Product

Product description:

Fixed window for use in exterior walls of domestic and commercial buildings.

Product specification

NorDan NTech Fixed frame - FA in size 1230x1480 mm is covered in this EPD.
Wooden window without aluminium cladding.
Triple glazed unit 4E + 16G + 4 + 16G + E4

Materials	kg	%
Absorbent - IGU	0,53	0,83
Adhesive and sealant	0,05	0,08
Aluminium	1,14	1,80
Argon gas - IGU	0,08	0,12
Coating materials	0,36	0,56
Gasket	0,37	0,58
Glass	47,96	75,53
Metal	0,01	0,02
Plastic	0,08	0,12
Sealant - IGU	1,20	1,89
Spacer - IGU	0,62	0,98
Wood	11,11	17,50
Total	63,50	100,00

Packaging	kg	%
Packaging - Plastic	0,13	3,45
Packaging - Steel	0,05	1,33
Packaging - Wood	3,59	95,23
Total incl. packaging	67,27	100,00

Technical data:

Fixed frame window. Triple glazed, 105 mm frame. Uwin 0,75 W/m2K.
Certified: BBA - British Board of Agrément, Secured by Design, NDVK, RISE P-marked production.
The total weight of the product is 63,50 kg. The packaging has an average weight of 3,77 kg.
Area of functional unit 1,82 m2. Conversion factor is 0,549 for 1 m2.

Market:

Europe, but scenarios beyond cradle-to-gate are based on the situation in the Norwegian market.

Reference service life, product

The reference service life is 40 years for painted timber frame.

Reference service life, building or construction works

60 years

LCA: Calculation rules

Declared unit:

1 pcs NorDan NTech Fixed frame - FA 105 (Without Aluminium Cladding)

Cut-off criteria:

All major raw materials and all the essential energy is included. The production processes for raw materials and energy flows with very small amounts (less than 1%) are not included. These cut-off criteria do not apply for hazardous materials and substances.

Allocation:

The allocation is made in accordance with the provisions of EN 15804. Effects of primary production of recycled materials is allocated to the main product in which the material was used. The recycling process and transportation of the material is allocated to this analysis. The PCR specific background data follow the allocation rules in the Ecoinvent v3.7.1 Cut-off database version. The allocation of water, energy and waste flows within the production facilities for windows and doors follows unit-based allocation adjusted with a point system to different product groups or products. This score system is regulated by a factor which increases with the resource intensity of each product. The unit-based allocation is adjusted by the weight of the product, excluding the weight of glass.

Data quality:

Specific data for the product composition are provided by the manufacturer. The data represent the production of the declared product and were collected for EPD development in the year of study. Background data is based on EPDs according to EN 15804 and different LCA databases. The data quality of the raw materials in A1 is presented in the table below.

