

1. General Information

QKE, GKFP, EPPA	Plastic windows (1.23 m x 1.48 m) with triple insulating glass
<hr/> Programme holder IBU – Institut Bauen und Umwelt e.V. Hegelplatz 1 D-10117 Berlin Germany	<hr/> Owner of the declaration QKE – Qualitätsverband Kunststoffzeugnisse e.V. Am Hofgarten 1–2; 53113 Bonn Germany GKFP – Gütegemeinschaft Kunststoff-Fensterprofilsysteme e.V. Am Hofgarten 1–2; 53113 Bonn Germany EPPA – European PVC Profiles and related Building Products Association ivzw Avenue de Cortenbergh 71; 1000 Brussels Belgium
<hr/> Declaration number EPD-QKE-20220156-IBG1-DE	<hr/> Declared product/Declared unit The declared unit consists of 1 m ² of window surface area. The reference window is a single-sash tilt and turn window 1.23 m x 1.48 m in size with triple insulating glass unit and PVC-U frame material with optional surface finishing (coated, covered with PVC foil or PMMA) and possibly additionally fitted with an aluminium covering shell. The planned replacement of individual gasket, hardware and glazing components during a 40-year use period have been included.
<hr/> This declaration is based on the following product category rules: Windows and doors, 01/2021 (PCR tested and approved by the independent advisory board (SVR))	<hr/> Scope of application: This declaration is an association EPD. It covers all constructional forms for PVC windows which comply with the stated characteristics. These are both blocked and bonded window designs and different profile reinforcement and surface design variants. Data from the production plants of the following system suppliers and window manufacturers was included: aluplast – Ettlingen (DE) Deceuninck – Bogen (DE), Calne (GB), Hooglede- Gits (BE), Jasin (PL), Roye (FR) GARGIULO – Nehren (DE) GEALAN – Bukarest (RO), Guopstos (LT), Rzgów (PL), Tanna (DE) hapa – Herrieden (DE) Internorm – Sarleinsbach (AT), Traun (AT) profine – Berlin (DE), Marmoutier (FR), Pirmasens (DE) REHAU – Srem (PL), Wittmund (DE) Salamander – Türkheim (DE), Wloclawek (PL) SCHÜCO – Weißenfels (DE) TMP – Bad Langensalza (DE) VEKA – Burgos (ES), Burnley (GB), Sendenhorst (DE), Skierniewice (PL), Thonon-les-Bains (FR) The weighted mean of the data from eleven member companies with 27 production sites in nine countries was used as a database for manufacturing the plastic profiles. The production quantity thus recorded corresponds to approximately 80% to the European
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<p>(President of Institut Bauen und Umwelt e.V.)</p> <hr/> <p>(Executive Director of Institut Bauen und Umwelt e.V.)</p>	<p>production of the profile manufacturers who are organised in the EPPA, GKFP and QKE associations.</p> <p>This association EPD can be used by the member companies of the three EPPA, GKFP and QKE associations as well as window manufacturers who use this company's plastic profile systems.</p> <p>The owner of the declaration is liable for the basic information and supporting evidence; any liability of the IBU in relation to manufacturer's information, LCA data and supporting evidence is excluded.</p> <p>This EPD was compiled in accordance with the requirements of EN 15804+A2. This standard is referred to in simplified form as EN 15804 in the following.</p> <hr/> <p>Verification</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="2" style="text-align: center;">European standard <i>EN 15804</i> serves as the core PCR</td> </tr> <tr> <td colspan="2" style="text-align: center;">Independent verification of the declaration and statements in accordance with <i>ISO 14025:2011</i></td> </tr> <tr> <td style="text-align: center;"><input type="checkbox"/> internal</td> <td style="text-align: center;"><input checked="" type="checkbox"/> external</td> </tr> </table> <hr/> <p>(Independent Verifier)</p>	European standard <i>EN 15804</i> serves as the core PCR		Independent verification of the declaration and statements in accordance with <i>ISO 14025:2011</i>		<input type="checkbox"/> internal	<input checked="" type="checkbox"/> external
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2. Product

2.1 Product description/Product definition

Single-sash window 1.23 m x 1.48 m with PVC-U frame profiles, triple insulating glass unit and tilt-turn hardware.

Steel, aluminium or glass fibre extruded into the PVC material can be used as reinforcement in the PVC profiles.

