

Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame



The Mercury Thermal Break Frame delivers maximum protection against cold penetration and air infiltration.

ASSA ABLOY

Door Group

ASSA ABLOY is committed to providing products and services that are environmentally sound throughout the entire production process and the product lifecycle. Our unconditional aim is to make sustainability a central part of our business philosophy and culture, but even more important is the job of integrating sustainability into our business strategy. The employment of EPDs will help architects, designers and LEED-APs select environmentally preferable door openings.

ASSA ABLOY will continue our efforts to protect the environment and health of our customers/end users and will utilize the EPD as one means to document those efforts.



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Frame



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According to ISO 14025

This declaration is an environmental product declaration (EPD) in accordance with ISO 14025. EPDs rely on Life Cycle Assessment (LCA) to provide information on a number of environmental impacts of products over their life cycle. Exclusions: EPDs do not indicate that any environmental or social performance benchmarks are met, and there may be impacts that they do not encompass. LCAs do not typically address the site-specific environmental impacts of raw material extraction, nor are they meant to assess human health toxicity. EPDs can complement but cannot replace tools and certifications that are designed to address these impacts and/or set performance thresholds – e.g. Type 1 certifications, health assessments and declarations, environmental impact assessments, etc. Accuracy of Results: EPDs regularly rely on estimations of impacts, and the level of accuracy in estimation of effect differs for any particular product line and reported impact. Comparability: EPDs are not comparative assertions and are either not comparable or have limited comparability when they cover different life cycle stages, are based on different product category rules or are missing relevant environmental impacts. EPDs from different programs may not be comparable.

PROGRAM OPERATOR	UL Environment
DECLARATION HOLDER	ASSA ABLOY Door Group
DECLARATION NUMBER	478714321.116.1
DECLARED PRODUCT	Mercury Thermal Break Frame
REFERENCE PCR	UL PCR for Commercial Steel Doors and/or Frames 9005
DATE OF ISSUE	December 19, 2016
PERIOD OF VALIDITY	5 Years
CONTENTS OF THE DECLARATION	Product definition and information about building physics Information about basic material and the material's origin Description of the product's manufacturing Indication of product processing Information about the in-use conditions Life cycle assessment results Testing results and verifications
The PCR review was conducted by	PCR Review Panel (epd@ulenvironment.com)
This declaration was independently verified in accordance with ISO 14025 by Underwriters Laboratories <input type="checkbox"/> INTERNAL <input checked="" type="checkbox"/> EXTERNAL	 Wade Stout, UL Environment
This life cycle assessment was independently verified in accordance with ISO 14044 and the reference PCR by	 Thomas P. Gloria, Industrial Ecology Consultants

¹ **Exclusions:** EPDs do not indicate that any environmental or social performance benchmarks are met, and there may be impacts that they do not encompass. LCAs do not typically address the site-specific environmental impacts of raw material extraction, nor are they meant to assess human health toxicity. EPDs can complement but cannot replace tools and certifications that are designed to address these impacts and/or set performance thresholds, e.g., Type 1 certifications, health assessments and declarations, environmental impact assessments, etc. **Accuracy of Results:** EPDs regularly rely on estimations of impacts, and the level of accuracy in estimation of effect differs for any particular product line and reported impact. **Comparability:** EPDs are not comparative assertions and are either not comparable or have limited comparability when they cover different life cycle stages, are based on different product category rules or are missing relevant environmental impacts. EPDs from different programs may not be comparable.



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Frame

ASSA ABLOY

Door Group



According
to
ISO 14025

Product Definition and Information

Production Description

Product name: Mercury Thermal Break Frame

This declaration represents a specific 5 3/4" jamb depth 3'0"x7'0" steel frame manufactured in the Milan, TN facility. All Mercury Thermal Break Frames' component assembly and manufacturing processes occur in the Milan, TN factory and are marketed under the ASSA ABLOY Door Group brands: Ceco Door and CURRIES

Product characteristics: Series TQB and TRB thermal break frames for 1-3/4" doors are formed from commercial quality hot-dipped galvanized steel conforming to ASTM A924 and A653. Frames are knocked down (K.D.) field assembled type or welded unit type. Head and jamb members of K.D. frames have die cut mitered corners that interlock rigidly when field assembled. Door stops are 5/8" high and have a 1/16" thick, positive thermal break with a Pemko S44 compression type gasket (weatherstrip). Pemko S44 gasket shipped loose with frame. Gasket is applied after finish paint. Single or double rabbet profile sizes are available in 1/8" increments. Thermal barrier anchor applications are available for new masonry, wood stud, metal stud or existing opening wall conditions, and to anchor jamb at bottom. To maximize efficiency use with an insulated door, a threshold, and a gasket/sweep at sill. See installation instructions at www.cecodoor.com.