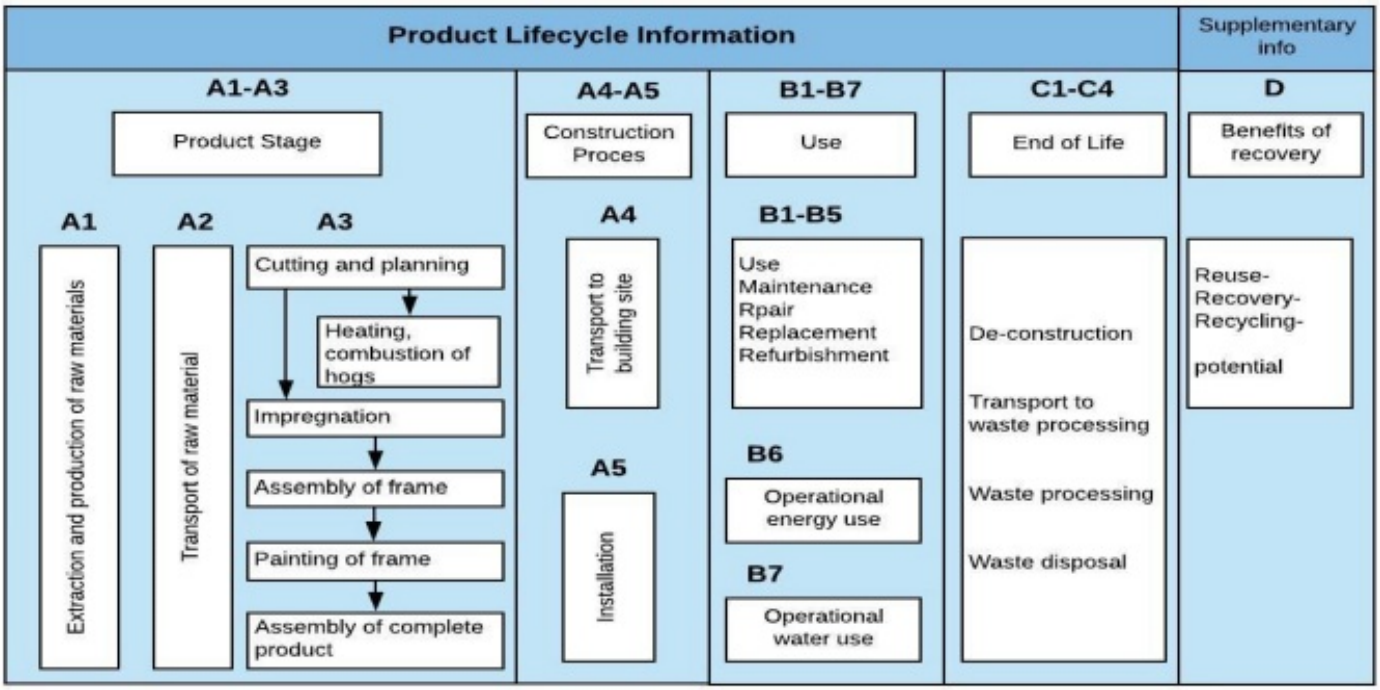
Material quantities of the specified product in reference size have been calculated by NorDan's business system.
The production data was collected in 2021 and is an average for 2020.

Materials	Source	Data quality	Year
Absorbent - IGU	ecoinvent 3.7.1	Specific	2020
Adhesive and sealant	ecoinvent 3.7.1	Specific	2020
Aluminium	ecoinvent 3.7.1	Specific	2020
Argon gas - IGU	ecoinvent 3.7.1	Database	2020
Coating materials	ecoinvent 3.7.1	Specific	2020
Gasket	ecoinvent 3.7.1	Specific	2020
Glass	ecoinvent 3.7.1	Database	2020
Metal	ecoinvent 3.7.1	Specific	2020
Packaging - Plastic	ecoinvent 3.6	Database	2019
Packaging - Steel	ecoinvent 3.6	Database	2019
Packaging - Wood	Modified ecoinvent 3.6	Database	2019
Plastic	ecoinvent 3.7.1	Specific	2020
Sealant - IGU	ecoinvent 3.7.1	Specific	2020
Spacer - IGU	ecoinvent 3.7.1	Specific	2020
Wood	ecoinvent 3.7.1	Specific	2020

System boundaries (X=included, MND=module not declared, MNR=module not relevant)

Product stage			Construction installation stage		Use stage							End of life stage				Beyond the system boundaries
Raw materials	Transport	Manufacturing	Transport	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	X	MND	X	MND	MND	MND	X	X	X	X	X

System boundary:



Additional technical information:

For the products with different sizes from the declared unit, the environmental impacts must be converted by using a conversion factor. The Norwegian EPD Foundation has published instructions on how to interpret EPDs for windows on its website (www.epdnorge.no) where different calculation methods have been stated. (Document: Bruksanvisninger i hvordan tolke EPD'er - Vinduer).

LCA: Scenarios and additional technical information

The following information describe the scenarios in the different modules of the EPD.

