

# Environmental Product Declaration

In accordance with  
ISO 14025 and EN 15804:  
2012+A2:2019 for:

**Technishield 50  
13mm-Glazed Rebated Door**



THE INTERNATIONAL EPD® SYSTEM  
EPD INTERNATIONAL AB  
EPD REGISTRATION NUMBER S-P-06715  
ISSUED ON 2022-11-01  
VALID TO 2027-10-27

An EPD should provide current information  
and may be updated if conditions change.  
The stated validity is therefore subject to the  
continued registration and publication at  
[www.environdec.com](http://www.environdec.com)



# Optima

# Introduction

---

Optima Products Limited (OPL) is a UK-based manufacturer of glazed partition systems and doors. Based in Radstock, Bath, OPL has been designing and producing innovative and performance-driven glass-based partition and door systems since the 1980s.

This EPD provides environmental performance indicators for OPL's Technishield 50 13mm-glazed rebated door. It is a cradle-to-gate with options EPD in accordance with the requirements of EN 15804, covering modules A1-A5, C1-C4 and D defined in that standard.

The EPD is based on a life cycle assessment (LCA) study which used production data for the 12-month period 1st January to 31st December 2019 from OPL's manufacturing facility in Radstock, UK.

The EPD presents details of the LCA, a description of the product life cycle it covers, values for the environmental indicators specified by EN 15804:2012 + A2:2019 with a brief explanation of those results; indicators required by EN 15804:2012 + A1:2013 are also included to ensure acceptance by the widest possible base of users. The declared unit is 1m<sup>2</sup> (including packaging).

## Company Profile

---

OPL designs and produces steel-framed glass doors from its manufacturing base in Radstock. The manufacturing facility uses the latest design techniques to ensure high quality products which are rigorously tested both in-house and externally before going to market.

The OPL product range is sold and installed through the Optima contracting divisions in the UK, Dubai and Kuala Lumpur and through a worldwide network of selected contracting partners.

OPL puts quality at the heart of design and production management, and operates a quality management system accredited to ISO 9001: 2015 (bmtrada certificate 2367).

In keeping with OPL's determination to drive good environmental practice in the entire product cycle, OPL operates an environmental management system accredited to ISO 14001: 2015 (bmtrada certificate 1827). In addition, it is a requirement on all our principal supply chain partners that they also operate similar systems.

### Contact

Andrew Stammers, HSQE Manager  
Andrew.Stammers@OptimaSystems.com  
T: +44 (0) 1761 433461

**Optima Products Limited**  
www.optimasystems.com  
Mill Road, Radstock,  
Bath BA3 5TX, UK

TECHNISHIELD 50 13MM-GLAZED REBATED DOOR

EPD programme:	The International EPD® System
EPD programme operator:	EPD International AB - Box 210 60 - SE-100 31 Stockholm - Sweden <a href="http://www.environdec.com">www.environdec.com</a>
EPD owner:	Optima Products Limited, Mill Road, Radstock, Bath BA3 5TX, UK <a href="http://www.optimasystems.com">www.optimasystems.com</a>
EPD registration No:	S-P-06715
Date of publication:	2022-11-01
EPD valid until:	2027-10-27
Procedure for data follow-up during EPD validity:	Involves third party Verifier: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>
EPD geographical scope:	UK
EPD based on Product Category Rules (PCR):	The CEN standard EN 15804 serves as the core PCR The International EPD® System's PCR 2019:14 Construction products, Version 1.11, 2021-02-05 EN 17213 Windows and doors - Environmental Product Declarations - Product category rules for windows and pedestrian doorsets
PCR review conducted by:	The Technical Committee of the International EPD® System Chair: Claudia Peña; contact via: <a href="mailto:info@environdec.com">info@environdec.com</a>
Independent verification of this EPD and data, according to ISO 14025/2006:	EPD process certification <input type="checkbox"/> external EPD verification <input checked="" type="checkbox"/>
Third party verifier:	Ugo Pretato - Recognised Individual Verifier
Accredited or approved by:	The International EPD® System
LCA conducted by:	EuGeos Limited - UK - <a href="http://www.eugeos.co.uk">www.eugeos.co.uk</a>
LCA software:	openLCA
Background database:	ecoinvent v3.6
System boundaries:	Cradle to gate with options (modules A4 & A5, C & D)
Time representativeness:	1st January to 31st December 2019

EPDs within the same product category but from different programmes may not be comparable.  
EPDs of construction products may not be comparable if they do not comply with EN 15804.