Hardware Provisions: Frames are handed. Hinge jambs are mortised for 4-1/2" or 5" high, standard and heavy weight hinges (specify which). 7 gage steel reinforcements are welded in place and are drilled and tapped for fasteners in accordance with ANSI A156.7. The strike jamb is prepared for 4-7/8" universal or 2-3/4" cylindrical strike in accordance with ANSI A 115.1&2 (specify which). Plaster guards are 26 gage steel. Optional hardware reinforcement (for O/H closer or holder) is 14 gage minimum steel welded in place.

Paint: Steel door frames are provided with one coat of oven-cured neutral color primer paint. Primer coat shall conform with ANSI A250.10. The primer coat is a preparatory base for necessary finish painting. Finish coat is also available on K.D. frames from a selection of standard colors (optional). Finish coat is electrostatically applied, oven-cured urethane enamel, and shall conform to ANSI A250.3.

Application

The Mercury Thermal Break Frame is typically used Healthcare, Hospitality, Education and Commercial office space applications. Market areas include:

K-12

- University
- Healthcare
- Worship
- Government
- Municipality
- Parks and Recreation



Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

Door Group



According to ISO 14025

Technical Data

For the declared product, the following technical data in the delivery status must be provided with reference to the test standard:

Technical Data

NFRC 102 "U" Value Standardized Thermal Transmittance & ASTM Test Methods	NFRC 400-2014 Resistance to Air Infiltration & ASTM Test Methods
Mercury Frame & Trio-E Flush Door NFRC "U" Value 0.36, "R" Value 2.65	Mercury Frame & Trio-E Flush Door NFRC 400-2014 1.0 L/s/m ² (0.1 cfm/ft ²)
Mercury Frame & FRP Flush Door NFRC "U" Value 0.39, "R" Value 2.56	Mercury Frame & FRP Flush Door NFRC 400-2014 1.0 L/s/m ² (0.1 cfm/ft ²)
Mercury Frame & Legion Flush Door NFRC "U" Value 0.429, "R" Value 2.19	Mercury Frame & Legion Flush Door NFRC 400-2014 1.0 L/s/m ² (0.1 cfm/ft ²)
Mercury Frame & Imperial Flush Door NFRC "U" Value 0.384, "R" Value 2.45	Mercury Frame & Imperial Flush Door NFRC 400-2014 1.0 L/s/m ² (0.1 cfm/ft ²)
Mercury Frame & Embossed Panel Imperial Door NFRC "U" Value 0.386, "R" Value 2.44	Mercury Frame & Embossed Panel Imperial Door NFRC 400-2014 1.0 L/s/m ² (0.1 cfm/ft ²)
Mercury Frame & Mercury Flush Door NFRC "U" Value 0.386, "R" Value 2.44	Mercury Frame & Mercury Flush Door NFRC 400-2014 1.0 L/s/m ² (0.1 cfm/ft ²)

Placing on the Market / Application Rules

Mercury Thermal Break Frames conform to the certifications and sustainability regulations below:

- ANSI/SDI A250.3-2007 (R2011) Test Procedure and Acceptance Criteria for Factory Applied Finish Coatings for Steel Doors and Frames
- ANSI/SDI A250.4-2011 Test Procedure and Acceptance Criteria for Physical Endurance for Steel Doors, Frames and Frame Anchors
- ANSI/SDI A250.6-2003 (R2009) Recommended Practice for Hardware Reinforcing on Standard Steel Doors and Frames
- ANSI/SDI A250.7-1997 (R2002) Nomenclature for Standard Steel Doors and Steel Frames
- ANSI/SDI A250.8-2014 Specifications for Standard Steel Doors and Frames (SDI-100)
- ANSI/SDI A250.10-1998 (R2011) Test Procedure and Acceptance Criteria for Prime Painted Steel Surfaces for Steel Doors and Frames
- SDI-108-2010 Recommended Selection and Usage Guide for Standard Steel Doors
- SDI-111-2009 Recommended Details for Standard Steel Doors, Frames, Accessories and Related Components
- SDI-112-2008 Zinc Coated (Galvanized / Galvannealed) Standard Steel Doors and Frames
- SDI-117-2009 Manufacturing Tolerances for Standard Steel Doors and Frames
- ANSI/UL 1784-2009 Air Leakage Tests of Door Assemblies

