

# Product category rules Part B – for profiles for windows, doors and facades

## General product category rules for environmental product declarations according to EN ISO 14025 and EN 15804

according to the program operation for the preparation of  
environmental product declarations (EPD) of the  
ift Rosenheim

Key words: Environmental Product Declaration, Profiles, Windows, Doors, Facades, Life  
Cycle Assessment, Product Category Rules



Product category rules  
PCR-Part B: Profiles for  
windows, doors and  
facades  
PCR-PR-2.3 : 2018

### Note

The present document is only a rough translation. In case of doubt, the German version  
applies.

## Content

1	Preliminary remark.....	3
2	Product category rules.....	3
2.1	Content.....	3
2.2	Verification, validation and release of the PCR.....	4
3	General product information.....	4
3.1	Product description / Product definition.....	4
3.2	Scope.....	5
3.3	Application.....	5
3.4	Quality assurance and management systems (optional).....	5
3.5	Technical data / performance of the product.....	6
4	Raw materials.....	6
4.1	Information on SVHC according to PCR Part A.....	6
4.2	Additional information.....	6
5	Life cycle assessment.....	7
5.1	Functional unit.....	7
5.2	Declared unit.....	7
5.3	Geographical and time-related system boundaries.....	7
5.4	Scope / System boundaries.....	8
5.5	Reference service life (RSL).....	8
5.6	Information on the product life cycle.....	8
6	Bibliography.....	10

## 1 Preliminary remark

The product category rules of the ift Rosenheim are divided into two parts and marked accordingly. Part A contains general product category rules, while this part B contains product group-specific rules. The valid versions can be obtained from ift Rosenheim.

The European Standards EN 15804, EN 16485 and prEN 17662 provide basic Product Category Rules for building products, services of all kinds and building processes and in particular for profiles for windows, doors and facades. They form the basis to secure that Environmental Product Declarations for building products, services of all kinds and building processes and in particular, for profiles for windows, doors and facades are derived, verified and displayed in a standardized way.

This PCR provides additional Product Category Rules for Type III Environmental Product Declarations (EPD) in particular for partitions. This PCR is therefore supplementing the requirements according to EN 15804, prEN 17662 and EN 17388 and do not replace them.

### Note

In EN 16485 and prEN 17662, precise specifications are made for the life cycle assessment and EPD preparation of profiles for windows, doors and facades within the various phases of the life cycle; these must be observed.

## 2 Product category rules

### 2.1 Content

This PCR defines for specific product groups:

Rules for the preparation of environmental product declarations (EPD) for

- Wood profiles for the production of windows and window doors according to DIN 68121-1,
- Profiles made of plasticizer-free polyvinyl chloride according to DIN EN12608,
- Metal profiles with and without thermal separation according to EN 14024 (Windows according to EN 14351-1 as well as smoke and fire protection windows according to prEN 16034)
- Open hot rolled profiles
- Cold rolled hollow profiles
- Hot-formed hollow profiles
- welded profiles from hot rolled plates or from aforementioned profiles

## PCR Profiles for windows, doors and facades

Product group: Profiles for windows, doors and facades  
Declaration code: PCR-PR-2.3 : 2018  
Date of release: 25.01.2018  
Next revision: 25.01.2023



- Profiles differentiating to aforementioned standards or made of other materials or composite materials

### 2.2 Verification, validation and release of the PCR

The committee of experts “ift-EPD and PCR” performs the validation and thus vouches for its correctness.

Interested Parties involved in the PCR assessment:

- Ift Rosenheim

This PCR document with the document number PCR-PR-2.3 was validated and released by the committee of experts (CE) of the ift Rosenheim GmbH. The PCR document is valid according to ISO 14025, EN 15804 and the ift guideline NA-01, five years.

Tracking of the editing / revisions:

Serial No.	Date	Editing comment	CE	Declaration code
1	12/2012	Initial verification and release	released	PCR-PR-1.0 : 2012
2	01/2013	Revision of the PCR	released	PCR-PR-1.1 : 2013
3	01/2018	Revision of the PCR	released	PCR-PR-2.1 : 2018
4	09/2019	Editorial changes	released	PCR-PR-2.1 : 2018
5	10/2021	Content changes	released	PCR-PR-2.3 : 2018

## 3 General product information

### 3.1 Product description / Product definition

The declared products must be described.

In doing so, the trade name of the products / product groups (including any product codes) to which the EPD applies must be stated in addition to a general product description. If it is not reasonably possible to name the products / product groups, e.g. in the context of association EPDs, the product description must clearly delimit the products / product groups to which the EPD applies.

Exemplary information:

- Profiles made of wood
- Profiles made of aluminum
- Profiles made of steel

### 3.2 Scope

These product category rules (PCR-PR-2.3) can be applied to profiles for the production of windows, doors and facades. Profiles made of the following materials are covered: plastic, metal, wood, as well as composite materials or combinations of the materials.

### 3.3 Application

Brief description of the scope of the declared products.

Example:

Profiles for the production of windows and doors from wood

### 3.4 Quality assurance and management systems (optional)

In order to guarantee the quality assurance of the product, certification systems can be used. Within the framework of the EPD, information can optionally be provided on quality assurance or QMS and EMS.

