ENVIRONMENTAL PRODUCT DECLARATION

as per *ISO 14025* and *EN 15804+A2*

Owner of the Declaration	dormakaba International Holding GmbH
Publisher	Institut Bauen und Umwelt e.V. (IBU)
Programme holder	Institut Bauen und Umwelt e.V. (IBU)
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Issue date	29.06.2026
Valid to	28.06.2031

Floor Spring BTS 84

dormakaba

www.ibu-epd.com | https://epd-online.com



General Information

dormakaba

Programme holder

IBU – Institut Bauen und Umwelt e.V.
Hegelplatz 1
10117 Berlin
Germany

Declaration number

EPD-DOR-20260401-CBA1-EN

This declaration is based on the product category rules:

Building Hardware products, 01.08.2021
(PCR checked and approved by the SVR)

Issue date

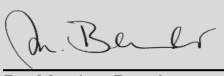
29.06.2026

Valid to

28.06.2031



Dipl.-Ing. Hans Peters
(Chairman of Institut Bauen und Umwelt e.V.)



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Floor Spring BTS 84

Owner of the declaration

dormakaba International Holding GmbH
DORMA Platz 1
58256 Ennepetal
Germany

Declared product / declared unit

1 piece of the product: Floor Spring BTS 84 consisting of the following items:

- Floor spring
- Cement box
- Product packaging

Scope:

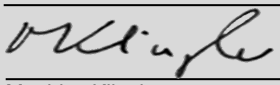
This Environmental Product Declaration refers to a Floor Spring BTS 84 manufactured by dormakaba. The production site is located in Suzhou (China).

The data represents the year 2024.
The owner of the declaration shall be liable for the underlying information and evidence; the IBU shall not be liable with respect to manufacturer information, life cycle assessment data and evidences.

The EPD was created according to the specifications of EN 15804+A2. In the following, the standard will be simplified as *EN 15804*.

Verification

The standard EN 15804 serves as the core PCR
Independent verification of the declaration and data according to ISO 14025:2011
☐ internally ☒ externally



Matthias Klingler,
(Independent verifier)

Product

Product description/Product definition

The BTS 84 is a floor spring specifically developed for double-action aluminium and toughened glass doors. It features a reduced installation depth of 40 mm, allowing for use in shallow floor recesses. The unit includes an optional hold-open function and is supplied with a range of accessories compatible with aluminium and glass door systems. Designed as a floor-mounted counterpart to the RTS 85 concealed transom door closer, the BTS 84 provides a compact and purpose-built solution for applications with limited installation space.

For the Floor Spring BTS 84 the standards which can be applied are the following:

- *EN 1154*
- *EN 1634-1*

The CE marking takes into account the proof of conformity with the respective harmonized standards based on the legal provisions above.

Application

The Floor Spring BTS 84 is applicable for the following:

- Double-action doors: glass, aluminium, wood, and hollow metal
- Retrofit installations

Technical Data

The BTS 84 has following technical properties:

Technical Data		BTS 84		
Spring strength		EN 2	EN 3	EN 4
Standard and external doors[1) 2)]	≤ 850 mm	●	–	–
	≤ 950 mm	–	●	–
	≤ 1100 mm	–	–	●
Closing speed variable by valve adjustment		●	●	●
Backcheck		–	–	–
Delayed action		–	–	–
Hold-open point 90°		○	○	○

● yes – no ○ Option

1) For applications involving particularly high or heavy doors, and doors which have to close against wind or draught conditions, the next larger closer size or the dormakaba BTS 80 should be selected.

2) Max. opening 130°. Door stop necessary for doors which can open further than 130°.

Performance data of the product with respect to its characteristics in accordance with the relevant technical provision which can be applied are mentioned above.

Base materials/Ancillary materials

The major material composition including the packaging of the product is listed below:

Name	Value	Unit
Steel	88	%
Others	5	%
Paper	4	%
Aluminium	3	%

The product includes partial articles which contain substances listed in the Candidate List of REACH Regulation *1907/2006/EC* (date: 04.02.2026) exceeding 0.1 percentage by mass: yes

- Lead (Pb): *7439-92-1 (CAS-No.)* is included in some of the alloys used. The concentration of lead in each individual alloy does not exceed 4% (by mass).

The *Candidate List* can be found on the ECHA website address: https://echa.europa.eu/de/home.