The profile surface can be made with different finishes: uncoated white, covered with PVC foil, covered with PMMA (polymethylmethacrylate), coated or fitted with a separate aluminium covering shell. This results in white or coloured, smooth or structured surfaces.

The gaskets consist of soft PVC, EPDM (ethylene-propylene-dien monomer) or TPE (thermoplastic elastomere); the hardware is mainly made of steel.

The average window for this EPD is the white steel-reinforced basic variant. However, the inputs/outputs determined from the production quantities are included

for profile production, whereby all surface finishing processes which are actually performed at the plants are included.

This EPD declares the average environmental quality for the PVC windows of the member companies of the EPPA, GKFP and QKE associations. Window manufacturers who use this company's plastic profile systems can also make use of the declaration. Detailed product data is available from the respective manufacturers' specific descriptions.

EU regulation no. 305/2011 (*CPR*) applies for placing the window on the market in the EU/EFTA (with the exception of Switzerland). The product requires a declaration of performance including the harmonised *DIN EN 14351-1:2016-12 Windows and doors – Product standard, performance characteristics – Part 1: Windows and external pedestrian doorsets* and CE labelling.

The respective national regulations apply to its use.

2.2 Application

Windows are inserted into the outer building shell for lighting, ventilation and weather protection.

2.3 Technical data

The figures and/or classes shown in the following table apply to the reference on which this EPD is based. Far higher classes are being achieved depending on the execution of the frame, hardware, gaskets and insulating glass unit.

Name	Value	Unit
Possible opening types	Tilt-turn	-
Glazing unit structure	4/16/4/16/4	mm
Total energy transmittance g	50	%
Heat transfer coefficient of glass Ug in accordance with EN 673	0.6	W/(m ² K)
Heat transfer coefficient of window Uw in accordance with EN 10077-1	0.87	W/(m ² K)
Air permeability in accordance with EN 12207	2–4	Class
Resistance to wind load in accordance with EN 12210	B1–C5	Class
Water tightness in accordance with EN 12208	4A–9A	Class
Mechanical stress (durability) in accordance with EN 12400	10,000–20,000	Cycles

The construction details and the performance values, in accordance with the declaration of performance, apply to the specific window unit put on the market by the respective manufacturer with regard to their main characteristics, in accordance with harmonised product standard DIN EN 14351-1:2016-12, *Windows and doors – Product standard, performance characteristics – Part 1: Windows and external pedestrian doorsets*.

2.4 Delivery status

This EPD relates to a reference window 1.23 m x 1.48 m in size.

2.5 Base materials/Ancillary materials

The main components of the approximately 72.5 kg reference window are:

Name	Value	Unit
40.86 kg insulating glass	56.4	m-%
16.70 kg PVC-U frame material	23.0	m-%
12.10 kg steel reinforcement	16.7	m-%
1.83 kg steel hardware	2.5	m-%
0.79 kg Soft PVC gaskets, EPDM, TPE	1.1	m-%
0.13 kg steel screws	0.2	m-%
0.05 kg PP setting blocks	0.1	m-%

The following representative generic composition for the individual formulae used by the profile manufacturers for the PVC frame is included for the EPD:

- 81.0 mass % PVC
- 8.1 mass % filler (chalk)

- 4.9 mass % impact resistance modifier
- 2.8 mass % Calcium-zinc stabilisers
- 3.2 mass % titanium oxide (TiO₂) pigment

Does a partial product contain candidate materials from the ECHA candidate list (as of 01/04/2020) of Substances of Very High Concern (SVHC) at above 0.1 mass %: Yes, the PVC profile. This may be the case if recycled old PVC window material is used in the core of the profile cross-section in the manufacture of this product. These profiles may contain lead compounds (CAS number 7439-92-1 of the ECHA candidate list as of 01/04/2020) at more than 0.1 mass %.

Does the product contain further Category 1A or 1B CMR substances (carcinogenic, mutagenic or toxic to reproduction) which are not on the ECHA candidate list at above 0.1 mass %: No.

Have biocidal products been added to this building product or has it been treated with biocidal products: No.

2.6 Manufacturing

As shown in Fig. 2-1, plastic windows are made of the following components: the PVC frame profiles with gaskets and if necessary reinforcement, the insulating glass and the hardware.