Exemplary information:

Inspection

- NF252 CSTB: Thermally insulated composite profiles (analogue QM323)
- Vindues Industrien Technical Requirements Vindues Industrien: laminated profiles for wooden windows
- EN 13307-1 CEN/TS13307-2 EN 13307: laminated profiles for wooden windows

ift product certification

- QM 301 Attack-resistant components: Doors, windows, curtain walls, lattice elements and closures
- QM 308 coated products made of glass for heat and sun protection
- QM 309 Solid, finger-jointed and laminated profiles for wooden windows - Guideline ift
- QM 320 Windows and exterior doors – manufacturers
- QM 323 Thermally insulated metal-plastic composite profiles
- QM 338 Seals and sealing profiles

Management systems

- Quality management DIN EN ISO 9001
- Environmental management DIN EN ISO 14001
- Energy management DIN EN ISO 50001
- Occupational health and safety management BS OHSAS 18001
- Integrated Management system (IMS)

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### Note

Existing data, e.g. from EMSs (environmental balances), can facilitate data collection in life cycle assessments.

### 3.5 Technical data / performance of the product

- Wood profiles for the production of windows and window doors according to DIN 68121-1,
- Profiles made of plasticizer-free polyvinyl chloride according to DIN EN12608,
- Metal profiles with and without thermal separation according to EN 14024 (Windows according to EN 14351-1 as well as smoke and fire protection windows according to prEN 16034)
- Profiles differentiating to aforementioned standards or made of other materials or composite materials

**Table 1** Characteristics and performance in the product category

	Characteristics and performance*	Unit
Obligation	Length weight	kg/m
Obligation	Gross density (EN 16485)	kg/m <sup>3</sup>
Obligation	Moisture content (EN 16485)	%
Optional	U-value	W/(m <sup>2</sup> K)
Optional	Frame depth, sash depth	m
Optional	Fire resistance class	-
	If applicable, further	

\* The reference product is described in the EPD with the mandatory information. The product characteristics can be given in a range to describe the reference product.

## 4 Raw materials

### 4.1 Information on SVHC according to PCR Part A

If products to which this PCR applies contain substances of very high concern (SVHC), these must be indicated in the EPD.

### 4.2 Additional information

The essential technical information on the product(s) or a reference to it shall be provided for the architect.

When considering the entire life cycle (cradle to grave), the product characteristics must be stated on the basis of the physical properties of the building or a reference to them.

Within the framework of the EPD, further information on building certification systems can be provided.

## 5 Life cycle assessment

For the preparation of an EPD, a life cycle assessment according to ISO 14040 and ISO 14044 is prepared as a basis. The data on which the life cycle assessment is based should be precise, complete and consistent. This life cycle assessment must be representative of the products presented in the declaration. The scope and limits of the life cycle assessment must be specified.

### 5.1 Functional unit

The functional unit indicates the quantified benefit of a product system used as a comparison unit (see EN 15804).

### 5.2 Declared unit

Declared products must be described and optionally represented graphically (e.g. CAD drawing). A functional or declared unit to which the EPD data refer must be specified.

The following declared unit must be specified:

- Length in linear meter or m, e.g. 1 m profile or derivable unit

Example:

The functional unit for profiles made of wood is given as a linear meter, with a length weight in kg.

### 5.3 Geographical and time-related system boundaries

General information according to PCR Part A.

Example:

Reference period Year 2009-2010

Reference area Europe

## 5.4 Scope / System boundaries

Example profiles:

### **Cradle to Gate according to EN 15804+A1:**

The system boundaries include the extraction of raw materials, the manufacture of the profiles and the assembly of the individual components to the finished packaged profiles at the factory gate.

### **Cradle to Gate according to EN 15804+A2:**

The system boundaries include the extraction of raw materials, the manufacture of the profiles and the assembly of the individual components to the finished packaged profiles at the factory gate as well the ablation, deposition and material and thermal recycling of the products.

### **Note:**

In the case of construction products and materials that are permitted as exceptions according to EN 15804+A2, the information on disposal may be omitted.

### **Cradle to Grave according to EN 15804+A1:**

The system boundaries also include the use, deconstruction, disposal and material and energy recovery of the profiles and its individual parts.

### **Cradle to Grave according to EN 15804+A2:**

The system boundaries also include the stage-of-life-phases application and use.

## 5.5 Reference service life (RSL)

It applies EN 15804.

## 5.6 Information on the product life cycle

Regulations to be observed during the life cycle:

Exemplary information:

Product manufacture:

- Product standard
- Applicable certification programs



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### Construction stage:

- Assembly guideline / instruction

### Use stage:

- Information on the useful life
- Information on VOC emissions (certification programmes)
- Information on use

### End-of-Life stage:

- Recycling initiatives or normal recovery and disposal systems
- Recycling rates in line with the industry standard
- Legal requirements for recovery

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### **Publication**

**PCR** Profiles for windows, doors and facades PCR-PR-2.3  
Product Category Rules according to EN ISO 14025 und EN 15804

Bibliographic information of the German Library. The German Library lists this publication in the German national bibliography; detailed bibliographic data can be found on the Internet:  
<http://dnb.ddb.de>

### **Layout**

ift Rosenheim GmbH  
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