# Product Information

## TECHNISHIELD 50 13MM-GLAZED REBATED DOOR

Technishield is a range of internal steel-framed door and screen units, supplied either single-glazed or double-glazed, and available, as standard, in powder-coated mild steel or 304 and/or 316 stainless steel to special order and subject to specification.



Technishield systems are available in a variety of configurations: as single or double doors, with or without screens at the side of or above the doors.

The single-glazed Technishield 50 door is a very versatile, steel-framed and fully glazed, single-acting door system, offering fire resistance up to 120 minutes in respect of Integrity only. The door is typically glazed with a 13mm intumescent laminated glass but can also accommodate thicker double-glazed units where greater acoustic performance is required.

The Technishield 50 door can be supplied as a latching door set with stainless steel lever handles or as an unlatched door with pull handles where lesser fire resistance of up to 60 minutes Integrity is needed. Electronic access control options are also available.

The door can be supplied as a single leaf or as a double leaf with equal or unequal leaves and can be incorporated directly into a Technishield 50 glazed screen. The maximum door height is 3000mm subject to the fire resistance requirement and the configuration.

The door and frame metalwork are factory-finished with a high-quality powder coat system. Technishield 50 can also be used for non-fire-resistant applications where a higher degree of robustness is required.

Technishield 50 rebated doors can be configured to provide resistance to the passage of smoke at ambient temperature (Sa) and medium heat (S200).

This EPD applies to OPL's powder-coated mild steel Technishield 50 13mm-Glazed Rebated Single Door.

### Technical data

The technical characteristics of OPL's Technishield 50 13mm-glazed rebated door are summarised below.

Name	Value	Unit
Fire resistance (EN 1634-1 & EN 13501-2 and BS 476-22) - Integrity only	Up to 120	Minutes
Smoke resistance (EN 1634-3 & EN 13501-2) - Ambient and medium heat	pass	S <sub>a</sub> and S <sub>200</sub>
Airborne sound insulation performance (EN ISO 10140-1 & 2 and EN ISO 717)	Up to 37	dB (R <sub>w</sub> )

OPL's Technishield doors are classified CPC 4212 under the UN CPC classification system V2.1.

# Product Information

---

## Manufacturing

OPL's Radstock manufacturing facility carries out the following manufacturing activities:

- Storage of components and packaging
- Profile finishing and coating
- Door framework assembly
- Packing of door frameworks

## Packaging

Within the UK, many doors are transported to site on reusable 'A' frames. Some wooden pallets and cases are used, particularly for exported items. OPL uses only FSC certified wood products for deliveries to customers. All pallets are set aside at their destination and returned for re-use.

## Installation

Door and screen frameworks from the Technishield 50 range are supplied unglazed for glazing when the units are fitted on site.

Glass is fitted and sealed into the door on site, and the doorframe screwed into place.

## Product use and maintenance

OPL's Technishield doors should be subjected to regular inspection and maintenance in accordance with the published OPL operation and maintenance schedule – see [www.optimasystems.com](http://www.optimasystems.com) for further details.

## End-of-life

It is recommended that steel doors being permanently removed from site, and with no planned re-use, be separated from the general waste disposal regime and the glass and steel components stripped out for potential recovery and/or recycling using regulated schemes.

The European Waste Catalogue (EWC) codes below apply to the product or parts of it when removed from the building:

EWC 17 02 02 Glass

EWC 17 04 05 Iron and steel

EWC 17 04 07 mixed metals is normally appropriate for separated door hardware

EWC 17 09 04 mixed construction and demolition wastes would apply to any material removed from the inside of steel profiles

# Product Information

---

## Content declaration

The material composition of the OPL's steel-framed doors characterised in this EPD is shown below. The masses quoted are indicative; total mass is not part of the product specification.

Product components	Mass in declared unit, kg	% of mass per declared unit, kg	Post-consumer material, weight %	Renewable material, weight %
Fire-resistant glass	21	51	0	0
Steel	20	49	0	0
Total	41	100	0	0

Packaging materials	Weight kg	Weight % (vs product)
Wooden pallets	3.54	9
Total:	3.54	9

No substance on the "Candidate List of Substances of Very High Concern for authorisation" derived under REACH is present either above the limits for registration with the European Chemicals Agency or in excess of 0.1 weight-% of the product.

## Residual risks and emergencies

There are no residual risks associated with the normal day to day use of OPL's steel-framed doors in the context for which they are designed and specified.

## Further product information

Detailed product information and datasheets can be found on our website: [www.optimasystems.com](http://www.optimasystems.com)

# Environmental Performance-Related Information

## LCA Information

This section of the EPD records key features of the LCA on which it is based.

