



ENGINEERING  
TOMORROW



## Environmental **Product Declaration**



### **DCR filter for CO<sub>2</sub> with 2 Core**

<b>EPD issued</b>	2024-04-29
<b>EPD expires</b>	2029-04-29
<b>EPD author</b>	Danfoss Climate Solutions RAC
<b>EPD type</b>	Cradle-to-grave
<b>Declared unit</b>	One product over its Reference Service Life
<b>Products included</b>	DCR filter for CO <sub>2</sub> DN50 (G - 1/2), 023U1202
<b>Manufacturing Location</b>	Tamil Nadu, India
<b>Use Location</b>	Europe
<b>Application</b>	Commercial Refrigeration System
<b>Mass</b>	22.83 kg without packaging 25.95 kg with packaging
<b>Dimensions (H×W×D)</b>	295x392x564 mm
<b>Verification</b>	<input type="checkbox"/> External <input checked="" type="checkbox"/> Internal <input type="checkbox"/> None
<b>Produced to</b>	<a href="#">Danfoss Product Category Rules</a> (2022-09)
<b>Internal independent verifier</b>	Danfoss Power Electronics & Drives A/S

#### **DISCLAIMER**

This EPD was prepared to the best of knowledge of Danfoss A/S. The life cycle assessment calculations were performed in accordance with ISO 14040 & 14044 and EN15804+A2.

All results were internally reviewed by independent experts. While this declaration has followed the guidance of ISO 14025, it has not been externally verified or registered by an EPD programme and therefore does not fully comply with the ISO 14025 standard.

This EPD has been published by Danfoss A/S on Danfoss Product Store and Danfoss Website. For questions, feedback or requests please contact your Danfoss sales representative.

## Introduction

This Environmental Product Declaration (EPD) follows the Danfoss Product Category Rules (PCR) (2022-09-20). These rules provide a consistent framework for calculating and reporting the environmental performance of Danfoss' products and are aligned with relevant international standards, particularly ISO 14025:2006 and EN 15804+A2:2019.

This document has been produced by Danfoss A/S following an internal verification process, but it is not a third-party verified document.

## What is an EPD?

An EPD is a document used to communicate transparently, the quantified environmental impacts of a product over its lifecycle stages. This quantification is done by performing a Life Cycle Assessment (LCA) in line with a consistent set of rules known as a PCR (Product Category Rules).

An EPD provides:

- A product's carbon footprint together with other relevant environmental indicators, including air pollution, water use, energy consumption, and waste, over its life cycle (Module A-C), as well as the expected benefits of reuse and recycling in reducing the impact of future products (Module D). See Table 1 for module descriptions.
- Environmental data allows customers to calculate LCAs and produce EPDs for their products.

## Type of EPD

This EPD is of the type 'cradle-to-grave' and includes all relevant modules: production (A1-A3), shipping (A4) and installation (A5); deconstruction (C1), waste collection and transport (C2), treatment (C3) and disposal (C4). It also includes potential net benefits to future products from recycling or reusing post-consumer waste (D). The codes in brackets are the module labels from EN 15804+A2. Modules concerning the use, maintenance, repair, replacement, refurbishment (B1-B5), and operational water use (B7) are excluded, following the cut-off rules from EN 15804.

**Table 1:** Modules of the product's life cycle included in the EPD.

Product stage			Installation		Use stage							End-of-life stage				Benefits
Raw materials	Transport	Manufacture	Transport	Installation	Use	Maintenance	Repair	Replacement	Refurbishment	Operational energy use	Operational water use	De-install.	Transport	Waste processing	Disposal	Benefits and loads outside system boundaries
<b>A1</b>	<b>A2</b>	<b>A3</b>	<b>A4</b>	<b>A5</b>	B1	B2	B3	B4	B5	B6	B7	<b>C1</b>	<b>C2</b>	<b>C3</b>	<b>C4</b>	<b>D</b>
<b>X</b>	<b>X</b>	<b>X</b>	<b>X</b>	<b>X</b>	MNR	MNR	MNR	MNR	MNR	MNR	MNR	<b>X</b>	<b>X</b>	<b>X</b>	<b>X</b>	<b>X</b>

(X = declared module; MNR = module not relevant)

## Product Description

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Type DCR Filter driers with replaceable solid 2 core, are used in liquid and or suction lines in CO<sub>2</sub> refrigeration systems. DCR variant is compatible with R744 gasses and can withstand a pressure up to 90 bar.