Manufacture

The BTS 84 Series is a concealed-mounted floor spring designed for use in aluminium and toughened glass door applications. It can be used in various configurations, including standard, narrow, or wide door frames, and is suitable for left-hand or right-hand doors with single- or double-action doors. The product enables controlled door closing with adjustable closing speed via two regulating valves and can be optionally equipped with mechanical hold-open points. The floor spring mainly consists of metal components (including housing, cam, piston, springs, and cover plate) combined with hydraulic oil for damping. The specific manufacturing steps and processes may vary depending on the product type and configuration.

Reference service life

The reference service life of the Floor Spring BTS 84 is about 20 years, depending on the application and frequency of use. For repairs and renewals, suitable spare parts are available. The floor spring is tested and certified to *EN 1154*, meaning they are designed to withstand a minimum of 500,000 cycles.

LCA: Calculation rules

Declared Unit

The declared unit is 1 piece of the product: Floor Spring BTS 84 including packaging

Name	Value	Unit
Declared unit	1	piece/product
Mass of declared Product without Packaging	4.76	kg
Mass of Packaging	0.18	kg
Total mass of declared product	4.94	kg

System boundary

The type of EPD is: cradle to gate with options, modules C1–C4, and module D (A1–A3 + C + D and additional modules: A4 + A5)

Production - Module A1-A3

The product stage includes: — A1, raw material extraction, processing and mechanical treatments, processing of secondary material input (e.g. recycling processes), — A2, transport to the manufacturer, — A3, manufacturing and assembly including provision of all materials, products and energy, as well as waste processing up to the end-of-waste state. The electricity used corresponds to an average emission factor of 0.785 kg CO_2 equivalent per kWh.

Construction stage - Modules A4-A5

The construction process stage includes: — A4, transport to the

building site; — A5, installation into the building; including provision of all materials, products and energy, as well as waste processing up to the end-of-waste state or disposal of final residues during the construction process stage.

End-of-life stage - Modules C1-C4 and D
The end-of-life stage includes: — C1, de-construction, demolition; — C2, transport to waste processing; — C3, waste processing for reuse, recovery and/or recycling; — C4, disposal; including provision and all transport, provision of all materials, products and related energy and water use. Module D (Benefits and loads beyond the system boundary) includes: — D, recycling potentials, expressed as net impacts and benefits.

Geographic Representativeness
Land or region, in which the declared product system is manufactured, used or handled at the end of the product´s lifespan: China

Comparability
Basically, a comparison or an evaluation of EPD data is only possible if all the data sets to be compared were created according to *EN 15804* and the building context, respectively the product-specific characteristics of performance, are taken into account. Background database: GaBi, CUP 2024.2.

LCA: Scenarios and additional technical information

Characteristic product properties of biogenic carbon

Name	Value	Unit
Biogenic carbon content in product	-	kg C
Biogenic carbon content in accompanying packaging	0.07	kg C

Suzhou (China) is considered for A3.

Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO_2.

Transport to the building site (A4)

Name	Value	Unit
Litres of fuel	0.00276	l/100km
Transport distance (for scaling)	100	km
Capacity utilisation (including empty runs)	55	%
Transport distance via truck (from dormakaba to harbor)	500	km
Transport distance via ship (from harbor to harbor)	10000	km

The product is transported via truck and ship. The main distribution regions are Asia and the EU. For Asia the product is stored in China with the calculated transport distances. For the rest of Europe, the product is stored in the dormakaba logistic center in Germany. In order to allow scaling to a specific point of installation 100 km are declared as well.

Installation into the building (A5)

Name	Value	Unit
Waste packaging (paper)	0.19	kg

Reference service life

Name	Value	Unit
Life Span according to the manufacturer	20	a

End of life (C1-C4)
C1: The product dismantling from the building is done manually without environmental burden.
C2: Transport to waste management is 50 km.

Name	Value	Unit
Collected separately waste type	4.75	kg
Recycling	4.51	kg
Energy recovery	0.24	kg

The product is disassembled in a recycling process. Material recycling is then assumed for metals. The plastic components are assumed to be incinerated with energy recovery. The minor proportions of residues arising from the recycling process are landfilled. Region for the End of Life is: Global.

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

Name	Value	Unit
Recycling	100	%

The collection rate is 100 %.