## Scope

This cradle-to-gate with options EPD covers the production stage (modules A1 - A3), the construction stage (modules A4 & A5), the end-of-life stage (modules C1-C4) and module D - see below; as permitted by EN 15804 modules A1-A3 are declared in aggregated form.

Product stage			Construction process stage		Use stage							End of life stage				Benefits & loads beyond the system boundaries
Raw material supply	Transport	Manufacturing	Transport to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste disposal	Disposal	Reuse- recovery- recycling- potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
Modules declared X included in LCA - ND: module not declared - NR: module not relevant																
X	X	X	X	X	ND	ND	ND	ND	ND	ND	ND	X	X	X	X	X
Geography																
GLO	GLO	GB	GB	GB	-	-	-	-	-	-	-	GB	GB	GB	GB	GLO
Specific data used																
85	>90	>90	>90	>90	-	-	-	-	-	-	-	-	-	-	-	-
Variation - products																
n/a	n/a	n/a	n/a	n/a	-	-	-	-	-	-	-	-	-	-	-	-
Variation - sites																
n/a	n/a	n/a	n/a	n/a	-	-	-	-	-	-	-	-	-	-	-	-



# Environmental Performance-Related Information

---

## Declared unit

The declared unit is one square metre of door with frame.

## System boundaries

This EPD covers the product stage, delivery to site, installation, and 'end-of-life' management. It therefore includes the following information modules:

- A1 - raw material extraction and processing, and the processing of secondary material input
- A2 - transport of raw materials and secondary material inputs to the manufacturer
- A3 - manufacturing of the construction product and packaging
- A4 - delivery of construction products to the building site
- A5 - assembly
- C1 - removal from the building
- C2 - transport to waste treatment facility
- C3 - waste treatment
- C4 - final disposal
- D - benefits associated with recycling in a different product system

Modules A1, A2 and A3 comprise the product stage and are declared as one aggregated module A1 – A3. This stage includes the extraction and manufacture of raw materials, intermediate products and energy, as well as waste processing up to the end-of-waste state (i.e. no longer considered a waste material) or disposal of final residues arising during the product stage.

Modules A4 & A5 are part of the "Construction Process stage".

Module C1 - C4 cover the end-of-life stage.

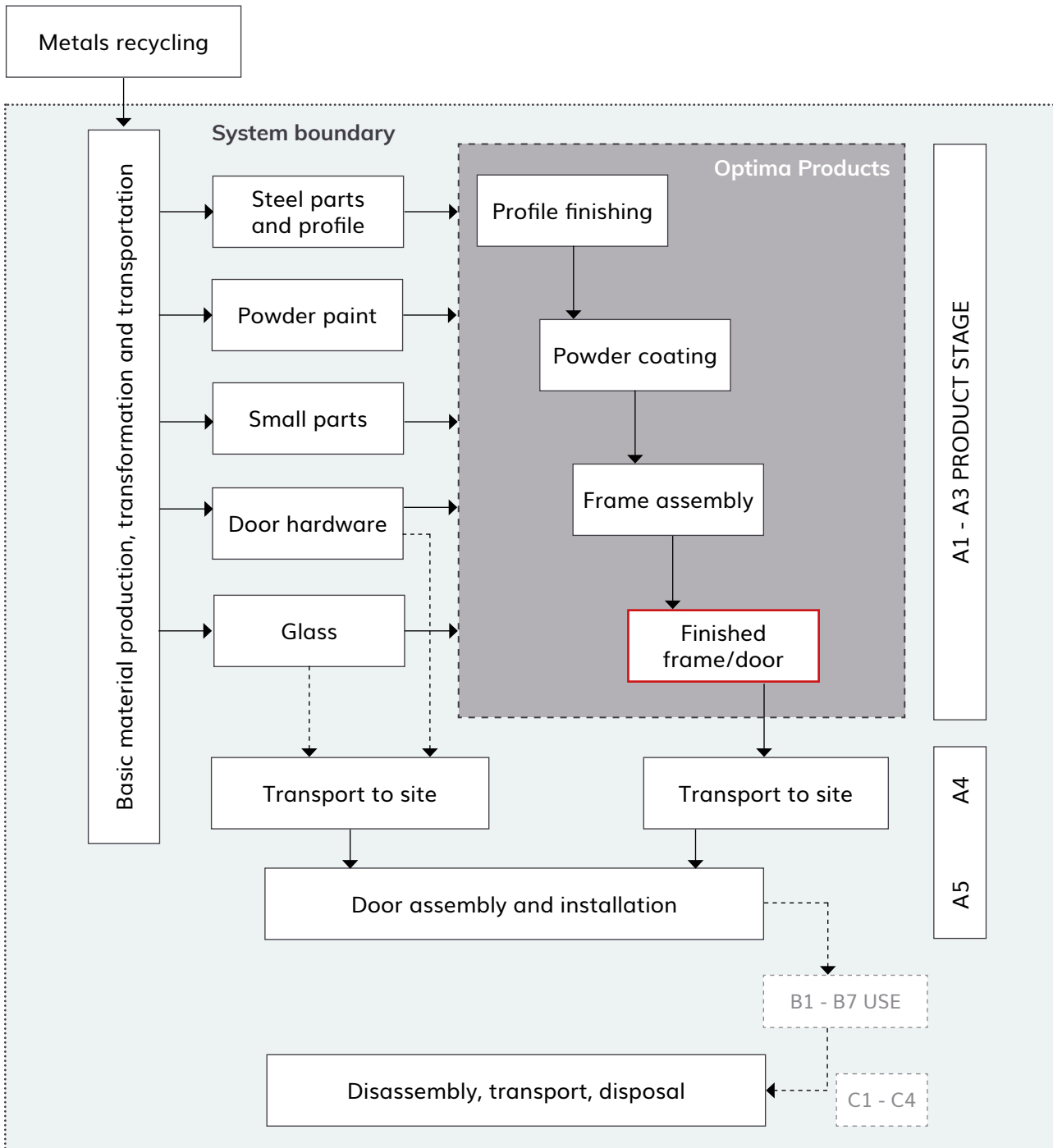
Module D provides an estimate of the potential benefits that would accrue to a different product system were the door constituents actually recycled or recovered at current rates and using current technologies.