The range features a variety of core designs for high moisture absorption and acid removal to reduce the risk of compressor burnout.

The DCR Filters come with unique cartridge design for ease of service and offer a high system reliability and welded joints for low leakage risk.

### Applications:

- Supermarket Rack
- CO<sub>2</sub> packages
- Commercial Refrigeration System
- OEM's

See more information about DCR CO<sub>2</sub> Filter Drier (012U1202) on [Danfoss Customer Engagement Tool](#)



**Figure 1: DCR Filter Drier for CO<sub>2</sub>.**

This product is sold without the core inside. The customer has the option to buy the core separately

The reference product used (FG code 023U1202) for this EPD is representative of Danfoss for all 2 Core DCR filter CO<sub>2</sub> (covered sales codes presented in annex). Since the reference product is the biggest DCR filter among the range, this EPD covers all products in the DCR filter driers for CO<sub>2</sub>, therefore representing a conservative scenario. This assumption is based on the mass, material composition. The results for this EPD were calculated the DCR filter without the core (sold separately). The products covered by this EPD are presented in table 13.

### Reference Service Life

For the purpose of this EPD the reference service life (RSL) of the product is considered to be 10 years.

### Intended market.

The intended market of this study is Europe, and the baseline scenario involves the distribution, installation, and end-of-life in Europe.

