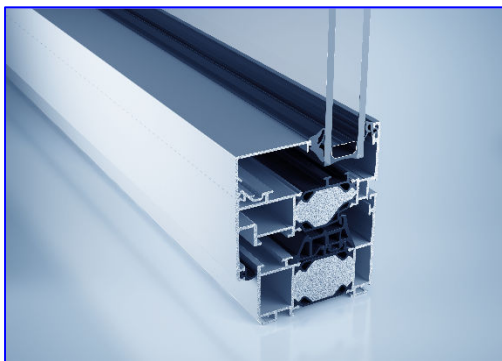


# Environmental Product Declaration



Declaration Code: EPD-AFT-GB-38.0



heroal-Johann Hen-  
kenjohann GmbH &  
Co. KG

## Frame Profiles for Windows and Doors

**D65, D72, D82, D93, W65, W72, W77,  
S65, S42, S77**



**Basis:**

DIN EN ISO 14025  
EN15804

Company EPD  
Environmental  
Product Declaration

Publication date:  
15.04.2021

Next revision:  
15.04.2026



[www.ift-rosenheim.de/  
published EPDs](http://www.ift-rosenheim.de/published-EPDs)

# Environmental Product Declaration



Declaration Code: EPD-AFT-GB-38.0

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<b>Practitioner of the LCA</b>	ift Rosenheim GmbH Theodor-Gietl-Straße 7-9 D-83026 Rosenheim		
<b>Declaration holder</b>	heroal-Johann Henkenjohann GmbH & Co. KG Österwieher Str. 80 33415 Verl		
<b>Declaration code</b>	EPD-AFT-GB-38.0		
<b>Designation of declared product</b>	Frame profiles for aluminium windows and doors D65, D72, D82, D93, W65, W72, W77, S65, S42, S77		
<b>Scope</b>	Window, lifting-sliding door and door systems in aluminium for all building classes		
<b>Basis</b>	This EPD was prepared on the basis of EN ISO 14025:2011 and DIN EN 15804:2012+A1:2013. In addition, the "Allgemeiner Leitfaden zur Erstellung von Typ III Umweltproduktdeklarationen" (Guidance on preparing Type III Environmental Product Declarations) applies. The Declaration is based on the PCR documents EN 17213 "PCR for windows and doors", "PCR Part A" PCR-A-0.2:2018 and "Profiles for windows, doors and façades" PCR-PR-2.1:2018."		
<b>Validity</b>	Publication date: 15.04.2021	Last revision: 15.04.2021	Next revision: 15.04.2026
	This verified Company Environmental Product Declaration (company EPD) applies solely to the specified products and is valid for a period of five years from the date of publication in accordance with DIN EN 15804.		
<b>LCA basis</b>	The LCA was prepared in accordance with DIN EN ISO 14040 and DIN EN ISO 14044. The data are based on both the data compiled from the production site of heroal-Johann Henkenjohann GmbH & Co. KG and the generic data derived from the "GaBi 10" database. LCA calculations were carried out for the included "cradle to gate life cycle with options" (cradle to gate with options) including all upstream chains (e.g. raw material extraction, etc.).		
<b>Notes</b>	The "Conditions and Guidance on the Use of ift Test Documents" apply. The declaration holder assumes full liability for the underlying data, certificates and verifications.		

Christian Kehrer Head of Certification and Surveillance Body	Dr. Torsten Mielecke Chairman of Expert Committee ift-EPD and PCR	Patrick Wortner External verifier



# 1 General product information

## Product definition

The EPD relates to the product group "Windows and Doors" and applies to:

**1 running metre of frame profile for aluminium windows and doors made by heroal-Johann Henkenjohann GmbH & Co. KG.**

The functional unit is obtained by summing up:

Assessed product	Declared unit	Metre weight
Doors	1 running metre	4.63 kg/m
Windows	1 running metre	2.63 kg/m
Lifting-sliding element	1 running metre	2.90 kg/m

Table 1: Product groups

The average unit is declared as follows:

Directly used material flows are determined using the average sizes (window: 1.23 m x 1.48 m, door: 1.23 m x 2.18 m, lifting-sliding element: 3.50 m x 2.18 m) in accordance with EN 17213 and assigned to the declared unit. All other inputs and outputs in the production were scaled to the declared unit in their entirety since no direct assignment to the average size is possible. The reference period is the year 2019.

The validity of the EPD is restricted to the following models:

Product groups		
PG 1 Doors	PG2 Windows	PG 3 Lifting-sliding elements
<b>D72 RL/CL front door RC3</b>	<b>W77 PH</b>	<b>S77</b>
D72 RL/CL front door RC2	W72 PW	S77 SL
D72 front door RC3	W72 CW	W72 PSK
D72 front door RC2	W72 RL/CL	S4
D93	W65	S42 HF
D82	W72 i external	S65
D65 commercial door	W72 HI	
D72 commercial door	W72	
D65 C SP Eloxal	W72 i internal	
	W77i	
	W77	
	W77 HI	
	W72 UD	
	W77 UD	

\*Bold = reference products

**Product description**

The heroyal D65, D72, D82 SP/FP and D93 SP/FP door systems in the form of commercial doors, front doors and fire doors, including associated door thresholds, door leaves/sashes and hardware, offer operational versatility with all the usual types of opening including tested escape and emergency exit routes (as per DIN EN 179/1125), automatic door systems, finger protection doors and burglar resistant doors.

The design of the heroyal distortion-resistant profile compound is characterised by the two-part configuration with inserted insulating strip and slide-in spring. The heroyal profile compound features the same mechanical characteristics (structural properties, transverse tensile loads, etc.) as conventional insulating strips both in the machined and unmachined states.

heroyal W65, W72 and W77 aluminium window systems are offered in a wide variety of shapes and are available as arched, segmented arched and elliptical arched windows. Thanks to the modular design they are compatible with other heroyal systems.

heroyal is the only company to manufacture the complete thermal-break aluminium / PVC composite profiles in a company works on the basis of third-party monitored production in accordance with QM 323. The perfect combination of adhesive cord and knurling applied during the heroyal insulating process ensures above-average rigidity and shear strength of the heroyal aluminium composite profiles.

heroyal S77 and S77 HI is a modular lifting-sliding profile system of modern design that meets the strictest technical requirements for new build and building renovation. It also enables multi-track design variations and accessible, barrier-free systems.

heroyal S77 SL opens up new large dimensions and guarantees maximum transparency thanks to its unique innovative frame design. This heroyal lifting-sliding door generation combines a moving monorail sash with a framed fixed light and offers minimum face widths.

The heroyal S42 and S65 aluminium sliding door system is characterised by its particularly easy and efficient manufacture and an innovative sash design. The pre-mounted labyrinth of the sash profiles also provides for very narrow meeting stiles (central joint). This offers an attractive solution for upmarket residential and commercial non-residential construction.