Delivery Status

Mercury Thermal Break Frames are placed horizontally on a wooden pallet with a cull board and one sheet of cardboard on the bottom. Cardboard corners and plastic wrap is then applied. One sheet of cardboard is placed on the top and 5 metal bands prepare the pallet for shipment.



Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

Door Group



According to
ISO 14025

Base Materials / Ancillary Materials

The composition of the Mercury Thermal Break Frame is as following:

Component	Percentage in mass (%)
Steel	98.00%
Gasketing	1.00%
Others	1.00%
Total	100.00%

Manufacture

Metal door and frame products are manufactured primarily from a galvanized, annealed steel sheet. The production of frames involves stamping and bending of the steel sheet, in addition to welding and painting processes. production process utilizes cutting, forming, stamping, CNC, welding, grinding and painting equipment. Frame components are fabricated from 16 ga and 14 ga cold rolled steel conforming to ASTM A1008 or hot-dipped galvanized steel conforming to ASTM A924 and A653. Hardware Reinforcements for most lock preps, 7 gauge steel hinge reinforcements. Hinge edges for 4-1/2" or 5" high, standard and heavy weight hinges. Paint: prime base coat per ANSI A250.10., Optional factory pre-finish per ANSI A250.3.

Environmental and Health During Manufacturing

ASSA ABLOY Door Group is committed to protecting human health and the environment; meeting or exceeding Federal, State, and local laws, regulations, codes, and guidelines; and employing sustainable pollution prevention practices. Painting and Welding areas of the manufacturing plant has extraction ventilation system to remove the dust, VOC and air borne materials. Sound abatement is implemented where possible and Personal Protective Equipment is provided. Waste water is pre-treated prior to dispensing into city water system.

- Environmental operations, GHG, energy, water, waste, VOC, surface treatment and H&S are being routinely monitored. Inspections, audits, and reviews are conducted periodically to ensure that applicable standards are met and Environmental Management program effectiveness is evaluated.
- Code of Conduct covers human rights, labor practices and decent work. Management of ASSA ABLOY is aware of their environmental and responsibilities, providing appropriate training, supporting accountability and recognizing outstanding performance.

Installation

Mercury Thermal Break Frames are typically installed into commercial applications per local, state and federal building codes, standards and requirements. Personal Protective Equipment should be provided at construction site.

Packaging

Mercury Thermal Break Frames are placed horizontally on a wooden pallet with a cull board and one sheet of cardboard on the bottom. Cardboard corners and plastic wrap is then applied. One sheet of cardboard is placed on the top and polyethylene bands prepare the pallet for shipment. The corrugated packaging is 100% recycled, Packaging material and polyethylene banding should be removed from packaging and collected separately for recycling.

Component	Percentage in mass (%)
Wood	55.00%
Cardboard/paper	36.00%
Plastic	9.00%
Steel	0.00%
Total	100%



Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

Door Group



According
to
ISO 14025

Conditions of Use

Frames arrive to the jobsite "ready to hang" meaning no finishing is required and typically no further machining is required. The location of the door, the amount of use dictates the amount of maintenance or service required to maintain the door in good working condition. No cleaning efforts need to be taken into consideration. Repairs or replacement are not usually necessary.

Environmental and Health During Use

There is no harmful emissive potential. No damage to health or impairment is expected under normal use corresponding to the intended use of the product.

Reference Service Life

Properly installed and maintained steel frames have a service life of 30 years. The location and intended use of the steel door frame assembly, the environment to which it is exposed, and the cycling of the door assembly will determine the steel door frame assembly life expectancy.

Extraordinary Effects

Fire

No danger to the environment can be anticipated during exposure to fire.

Water

No substances are used which have a negative impact on ecological water quality on contact by the frame with water. The frame is designed for traditional locations and is not intended for flood protection.