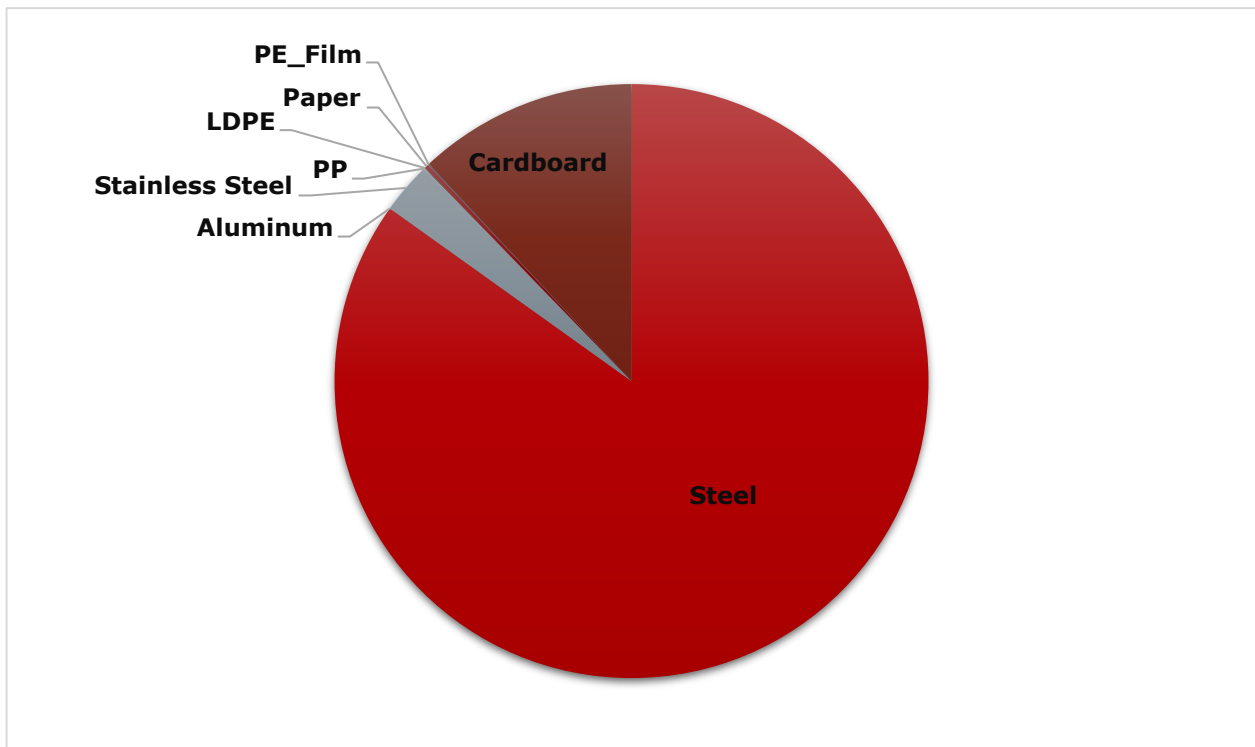
## Product Description

**Table 2:** Product composition

Material	Mass (kg)	%
<b>Metals</b>	22.75	99%
Steel	22.03	96%
Aluminum	0.001	0.004%
Stainless Steel	0.73	3%
<b>Plastics</b>	0.02	0.1%
PP	0.01	0.1%
LDPE	0.01	0.0%
<b>Other</b>	0.06	0.3%
Paper	0.06	0.3%
<b>Total product</b>	22.83	100%
PE Film	0.02	1%
Cardboard	3.10	99%
<b>Total packaging</b>	3.12	100%
<b>Total product &amp; packaging</b>	25.95	

The EPD values were calculated for this composition.

The declared unit is One product over its Reference Service Life (10 years), with a mass of 25.951 kg.



**Figure 2:** Material Composition Overview

## Overview of LCA study

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### Data quality

The data quality of the selected datasets is generally assessed as good and very good in terms of geographical, time, and technology representativeness and applicability. Background data is from LCA software LCA for Experts (Sphera) database version 2023.2.

### Allocation and cut-off criteria

The allocation is made in accordance with the provisions of EN 15804+A2. All major raw materials and all the essential energy are included. All hazardous materials and substances are considered in the inventory. Data sets within the system boundary are complete and fulfill the criteria for the exclusion of inputs and output criteria. No known material or energy flows were ignored, including those which fell below the limit of 1%. Accordingly, the total sum of input flows ignored is certainly less than 5% of the energy and mass applied.

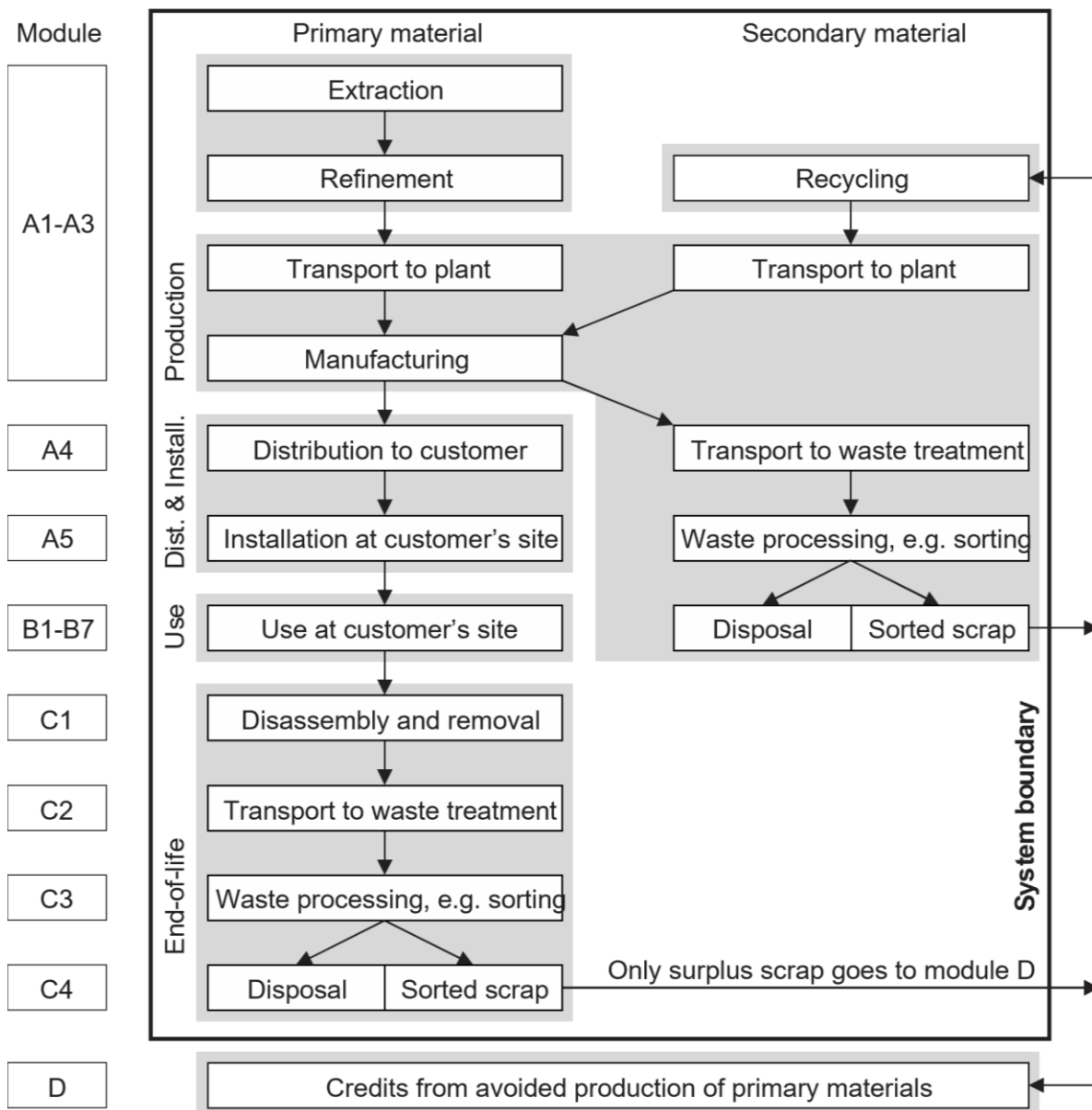
The child parts like Core, felt mat & flat gaskets were not included in the Bill of material. And the production process like Plating was also not included in the calculation.