	Windows		Doors
	Windows	Lifting-sliding	Doors
<b>Profile system</b>			
System dimensions			
Face widths	50–250 mm	35–52 mm	50–250 mm
Frame:	74–254 mm	68–104 mm	74–254 mm
Leaf/sash:	33–67 mm	68–104 mm	56 – 124 mm
Installation depth:	65/72/77 mm	77- 202 mm	65/72/82/93 mm
Thickness of glass / infill panel:	6 - 66 mm	6 - 52 mm	6 - 68 mm / 92 mm
Max. weight of infill panels:	300 kg	400 kg	360 kg
Max. leaf/sash height:	2,800 mm	3,000 mm	3,000 mm
<b>Opening type / direction</b>	Tilt, turn, tilt/turn, tilt-before-turn, French and fixed light; Inward / outward opening	Lifting, sliding, in combination with fixed light, 1-3 track frames	Turn, French, folding, in combination with fixed light; Inward / outward opening
<b>Frame material</b>	3-chamber aluminium/PVC compound		
<b>Construction type</b>	Single, double leaf in punched and unitised construction	Single, multiple systems, in combination with fixed light, 1-3 track frames	Single, double leaf in punched and unitised construction
<b>Thermal-break</b>	Insulators: PA66GF25, PPO/PA-GF20		Insulators: PA66GF25, PA66GF25 LI/Low Lambda
<b>Rebate seal</b>	Different plastics.		
<b>Surface</b>	Wide range of designs with a large selection of standard RAL and DB colours as well as Eloxal, Les Couleurs® Le Corbusier and heroyal Surface Design (SD).		
<b>Sealing systems</b>	Extruded EPDM glazing gaskets		
<b>Glazing gasket</b>	Extruded EPDM glazing gaskets		
<b>Accessories and seals/gaskets</b>	Accessories and hardware as well as quantities according to the heroyal systems.		

For reliable planning and easy installation of additional window shading devices, heroyal provides ideal combination options from the tried and tested heroyal C50 window systems and the high-quality heroyal VS Z solar shading devices.

This EPD does not apply to:

- roof windows because their design differs too much from the declared windows.
- bonded glass systems
- escape and emergency exit doors
- finger protection doors

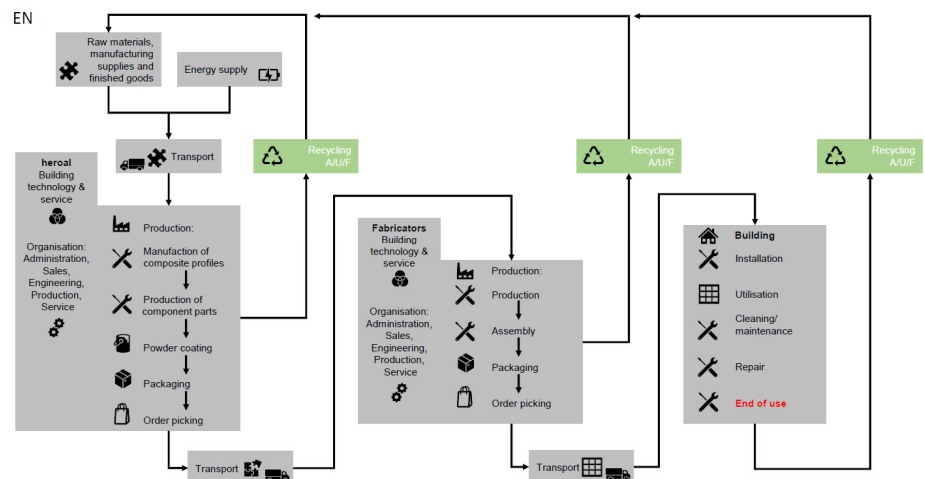
Additional components such as external/internal shutters, e.g. roller shutters, solar shading devices, roller shutter boxes, etc. as well as drive mechanisms for automatic doors must be considered separately.

Additional information for architects:

Also observe the relevant system descriptions from the manufacturer.

For a detailed product description refer to the manufacturer specifications or the product specifications of the respective offer/quotation.

## Product manufacture



## Applications

Aluminium window systems and aluminium door systems for residential and commercial buildings, office and administrative buildings, industrial buildings, sports and cultural buildings, single-family houses and multiple dwellings units.

## Verifications

The following verifications are held:

- product qualities according to MINERGIE® (W72, S77 SL, D72)
- product qualities according to MINERGIE-P® (W77)
- passive house component quality (W77 PH)

For information on further and updated verifications (incl. other national approvals) refer to [www.heroal.de](http://www.heroal.de).

**Quality assurance**

The following quality assurance systems are in place:

- quality assurance according to ift QM323 (W72)
- factory production control (FPC)
- Qualicoat quality seal (powder coating)
- powder coating quality to GSB AL 631-5 (Sea Proof)
- member of A/U/F e.V. (material cycle)

**Management systems**

The following management systems are in place:

- quality management system to DIN EN ISO 9001:2015
- energy management system to DIN EN ISO 50001:2011

**Additional information**

For additional verifications of applicability or conformity refer to the CE marking and the documents accompanying the product, if applicable.

**2 Materials used****Primary materials**

The primary materials used are listed in the LCA (see Section 7).

**Declarable substances**

The product contains no substances from the REACH candidate list (declaration dated 12.05.2020).

All relevant safety data sheets are available from heroal-Johann Henkenjohann GmbH & Co. KG.

**3 Construction process stage****Processing recommendations, installation**

Observe the instructions for assembly/installation, operation, maintenance and disassembly, provided by the manufacturer. For this, see [www.heroal.de](http://www.heroal.de)

**4 Use stage****Emissions to the environment**

No emissions to indoor air, water and soil are known. There may be VOC emissions.

**Reference service life (RSL)**

The RSL information was provided by the manufacturer. The RSL shall refer to the declared technical and functional performance of the product within the building. It shall be established in accordance with specific rules set out in the European product standards and shall also take into account ISO 15686-1, -2, -7 and -8. Where European product standards provide guidance on determining RSL, such guidance shall have priority. If it is not possible to determine the service life as the RSL in accordance with ISO 15686, the BBSR table "Nutzungsdauer von Bauteilen zur Lebenszyklusanalyse nach BNB" (service life of building components for life cycle assessment in accordance with the sustainable construction evaluation system) can be used. For further information and explanations refer to [www.nachhaltigesbauen.de](http://www.nachhaltigesbauen.de).



For this EPD the following applies:

The reference service life (RSL) can be determined for a "cradle to gate with options" EPD only if all of the Modules A1-A3 and B1-B5 are specified;

According to the BBSR table, the Frame profiles for aluminium windows and doors manufactured by heroal-Johann Henkenjohann GmbH & Co. KG have a service life of 50 years.

The service life is dependent on the characteristics of the product and in-use conditions. The characteristics described in the EPD are applicable, in particular the characteristics listed below:

- Outdoor environment: Climatic influences may have a negative impact on the service life.
- Indoor environment: No impacts known that have a negative effect on the service life

The service life solely applies to the characteristics specified in this EPD or the corresponding references.

