6. LCA: Interpretation

Raw material extraction (A1) and production (A3) phases are the main contributors to all indicators, especially on ADP –elements for A1. Their impacts come from zamak and aluminium extraction and from the turning process for steel. Transport phase (A4) to building site is a non-negligible contributor to the impacts, especially for the ODP indicator.

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.
The results are conservative as complying with the composition given in section 2.6.



7. Requisite evidence

No testing results are required by the PCR part B

8. References

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