The DCR filter drier is sold without the core inside, thus the customer has the option to buy the core separately.

## Overview of LCA study

### System boundaries

The results in this EPD are split into life cycle modules following EN 15804 (Figure 3): production (A1-A3), distribution (A4), (A5) installation, use (B6), and the end of the product's life (C1-C4). Module D represents environmental benefits and loads that occur beyond the system boundary (i.e., in future products).



**Figure 3:** Modular structure used in this EPD (following EN 15804+A2)

## Overview of LCA study

### Product and packaging manufacture (A1-A3)

Final manufacturing occurs in the Oragadam plant, in India, data was collected for year 2024. The facility is certified according to IATF 16949 compliant, ISO 14001, ISO 9001, PED/PESR, UL & MID. Where waste generated on-site is recyclable, it is separated and recycled. For further information, [see here](#). All packaging materials can be safely recycled or incinerated if appropriate local facilities are available.

**Table 3:** Biogenic carbon content in the product

	Total (excluding recycling)
Biogenic carbon content in product [kg]	0,00E+0
Biogenic carbon content in accompanying packaging [kg]	1.08E+0

*Note: 1 kg of biogenic carbon is equivalent to 44/12 kg of CO<sub>2</sub>.*

### Shipping and installation (A4-A5)

The intended market for 2 Core DCR Filter for CO<sub>2</sub> is Europe. The assembly factory is in India, so 15,000km by Sea and 500km by truck, used to represent the distance between the factory and the final customer. The distance was calculated using sales data.

Module A5 includes disposal of packaging materials only, the benefits from e.g., energy recovered after plastic incineration are allocated to module D. The product is assumed to be installed by hand and there is no loss of product during installation. Energy use in handheld tools during installation is not included as it falls under the cut-off criteria.

### End-of-life (C1-C4)

The following end-of-life procedure has been applied:

- Manual dismantling is used to separate recyclable bulk materials, e.g., bulk metals and plastics.
- Shredding is used for the remaining parts, such as printed circuit board assemblies.
- Ferrous metals, non-ferrous metals, and bulk plastics are recovered through recycling.
- The remaining materials go to either energy recovery or landfill.

In line with EN 15804+A2, only the 'net scrap' (i.e., the leftover recyclable materials remaining after inputs of recycled content required in the manufacturing phase are first satisfied) is used to calculate the benefits and loads beyond the system boundary (Module D).

For this EPD an average scenario with 50% of the product sent to recycling and 50% of the product sent to landfill (C3, C4, D) was used.

This scenario is designed to represent an average end-of-life scenario.

For the EPD this average scenario was chosen as it is assumed that it represents the majority of cases on average.

1. Recycling scenario with 100% of the product sent to recycling at the end-of-life, excluding fractions that cannot be recycled or incinerated (e.g., glass reinforcing in glass-filled plastics) and are sent to landfill.

## Overview of LCA study

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This scenario illustrates best-case performance. It assumes a 100% collection rate and the best available recycling technologies. Under this scenario, electrical cables, and all metals, flat glass, and unreinforced plastics found within the body and chassis of the product are recycled. Printed circuit board assemblies are incinerated, and the copper and precious metals (gold, silver, palladium, and platinum) are recycled.