The reference service life (RSL) does not reflect the actual life span, which is usually determined by the service life and the refurbishment of a building. It does not give any information on the useful life, warranty referring to performance characteristics or guarantees.

## 5 End-of-life stage

### Possible end-of-life stages

The Frame profiles for aluminium windows and doors are shipped to central collection points. There the products are usually shredded and sorted into their constituents. The end-of-life stage depends on the site where the products are used and is therefore subject to the local regulations. Observe the locally applicable regulatory requirements.

This EPD shows the end-of-life modules based on EN 17213 (aluminium windows/doors – Figure B.1). Specific components of metals and glass are recycled; most plastics are thermally recycled. Residual fractions are sent to landfill.

### Disposal routes

The LCA includes the average disposal routes.

**All life cycle scenarios are detailed in the Annex.**





## 6 Life Cycle Assessment (LCA)

Environmental product declarations are based on life cycle assessments (LCAs) which use material and energy flows for the calculation and subsequent representation of environmental impacts.

Life cycle assessments have been developed as the basis for the Frame profiles for aluminium windows and doors. These LCAs are in conformity with the requirements set out in DIN EN 15804 and the international standards DIN EN ISO 14040, DIN EN ISO 14044, ISO 21930 and EN ISO 14025.

The LCA is representative of the products presented in the Declaration and the specified reference period.

### 6.1 Definition of goal and scope

#### Goal

The goal of the LCA is to demonstrate the environmental impacts of the products. In accordance with DIN EN 15804, the environmental impacts covered by this Environmental Product Declaration are presented for the entire product life cycle in the form of basic information. No other additional environmental impacts are specified.

#### Data quality, data availability and geographical and time-related system boundaries

The specific data originate exclusively from the 2019 fiscal year. They were collected on-site at the plant located in 33415 Verl and originate in parts from company records and partly from values directly obtained by measurement. Validity of the data was checked by the ift Rosenheim.

The generic data originate from the "GaBi 10" professional and building materials databases. The last update of both databases was in 2021. Data from before this date originate also from these databases and are not more than 10 years old. No other generic data were used for the calculation.

Data gaps were either filled with comparable data or conservative assumptions, or the data were cut off in compliance with the 1% rule.

The life cycle was modelled using the sustainability software tool "GaBi ts" for the development of life cycle assessments.

#### Scope / system boundaries

The system boundaries refer to the supply of raw materials and purchased parts, manufacture/production, use and end-of-life stage of Frame profiles for aluminium windows and doors. No additional data from pre-suppliers/subcontractors or other sites were taken into consideration.

#### Cut-off criteria

All company data collected, i.e. all commodities/input and raw materials used, the thermal energy and electricity consumption, were taken into consideration.

The boundaries cover only the product-relevant data. Building sections/parts of facilities that are not relevant to the manufacture of the products, were excluded.

The transport distances of the pre-products used were taken into consideration as a function of 100% of the mass of the products.

The transport mix is composed as follows and originates from the research project "EPDs für transparente Bauelemente" (EPDs for transparent building components):

- truck, 26 – 28 t total weight / 18.4 t payload, Euro 6, freight, 85% capacity used, 100 km;
- truck-trailer, 28 – 34 t total weight / 22 t payload, Euro 6, 50% capacity used, 50 km;
- freight train, electrical and diesel driven; D 60%, E 51% capacity used, 50 km
- seagoing vessel, consumption mix, 50 km.

The criteria for the exclusion of inputs and outputs as set out in DIN EN 15804 are fulfilled. From the data analysis it can be assumed that the total of negligible processes per life cycle stage does not exceed 1% of the mass/primary energy. This way the total of negligible processes does not exceed 5% of the energy and mass input. The life cycle calculation also includes material and energy flows that account for less than 1%.

## 6.2 Inventory analysis

### Goal

All material and energy flows are described below. The processes covered are presented as input and output parameters and refer to the declared/functional units.

### Life cycle stages

The Annex shows the entire life cycle of Frame profiles for aluminium windows and doors. The product stage "A1 – A3", construction process stage "A4 – A5", use stage "B2 – B7", end-of-life stage "C1 – C4" and the benefits and loads beyond the system boundaries "D" are considered.

### Benefits

The below benefits have been defined as per DIN EN 15804:

- benefits from recycling
- benefits (thermal and electrical) from incineration

### Allocation of co-products

During manufacture the following allocation takes place:  
The allocation is based on the running metre of the products (physical property). Extrusion waste is recycled directly.

### Allocations for re-use, recycling and recovery

If the products are reused/recycled and recovered during the product stage (rejects), the elements are shredded, if necessary and then sorted into their constituents. This is done by various process plants, e.g. magnetic separators.

The system boundaries were set following their disposal, reaching the end-of-waste status.



**Allocations beyond life cycle boundaries**

The use of recycled materials in the manufacturing process was based on the current market-specific situation. In parallel to this, a recycling potential was taken into consideration that reflects the economic value of the product after recycling (recyclate) .

Secondary material designated as inputs to Frame profiles for aluminium windows and doors is calculated as input without loads. For this no benefits are assigned to Module D, but consumption to Modules C3 and C4 (worse case consideration).

The system boundary set for the recycled material refers to collection.

**Secondary material**

The use of secondary material by heroal-Johann Henkenjohann GmbH & Co. KG was considered in Module A3. Secondary material is used.

**Inputs**

The LCA includes the following production-relevant inputs per 1 running metre of frame profile for windows and doors:

**Energy**

The input material of natural gas is based on "Thermische Energie für Erdgas Deutschland" (thermal energy for natural gas Germany). Diesel is based on "Diesel Mix Deutschland" (Diesel mix Germany). Distant heating is based on "Fernwärme Deutschland" (distant heating Germany). Electricity mix is based on "Strommix heroal (heroal electricity mix) (see Table 2).

Electricity disclosure of energy supplier	Shares in %
Renewable energies	68
Natural gas	5
Coal	22
Other fossil resources	4
Nuclear energy	1

Table 2: "heroal" electricity mix"

A portion of the process heat is used for space heating. This can, however, not be quantified, hence a "worst case" figure was taken into account for the product.

**Water**

The water consumed by the individual process steps for the manufacture amounts to a total of 3.09 l per running metre of door profile, 3.02 l per running metre of window profile and 2.74 l per running metre of lifting-sliding element profile.

The consumption of fresh water specified in Section 6.3 originates (among others) from the process chain of the pre-products and the process water for cooling.

**Raw material / pre-products**

The charts below show the share of raw materials/pre-products in percent.