# Environmental Performance-Related Information

All upstream resource extraction and manufacturing processes are included in the system. All energy used in factories and offices at OPL'S Radstock site is included; energy used in OPL's offices at locations other than Radstock is excluded. Maintenance of equipment is also excluded.

The product life cycle covered by this EPD is illustrated below.



SYSTEM BOUNDARIES FOR TECHNISHIELD DOOR LCA

# Environmental Performance-Related Information

---

## Cut-off criteria

According to EN 15804 and the PCR, flows can be omitted (cut-off) from a core process in the LCA up to a maximum of 1% of the total mass of material inputs. The total of input flows omitted in this way for any single module must not exceed 5% of the total energy usage and mass inputs for that module. The following must be included in all cases, regardless of the proportion of mass or energy they represent:

- Inputs giving rise to significant environmental effects or energy use in their extraction, use or disposal
- Inputs or outputs classified as hazardous waste

The data collected from OPL encompassed all raw materials, packaging materials and process aids, as well as associated transport to the manufacturing site. Process energy and water use, and direct production waste are included within the data. There are no emissions to air or water apart from un-monitored combustion gases and trade effluent; these are quantified by virtue of mass balance (trade effluent) or by their inclusion in generic processes characterising inputs (gas combustion). Non-hazardous material inputs to manufacture amounting, in combination, to <0.1% of all inputs during the data period were omitted from the LCA. Fixings, sealants and other materials used for installation were also omitted: as noted in EN 17213:2020, these are commonly considered to be within the cut-off criteria. OPL's mild steel framework is plated with zinc and/or nickel in the upstream supply chain; no details of this process were available and it is omitted from the LCA.

## Data sources and data quality

Data used for this EPD were collected following guidance in ISO 14044:2006; the most current available data were used in accordance with EN 15804.

The manufacturer-specific data used in LCA calculations cover a period of 1 year from 1st January 2019 to 31st December 2019. They are therefore based on 1 year averaged data and have been updated within the 5 years prior to publication of the EPD. These data were checked to ensure that sufficient materials and water were included within the inputs to account for all outputs, including products and wastes. Their technological coverage reflects physical reality for the declared product.

Other (generic) data sets used for calculations have been updated within the last 10 years.

Inputs to and outputs from the system are accounted for over a 100-year time period; long-term emissions are therefore omitted from the LCIA.

## Background data

Background (generic) data for raw material inputs and fuels were taken from the ecoinvent v3.6 database, augmented where necessary to ensure the data used are as representative as possible of the materials actually used by OPL. This fulfils the EN 15804 requirement that generic data used in the LCA have been updated within the last 10 years. Data quality has been reviewed for all processes that contribute significantly to the overall LCA.

## Allocation

In the background data, the ecoinvent default allocation is applied to all processes except those in which secondary materials are used, where the "cut-off" allocation is applied. This ensures that secondary materials are free of upstream burdens that arise prior to their reaching the "end of waste" state, in accordance with Section 6.3.4.2 of EN 15804.

Manufacturing data for OPL Radstock facility have been sub-divided where possible to avoid allocation. Remaining inputs and outputs are allocated on the basis of physical relationships.