2. Landfill scenario with 100% of the product sent to landfill.

This scenario assumes that the whole product, including its packaging, is landfilled. It is designed to represent a poor end-of-life route where valuable resources are lost.

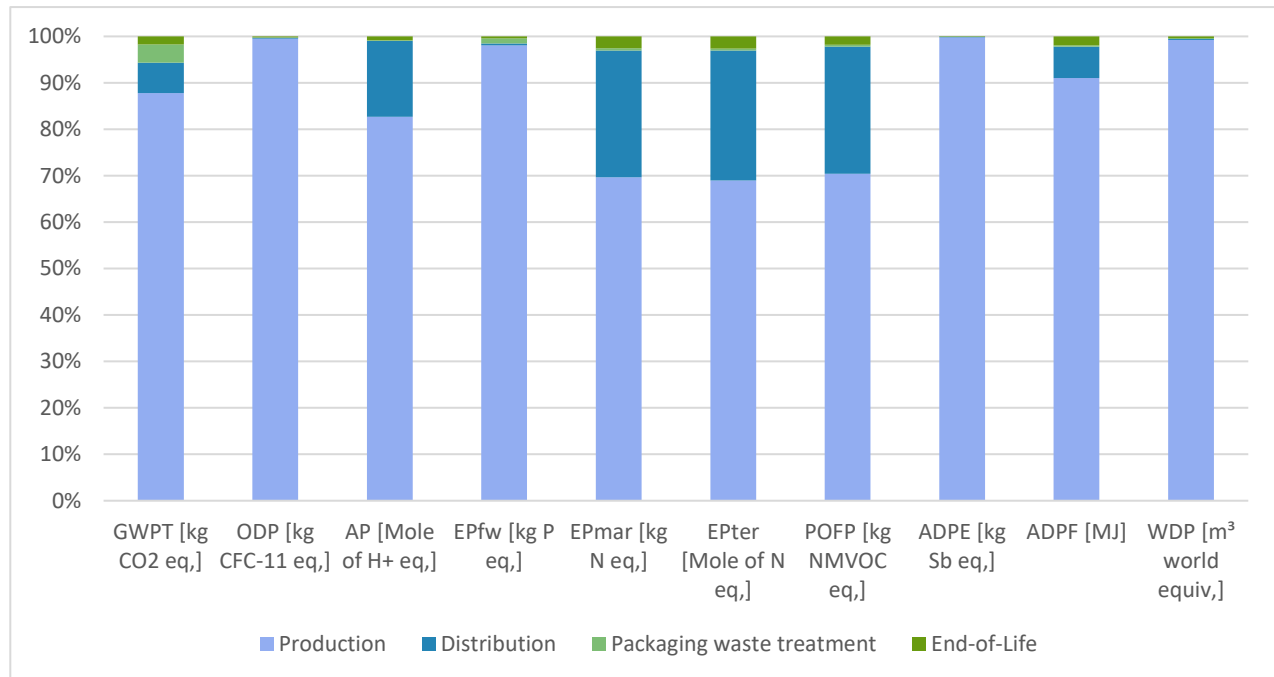
### Benefits and loads beyond the system boundary (D)

Module D considers the net benefit of recycling (including energy recovery) of materials in the product and packaging, taking into account losses in the recycling process and the recycled material used in the production of the product. Module D covers the two end-of-life scenarios, as described above.



## Environmental performance

This section presents the environmental performance of one-unit 0123U1202. Figure 5 presents the environmental impact of one-unit DCR filter drier for CO<sub>2</sub> across several environmental impact categories (following EN 15804+A2:2019) per life cycle stage, over its full life cycle, including Global Warming Potential.



**Figure 4:** Breakdown of environmental impacts by life cycle stages (see Table 6 for descriptions of environmental impact indicators).