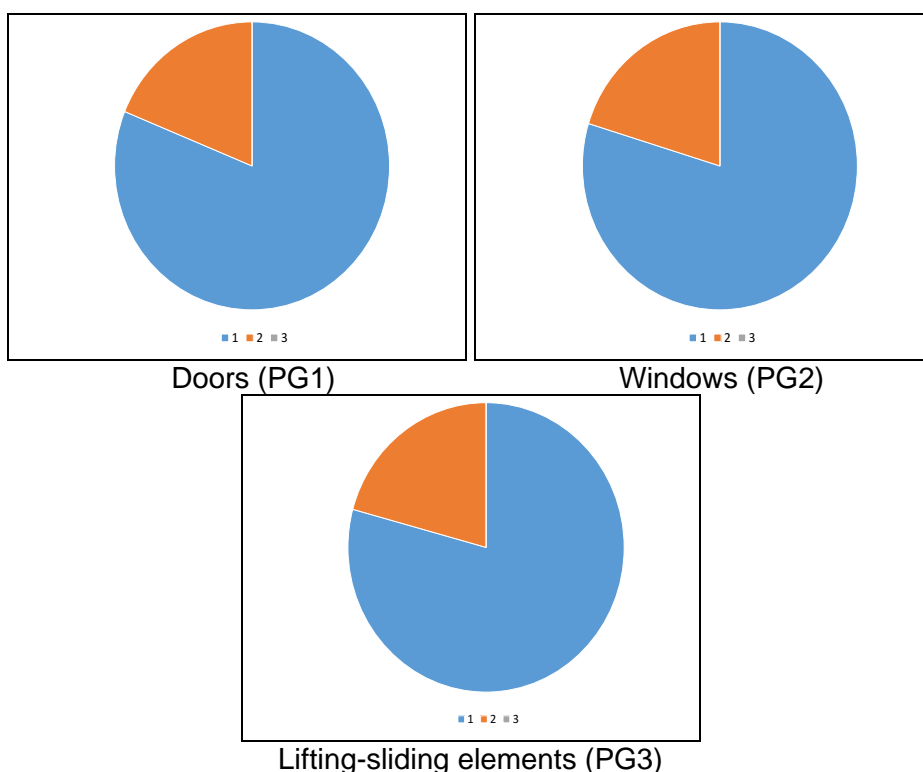


Figure 1: Percentage of individual materials per declared unit

No.	Material	Mass in %		
		PG1	PG2	PG3
1	Metals	81.16	79.76	79.25
2	Plastics	18.84	20.24	20.75
3	Other	0.00	0.00	0.00

Table 3: Percentage of individual materials per declared unit

**Ancillary materials and consumables**

6.81 g of ancillary materials and consumables are used per running metre of door profile, 6.66 g per running metre of window profile and 6.05 g per running metre of lifting-sliding profile.

**Product packaging**

The amounts used for product packaging are as follows:

No.	Material	Mass in g		
		PG1	PG2	PG3
1	Wood	0.50	0.49	0.45
2	Cardboard	64.19	62.73	57.05
3	PE film	70.07	68.49	62.27

Table 4: Weight in kg of packaging per declared unit

**Outputs**

The LCA includes the following production-relevant outputs per 1 running metre of frame profile for windows and doors:

**Waste**

Secondary raw materials were included in the benefits.  
See Section 6.3 Impact assessment.

**Waste water**

Manufacture produces 2.56 l waste water per running metre of door profile, 2.52 l waste water per running metre of window profile and 2.29 l waste water per running metre of lifting-sliding element profile.

**6.3 Impact assessment****Goal**

The impact assessment covers both inputs and outputs. The impact categories applied are stated below:

**Impact categories**

The models for impact assessment were applied as described in DIN EN 15804-A1.

The impact categories presented in the EPD are as follows:

- depletion of abiotic resources (fossil fuels);
- depletion of abiotic resources (mineral substances);
- acidification of soil and water;
- ozone depletion;
- global warming;
- eutrophication;
- photochemical ozone creation.

**Waste**

The waste generated during the production of 1 running metre of frame profile for windows and doors is evaluated and shown separately for the fractions trade wastes, special wastes and radioactive wastes. Since waste handling is modelled within the system boundaries, the amounts shown refer to the deposited wastes. A portion of the waste indicated is generated during the manufacture of the pre-products.

Results per 1 running metre of frame profile for aluminium doors (PG1)																
ift ROSENHEIM	Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
<b>Central environmental impacts</b>																
GWP	kg CO <sub>2</sub> eq.	30.10	0.79	0.14	-	8.40	1.46	0.00	16.69	0.00	0.00	0.00	0.22	2.84	3,32E-03	-17.80
ODP	kg CFC -11 eq.	6.70E-09	1.37E-16	2.10E-17	-	1.81E-14	1.06E-14	0.00	6.70E-09	0.00	0.00	0.00	3.79E-17	2.04E-15	1.82E-17	-5.10E-14
AP	kg SO <sub>2</sub> eq.	0.09	1,82E-03	1,46E-05	-	8,25E-03	9,37E-04	0.00	2,14E-02	0.00	0.00	0.00	4,19E-04	2,77E-04	2,00E-05	-7,30E-02
EP	kg PO <sub>4</sub> <sup>3-</sup> eq.	9,01E-03	4,53E-04	3,01E-06	-	1,37E-03	1,46E-04	0.00	5,39E-03	0.00	0.00	0.00	1,04E-04	5,01E-05	2,27E-06	-4,29E-03
POCP	kg ethene eq.	5,50E-03	-6,47E-04	1,22E-06	-	2,25E-03	1,34E-04	0.00	7,35E-04	0.00	0.00	0.00	-1,36E-04	2,57E-05	1,52E-06	-4,05E-03
ADPE	kg Sb eq.	2,17E-05	6,86E-08	1,39E-09	-	1,83E-06	1,87E-07	0.00	1,55E-05	0.00	0.00	0.00	1,89E-08	3,37E-08	1,22E-09	-6,35E-06
ADPF	MJ	385.00	10.70	2,23E-02	-	257.00	20.10	0.00	203.62	0.00	0.00	0.00	2.95	0.91	4,53E-02	-201.00
<b>Use of resources</b>																
PERE	MJ	155.00	0.60	1.04	-	3.68	2.00	0.00	59.03	0.00	0.00	0.00	0.17	0.52	6,26E-03	-99.90
PERM	MJ	0.22	0.00	-1.04	-	0.00	0.00	0.00	-0.82	0.00	0.00	0.00	0.00	0.00	0.00	0.00
PERT	MJ	155.00	0.60	4,99E-03	-	3.68	2.00	0.00	57.99	0.00	0.00	0.00	0.17	0.52	6,26E-03	-99.90
PENRE	MJ	437.00	10.70	1.46	-	258.00	20.90	0.00	241.67	0.00	0.00	0.00	2.96	19.54	1.01	-238.00
PENRM	MJ	2.32	0.00	-1.44	-	0.00	0.00	0.00	-18.30	0.00	0.00	0.00	0.00	-18.22	-0.96	0.00
PENRT	MJ	439.00	10.70	2,58E-02	-	258.00	20.90	0.00	223.05	0.00	0.00	0.00	2.96	1.32	4,65E-02	-238.00
SM	kg	0.20	0.00	0.00	-	0.00	0.00	0.00	0.20	0.00	0.00	0.00	0.00	0.00	0.00	0.00
RSF	MJ	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
NRSF	MJ	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
FW	m <sup>3</sup>	0.31	6,85E-04	3,41E-04	-	4,84E-02	4,41E-03	0.00	7,37E-02	0.00	0.00	0.00	1,89E-04	6,45E-03	1,15E-05	-0.24
<b>Waste categories</b>																
HWD	kg	4,30E-06	5,41E-10	4,70E-12	-	3,51E-08	2,74E-09	0.00	4,28E-06	0.00	0.00	0.00	1,49E-10	3,20E-10	4,94E-12	-2,29E-08
NHWD	kg	5.34	1,60E-03	1,72E-03	-	7,76E-02	9,49E-03	0.00	0.78	0.00	0.00	0.00	4,40E-04	1,17E-02	0.23	-4.81
RWD	kg	2,13E-02	1,30E-05	1,38E-06	-	5,77E-04	3,08E-04	0.00	7,48E-03	0.00	0.00	0.00	3,58E-06	1,66E-04	4,88E-07	-1,45E-02
<b>Output material flows</b>																
CRU	kg	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
MFR	kg	4,01E-02	0.00	0.00	-	0.00	0.00	0.00	3.55	0.00	0.00	0.00	0.00	3.51	0.00	0.00
MER	kg	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
EEE	MJ	0.18	0.00	0.28	-	0.00	1.67	0.00	6.40	0.00	0.00	0.00	0.00	5.94	0.00	0.00
EET	MJ	0.40	0.00	0.50	-	0.00	2.97	0.00	11.50	0.00	0.00	0.00	0.00	10.60	0.00	0.00