A4

The transport from production to construction site is based on a scenario where the product is transported on a large truck from Moi to warehouse in Oslo, Norway (413 km). Transport from warehouse to a construction site is assumed to be 50 km on a medium truck.

A5

According to the report from EPD-Norge Harmonising the documentation of scenarios beyond cradle to gate, EN 15804, there is no loss on site during construction activities. The product in this EPD is painted and surface treated in the production and not at the building site. Therefore, there is only 2 items left in this module. 1) Waste treatment of packaging which is considered in the EPD calculations. 1) Energy use during installation. This can be varied depending on the floor, type of building and several other unknown parameters, and therefore ignored in the calculation.

B2/B3

The maintenance scenario includes cleaning and painting. Cleaning is performed 3 times per year. It is calculated with 30 ml of detergent and 3 liters of water each year. Products without aluminium cladding are assumed to be painted 1 time from inside and 2 times from outside during its lifetime. No repair is assumed during the product lifetime.

B4/B5

* Number or RSL (Reference Service Life). The window has RSL of 40 years. The RSL is determined by using SINTEF design guide 700.320. Windows with 40 years RSL is assumed to have one entire window replacement during the lifetime of the building (See Module B4). It is assumed that this change is occurred after 30 years when the IGU reaches its end of life. There is no need for refurbishment during the product lifetime.

C1

As there are no data for de-construction, it is assumed no activities in C1 in this study. The product is assumed to be treated as mixed waste and sent to incineration. The combustible materials are then energy recovered, while glass is assumed to end up in the bottom ash and then landfilled. The metals are usually sorted out of the bottom ash and then recycled, but there is no data of the share which are recycled and therefore standard values from Ecoinvent is utilized.

C2

The transport of the product as waste is calculated based on a scenario with 50 km distance.

C3

Windows are assumed to be sorted as mixed construction waste and treated with incineration with energy recovery. However, the manufacturer has documented the recycling potentials for its product in the Building Product Declaration (BPD).
BPD is published on NorDan's public document system, NDocs. In the documentation, chapter 10, the specific material and energy recovery potential is reported for the product.
URL: https://portal.nordan.no/ndocs/search?category=document_EPD

C1, C3, C4

The benefits beyond life cycle have been modelled based on the output flows from module C3. This includes energy from incineration and scrap metal recovered from the ashes. The amount recovered metal is assumed to avoid production of primary metals in accordance to 6.4.3.3 in EN 15804. The exported energy is substituting Norwegian district heating mix and electricity mix. Inventory processes causing substitution of avoided virgin raw materials has been constructed for each material.

Transport from production place to user (A4)	Capacity utilisation (incl. return) %	Distance (km)	Fuel/Energy Consumption	Unit	Value (Liter/tonne)
Truck, 16-32 tonnes, EURO 6 (kgkm) - RER	36,7 %	50	0,043	l/tkm	2,15
Truck, over 32 tonnes, EURO 6 (kgkm) - RER	53,3 %	413	0,023	l/tkm	9,50

Assembly (A5)	Unit	Value			
Waste, metal, average treatment (kg)	kg	0,05			
Waste, packaging, pallet, EUR wooden pallet, reusable, average treatment (kg) A5	kg	3,59			
Waste, packaging, plastic film (LDPE), to average treatment (kg)	kg	0,13			

Maintenance (B2)	Unit	Value			
Detergent, Husvask (kg)	kg/DU	1,84			
Paint, 40% water, wet mass (kg)	kg/DU	0,20			
Truck, over 32 tonnes, EURO 5 (kgkm) - RER	kgkm/DU	612,00			
Waste paint, 40% water, wet mass, incineration in Norway (kg)	kg	0,20			
Water, tap water (kg) - Europe without Switzerland	kg/DU	180,00			

Replacement (B4)	Unit	Value			
Replacement (p)	Units/DU	1,00			
Waste treatment of replaced materials (p)	Units	1,00			

Transport to waste processing (C2)	Capacity utilisation (incl. return) %	Distance (km)	Fuel/Energy Consumption	Unit	Value (Liter/tonne)
Truck, unspecified (kgkm) - RER	48,7 %	50	0,051	l/tkm	2,55