# Environmental Performance-Related Information

## Assumptions and estimates

The "primary energy used as material (PERM; PENRM)" indicators are calculated using - as characterisation factors - published values for constituent materials which can yield energy on combustion, where available, and from published calorific values where PERM or PENRM values are not available.

In this EPD, the following values are used:

- Renewable primary energy as material: wood - 16MJ/kg

"Primary energy as fuel" indicators (PENRE, PERE) are calculated as the total primary energy demand minus primary energy used as material.

Delivery of the product to users' sites, installation and transport to waste processing and final disposal are modelled using scenarios. The relevant parameters for the transport scenarios are shown in the table below.

Scenario parameters - transport		
Parameter	A4 transport to site	C2 transport to waste treatment
	Quantity and unit	
Vehicle type	lorry	
Vehicle load capacity	10t; n/a	
Fuel type and consumption	diesel, 0.1 l/km	
Volume capacity utilisation factor	1	
Capacity utilisation (including empty returns)	38%	33%
Distance to site	200km	50km
Bulk density of transported products	n/a (mixed materials)	n/a (mixed materials)

Installation (Module A5) is modelled on the basis of electricity use of 0.04kWh per square metre.

Management of packaging waste is included in Module A5. Pallets leaving the system in this module are included in the inventory as components for reuse; an output of biogenic CO<sub>2</sub> is included in this module so that biogenic C is approximately in balance across the life cycle. The same assumptions are applied for waste transport as in Module C2. Removal from the building (Module C1) is assumed to use the same energy as installation.

In the end-of-life modules, it is assumed that doors are removed (module C1), all glass is then recovered and all steel recycled. The insulating material is assumed to be landfilled as inert waste; disposal of this material - where present - is modelled in module C4.

# Environmental Performance-Related Information

Module D quantifies the benefits and loads associated with recycling materials and exporting energy from waste management activities, were the recycled materials and recovered energy to be used in another product system. The benefits reported in Module D are calculated for net flows of secondary materials across the system boundary (materials to be recycled leaving the system minus recycled materials used in manufacture, and other modules declared in the EPD. The net quantity of steel recycled is based on a recycling rate of 95% and recycled content of 25% for steel used to make the products. Net output quantities of materials used in the Module D calculation are shown in the table below, with the associated "quality factors" and the virgin materials assumed to be displaced.

Scenario parameters - Module D					
Output to recycling/recovery	Assumed fate	Displaced input flow	Quality factor	Net output Quantity	Units
Fire-resistant glass	recovered	limestone aggregate	1	21.1	kg
Steel	recycled	generic converter steel	0.95	14.4	kg

## Environmental indicators

This EPD contains environmental information about OPL's Technishield 50 13mm-glazed rebated door in the form of quantitative indicator values for a number of parameters, which encompass calculated environmental impact potentials, resource and energy use, waste generation and material and energy outputs from the product system that may be reused, recycled or recovered into other, unspecified product life cycles. These parameters are listed below along with the abbreviations used for them in the tables of indicator values that follow.

Parameter	Abbreviation	Units
<b>Potential environmental impacts</b>		
Climate change – GWP fossil	GWP-fossil	kg CO <sub>2</sub> eq
Climate change – GWP biogenic	GWP-biogenic	kg CO <sub>2</sub> eq
Climate change – GWP land transformation	GWP-luluc	kg CO <sub>2</sub> eq
Climate change – GWP total	GWP-total	kg CO <sub>2</sub> eq
Climate change - GWP fossil & land transformation <sup>1</sup>	GWP-GHG	kg CO <sub>2</sub> eq
Acidification potential	AP	mol H <sup>+</sup> eq
Eutrophication – freshwater	EP-freshwater	kg P eq & kg PO <sub>4</sub> <sup>3-</sup> eq
Eutrophication – marine	EP-marine	kg N eq
Eutrophication – terrestrial	EP-terrestrial	mol N eq
Photochemical ozone formation	POFP	kg NMVOC eq
Ozone depletion	ODP	kg CFC-11 eq
Depletion of abiotic resources – minerals & metals <sup>2</sup>	ADPMM	kg Sb eq
Depletion of abiotic resources – fossil fuels <sup>2</sup>	ADPFF	MJ, ncv
Water (user) deprivation potential <sup>2</sup>	WDP	m <sup>3</sup> world-eq deprived