**Key:**

**GWP** – global warming potential    **ODP** – ozone depletion potential    **AP** - acidification potential    **EP** - eutrophication potential    **POCP** - photochemical ozone formation potential    **ADPE** - abiotic depletion potential – non-fossil resources    **ADPF** - abiotic depletion potential – fossil resources    **PERE** - Use of renewable primary energy    **PERM** - use of renewable primary energy resources    **PERT** - total use of renewable primary energy resources    **PENRE** - use of non-renewable primary energy    **PENRM** - use of non-renewable primary energy resources    **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** - net use of fresh water    **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 per 1 running metre of frame profile for aluminium windows (PG2)																
ift ROSENHEIM	Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
<b>Central environmental impacts</b>																
GWP	kg CO <sub>2</sub> eq.	28.00	0.45	0.11	-	4.02	1.67	0.00	21.08	0.00	0.00	0.00	0.12	1.72	1.89E-03	-9.77
ODP	kg CFC -11 eq.	5.28E-09	7.83E-17	1.65E-17	-	8.64E-15	1.22E-14	0.00	5.28E-09	0.00	0.00	0.00	2.15E-17	1.93E-15	1.03E-17	-3.23E-14
AP	kg SO <sub>2</sub> eq.	0.08	1.04E-03	1.15E-05	-	3.95E-03	1.08E-03	0.00	4.75E-02	0.00	0.00	0.00	2.38E-04	2.08E-04	1.14E-05	-3.91E-02
EP	kg PO <sub>4</sub> <sup>3-</sup> eq.	7.85E-03	2.59E-04	2.37E-06	-	6.57E-04	1.68E-04	0.00	5.95E-03	0.00	0.00	0.00	5.88E-05	3.50E-05	1.29E-06	-2.33E-03
POCP	kg ethene eq.	5.18E-03	-3.69E-04	9.60E-07	-	1.08E-03	1.54E-04	0.00	2.61E-03	0.00	0.00	0.00	-7.73E-05	1.85E-05	8.65E-07	-2.18E-03
ADPE	kg Sb eq.	1.55E-05	3.91E-08	1.09E-09	-	8.77E-07	2.14E-07	0.00	1.22E-05	0.00	0.00	0.00	1.07E-08	2.76E-08	6.94E-10	-3.49E-06
ADPF	MJ	366.00	6.10	1.76E-02	-	123.00	23.00	0.00	269.61	0.00	0.00	0.00	1.68	0.79	2.57E-02	-112.00
<b>Use of resources</b>																
PERE	MJ	146.00	0.34	1.02	-	1.76	2.29	0.00	95.35	0.00	0.00	0.00	9.37E-02	0.49	3.55E-03	-54.30
PERM	MJ	0.18	0.00	-1.01	-	0.00	0.00	0.00	-0.83	0.00	0.00	0.00	0.00	0.00	0.00	0.00
PERT	MJ	147.00	0.34	3.93E-03	-	1.76	2.29	0.00	95.34	0.00	0.00	0.00	9.37E-02	0.49	3.55E-03	-54.30
PENRE	MJ	416.00	6.12	1.42	-	124.00	23.90	0.00	313.90	0.00	0.00	0.00	1.68	12.07	0.60	-132.00
PENRM	MJ	2.29	0.00	-1.40	-	0.00	0.00	0.00	-10.57	0.00	0.00	0.00	0.00	-10.88	-0.57	0.00
PENRT	MJ	418.00	6.12	2.03E-02	-	124.00	23.90	0.00	303.04	0.00	0.00	0.00	1.68	1.19	2.64E-02	-132.00
SM	kg	0.19	0.00	0.00	-	0.00	0.00	0.00	0.19	0.00	0.00	0.00	0.00	0.00	0.00	0.00
RSF	MJ	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
NRSF	MJ	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
FW	m <sup>3</sup>	0.26	3.91E-04	2.69E-04	-	2.32E-02	5.06E-03	0.00	0.14	0.00	0.00	0.00	1.07E-04	4.03E-03	6.51E-06	-0.13
<b>Waste categories</b>																
HWD	kg	1.08E-06	3.09E-10	3.70E-12	-	1.68E-08	3.15E-09	0.00	1.07E-06	0.00	0.00	0.00	8.47E-11	2.96E-10	2.80E-12	-1.35E-08
NHWD	kg	5.13	9.10E-04	1.35E-03	-	3.72E-02	1.09E-02	0.00	2.72	0.00	0.00	0.00	2.50E-04	7.29E-03	0.13	-2.55
RWD	kg	2.04E-02	7.41E-06	1.09E-06	-	2.76E-04	3.53E-04	0.00	1.30E-02	0.00	0.00	0.00	2.03E-06	1.58E-04	2.77E-07	-8.12E-03
<b>Output material flows</b>																
CRU	kg	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
MFR	kg	3.16E-02	0.00	0.00	-	0.00	0.00	0.00	2.00	0.00	0.00	0.00	0.00	1.97	0.00	0.00
MER	kg	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
EEE	MJ	0.14	0.00	0.22	-	0.00	1.92	0.00	3.91	0.00	0.00	0.00	0.00	3.55	0.00	0.00
EET	MJ	0.31	0.00	0.39	-	0.00	3.41	0.00	7.02	0.00	0.00	0.00	0.00	6.31	0.00	0.00