Waste processing (C3)	Unit	Value			
Materials to recycling (kg)	kg	0,21			
Waste treatment per kg Glass, incineration with fly ash extraction (kg) - CH - C3	kg	48,04			
Waste treatment per kg Hazardous waste, incineration (kg)	kg	0,00			
Waste treatment per kg municipal solid waste, incineration with fly ash extraction (kg)	kg	0,01			
Waste treatment per kg Paint, hazardous waste incineration (kg) - C3	kg	0,29			
Waste treatment per kg Plastic, Mixture, municipal incineration with fly ash extraction (kg)	kg	0,51			
Waste treatment per kg Polyurethane (PU), incineration (kg)	kg	2,04			
Waste treatment per kg Rubber, municipal incineration with fly ash extraction (kg)	kg	0,37			
Waste treatment per kg Scrap aluminium, incineration with fly ash extraction (kg) - CH - C3	kg	1,14			
Waste treatment per kg Scrap steel, incineration with fly ash extraction (kg) - CH - C3	kg	0,27			
Waste treatment per kg Wood, from incineration (kg)	kg	11,96			

Disposal (C4)	Unit	Value			
Landfilling of ashes from incineration of Glass, process of ashes and residues (kg) - CH - C4	kg	48,04			
Landfilling of ashes from incineration of Hazardous waste, from incineration (kg)	kg	0,00			
Landfilling of ashes from incineration of Municipal solid waste, process per kg ashes and residues (kg)	kg	0,00			
Landfilling of ashes from incineration of Plastics, Mixture, municipal incineration with fly ash extraction, process per kg ashes and residues (kg)	kg	0,02			
Landfilling of ashes from incineration of Polyurethane (PU), process per kg ashes and residues - C4 (kg)	kg	0,08			
Landfilling of ashes from incineration of Rubber, process per kg ashes and residues - C4 (kg)	kg	0,02			
Landfilling of ashes from incineration of Scrap aluminium, process of ashes and residues (kg) - CH - C4	kg	1,02			
Landfilling of ashes from incineration of Scrap steel, process of ashes and residues (kg) - CH - C4	kg	0,18			
Landfilling of ashes from incineration of Wood, process per kg ashes and residues - C4 (kg)	kg	0,14			
Landfilling of ashes from incineration per kg Paint, hazardous waste incineration (kg)	kg	0,01			

Benefits and loads beyond the system boundaries (D)	Unit	Value			
Substitution of electricity, in Norway (MJ)	MJ	13,12			
Substitution of primary aluminium with net scrap (kg)	kg	0,09			
Substitution of primary steel with net scrap (kg)	kg	0,09			
Substitution of thermal energy, district heating, in Norway (MJ)	MJ	198,53			

LCA: Results

The LCA results are presented below for the declared unit defined on page 2 of the EPD document.