# Environmental Performance-Related Information

Parameter	Abbreviation	Units
<b>Resource use</b>		
Renewable primary energy as energy carrier	PERE	MJ
Renewable primary energy resources as material utilisation	PERM	MJ
Total renewable primary energy use (sum of the two parameters above)	PERT	MJ
Non-renewable primary energy as energy carrier	PENRE	MJ
Non-renewable primary energy resources as material utilisation	PENRM	MJ
Total non-renewable primary energy use (sum of the two parameters above)	PENRT	MJ
Use of secondary material	SM	kg
Use of renewable secondary fuels	RSF	MJ
Use of non-renewable secondary fuels	NRSF	MJ
Net use of fresh water	FW	m <sup>3</sup>
<b>Wastes</b>		
Hazardous waste disposed	HWD	kg
Non-hazardous waste disposed	NHWD	kg
Radioactive waste disposed	TRWD	kg
<b>Output flows</b>		
Components for re-use	CRU	kg
Materials for recycling	MFR	kg
Materials for energy recovery	MER	kg
Exported energy - electrical	EEE	MJ
Exported energy - thermal	EET	MJ

1 - GWP-GHG includes all greenhouse gases included in GWP-total but excludes biogenic carbon dioxide uptake and emissions and biogenic carbon stored in the product. This indicator is thus almost equal to the GWP indicator originally defined in EN 15804:2012+A1:2013

2 - The results of this environmental impact indicator shall be used with care because either the uncertainties associated with the results are high or there is limited experience with the indicator

# LCA Results

## TECHNISHIELD 50 13MM-GLAZED REBATED DOOR

Environmental indicator results for OPL's Technishield 50 13mm-glazed rebated door are shown in the 4 following tables for the declared unit of one square metre; modules A1 - A3 are shown on an aggregated basis.

Environmental Impacts (EN 15804 + A2)	Unit	A1 - A3	A4	A5	C1	C2	C3	C4	D
GWP-fossil	kg CO <sub>2</sub> eq	1.27E+02	1.92E+00	1.73E-02	1.73E-02	4.44E-01	8.89E-01	0.00E+00	-2.81E+01
GWP-biogenic	kg CO <sub>2</sub> eq	-6.97E+00	-7.30E-04	6.60E+00	-1.79E-05	-1.70E-04	-6.38E-02	0.00E+00	1.28E-01
GWP-luluc	kg CO <sub>2</sub> eq	1.70E-01	8.40E-04	1.10E-06	1.10E-06	1.90E-04	1.08E-03	0.00E+00	-8.88E-03
GWP-total	kg CO <sub>2</sub> eq	1.20E+02	1.92E+00	1.73E-02	1.73E-02	4.44E-01	8.26E-01	0.00E+00	-2.80E+01
GWP-GHG	kg CO <sub>2</sub> eq	1.27E+02	1.92E+00	1.73E-02	1.73E-02	4.44E-01	8.92E-01	0.00E+00	-2.81E+01
AP	mol H <sup>+</sup> eq	4.29E-01	4.55E-03	4.20E-05	4.20E-05	1.05E-03	7.66E-03	0.00E+00	-1.10E-01
EP-freshwater	kg P eq	4.85E-03	1.86E-05	5.56E-07	5.56E-07	4.28E-06	6.85E-05	0.00E+00	-1.24E-03
	kg PO <sub>4</sub> <sup>3-</sup> eq	1.49E-02	5.70E-05	1.71E-06	1.71E-06	1.31E-05	2.10E-04	0.00E+00	-3.80E-03
EP-marine	kg N eq	7.77E-02	6.00E-04	8.79E-06	8.79E-06	1.40E-04	6.10E-04	0.00E+00	-2.11E-02
EP-terrestrial	mol N eq	8.58E-01	6.61E-03	9.58E-05	9.58E-05	1.52E-03	7.79E-03	0.00E+00	-2.26E-01
POFP	kg NMVOC eq	3.60E-01	3.17E-03	2.57E-05	2.57E-05	7.30E-04	2.88E-03	0.00E+00	-1.05E-01
ODP	kg CFC-11 eq	1.28E-05	4.25E-07	1.75E-09	1.75E-09	9.80E-08	1.19E-07	0.00E+00	-1.45E-06
ADPMM	kg Sb eq	8.13E-03	6.91E-05	1.34E-08	1.34E-08	1.59E-05	5.35E-05	0.00E+00	-1.40E-04
ADPFF	MJ, ncv	1.78E+03	2.83E+01	3.03E-01	3.03E-01	6.53E+00	1.19E+01	0.00E+00	-3.75E+02
WDP	m <sup>3</sup> world-eq dprv	2.25E+03	3.42E+01	2.44E-01	2.44E-01	7.89E+00	7.25E+01	0.00E+00	-1.48E+02
<b>Resource use</b>									
PERE	MJ	8.86E+01	4.88E-01	1.89E-03	1.89E-03	1.12E-01	2.18E+00	0.00E+00	-9.52E+00
PERM	MJ	5.66E+01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PERT	MJ	1.45E+02	4.88E-01	1.89E-03	1.89E-03	1.12E-01	2.18E+00	0.00E+00	-9.52E+00
PENRE	MJ	1.92E+03	2.90E+01	4.80E-01	4.80E-01	6.69E+00	1.37E+01	0.00E+00	-3.82E+02
PENRM	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PENRT	MJ	1.92E+03	2.90E+01	4.80E-01	4.80E-01	6.69E+00	1.37E+01	0.00E+00	-3.82E+02
SM	kg	7.38E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
RSF	MJ	1.69E+00	1.76E-02	2.24E-05	2.24E-05	4.05E-03	5.59E-02	0.00E+00	-1.35E-01
NRSF	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
FW	m <sup>3</sup>	9.68E-01	2.44E-03	6.70E-05	6.70E-05	5.60E-04	5.73E-03	0.00E+00	-1.06E-01
<b>Waste</b>									
HWD	kg	1.58E+01	3.38E-02	8.40E-04	8.40E-04	7.78E-03	7.03E-02	0.00E+00	-4.39E+00
NHWD	kg	1.75E+02	1.87E+00	2.39E-02	2.39E-02	4.32E-01	4.23E+00	0.00E+00	-4.74E+01
TRWD	kg	4.97E-03	2.00E-04	3.67E-06	3.67E-06	4.50E-05	7.19E-05	0.00E+00	-5.00E-04
<b>Output flows</b>									
CRU	kg	0.00E+00	0.00E+00	3.50E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
MFR	kg	6.98E+00	1.15E-02	1.39E-05	1.39E-05	2.64E-03	2.02E+01	0.00E+00	-3.11E+00
MER	kg	1.98E-02	2.00E-04	3.21E-07	3.21E-07	4.51E-05	6.10E-04	0.00E+00	-2.14E-03
EEE	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
EET	MJ	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