LCA: Results

DESCRIPTION OF THE SYSTEM BOUNDARY (X = INCLUDED IN LCA; MND = MODULE OR INDICATOR NOT DECLARED; MNR = MODULE NOT RELEVANT)

Product stage			Construction process stage		Use stage							End of life stage				Benefits and loads beyond the system boundaries
Raw material supply	Transport	Manufacturing	Transport from the gate to the site	Assembly	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-construction demolition	Transport	Waste processing	Disposal	Reuse-Recovery-Recycling-potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	X	X	MND	MND	MNR	MNR	MNR	MND	MND	X	X	X	X	X

RESULTS OF THE LCA - ENVIRONMENTAL IMPACT according to EN 15804+A2: 1 piece Floor Spring BTS 84

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
GWP-total	kg CO_2 eq	1.73E+01	4.9E-01	3.12E-01	0	2.45E-02	6.15E-01	0	-6.99E+00
GWP-fossil	kg CO_2 eq	1.75E+01	4.77E-01	6.38E-03	0	2.35E-02	6.15E-01	0	-7.02E+00
GWP-biogenic	kg CO_2 eq	-2.59E-01	1.29E-02	3.05E-01	0	1.02E-03	-3.32E-06	0	2.99E-02
GWP-luluc	kg CO_2 eq	8.06E-03	1.75E-05	4.24E-06	0	9.17E-07	3.95E-05	0	-9.38E-04
ODP	kg CFC11 eq	5.35E-11	3.96E-14	3.74E-14	0	2.05E-15	2.23E-13	0	-2.44E-12
AP	mol H^+ eq	5.23E-02	6.2E-03	7.63E-05	0	2.59E-05	1.04E-04	0	-1.8E-02
EP-freshwater	kg P eq	2.06E-05	1.24E-07	1.07E-08	0	5.99E-09	5.19E-08	0	-2.33E-06
EP-marine	kg N eq	1.24E-02	1.56E-03	2.81E-05	0	9.24E-06	2.29E-05	0	-2.83E-03
EP-terrestrial	mol N eq	1.4E-01	1.71E-02	3.49E-04	0	1.05E-04	4.81E-04	0	-2.65E-02
POCP	kg NMVOC eq	3.86E-02	4.44E-03	7.44E-05	0	2.71E-05	6.4E-05	0	-1.1E-02
ADPE	kg Sb eq	2.18E-04	1.16E-08	3.95E-10	0	6.09E-10	2.02E-09	0	-4.18E-05
ADPF	MJ	1.9E+02	6.25E+00	8.44E-02	0	3.28E-01	3.06E-01	0	-7.64E+01
WDP	m^3 world eq deprived	1.82E+00	9.21E-04	3.4E-02	0	4.72E-05	5.76E-02	0	-4.65E-01

GWP = Global warming potential; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential of land and water; EP = Eutrophication potential; POCP = Formation potential of tropospheric ozone photochemical oxidants; ADPE = Abiotic depletion potential for non-fossil resources; ADPF = Abiotic depletion potential for fossil resources; WDP = Water (user) deprivation potential)

RESULTS OF THE LCA - INDICATORS TO DESCRIBE RESOURCE USE according to EN 15804+A2: 1 piece Floor Spring BTS 84

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PERE	MJ	3.44E+01	3.04E-02	2.34E+00	0	1.58E-03	1.1E-01	0	-5.89E+00
PERM	MJ	2.32E+00	0	-2.32E+00	0	0	0	0	0
PERT	MJ	3.67E+01	3.04E-02	2.3E-02	0	1.58E-03	1.1E-01	0	-5.89E+00
PENRE	MJ	1.76E+02	6.25E+00	8.44E-02	0	3.28E-01	1.1E+01	0	-7.64E+01
PENRM	MJ	1.07E+01	0	0	0	0	-1.07E+01	0	0
PENRT	MJ	1.86E+02	6.25E+00	8.44E-02	0	3.28E-01	3.06E-01	0	-7.64E+01
SM	kg	1.23E+00	0	0	0	0	0	0	3.49E+00
RSF	MJ	0	0	0	0	0	0	0	0
NRSF	MJ	0	0	0	0	0	0	0	0
FW	m^3	5.02E-02	3.73E-05	8E-04	0	1.92E-06	1.38E-03	0	-5.98E-01

PERE = Use of renewable primary energy excluding renewable primary energy resources used as raw materials; PERM = Use of renewable primary energy resources used as raw materials; PERT = Total use of renewable primary energy resources; PENRE = Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials; PENRM = Use of non-renewable primary energy resources used as raw materials; PENRT = Total use of non-renewable primary energy resources; SM = Use of secondary material; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Use of net fresh water

RESULTS OF THE LCA – WASTE CATEGORIES AND OUTPUT FLOWS according to EN 15804+A2: 1 piece Floor Spring BTS 84