Fig. 2-1: Schematic diagram of the manufacture of a window unit

The PVC profiles are produced in an extrusion process from a mixture of PVC powder and additives. The latter protect the PVC against damage during processing and give the profile the necessary characteristics such as impact resistance, colour, and weather resistance. The PVC powder for producing the frames is a widely available mass plastic and is manufactured by polymerisation. Due to its chemical structure, PVC contains a considerable proportion of the halogen chlorine.

Coloured surfaces can be produced by fitting an aluminium covering shell, applying a foil, coating or by co-extrusion with a PMMA layer. Gaskets are either attached to the window profile in a co-extrusion process during extrusion or rolled in subsequently.

The window profiles are supplied to window manufacturers in standard lengths. There they are sawn to the lengths required for respective windows. As far as necessary, steel reinforcement is pushed in and screwed in place. The profiles are then welded, the hardware attached and the glazing and glazing beads inserted.

The steel to produce the hardware is mainly manufactured from iron ore in a furnace process through reduction with coke.

The raw material base for the manufacture of the glazing is quartz sand and the addition of various fluxing and oxidation agents (soda ash, sodium sulphate, potassium carbonate, etc.). In a further processing step, the melted raw glass is placed in a tin melt from which

a flat glass ribbon is continuously drawn (float glass process).

Quality assurance

GKFP e.V. member companies are subject to external quality control as part of voluntary self-commitment. Those plastic window profile systems which may be labelled with *RAL-GZ 716* are listed on the association's website at gkfp.de/en: www.gkfp.de/en/product-overview/profile-systems-with-ral-quality-mark

Those window manufacturers which use the RAL quality mark in accordance with *RAL-GZ 695* are also subject to external monitoring. A list is available on the Gütegemeinschaft Fenster, Fassaden und Haustüren e.V. website (window.de/guetegemeinschaft-fenster) at: www.ral-fachbetriebe.fenster-können-mehr.de.

2.7 Environment and health during manufacturing

Individual measures at production plants such as the implementation of an environmental or energy management system in accordance with *ISO 14001* or *ISO 50001* are to be found in individual company profiles.

2.8 Product processing/installation

The finished windows are transported to the construction site and built into the building structure. Galvanised steel screws are used for installation. The use of installation foam (polyurethane) is possible.

2.9 Packaging

Cardboard, polyethylene wrap and foam pads are used to transport the individual components to the window manufacturer. The frame profiles are generally transported in reusable steel cassettes and occasionally in disposal wooden pallets. Reusable frames are normally used to deliver the windows together with foam pads and polyethylene stretch film, cardboard and polypropylene load-securing belts and aluminium or steel clamps.

If not reused, metal packaging material is recycled; other packaging is generally thermally recycled or otherwise disposed of in landfill.

Waste code according to the *European Waste Catalogue*:

- 15 01 01 Cardboard
- 15 01 02 Plastics
- 15 01 03 Solid wood and wood-based materials
- 15 01 04 Metals

2.10 Condition of use

Plastic windows are very long-lasting and durable. Their material composition does not change during use.

2.11 Environment and health during use

The environment and health are not negatively affected by the PVC frame material. This also applies to the window element as long as the use of solvent-free components is guaranteed downstream in the supply chain.

2.12 Reference service life

The period of use for the product and its components is assumed as follows in accordance with *BBSR 2017*:

- 40 years for the plastic window
- 30 years for the insulating glass unit
- 30 years for the hardware
- 20 years for the gasket

One replacement set of gaskets, hardware and glazing is included in the EPD since the service life for the components is less than that of the finished product.

2.13 Extraordinary influences

Fire

Depending on the design and surface finish, plastic windows can achieve classes E to B in accordance with *EN 13501-1* with regard to reaction to fire.

Name	Value
Building material class	E–B
Flaming droplets	d0
Smoke production	s3

Water

No effects which are detrimental to the environment occur on the unexpected water exposure, such as flooding..

The watertightness of the window is influenced by the design implementation and durability of the frame profile, the gasket and hardware. Different classes of water tightness are achieved accordingly (see 2.3).

Mechanical destruction

No negative effects for the environment occur on unforeseen mechanical destruction.

2.14 End-of-life phase

Material recycling is easily possible and technically realised for all window components. The PVC frame material is maintained in a controlled closed circuit and reused in window profiles after reprocessing. The steel used for hardware and reinforcements can also be recycled without any loss of quality. Material recycling is also easy for the glazing but usually associated with a loss in quality.

2.15 Disposal

The individual components of the plastic window can be incinerated as non-dangerous waste (without energy recovery) or disposed of in landfill.