**Key:**

**GWP** – global warming potential    **ODP** – ozone depletion potential    **AP** - acidification potential    **EP** - eutrophication potential    **POCP** - photochemical ozone formation potential    **ADPE** - abiotic depletion potential – non-fossil resources    **ADPF** - abiotic depletion potential – fossil resources    **PERE** - Use of renewable primary energy    **PERM** - use of renewable primary energy resources    **PERT** - total use of renewable primary energy resources    **PENRE** - use of non-renewable primary energy    **PENRM** - use of non-renewable primary energy resources    **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** - net use of fresh water    **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 per 1 running metre of frame profile for aluminium lifting-sliding elements (PG3)																
ift ROSENHEIM	Unit	A1-A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
<b>Central environmental impacts</b>																
GWP	kg CO <sub>2</sub> eq.	31.50	0.49	0.13	-	1.21	1.42	0.00	25.06	0.00	0.00	0.00	0.14	1.97	2.08E-03	-9.54
ODP	kg CFC -11 eq.	6.00E-09	8.64E-17	1.87E-17	-	2.60E-15	1.04E-14	0.00	6.00E-09	0.00	0.00	0.00	2.37E-17	1.95E-15	1.14E-17	-3.32E-14
AP	kg SO <sub>2</sub> eq.	0.10	1.15E-03	1.30E-05	-	1.19E-03	9.14E-04	0.00	6.01E-02	0.00	0.00	0.00	2.62E-04	2.24E-04	1.25E-05	-3.79E-02
EP	kg PO <sub>4</sub> <sup>3-</sup> eq.	9.45E-03	2.85E-04	2.67E-06	-	1.98E-04	1.43E-04	0.00	7.63E-03	0.00	0.00	0.00	6.49E-05	3.84E-05	1.42E-06	-2.27E-03
POCP	kg ethene eq.	5.83E-03	-4.07E-04	1.08E-06	-	3.24E-04	1.31E-04	0.00	3.28E-03	0.00	0.00	0.00	-8.53E-05	2.01E-05	9.54E-07	-2.12E-03
ADPE	kg Sb eq.	2.53E-05	4.32E-08	1.24E-09	-	2.64E-07	1.82E-07	0.00	2.06E-05	0.00	0.00	0.00	1.19E-08	2.90E-08	7.65E-10	-4.89E-06
ADPF	MJ	406.00	6.74	1.99E-02	-	36.90	19.60	0.00	311.45	0.00	0.00	0.00	1.85	0.82	2.83E-02	-109.00
<b>Use of resources</b>																
PERE	MJ	160.00	0.38	0.92	-	0.53	1.95	0.00	110.61	0.00	0.00	0.00	0.10	0.50	3.92E-03	-52.70
PERM	MJ	0.18	0.00	-0.92	-	0.00	0.00	0.00	-0.74	0.00	0.00	0.00	0.00	0.00	0.00	0.00
PERT	MJ	160.00	0.38	4.44E-03	-	0.53	1.95	0.00	109.69	0.00	0.00	0.00	0.10	0.50	3.92E-03	-52.70
PENRE	MJ	460.00	6.76	1.30	-	37.20	20.40	0.00	361.37	0.00	0.00	0.00	1.85	13.77	0.69	-129.00
PENRM	MJ	3.48	0.00	-1.28	-	0.00	0.00	0.00	-11.01	0.00	0.00	0.00	0.00	-12.55	-0.66	0.00
PENRT	MJ	464.00	6.76	2.30E-02	-	37.20	20.40	0.00	350.88	0.00	0.00	0.00	1.85	1.22	2.91E-02	-129.00
SM	kg	0.20	0.00	0.00	-	0.00	0.00	0.00	0.20	0.00	0.00	0.00	0.00	0.00	0.00	0.00
RSF	MJ	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
NRSF	MJ	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
FW	m <sup>3</sup>	0.32	4.31E-04	3.03E-04	-	6.98E-03	4.30E-03	0.00	0.20	0.00	0.00	0.00	1.18E-04	4.58E-03	7.18E-06	-0.13
<b>Waste categories</b>																
HWD	kg	1.22E-04	3.41E-10	4.18E-12	-	5.06E-09	2.68E-09	0.00	1.22E-04	0.00	0.00	0.00	9.34E-11	3.02E-10	3.09E-12	-1.35E-08
NHWD	kg	5.56	1.00E-03	1.53E-03	-	1.12E-02	9.26E-03	0.00	3.27	0.00	0.00	0.00	2.75E-04	8.30E-03	0.15	-2.46
RWD	kg	2.24E-02	8.17E-06	1.23E-06	-	8.30E-05	3.00E-04	0.00	1.51E-02	0.00	0.00	0.00	2.24E-06	1.60E-04	3.06E-07	-7.97E-03
<b>Output material flows</b>																
CRU	kg	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
MFR	kg	3.56E-02	0.00	0.00	-	0.00	0.00	0.00	2.18	0.00	0.00	0.00	0.00	2.14	0.00	0.00
MER	kg	0.00	0.00	0.00	-	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
EEE	MJ	0.16	0.00	0.25	-	0.00	1.63	0.00	4.50	0.00	0.00	0.00	0.00	4.09	0.00	0.00
EET	MJ	0.36	0.00	0.44	-	0.00	2.90	0.00	8.07	0.00	0.00	0.00	0.00	7.27	0.00	0.00

**Key:**

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#### 6.4 Interpretation, LCA presentation and critical review

##### Evaluation

The environmental impacts of

- frame profiles for aluminium doors
- frame profiles for aluminium windows
- frame profiles for aluminium lifting-sliding elements

differ considerably from each other. The differences result mainly from the amount of pre-products and raw materials used. This was to be expected in particular due to the use of anodised aluminium profiles.

The environmental impacts of the manufacture result mainly from the use of aluminium / its upstream chains and the anodisation of the profiles. For the frame profiles for doors and lifting-sliding elements, the use of insulating strips and their upstream chains presents an additional factor that must be taken into account.

The cleaning operations using glass cleaners containing ethanol and isopropanol over the 50-year use stage also play a notable role in environmental impacts. Additional central values during the use stage originate from the one-off replacement of frame profiles in the context of building renovation during a 50-year time period.

For scenario C4 only marginal consumptions arising from the physical pre-treatment and management of the disposal site are expected. Allocation to individual products is almost impossible for site disposal. In terms of product recycling, for aluminium between 20% and 34% of the environmental impacts arising during the life cycle can be assigned as benefits to scenario D, depending on the product group.

The charts below show the allocation of the main environmental impacts.