Environmental impact											
Indicator		Unit	A1-A3	A4	A5	B2	B4	C1	C2	C3	C4	D
	GWP-total	kg CO_2 -eq	7,07E+01	2,97E+00	5,46E+00	2,47E+00	7,91E+01	0	4,43E-01	2,73E+01	5,46E-01	-2,10E+00
	GWP-fossil	kg CO_2 -eq	9,33E+01	2,97E+00	1,58E-02	2,29E+00	9,63E+01	0	4,43E-01	9,15E+00	5,45E-01	-2,04E+00
	GWP-biogenic	kg CO_2 -eq	-2,26E+01	1,26E-03	5,44E+00	7,92E-03	-1,72E+01	0	1,90E-04	1,82E+01	4,10E-04	-6,06E-03
	GWP-luluc	kg CO_2 -eq	8,40E-02	9,33E-04	2,28E-06	1,69E-01	8,50E-02	0	1,57E-04	2,14E-04	1,66E-04	-5,47E-02
	ODP	kg CFC11 -eq	1,26E-05	7,08E-07	1,55E-09	1,20E-07	1,33E-05	0	1,01E-07	1,18E-07	1,70E-07	-8,39E-02
	AP	mol H+ -eq	8,12E-01	9,37E-03	5,44E-05	1,47E-02	8,22E-01	0	2,52E-03	8,67E-03	3,88E-03	-1,53E-02
	EP-FreshWater	kg P -eq	2,62E-03	2,36E-05	8,46E-08	1,25E-04	2,64E-03	0	3,64E-06	1,22E-05	5,41E-06	-1,39E-04
	EP-Marine	kg N -eq	1,44E-01	2,02E-03	2,91E-05	2,33E-03	1,46E-01	0	9,02E-04	4,11E-03	1,39E-03	-3,88E-03
	EP-Terrestial	mol N -eq	1,67E+00	2,25E-02	2,33E-04	2,14E-02	1,69E+00	0	9,94E-03	4,10E-02	1,53E-02	-4,20E-02
	POCP	kg NMVOC -eq	4,57E-01	8,81E-03	6,38E-05	8,95E-03	4,66E-01	0	2,84E-03	1,05E-02	4,41E-03	-1,23E-02
	ADP-minerals&metals[1]	kg Sb-eq	1,17E-03	5,83E-05	1,52E-07	2,98E-05	1,23E-03	0	1,15E-05	4,00E-06	9,51E-06	-1,20E-05
	ADP-fossil[1]	MJ	1,21E+03	4,76E+01	1,10E-01	4,74E+01	1,26E+03	0	6,79E+00	9,11E+00	1,26E+01	-2,73E+01
	WDP[1]	m^3	2,71E+03	3,82E+01	2,48E-01	2,09E+01	2,75E+03	0	6,44E+00	3,48E+01	2,43E+01	-6,52E+02

GWP-total = Global Warming Potential total; GWP-fossil = Global Warming Potential fossil fuels; GWP-biogenic = Global Warming Potential biogenic; GWP-luluc = Global Warming Potential land use and land use change; ODP = Depletion potential of the stratospheric ozone layer; AP = Acidification potential, Accumulated Exceedance; EP-freshwater = Eutrophication potential, fraction of nutrients reaching freshwater end compartment: EP-marine = Eutrophication potential, fraction of nutrients reaching marine end compartment; EP-terrestrial = Eutrophication potential, Accumulated Exceedance; POCP = Formation potential of tropospheric ozone; ADP-minerals&metals = Abiotic depletion potential for non-fossil resources; ADP-fossil = Abiotic depletion for fossil resources potential; WDP = Water (user) deprivation potential, deprivation-weighted water consumption

"Reading example: 9,0 E-03 = 9,0*10-3 = 0,009"
*INA Indicator Not Assessed

1. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator

Remarks to environmental impacts

Global warming potential in A1-A3 includes sequestration of carbon in the wood. This amount is accounted as an emission in module C3. Additionally, it is included sequestration in the wood packaging. This is accounted as an emission in module A5.

Additional environmental impact indicators

Indicator		Unit	A1-A3	A4	A5	B2	B4	C1	C2	C3	C4	D
	PM	Disease incidence	1,05E-05	2,56E-07	7,51E-10	9,88E-08	1,07E-05	0	4,04E-08	1,40E-07	7,12E-08	-6,38E-07
	IRP[2]	kgBq U235 -eq	4,27E+00	2,08E-01	4,44E-04	7,80E-02	4,48E+00	0	2,97E-02	2,93E-02	5,05E-02	-1,48E-01
	ETP-fw[1]	CTUe	3,05E+03	3,49E+01	1,13E-01	4,78E+01	3,09E+03	0	5,08E+00	3,75E+01	7,33E+00	-1,07E+02
	HTP-c[1]	CTUh	1,50E-07	0,00E+00	8,00E-12	3,10E-09	1,50E-07	0	0,00E+00	3,80E-09	2,61E-10	-4,12E-09
	HTP-nc[1]	CTUh	1,74E-06	3,45E-08	3,92E-10	3,14E-08	1,77E-06	0	6,73E-09	5,21E-08	6,86E-09	-9,85E-08
	SQP[1]	dimensionless	5,14E+03	5,09E+01	1,13E-01	1,85E+01	5,19E+03	0	5,82E+00	2,81E+00	2,72E+01	-1,10E+02