Waste code according to the *European Waste Catalogue*:

- 17 02 02 Glass
- 17 02 03 Plastics
- 17 04 02 Aluminium
- 17 04 05 Iron and steel

2.16 Further information

Further information is available via the websites of the associations

www.eppa-profiles.eu
www.gkfp.de
www.qke-bonn.de

and also system houses and window manufacturers.

3. LCA: Calculation rules

3.1 Declared unit

The declared unit is 1 m² of window area on a reference window (similar to *EN 14351-1* and *EN 17213*). Its frame area ratio F_F in relation to the overall surface area is around 33%.

Name	Value	Unit
Declared unit	1	m ²
Reference window width x height	1.23 x 1.48	m
frame area ratio	33	%
Mass	72.5	kg
Conversion factor Reference window up to 1 m ²	0.5493	-
Declared unit mass	39.8	kg

The balanced production volume used for average calculation is based on the information from the company named in the scope of application. The underlying production process varies only slightly from one manufacturer to another. It is therefore assumed that the data is representative and robust.

3.2 System boundary

The complete lifecycle from the cradle to the grave is examined for the declared unit. The production stage (Modules A1-A3), the construction stage (A4, A5), the use stage (B1, B2), the disposal stage (C1-C4) and benefits and loads beyond the system boundary (D) are relevant but not the further modules of the use stage (B3-B7).

Manufacturing

The aggregated illustration in the form of A1-A3 is used for manufacturing. This includes the provision of raw materials and energy, the production of steel reinforcement, glazing, hardware and PVC profiles, transport of the components to the window manufacturer, the energy consumption needed for this and accruing production waste. The consumption for heating the production plants and also the attached rooms is also specifically included. However, investment goods (machines, buildings, etc.) remain ignored.

Transport from the window-maker to the construction site is included in Module A4 and also the auxiliary and operating materials used for installation and the disposal of packaging waste in Module A5 in accordance with *EN 17213*.

Use phase

The transmission heat loss during the use phase is included in Module B1 and the replacement of window components mentioned in 2.12 in Module B2.

Disposal

All processes which relate to the removal, dismantling or breaking of the window out of the building and which are not to be regarded at building level was calculated into Module C1.

Redistribution transports from the construction site to waste treatment fall in Module C2. Waste management processes, especially energy recovery from waste, are included in Module C3. This also includes sorting for recycling.

Disposal and also thermal waste treatment land in Module C4.

Credits

Finally, Module D shows the reuse, recovery and recycling potential beyond the system boundary.

3.3 Estimations and assumptions

Average transport distances from background date will be assumed insofar as no specific information on transports is available. This especially concerns Module A2.

Dust and emissions accruing during production or disposal are also examined by means of generic data.

With regard to replacing components during use and also the removal of the window it is assumed that the expenses are equivalent to those of installation.

3.4 Cut-off rules

All known inputs and outputs are included in the lifecycle. Data gaps are filled with conservative assumptions and generic data. The input flows ignored are each below 1% of the total mass or the total flow of the primary energy. In total, they each represent less than 5% of the total mass or 5% of the total energy.

3.5 Background data

The modelling of the lifecycle is performed in the GaBi LCA software. The background data especially for the raw materials and the production of PVC, insulating glass unit and hardware originate from the *ecoinvent 3.7* database. As specific, current and representative data as possible is used. The data used is not more than ten years old.

3.6 Data quality

Data from twelve companies with 28 production plants in nine countries are used as primary profile extrusion and window manufacturing data, see scope of application. This data, which was collected for 2019, was checked for plausibility and consistency. Further average information originates from the associations. The quality of the specific data is therefore to be regarded as extremely good.

At least 80% of all contributions to the core indicators of each impact category result from five background data records. Their representativeness is predominantly to be regarded as good to excellent. Data records with lower representativeness are only used in individual cases. The quality of the background data is therefore to be estimated as good overall.

3.7 Period under review

The primary data was collected for 2019.

Averages weighted with the production volume are used for production data for profile extrusion and window manufacture.

3.8 Allocation

No co-products accrue when producing the window and in further processes (Modules A1-A3). No co-product allocation is therefore necessary in foreground processes. Co-products for which an allocation is present in background data records accrue in the pre-chain for PVC, for example when producing vinyl chloride.

Energies used, auxiliary and operating materials and also waste (Modules A1-A3) are each recorded at plant level and distributed to the products across the produced mass.