**The values obtained from the LCA calculation are suitable for the certification of buildings.**

**Charts**

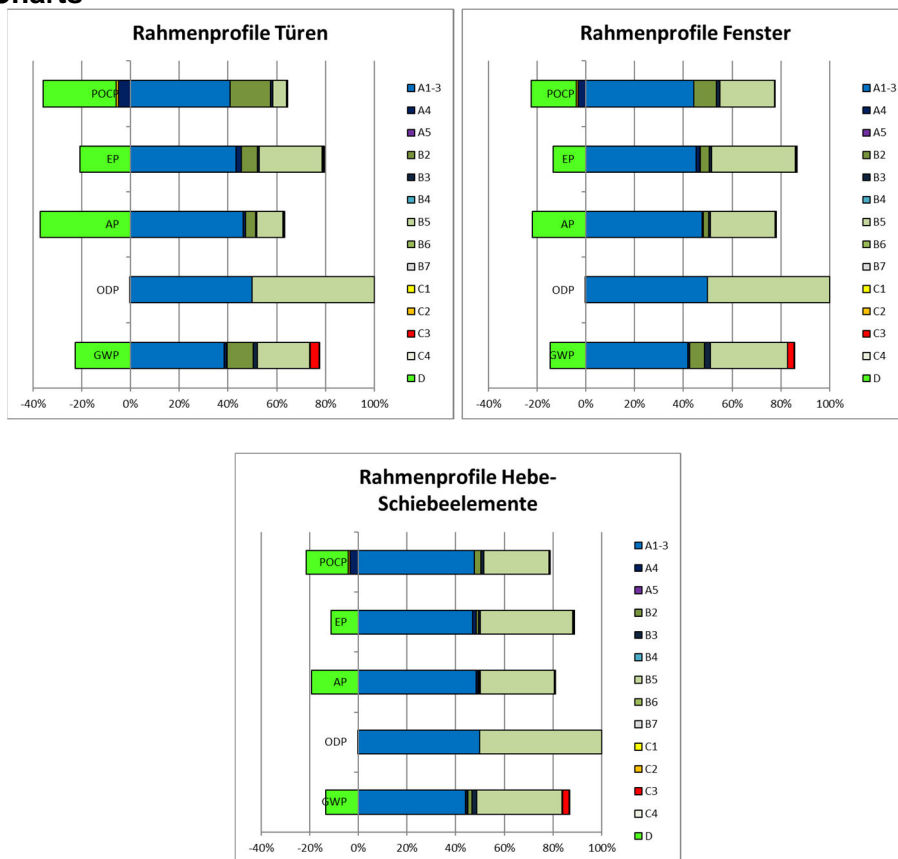


Figure 2: Percentage of the modules in selected environmental impact categories

**Report**

The LCA report underlying this EPD was developed according to the requirements of DIN EN ISO 14040 and DIN EN ISO 14044 as well as DIN EN 15804 and DIN EN ISO 14025. It is not addressed to third parties for reasons of confidentiality. It is deposited with the ift Rosenheim. The results and conclusions reported to the target group are complete, correct, without bias and transparent. The results of the study are not designed to be used for comparative statements intended for publication.

**Critical review**

The critical review of the LCA and of the report took place in the course of verification of the EPD and was carried out by Patrick Wortner, MBA and Eng., Dipl.-Ing. (FH), an external verifier.

**7 General information regarding the EPD**

**Comparability**

This EPD was prepared in accordance with DIN EN 15804 and is therefore only comparable to those EPDs that also comply with the requirements set out in DIN EN 15804. Any comparison must refer to the building context and the same boundary conditions of the various life cycle stages. For comparing EPDs of construction products, the rules set out in DIN EN 15804 (Clause 5.3) apply.



Product group: "Windows and Doors"

The detailed individual results of the products were summarised on the basis of conservative assumptions and differ from the average results. Identification of the product groups and the resulting variations are documented in the background report.

**Communication**

The communications format of this EPD meets the requirements of EN 15942:2012 and is therefore the basis for B2B communication. Only the nomenclature has been changed according to DIN EN 15804.

**Verification**

Verification of the Environmental Product Declaration is documented in accordance with the ift "Richtlinie zur Erstellung von Typ III Umweltproduktdeklarationen" (Guidance on preparing Type III Environmental Product Declarations) in accordance with the requirements set out in DIN EN ISO 14025.

The Declaration is based on the PCR - documents EN 17213 "PCR for windows and doors", "PCR Part A" PCR-A-0.2:2018 and "Profiles for windows, doors and façades" PCR-PR-2.1:2018."

The European standard EN 15804 serves as the core PCR <sup>a)</sup>
Independent verification of the Declaration and statement according to EN ISO 14025:2010 <input type="checkbox"/> internal <input checked="" type="checkbox"/> external
Independent third-party verifier: <sup>b)</sup> Patrick Wortner
<sup>a)</sup> Product category rules <sup>b)</sup> Optional for business-to-business communication Mandatory for business-to-consumer communication (see EN ISO 14025:2010, 9.4)

**Revisions of this document**

No.	Date	Note:	Practitioner of the LCA	Verifier
1	14.04.2021	External Verification	Zwick	Wortner

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Product group: "Windows and Doors"

30. **PCR Part A.** *Product category rules for environmental product declarations as per EN ISO 14025 and EN 15804.*

Rosenheim: ift Rosenheim, 2018



## 9 Annex

### Description of life cycle scenarios for Frame profiles for aluminium windows and doors

Product stage			Construction stage		Use stage							End-of-life stage				Benefits and loads from beyond the system boundaries
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Raw material supply	Transport	Manufacture	Transport	Construction/Installation	Use	Inspection, maintenance, cleaning	Repair	Exchange / Replacement	Improvement / Modernisation	Operational energy use	Operational water use	Deconstruction	Transport	Waste management	Disposal	Re-use Recovery Recycling potential
✓	✓	✓	✓	✓	—	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

Calculation of the scenarios was based on a building service life of 50 years (in accordance with RSL of Section 4 Use stage).

The scenarios were based on information provided by the manufacturer. The scenarios were furthermore based on the research project "EPDs for transparent building components" (1).

**Note:** The standard scenarios selected are presented in bold type. They were also used for calculating the indicators in the summary table.

- ✓ Included in the LCA
- Not included in the LCA



<b>A4 Transport to the construction site</b>		
No.	Scenario	Description
A4	Small series via local manufacturers	7.5 t truck (Euro 0-6 mix), 2.7 t payload, full capacity, approx. 50 km to site and empty return trip as well as 7.5 t truck (Euro 0-6 mix), 2.7 t payload, 20% load, approx. 50 km to site and empty return trip
Weights: PG1: 4.77 kg/running metre, PG2: 2.76 kg/running metre, PG3: 3.02 kg/running metre		
Since only one scenario is used, the results are shown in the relevant summary table.		
<b>A5 Construction/Installation</b>		
No.	Scenario	Description
A5	Manual	The elements are installed without mechanical handling.
In case of deviating consumption during installation/assembly of the products which forms part of site management, they are covered at the building level.		
Ancillary materials, consumables, use of energy and water, material losses and waste as well as transport distances during installation are negligible.		
It is assumed that the packaging material in the Module construction / installation is sent to waste handling. Waste is only thermally recycled in line with the conservative approach. Benefits from A5 are specified in Module D. Benefits from waste incineration: electricity replaces electricity mix (EU 28); thermal energy replaces thermal energy from natural gas (EU 28). Transport to the recycling plants is not taken into account.		
Since only one scenario is used, the results are shown in the relevant summary table.		
<b>B1 Use (not included)</b>		
Refer to Section 5 Use stage - Emissions to the environment. Emissions cannot be quantified.		
<b>B2 Inspection, maintenance, cleaning</b>		
Since only one scenario is used, the results are shown in the relevant summary table.		
<b>B2.1 Cleaning</b>		
No.	Scenario	Description
B2.1	Rarely, manual	Less than 2.5 m height or industrial climber, manually using suitable cleaning agents, annually 2.5 l consumed per 1 m <sup>2</sup> and cleaning (1) (PG1: 21.40 l / 50 yr, PG2: 10.25 l / 50 yr, PG3: 3.08 l / 50 yr per running metre)
Ancillary materials, consumables, use of energy and water, material losses and waste as well as transport distances during cleaning are negligible.		
Since only one scenario is used, the results are shown in the relevant summary table.		