# LCA Results

## Additional Environmental Information

ENVIRONMENTAL IMPACTS (EN 15804+A1:2013)

TECHNISHIELD 50 13MM-GLAZED REBATED DOOR

For information, indicator values calculated using the methods prescribed in the earlier version of EN 15804 (EN 15804+A1:2013) are provided in the table below for the declared unit of 1m<sup>2</sup>; modules A1 - A3 are shown on an aggregated basis.

Environmental Impacts (EN 15804 + A1)		Unit	A1 - A3	A4	A5	C1	C2	C3	C4	D
Global warming potential	GWP	kg CO <sub>2</sub> eq	1.23E+02	1.90E+00	1.71E-02	1.71E-02	4.40E-01	8.75E-01	0.00E+00	-2.70E+01
Depletion potential of the stratospheric ozone layer	ODP	kg CFC-11 eq	1.24E-05	3.39E-07	1.98E-09	1.98E-09	7.81E-08	1.03E-07	0.00E+00	-1.28E-06
Acidification potential of land and water	AP	kg SO <sub>2</sub> eq	3.66E-01	3.94E-03	3.56E-05	3.56E-05	9.10E-04	6.88E-03	0.00E+00	-9.31E-02
Eutrophication potential	EP	kg PO <sub>4</sub> <sup>3-</sup> eq	4.64E-02	3.90E-04	4.79E-06	4.79E-06	8.92E-05	4.80E-04	0.00E+00	-1.17E-02
Formation potential of tropospheric ozone photochemical oxidants	POCP	kg ethene eq	6.05E-02	2.40E-04	1.62E-06	1.62E-06	5.99E-05	3.40E-04	0.00E+00	-1.85E-02
Abiotic depletion potential for non-fossil resources	ADPE	kg Sb eq	8.13E-03	6.91E-05	1.34E-08	1.34E-08	1.59E-05	5.35E-05	0.00E+00	-1.40E-04
Abiotic depletion potential for fossil resources	ADPF	MJ	1.78E+03	2.83E+01	3.03E-01	3.03E-01	6.53E+00	1.19E+01	0.00E+00	-3.75E+02

## Biogenic carbon

Carbon dioxide (CO<sub>2</sub>) is absorbed from the atmosphere by trees, so any wood-based product contains some carbon from this source. This carbon is considered as a negative emission in some carbon accounting systems. The biogenic carbon in the product and its packaging in this EPD is shown below (per declared unit).