Recyclates deployed (Modules A1-A3) are included in terms of a closed loop so that no allocation takes place.

In Module D, benefits and loads result from recycling PVC and metals as well as energy recovery from waste.

3.9 Comparability

A comparison or the evaluation of EPD data is principally only possible if all data sets to be compared were compiled in accordance with *EN 15804* and the building context or product-specific performance characteristics are included.

This LCA was compiled with the *ecoinvent 3.7* database.

4. LCA: Scenarios and further technical information

Characteristic product properties

Biogenic carbon

The total mass of biogenic carbon materials is less than 5% of the total mass of the product and the associated packaging.

Basic information

The downstream technical information is the basis for the declared modules or can be used for the development of specific scenarios in the context of a building assessment if modules are not declared (MND).

Statements mainly relate to a declared unit.

Transport to the construction site (A4)

Name	Value	Unit
Specific fuel consumption per tonne kilometre	0.132	l/(t*km)
7.5 t truck		
40 t truck	0.023	l/(t*km)
Transport distance	9	km
7.5 t truck		
40 t truck	69	km

Installation into the building (A5)

The auxiliary and operating materials (e.g. fixing materials, gaskets) are included in the window's LCA in accordance with *EN 17213* but not the energy consumption during installation which is to be regarded

at building level, which is why this data is for information only.

Name	Value	Unit
Polyurethane installation foam	0.180	kg
Screws	0.077	kg
Electricity consumption	0.085	kWh

Use (B1)

The net heat losses caused by the window are included here. These consist of the transmission heat losses and the solar gains. Since these depend very strongly on actual climatic conditions at the place of installation and the technical circumstances of individual buildings, the environmental effects stated in this EPD are merely to be regarded as examples.

The following conditions are assumed: The calculations for heat losses and gains and the results of the impact assessment are based on parameters of average European conditions. The energy requirement during the use phase at the reference location is calculated in accordance with *DIN V 18599-2*. The following applies:

Name	Value	Unit
EU degree day factor	2135	K*d
Solar radiation	155	kWh/m ²

The provision of heat energy is modelled as follows with German energy needs:

- 49% Gas
- 25% Heating oil
- 14% District heating
- 12% Other (e. g. biomass, electricity)

Maintenance (B2)

The use period for the window is calculated as 40 years in accordance with *BBSR 2017*. The replacement of individual components after reaching the end of their technical useful life (see 2.12) is included in B2 in accordance with *EN 17213*:

Name	Value	Unit
Replacement cycle – Glazing	1	Number/RSL
- Gaskets	1	Number/RSL
- Hardware	1	Number/RSL
Electricity consumption	0.085	kWh
Polyurethane installation foam	0.180	kg
Screws	0.077	kg

End-of-life (C1–C4)

The recycling quotas and disposal routes are country-specific and deviate strongly from one another in the European area. The LCA is based on the following assumptions:

Name	Value	Unit
Collection quota across all materials	95	%
* thereof to recycling	-	
Glass	65	%
PVC	59	%
Steel/aluminium	92	%
Other	0	%
* thereof materials to be disposed of by burning	-	
Glass	25	%

PVC	35	%
Steel/aluminium	0	%
Other	20	%
Transport distance	22	km
Dismantling electricity consumption	0.085	kWh

Reuse, recovery and recycling potential (D), relevant scenario information

The energy resulting from thermal and material recycling (thermal energy and electricity) and the recycling material accruing are credited in this module as follows:

Name	Value	Unit
Net flow secondary glass	16.05	kg
Net flow secondary PVC	4.04	kg
Net flow secondary steel	2.53	kg
Exported electrical energy	3.67	MJ
Exported thermal energy	8.11	MJ

5. LCA: Results

The net heat losses caused by the window are included for B1 use phase. The LCA results shown here are for information only as the losses depend very strongly on actual climatic conditions at the installation location and the technical circumstances of individual buildings.

Important

EP fresh water: This indicator was implemented in co-ordination with the characterisation module (EUTREND model, Struijs et al., 2009b, as in ReCiPe; <http://eplca.jrc.ec.europa.eu/LCDN/developerEF.xhtml>) calculated as "kg P eq".