Mechanical Destruction

No danger to the environment can be anticipated during mechanical destruction.

Re-use Phase

Frames are not typically reused once installed.

Disposal

The majority of components are steel and can be recycled.

Further Information

ASSA ABLOY Door Group
9159 Telecom Drive
Milan, TN 38358

Life Cycle Assessment

Declared Unit

The declaration refers to the declared unit of 1 Mercury Thermal Break Frame

Name	Value	Unit
Declared unit	1	unit of frame
Mass	21.88	kg
Conversion factor to 1 kg	0.046	-



Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

Door Group



According to ISO 14025

System Boundary

This is a cradle to gate with options Environmental Product Declaration. The following life cycle phases were considered:

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 gate to the site	Construction/ installation process	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	Deconstruction /demolition	Transport	Waste processing	Disposal	Reuse- Recovery- Recycling potential
A1	A2	A3	A4	A5	B1	B2	B3	B4	B5	B6	B7	C1	C2	C3	C4	D
X	X	X	X	X	MND	MND	MND	MND	MND	MND	MND	MND	X	X	X	X

Description of the System Boundary Stages Corresponding to the PCR
(X = Included; MND = Module Not Declared)

*This includes provision of all materials, products and energy, packaging processing and its transport, as well as waste processing up to the end-of waste state or disposal of final residues.

Estimates and Assumptions

End of Life

In the end of life phase, for all the materials which can be recycled, a recycling scenario with 100% collection rate was assumed.

Cut-off Criteria

In the assessment, all available data from the production process are considered, i.e. all raw materials used, auxiliary materials (e.g. lubricants), thermal energy consumption and electric power consumption - including material and energy flows contributing less than 1% of mass or energy (if available). In case a specific flow contributing less than 1% in mass or energy is not available, worst case assumption proxies are selected to represent the respective environmental impacts. Impacts relating to the production of machines and facilities required during production are out of the scope of this assessment.

Background data

For life cycle modeling of the considered products, the GaBi 6 Software System for Life Cycle Engineering, developed by thinkstep, is used (GaBi 6 2013). The GaBi-database contains consistent and documented datasets which are documented in the online GaBi-documentation (GaBi 6 2013D). To ensure comparability of results in the LCA, the basic data of GaBi database were used for energy, transportation and auxiliary materials.

Data Quality

The data sources used are complete and representative of North America in terms of the geographic and technological coverage and are a recent vintage (i.e. less than ten years old). The data used for primary data are based on direct information sources of the manufacturer. Secondary data sets were used for raw materials extraction and processing, end of life, transportation, and energy production flows. Wherever secondary data is used, the study adopts critically reviewed data for consistency, precision, and reproducibility to limit uncertainty.

Period Under Review

The period under review is the full calendar year of 2014.



Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

Door Group



According to
ISO 14025

Allocation

Allocation was determined on a per unit basis.

Comparability

A comparison or an evaluation of EPD data is only possible if all 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. Environmental declarations from different programs may not be comparable. Full conformance with the PCR for Commercial Steel Doors and/or Steel Frames allows EPD comparability only when all stages of a product's life cycle have been considered. However, variations and deviations are possible.

LCA: Modeling Scenarios and Additional Technical Information

The following technical information is a basis for the declared modules or can be used for developing specific scenarios in the context of a building assessment if modules are not declared.

Installation into the building (A5)		
Name	Value	Unit
Auxiliary	-	kg
Water consumption	-	m ³
Other resources	-	kg
Electricity consumption	-	kWh
Other energy carriers	-	MJ
Material loss	-	kg
Output substance following waste treatment on-site	0.25	kg
Dust in the air	-	kg
VOC in the air	-	kg

Reference Service Life		
Name	Value	Unit
Reference Service Life	30	years

End of life (C1-C4)		
Name	Value	Unit
Collected separately	21.88	kg
Collected as mixed construction waste	0.00	kg
Reuse	0.00	kg
Recycling	21.44	kg
Energy recovery	-	kg
Landfilling	0.44	kg

LCA Results

Results shown below were calculated using TRACI 2.1 Methodology.