Biogenic carbon content per declared unit	Unit	Quantity
Biogenic carbon content in product	kg C	0
Biogenic carbon content in packaging	kg C	1.8

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



# Interpretation

---

The environmental burdens of Optima's steel-framed doors are concentrated in the production stage of the life cycle. For example, the carbon footprint (GWP<sub>total</sub>) is two orders of magnitude or greater for modules A1-A3 than for any other module. The manufacture of steel profile and fire-resistant glass account for more than half of the A1-A3 carbon footprint.

The product is assumed free of biogenic material, therefore the negative value of GWP<sub>biogenic</sub> for modules A1-A3 is associated primarily with wooden packaging used by Optima and allocated to these products. The indicator value for ADPMM is dominated by non-ferrous metals such as brass in the generic data representing door hardware and should be considered illustrative only.

Optima's own activities make a small contribution to the Water Deprivation Potential indicator (<15%), with material production accounting for much of the remainder. Exact locations of primary material production are, however, uncertain. Therefore, this indicator value should be considered to have low reliability.

For ODP, releases of Halon 1301, Halon 1211 and CFC-114 in generic inventory data for upstream processes account for almost 95% of the indicator values obtained. Some information sources of these generic data predate Montreal Protocol deadlines for replacement of these substances in all but essential uses. ODP indicator values should therefore be treated with caution.

PENRE and ADPFF, although reported in the same units, are calculated by different methods. PENRE includes nuclear energy and energy in wood extracted from primary forests, whereas ADPFF does not. The fossil fuel-derived component of PENRE is identical to the ADPFF indicator value.

Values of RSF reflect use of fuels such as waste wood and biogas in background datasets. Values of MFR in modules other than A1-A3, C3, derive from background datasets and are considered to have high uncertainty.

## References

---

ecoinvent database (v3.6) - [www.ecoinvent.ch](http://www.ecoinvent.ch)

EN 15804:2012 + A1:2013 and EN 15804:2012 + A2:2019 - Sustainability of construction works - Environmental Product Declarations - Core rules for the product category of construction products.

EN17213:2020 – Windows and doors - Environmental Product Declarations - product category rules for windows and pedestrian doorsets.

General Program Instructions, V3.1, 2019-09-18 - The International EPD® System - EPD International AB.

ISO 9001:2015 - Quality management system. Requirements.

ISO 14001:2015 - Environmental management systems – Requirements with guidance for use.

ISO 10140-1:2016 - Acoustics - Laboratory measurement of sound insulation of building elements - Part 1: Application rules for specific products

ISO 10140-2:2010 - Acoustics - Laboratory measurement of sound insulation of building elements - Part 2: Measurement of airborne sound insulation

ISO 717-1:2020 - Acoustics. Rating of sound insulation in buildings and of building elements - Part 1: Airborne sound insulation

# References

---

EN 1634-1:2014 - Fire resistance and smoke control tests for door and shutter assemblies, openable windows and elements of building hardware - Part 1: Fire resistance test for door and shutter assemblies and openable windows

EN 1634-3:2004 - Fire resistance and smoke control tests for door and shutter assemblies, openable windows and elements of building hardware - Part 3: Smoke control test for door and shutter assemblies

EN 13501-2:2016 - Fire classification of construction products and building elements - Part 2: Classification using data from fire resistance tests, excluding ventilation services

BS 476-22:1987 - Fire tests on building materials and structures - Part 22: Method for determination of the fire resistance of non-loadbearing elements of construction

ISO 14025:2009-11: Environmental labels and declarations - Type III environmental declarations - Principles and procedures.

Optima Products LCA - Report for Optima Products Limited - EuGeos Limited (2022).

PCR 2019:14 Construction products Version 1.11, 2021-02-05 - The International EPD® System - EPD International AB.

## **Glossary**

The International EPD® System: a programme for Type III environmental declarations, maintaining a system to verify and register EPD®s as well as keeping a library of EPD®s and PCRs in accordance with ISO 14025. ([www.environdec.com](http://www.environdec.com))

Life cycle assessment (LCA): LCA studies the environmental aspects and quantifies the potential impacts (positive or negative) of a product (or service) throughout its entire life. ISO standards ISO 14040 and ISO 14044 set out conventions for conducting LCA.

REACH Regulation: REACH is the European Regulation on Registration, Evaluation, Authorisation and Restriction of Chemicals. It entered into force in 2007, replacing the former legislative framework for chemicals in the EU.

# Optima

Courtyard House  
West End Road  
High Wycombe  
Buckinghamshire  
HP11 2QB

T. +44 1494 492725 | E. [Action@OptimaSystems.com](mailto:Action@OptimaSystems.com)  
**W. [OptimaSystems.com](https://www.OptimaSystems.com)**

© Optima Products Limited