Restriction notice 1 – applies to the IRP indicator

This effect category mainly deals with the possible effect of low-dose ionising radiation on human health in the nuclear cycle. It does not take into account effects which are attributable to possible nuclear accidents and occupational exposure, or to the disposal of radioactive waste in underground facilities. The potential ionising radiation emanating from the soil, from radon and from some building materials is also not measured by this indicator.

Restriction notice 2 – applies to the indicators ADPE, ADPF, WDP, ETP-fw, HTP-c, HTP-nc, SQP

The results of this environmental impact category must be applied with care, as uncertainties with these results are high or because there is a lack of experience with the indicator.

6. LCA: Interpretation

6.1 Summary

Many of the environmental impact and resource use indicators are dominated by the manufacturing phase (Modules A1-A3). In addition, maintenance (Module B2), the energy consumption needed to compensate heat losses through the window (Module B1) and to a lesser extent waste treatment (Module C3) take a major share of the indicators.

The impacts within the system boundary can be compensated by recovery and recycling potentials beyond the system boundary (Module D).

Within Modules A1-A3 the insulating glass, the metal components and the PVC dryblend contribute to the results to a similar extent. Around 1/4 of the greenhouse emissions for this module can be attributed to the production of the PVC profile.

Sensitivity observations show that different window designs (e.g. with regard to reinforcement material or also in relation to the dimensions) and also the surface design mainly influence the environmental impacts of the manufacturing phase by up to $\pm 10\%$.

The largest contribution in Module B2 originates from the replacement of the glazing.

The declaration of Module B1 is optional for windows. However, since the heat losses described have a significant influence on the energy balance of a building it makes sense to assess their use phase. The values declared for B1 apply only to the exemplary application case specified in Section 4 and are purely of an informative nature. Optimisation would involve reducing transmission heat losses determined by the heat transfer coefficients and to optimise the solar gains (e.g. through alignment and shadows).

6.2 Sensitivity to the use of PVC recyclate

The impacts described above caused by the PVC frame material used change with the PVC recyclate ratio. The environmental impacts decrease in Modules A1-A3 if fresh PVC material is replaced by recyclate. In case of a share of 40% the effects here decrease by 7% on average (range 0% to -25%).

Furthermore, an increase in the proportion of recyclate in the profile results in assessment differences in Module C3 (PENRM indicator) and also smaller benefits in Module D due to the reduced quantity of PVC recyclate which crosses the system boundary. This drops on average by 24% with a 40% share of recyclate (range -51% to +9%).

Fig. 6-1 shows how greatly the total GWP indicator in modules A1–A3 is reduced by an increase in recyclate content. The recyclate content determined for 2019 was approximately 21%.

Fig. 6-1: Total GWP of the window manufacturing modules (A1–A3) depending on the recyclate content. The use of PVC recyclate in the profile is, however, limited. On the one hand because unlimited amounts of recycling material are not available and on the other due to the profile design, where design or quality-related requirements can make the use of fresh material necessary.

A maximum of 40% PVC recyclate in relation to the annual tonnage of profile production appears technically realisable under these framework conditions. Individual profiles can contain a significantly higher proportion of recyclate in spite of this.

6.3 Isolated view of the impact indicators and their influencing factors

6.3.1 Environmental impacts

Fig. 6-2: Indicators to describe the environmental impacts, distribution per module

Global warming potential (GWP)

Greenhouse gas emissions are above all attributable to production, energy consumption in the use phase and maintenance. The most relevant greenhouse gases are carbon dioxide (fossil 86%, biogenic 4%) and methane (fossil 8%, biogenic 2%). The effects of land use changes are extremely low.

Depletion potential of the stratospheric ozone layer (ODP)

Impacts on ozone depletion mainly result from manufacturing, energy consumption in the use phase and maintenance. Emissions of halon 1301, halon 1211 and tetrachloromethane are mainly responsible for this.

Acidification potential of land and water (AP)

Acidification potential results above all from emissions of nitrogen oxides and sulphur oxides which occur during the production phase and maintenance.

Eutrophication potential (EP)

Impacts on the eutrophication of water and soil originate above all from the production phase and maintenance. The relevant emissions are phosphates and nitrogen oxides.

Formation potential for tropospheric ozone photochemical oxidants (POCD)

Ozone formation close to the ground is above all attributable to the production and maintenance phases. The relevant emissions are nitrogen oxides and various volatile organic compounds without methane (NMVOC).