TRACI 2.1 Impact Assessment									
Parameter	Parameter	Unit	A1-A3	A4	A5	C2	C3	C4	D
GWP	Global warming potential	kg CO ₂ -Eq.	5.6E+01	2.6E+00	4.8E-02	2.0E-01	0.0E+00	1.3E-02	-2.7E+01
ODP	Depletion potential of the stratospheric ozone layer	kg CFC-11 Eq.	1.3E-09	9.9E-11	1.5E-11	7.7E-12	0.0E+00	7.8E-14	9.3E-07
AP Air	Acidification potential for air emissions	kg SO ₂ -Eq.	2.0E-01	1.6E-02	2.8E-04	1.2E-03	0.0E+00	1.1E-05	-6.5E-02
EP	Eutrophication potential	kg N-Eq.	1.5E-02	8.7E-04	1.0E-04	6.8E-05	0.0E+00	7.4E-07	-4.7E-04
SP	Smog formation potential	kg O ₃ -Eq.	2.7E+00	4.3E-01	1.2E-03	3.4E-02	0.0E+00	2.5E-04	-6.3E-01
FFD	Fossil Fuel Depletion	MJ-surplus	2.6E+01	4.6E+00	1.3E-02	3.6E-01	0.0E+00	1.6E-03	4.2E+00

Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

Door Group



According to ISO 14025

Results shown below were calculated using CML 2001 - April 2013 Methodology.

CML 4.1 Impact Assessment									
Parameter	Parameter	Unit	A1-A3	A4	A5	C2	C3	C4	D
GWP	Global warming potential	kg CO ₂ -Eq.	5.7E+01	2.6E+00	7.4E-02	2.0E-01	0.0E+00	1.3E-02	-2.7E+01
ODP	Depletion potential of the stratospheric ozone layer	kg CFC-11 Eq.	1.2E-09	9.9E-11	1.4E-11	7.7E-12	0.0E+00	7.4E-14	8.5E-07
AP Air	Acidification potential for air emissions	kg SO ₂ -Eq.	1.9E-01	1.3E-02	1.1E-04	1.0E-03	0.0E+00	9.0E-06	-6.4E-02
EP	Eutrophication potential	kg(PO ₄) ³ -Eq.	2.1E-02	2.3E-03	1.2E-04	1.8E-04	0.0E+00	1.5E-06	-1.8E-03
POCP	Formation potential of tropospheric ozone photochemical oxidants	kg ethane-Eq.	2.7E-02	1.8E-03	2.9E-05	1.4E-04	0.0E+00	7.0E-07	-1.4E-02
ADPE	Abiotic depletion potential for non-fossil resources	kg Sb-Eq.	1.0E-03	1.1E-09	-2.7E-09	8.4E-11	0.0E+00	7.8E-10	-2.7E-04
ADPF	Abiotic depletion potential for fossil resources	MJ	6.3E+02	3.3E+01	9.6E-02	2.6E+00	0.0E+00	1.4E-02	-2.8E+02

Results below contain the resource use throughout the life cycle of the product.

Resource Use									
Parameter	Parameter	Unit	A1-A3	A4	A5	C2	C3	C4	D
PERE	Renewable primary energy as energy carrier	MJ, lower calorific value	3.6E+01	0.0E+00	3.6E-03	0.0E+00	0.0E+00	1.7E-03	1.4E+01
PERM	Renewable primary energy resources as material utilization	MJ, lower calorific value	4.3E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
PERT	Total use of renewable primary energy resources	MJ, lower calorific value	4.0E+01	0.0E+00	3.6E-03	0.0E+00	0.0E+00	1.7E-03	1.4E+01
PENRE	Nonrenewable primary energy as energy carrier	MJ, lower calorific value	6.5E+02	3.3E+01	1.0E-01	2.6E+00	0.0E+00	1.5E-02	-2.5E+02
PENRM	Nonrenewable primary energy as material utilization	MJ, lower calorific value	4.5E+02	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
PENRT	Total use of nonrenewable primary energy resources	MJ, lower calorific value	1.1E+03	3.3E+01	1.0E-01	2.6E+00	0.0E+00	1.5E-02	-2.5E+02
SM	Use of secondary material	MJ, lower calorific value	4.6E+02	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
RSF	Use of renewable secondary fuels	MJ, lower calorific value	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
NRSF	Use of nonrenewable secondary fuels	MJ, lower calorific value	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
FW	Use of net fresh water	m ³	4.4E+01	0.0E+00	4.9E-03	0.0E+00	0.0E+00	2.0E-03	-4.9E-02

Results below contain the output flows and wastes throughout the life cycle of the product.