PM = Particulate Matter emissions; IRP = Ionizing radiation – human health; ETP-fw = Eco toxicity – freshwater; HTP-c = Human toxicity – cancer effects; HTP-nc = Human toxicity – non cancer effects; SQP = Potential Soil Quality Index (dimensionless)

"Reading example: 9,0 E-03 = 9,0*10-3 = 0,009"
*INA Indicator Not Assessed

1. The results of this environmental impact indicator shall be used with care as the uncertainties on these results are high or as there is limited experienced with the indicator
2. 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 nor due to radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon and from some construction materials is also not measured by this indicator.

Resource use												
Indicator		Unit	A1-A3	A4	A5	B2	B4	C1	C2	C3	C4	D
	PERE	MJ	4,29E+02	6,13E-01	2,39E-03	3,80E+00	4,30E+02	0	9,75E-02	1,02E+00	2,31E-01	-1,05E+02
	PERM	MJ	2,40E+02	0,00E+00	-4,98E+01	0,00E+00	1,90E+02	0	0,00E+00	-1,90E+02	0,00E+00	0,00E+00
	PERT	MJ	6,69E+02	6,13E-01	-4,98E+01	3,80E+00	6,20E+02	0	9,75E-02	-1,89E+02	2,31E-01	-1,05E+02
	PENRE	MJ	1,11E+03	4,76E+01	1,10E-01	4,77E+01	1,16E+03	0	6,80E+00	9,11E+00	1,26E+01	-2,73E+01
	PENRM	MJ	9,68E+01	0,00E+00	-5,52E+00	0,00E+00	9,13E+01	0	0,00E+00	-9,12E+01	0,00E+00	0,00E+00
	PENRT	MJ	1,21E+03	4,76E+01	-5,41E+00	4,77E+01	1,25E+03	0	6,80E+00	-8,21E+01	1,26E+01	-2,73E+01
	SM	kg	1,03E-01	0,00E+00	0,00E+00	0,00E+00	1,03E-01	0	0,00E+00	0,00E+00	0,00E+00	0,00E+00
	RSF	MJ	8,35E-01	2,15E-02	6,75E-05	1,19E-02	8,57E-01	0	3,47E-03	2,12E-02	6,12E-03	-1,56E-02
	NRSF	MJ	7,54E-01	7,32E-02	4,80E-04	1,26E-02	8,28E-01	0	1,22E-02	0,00E+00	2,23E-01	-5,92E+00
	FW	m^3	2,46E+00	5,36E-03	6,49E-05	2,20E-01	2,47E+00	0	7,69E-04	1,57E-02	1,13E-02	-1,42E-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 materials; RSF = Use of renewable secondary fuels; NRSF = Use of non-renewable secondary fuels; FW = Net use of fresh water

"Reading example: 9,0 E-03 = 9,0*10-3 = 0,009"
*INA Indicator Not Assessed

End of life - Waste

Indicator		Unit	A1-A3	A4	A5	B2	B4	C1	C2	C3	C4	D
	HWD	kg	1,68E+00	2,58E-03	0,00E+00	1,09E-02	1,69E+00	0	3,66E-04	0,00E+00	4,94E+01	2,02E-03
	NHWD	kg	2,66E+01	3,82E+00	3,60E-01	4,99E-01	3,08E+01	0	4,21E-01	4,80E+01	4,07E-01	-6,59E-01
	RWD	kg	5,11E-03	3,25E-04	0,00E+00	7,51E-05	5,43E-03	0	4,62E-05	0,00E+00	7,75E-05	-1,27E-04