<b>B2.2 Maintenance</b>		
<b>No.</b>	<b>Scenario</b>	<b>Description</b>
B2.2	Normal use (e.g. office or public buildings)	Annual functional check, visual inspection, greasing/lubrication of hardware and, if necessary, repair. Lubricants per 50 yr: PG1: 0.044 kg, PG2: 0.021 kg, PG3: 0.006 kg per running metre
Ancillary materials, consumables, use of energy and water, waste, material losses and transport distances during maintenance are negligible.		
Since only one scenario is used, the results are shown in the relevant summary table.		
<b>B3 Repair</b>		
<b>No.</b>	<b>Scenario</b>	<b>Description</b>
B3	Normal use and heavy use	One replacement*: total hardware and seals/gaskets (1)
* Assumptions for evaluation of possible environmental impacts; statements made do not constitute any guaranty or warranty of performance.		
For updated information refer to the relevant instructions for assembly/installation, operation and maintenance from heroal-Johann Henkenjohann GmbH & Co. KG .		
Ancillary materials, consumables, use of energy and water, waste, material losses and transport distances during repair are negligible.		
Since only one scenario is used, the results are shown in the relevant summary table.		
<b>B4 Interchange / replacement (not relevant)</b>		
<b>No.</b>	<b>Scenario</b>	<b>Description</b>
B4	Normal use and heavy use	No replacement over a 50 year period*
<b>B5 Improvement / modernisation</b>		
<b>No.</b>	<b>Scenario</b>	<b>Description</b>
B5	Normal use and heavy use	One replacement in the context of upgrade / renovation / refurbishment of the building*
The environmental impacts of the selected scenario originate from the product, construction and disposal phases.		
Ancillary materials, consumables, use of energy and water, waste, material losses and transport distances are taken into account.		
For updated information refer to the relevant instructions for assembly/installation, operation and maintenance from heroal-Johann Henkenjohann GmbH & Co. KG .		
Since only one scenario is used, the results are shown in the relevant summary table.		



**B6 Operational energy use (not relevant)**

There is no energy consumption during normal use.

There is no transport consumption for energy use in buildings. Ancillary materials, consumables and water, waste materials and other scenarios are negligible.

Since only one scenario is used, the results are shown in the relevant summary table.

**B7 Operational water use (not relevant)**

No water consumption when used as intended. Water consumption for cleaning is specified in Module B2.1.

There is no transport consumption for water use in buildings. Ancillary materials, consumables, waste materials and other scenarios are negligible.

Since only one scenario is used, the results are shown in the relevant summary table.

**C1 Deconstruction**

No.	Scenario	Description
C1	Deconstruction	Based on EN 17213 (metal windows/doors – Figure B.1): 95% deconstruction; Remainder to landfill.  Further deconstruction rates are possible, give adequate reasons.

No relevant inputs or outputs apply to the scenario selected. The energy consumed for deconstruction is negligible. Any arising consumption is marginal.

Since only one scenario is used, the results are shown in the summary table.

In case of deviating consumption the removal of the products forms part of site management and is covered at the building level.

**C2 Transport**

No.	Scenario	Description
C2	Transport	Transport to collection point using 7.5 t truck (Euro 0-6 mix), full capacity, approx. 50 km to collection point and empty return trip. From collection point to recycling plant using 34 - 40 t truck (Euro 0-6 mix), 27 t payload, full capacity, approx. 150 km and empty return trip.

Since only one scenario is used, the results are shown in the summary table.



<b>C3 Waste management</b>				
<b>No.</b>	<b>Scenario</b>	<b>Description</b>		
C3	Disposal	Share for recirculation of materials: <ul style="list-style-type: none"> <li>• 100% metals in melt</li> <li>• 100% plastics thermal recycling in waste incineration plant (R1&gt;0.6)</li> <li>• remainder to landfill</li> </ul>		
As the products are placed on the European market, the disposal scenario is based on average European data sets.				
The below table presents the disposal processes and their percentage by mass/weight. The calculation is based on the above mentioned shares in percent related to the declared unit of the product system.				
<b>C3 Disposal</b>	<b>Unit</b>	<b>PG1</b>	<b>PG2</b>	<b>PG3</b>
Collection process, collected separately	kg	4.40	2.50	2.78
Collection process, collected as mixed construction waste	kg	0.23	0.13	0.15
Recovery system, for re-use	kg	0.00	0.00	0.00
Recovery system, for recycling	kg	3.51	1.97	2.14
Recovery system, for energy recovery	kg	0.89	0.53	0.61
Disposal	kg	0.25	0.14	0.16
Since only one scenario is used, the results are shown in the summary table.				
<b>C4 Disposal</b>				
<b>No.</b>	<b>Scenario</b>	<b>Description</b>		
C4	Disposal	The non-recordable amounts and losses within the re-use/recycling chain (C1 and C3) are modelled as "disposed".		
The consumption in scenario C4 results from physical pre-treatment, waste recycling and management of the disposal site. The benefits obtained here from the substitution of primary material production are allocated to Module D, e.g. electricity and heat from waste incineration.				
Since only one scenario is used, the results are shown in the summary table.				



D Benefits and loads from beyond the system boundaries		
No.	Scenario	Description
D	Recycling potential	Aluminium recyclate from C3 excluding the recyclate used in A3 replaces 60% of aluminium compound; Stainless steel scrap from C3 excluding the scrap used in A3 replaces 60% of stainless steel; Steel scrap from C3 excluding the scrap used in A3 replaces 60% of steel; Benefits from waste incineration: electricity replaces electricity mix (EU-28); thermal energy replaces thermal energy from natural gas (EU-28).
<p>The values in Module D result from recycling of the packaging material in Module A5 and from deconstruction at the end of service life.</p> <p>Since only one scenario is used, the results are shown in the summary table.</p>		

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### **Notes**

This EPD is mainly based on the work and findings of the Institut für Fenstertechnik e.V., Rosenheim (ift Rosenheim) and specifically on the ift-Richtlinie NA-01/3 Allgemeiner Leitfaden zur Erstellung von Typ III Umweltproduktdeklarationen. (Guideline NA.01/3 - Guidance on preparing Type III Environmental Product Declarations)

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