Output Flows and Waste Categories									
Parameter	Parameter	Unit	A1-A3	A4	A5	C2	C3	C4	D
HWD	Hazardous waste disposed	kg	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	1.4E-02
NHWD	Non-hazardous waste disposed	kg	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	6.7E-01
RWD	Radioactive waste disposed	kg	7.4E-03	0.0E+00	1.1E-06	0.0E+00	0.0E+00	4.2E-07	8.9E-03
CRU	Components for re-use	kg	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
MFR	Materials for recycling	kg	2.3E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	1.4E-01
MER	Materials for energy recovery	kg	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
EEE	Exported electrical energy	MJ	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00	0.0E+00
EEE	Exported thermal energy	MJ	0.0E+00	0.0E+00	-1.9E-02	0.0E+00	0.0E+00	-9.6E-03	0.0E+00



Environmental Product Declaration

ASSA ABLOY Mercury Thermal Break

Frame

ASSA ABLOY

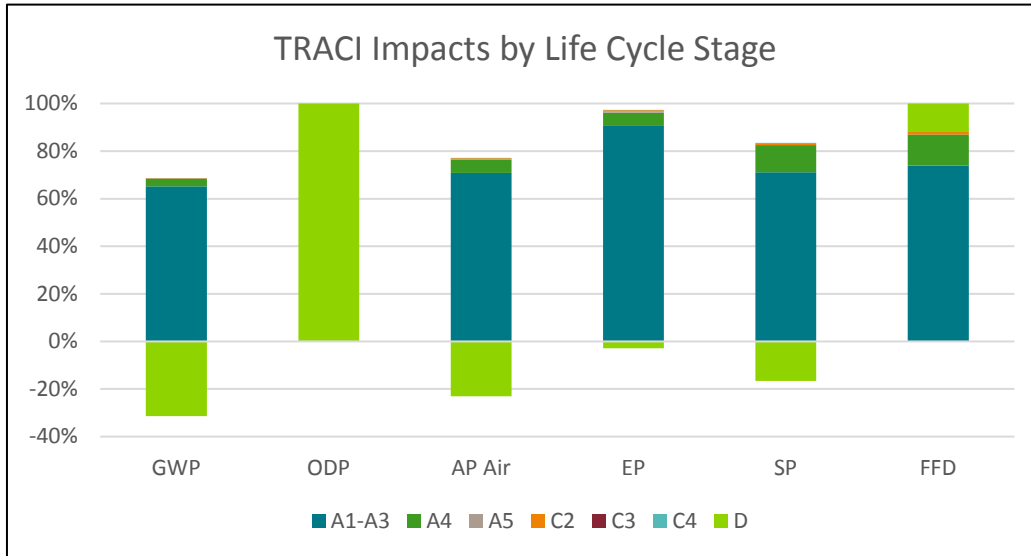
Door Group



According to ISO 14025

Interpretation

The production (A1-A3) life cycle stage drives the results in all of the environmental impact categories. Manufacturing impacts (A3) are primarily driven by electricity use. Raw materials, particularly steel drives the production stage (A1), as this material is the primary material within the product. Transportation impacts (A2) have a negligible impact within the production stage.



References

- PCR Part A UL Environment and Institut Bauen und Umwelt e.V., Königswinter (pub.): Product Category Rules for Construction Products from the range of Environmental Product Declarations of Institut Bauen und Umwelt (IBU), Part A: Calculation Rules for the Life Cycle Assessment and Requirements on the Background Report. July 2014, version 1.3
- PCR Part B UL Environment and Institut Bauen und Umwelt e.V., Königswinter (pub.): Product Category Rules for Commercial Steel Doors and/or Steel Frames UL 9005. Version March 2015.
- ISO 14025 ISO 14025:2011-10, Environmental labels and declarations — Type III environmental declarations — Principles and procedures.
- ISO 14040 ISO 14040:2009-11, Environmental management — Life cycle assessment — Principles and framework.
- ISO 14044 ISO 14044:2006-10, Environmental management — Life cycle assessment — Requirements and guidelines.
- EN 15804 EN 15804:2012-04: Sustainability of construction works — Environmental Product Declarations — Core rules for the product category of construction product
- ULE 2013 UL Environment, General Program Instructions, 2013.