HWD = Hazardous waste disposed; NHWD = Non-hazardous waste disposed; RWD = Radioactive waste disposed

"Reading example: 9,0 E-03 = 9,0*10-3 = 0,009"
*INA Indicator Not Assessed

End of life - Output flow

Indicator		Unit	A1-A3	A4	A5	B2	B4	C1	C2	C3	C4	D
	CRU	kg	0,00E+00	0,00E+00	3,41E+00	0,00E+00	3,41E+00	0	0,00E+00	0,00E+00	0,00E+00	0,00E+00
	MFR	kg	2,78E-01	0,00E+00	1,16E-01	0,00E+00	3,94E-01	0	0,00E+00	2,11E-01	0,00E+00	0,00E+00
	MER	kg	1,92E+00	0,00E+00	1,78E-01	0,00E+00	2,10E+00	0	0,00E+00	6,43E+01	0,00E+00	0,00E+00
	EEE	MJ	8,31E-01	0,00E+00	1,24E-01	1,18E-01	9,55E-01	0	0,00E+00	1,32E+01	0,00E+00	0,00E+00
	EET	MJ	1,23E+01	0,00E+00	1,87E+00	8,19E-01	1,42E+01	0	0,00E+00	1,99E+02	0,00E+00	0,00E+00

CRU = Components for re-use; MFR = Materials for recycling; MER = Materials for energy recovery; EEE = Exported energy electrical; EET = Exported energy thermal

"Reading example: 9,0 E-03 = 9,0*10-3 = 0,009"
*INA Indicator Not Assessed

Biogenic Carbon Content

Indicator	Unit	At the factory gate
Biogenic carbon content in product	kg C	6,76E+00
Biogenic carbon content in accompanying packaging	kg C	1,48E+00

Note: 1 kg biogenic carbon is equivalent to 44/12 kg CO2

Additional requirements

Greenhouse gas emissions from the use of electricity in the manufacturing phase

National production mix from import, low voltage (production of transmission lines, in addition to direct emissions and losses in grid) of applied electricity for the manufacturing process (A3).

Electricity mix	Source	Amount	Unit
Electricity, Poland (kWh)	ecoinvent 3.6	1060,47	g CO2-eq/kWh
Electricity, Norway (kWh)	ecoinvent 3.6	24,33	g CO2-eq/kWh

Dangerous substances

The product contains substances given by the REACH Candidate list that are less than 0,1 % by weight.

Indoor environment

Danish Indoor Climate Labelling - Certificate no. 174
ND NTech - EMISSION CLASS 1

Emission measured after 28 days:
TVOC28 0,27 mg/m3
Formaldehyde28 <0,005 mg/m3

Additional Environmental Information

Additional environmental impact indicators required in NPCR Part A for construction products											
Indicator	**Unit**	A1-A3	A4	A5	B2	B4	C1	C2	C3	C4	D
GWPIOBC	kg CO_2 -eq	9,65E+01	2,97E+00	1,58E-02	2,47E+00	9,95E+01	0	4,43E-01	9,14E+00	5,47E-01	-2,10E+00

GWP-IOBC: Global warming potential calculated according to the principle of instantaneous oxidation. In order to increase the transparency of biogenic carbon contribution to climate impact, the indicator GWP-IOBC is required as it declares climate impacts calculated according to the principle of instantaneous oxidation. GWP-IOBC is also referred to as GWP-GHG in context to Swedish public procurement legislation.

Bibliography

ISO 14025:2010 Environmental labels and declarations - Type III environmental declarations - Principles and procedures.
ISO 14044:2006 Environmental management - Life cycle assessment - Requirements and guidelines.
EN 15804:2012+A2:2019 Environmental product declaration - Core rules for the product category of construction products.
ISO 21930:2017 Sustainability in buildings and civil engineering works - Core rules for environmental product declarations of construction products.
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EPD Norway Bruksanvisninger i hvordan tolke EPD'er - Vinduer URL: https://www.epd-norge.no [in Norwegian]

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