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
HWD	kg	4.96E-07	1.93E-10	4.81E-11	0	1.01E-11	2.49E-10	0	-4.4E-07
NHWD	kg	8.52E-01	5.98E-04	8.61E-03	0	3.13E-05	6.15E-02	0	4.42E-01
RWD	kg	3.94E-03	7.03E-06	4.25E-06	0	3.64E-07	9.61E-06	0	-1.89E-03
CRU	kg	0	0	0	0	0	0	0	0
MFR	kg	0	0	0	0	0	4.51E+00	0	0
MER	kg	0	0	0	0	0	0	0	0
EEE	MJ	0	0	4.15E-01	0	0	9.4E-01	0	0
EET	MJ	0	0	7.52E-01	0	0	2.18E+00	0	0

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 OF THE LCA – additional impact categories according to EN 15804+A2-optional: 1 piece Floor Spring BTS 84

Parameter	Unit	A1-A3	A4	A5	C1	C2	C3	C4	D
PM	Disease incidence	7.25E-07	1.08E-07	4.2E-10	0	2.37E-10	1.2E-09	0	-1.93E-07
IR	kBq U235 eq	5.06E-01	9.65E-04	6.68E-04	0	4.99E-05	1.02E-03	0	-2.39E-01
ETP-fw	CTUe	7.43E+01	4.63E+00	3.69E-02	0	2.43E-01	1.17E-01	0	-6.86E+00
HTP-c	CTUh	9.21E-04	8.36E-11	2.19E-12	0	4.39E-12	9.5E-12	0	-2.45E-08
HTP-nc	CTUh	8.69E-08	2.64E-09	4.32E-11	0	1.38E-10	7.18E-10	0	4.58E-09
SQP	SQP	5.32E+01	2.18E-02	2.57E-02	0	1.13E-03	1E-01	0	-2.11E+00

PM = Potential incidence of disease due to PM emissions; IR = Potential Human exposure efficiency relative to U235; ETP-fw = Potential comparative Toxic Unit for ecosystems; HTP-c = Potential comparative Toxic Unit for humans (cancerogenic); HTP-nc = Potential comparative Toxic Unit for humans (not cancerogenic); SQP = Potential soil quality index

Disclaimer 1 – for the indicator “Potential Human exposure efficiency relative to U235”. This impact category deals mainly with the eventual impact of low-dose ionizing radiation on human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure or radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, radon and from some construction materials is also not measured by this indicator.

Disclaimer 2 – for the indicators “abiotic depletion potential for non-fossil resources”, “abiotic depletion potential for fossil resources”, “water (user) deprivation potential, deprivation-weighted water consumption”, “potential comparative toxic unit for ecosystems”, “potential comparative toxic unit for humans – cancerogenic”, “Potential comparative toxic unit for humans - not cancerogenic”, “potential soil quality index”. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high as there is limited experience with the indicator.

This EPD was created using a software tool.

References

EN 1154
DIN EN 1154: 2003-04, Building hardware – Controlled door closing devices Requirements and test methods (includes amendment A1:2002); German version EN 1154: 1996 + A1 :2002

EN 1634-1
EN 1634-1:2018-04, 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 15804
EN 15804+A2:2019+AC:2021, Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction products

ECHA
European Chemical Agency

ISO 14025
DIN EN ISO 14025:2011, Environmental labels and declarations — Type III environmental declarations — Principles and procedures

REACH
Regulation (EC) No 1907/2006 of the European Parliament and of the Council on the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH)

RoHS
2011/65/EU, Directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment

Further References

IBU 2022
General Instructions for the EPD programme of Institut Bauen und Umwelt e.V. Version 2.1, Berlin: Institut Bauen und Umwelt e.V., 2022, www.ibu-epd.com

SPHERA LCA FE
Sphera LCA for Experts, LCA FE,
Software system and databases,
Managed LCA content MLC (fka GaBi database),
University of Stuttgart and Sphera Solutions GmbH

MLC documentation
MLC life cycle inventory data documentation
https://lcadatabase.sphera.com/

LCA-tool dormakaba
Tool No.: IBU-DOR-202508-LT2-EN.
Developed by Sphera Solutions GmbH

PCR Part A
PCR – Part A: Calculation Rules for the Life Cycle Assessment and Requirements on the Project Report according to EN 15804+A2:2019, Version 1.4, 2024, Institut Bauen und Umwelt e.V., www.ibu-epd.com

PCR Part B
PCR – Part B: Requirements on the EPD for Building Hardware product, version 08/2021, Institut Bauen und Umwelt e.V., www.ibu-epd.com

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