Abiotic depletion potential for non-fossil resources (ADPE)

The consumption of non-fossil resources results above all from production and maintenance. Consumption can be partly compensated beyond the system boundary (substitution of primary material). The elements which make the greatest contribution are tellurium, lead, silver, gold, zinc and copper.

Abiotic depletion potential for fossil resources (ADPF)

Fossil resources are consumed above all through the use of energy in production and by maintenance. This concerns above all natural gas, oil and coal energy carriers.

Use of water (WDP)

Use of water results above all from energy production with hydro-electric power for manufacture and maintenance. Water is, however, actually used for providing the raw materials - glass, steel and PVC.

6.3.2 Use of resources

Fig. 6-3: Indicators to describe the use of resources

Renewable primary energy as energy carrier (PERE) and for material use (PERM)

Renewable primary energy is used above all energetically in the production and maintenance phases. This is mainly biomass and hydro-electric and wind power. Material use, on the other hand, plays a smaller role; effects result from the stabiliser used.

Non-renewable primary energy as energy carrier (PENRE) and for material use (PENRM)

Non-renewable primary energy is also mainly used as energy; consumption of gas, oil and coal in the production, maintenance and use phases is relevant here. Material use in new PVC is of less significance.

Use of secondary materials (SM)

Secondary materials are used for the provision of metal components, especially steel, and also PVC and glass. Secondary materials in Module D are also provided for use beyond the system boundary.

Secondary fuels (RSF, NRSF)

No secondary fuels are used.

Use of net fresh water (FW)

Use of water is used above all for energy production with hydro-electric power for production, maintenance and use. The use of fresh water results above all from the production of raw materials - glass, steel and PVC.

6.3.3 Output flows and waste categories

Fig. 6-4: Waste categories and output flows

Hazardous waste for disposal (HWD)

The limited validity of the results for this indicator should be noted. Small quantities of hazardous waste are deposited in PVC production and its pre-chains.

Non-hazardous waste disposal (NHWD)

The limited validity of the results for this indicator should be noted. Non-hazardous waste accrues above all from waste disposal (Module C4) and replacement. This is mainly deposited glass waste. On the other hand, the contribution from PVC production is extremely small.

Radioactive waste disposal (RWD)

The limited validity of the results for this indicator should be noted. Proportions of electricity from nuclear energy are used in the manufacture of PVC which result in direct (fuel rods) and indirect (tailings) contributions to the RWD indicator.

Components for reuse (CRU)

Nothing accrues.

Materials for recycling (MFR)

Materials for recycling are provided above all by waste treatment (Module C3), maintenance and to a lesser extent by recycling production waste. This is glass, metal and PVC.

Materials for energy recovery (MER)

Nothing accrues

Exported energy (EEE, EET)

Energy in the form of electricity (EEE) and heat (EET) is recovered especially from waste treatment (Module C3)

and exported, and here above all by incinerating PVC waste.

6.3.4 Additional impact categories

Fig. 6-5: Additional impact categories in accordance with *EN 15804+A2*:

The distribution of further indicators to be stated optionally in individual modules of the lifecycle in accordance with *EN 15804* can be seen in Fig. 6-5. There is no discussion.

7. Requisite evidence

7.1 Reaction to fire

Fire tests in accordance with *EN 13823* on several samples from various manufacturers by Efectis Nederland BV, project number 2012-Efectis-R0205

Results:

In accordance with the average parameters determined, plastic windows fulfill the classification criteria according to *DIN EN 13501-1:2007+A1:2009* as follows:

Fire behaviour: B–E
Smoke production: s3
Flaming droplets: d0

7.2 VOC emissions

7.2.1

Final Report VOC Emission Study 'Plastic Windows'
Institut für Holztechnologie Dresden gemeinnützige GmbH (IHD). No. 1516009. July 2017

The results of several examinations of indoor pollution with VOC emissions are summarised in the report.

Results:

With regard to the French *Décret n° 2011-321* VOC ordinance for building products, all window elements examined fulfilled the best possible class A+ according to *Arrêté étiquetage 2011*.

With regard to the German *AgBB* assessment schema, all PVC frame profile variants examined (white, coated, foil-covered) fulfilled the requirements.

7.2.2

Research project on VOC emissions in building components

The Federal Office for Building and Regional Planning (BBR) as part of the research initiative on the future of building, file ref. Z6-10.08.18.7-08.20/II2-F20-08-005; December 2010

Results: With regard to indoor pollution, the requirements of the assessment by the *AgBB* schema are undercut.