**Table 5:** Environmental Impact Indicators

	Production	Distribution	Packaging waste treatment	End-of-Life				(Not included in Figure 5)
Life cycle stages based on EN 15804+A2	A1-A3	A4	A5	C1	C2	C3	C4	D
<div> <div>Description</div> <div>Environmental Impact Indicators</div> </div>	Manufacture of the product from 'cradle-to-gate'	Transport of the product to the customer	Installation of the product and disposal of used packaging	Deinstallation of the product from the site	Transport of the product to waste treatment	Processing waste for recycling	Disposal of waste that cannot be recycled (through landfill and incineration)	Potential benefits and loads beyond the system boundary due to reuse, recycling, and energy recovery
GWPT [kg CO <sub>2</sub> eq.]	9.58E+01	7.21E+00	4.27E+00	0.00E+00	2.33E-01	1.31E+00	3.45E-01	-2.37E+00
GWPF [kg CO <sub>2</sub> eq.]	9.97E+01	7.20E+00	3.00E-01	0.00E+00	2.33E-01	1.29E+00	3.02E-01	-2.37E+00
GWPB [kg CO <sub>2</sub> eq.]	-3.97E+00	0.00E+00	3.97E+00	0.00E+00	0.00E+00	0.00E+00	4.30E-02	0.00E+00
GWPLULUC [kg CO <sub>2</sub> eq.]	8.39E-02	9.81E-03	3.03E-04	0.00E+00	5.63E-06	1.18E-02	5.36E-04	-5.50E-03
ODP [kg CFC-11 eq.]	2.86E-10	5.52E-13	2.00E-13	0.00E+00	2.72E-17	1.66E-13	4.39E-13	-1.43E-12
AP [Mole of H+ eq.]	1.04E+00	2.07E-01	1.60E-03	0.00E+00	3.20E-04	8.05E-03	2.00E-03	-1.29E-02
EPfw [kg P eq.]	1.21E-03	5.21E-06	1.34E-05	0.00E+00	5.05E-08	4.68E-06	7.00E-07	-2.55E-06
EPmar [kg N eq.]	1.30E-01	5.09E-02	8.64E-04	0.00E+00	1.27E-04	3.93E-03	7.02E-04	-1.94E-03
EPter [Mole of N eq.]	1.37E+00	5.57E-01	7.87E-03	0.00E+00	1.40E-03	4.36E-02	7.69E-03	-2.09E-02
POFP [kg NMVOC eq.]	3.71E-01	1.44E-01	2.17E-03	0.00E+00	3.03E-04	7.47E-03	1.70E-03	-6.55E-03
ADPE [kg Sb eq.]	1.10E-04	1.25E-07	1.54E-08	0.00E+00	8.30E-09	8.42E-08	1.25E-08	-3.05E-06
ADPF [MJ]	1.19E+03	8.86E+01	4.07E+00	0.00E+00	3.36E+00	1.74E+01	4.17E+00	-5.92E+01
WDP [m <sup>3</sup> world equiv.]	9.62E+00	2.28E-02	1.84E-02	0.00E+00	3.94E-04	1.55E-02	1.91E-02	-8.93E-01

How to read scientific numbers:

e.g. 2,05E02 = 2,05 x 10<sup>2</sup> = 205

2,04E-01 = 2,04 x 10<sup>-1</sup> = 0,204

**Table 6:** Environmental impact indicator descriptions

Acronym	Unit	Indicator
GWPT	kg CO <sub>2</sub> eq.	Carbon footprint (Global Warming Potential) – total
GWPF	kg CO <sub>2</sub> eq.	Carbon footprint (Global Warming Potential) – fossil
GWPB	kg CO <sub>2</sub> eq.	Carbon footprint (Global Warming Potential) – biogenic
GWPLULUC	kg CO <sub>2</sub> eq.	Carbon footprint (Global Warming Potential) – land use and land use change
ODP	kg CFC-11 eq.	Depletion potential of the stratospheric ozone layer
AP	Mole H <sup>+</sup> eq.	Acidification potential
EPfw	kg P eq.	Eutrophication potential – aquatic freshwater
EPmar	kg N eq.	Eutrophication potential – aquatic marine
EPter	Mole of N eq.	Eutrophication potential – terrestrial
POFP	kg NMVOC eq.	Summer smog (photochemical ozone formation potential)
ADPE*	kg Sb eq.	Depletion of abiotic resources – minerals and metals
ADPF*	MJ	Depletion of abiotic resources – fossil fuels
WDP*	m <sup>3</sup> world eq.	Water deprivation potential (deprivation-weighted water consumption)

Results for modules A1-A3 are specific to the product. All results from module A4 onwards should be considered as scenarios that represent one possible outcome. The true environmental performance of the product will depend on actual use.

The results in this section are relative expressions only and do not predict actual impacts, the exceeding of thresholds, safety margins, or risks. EPDs from others may not be comparable.

### Carbon footprint

The total carbon footprint (GWPT), cradle-to-grave, of the product is 1.09E+02kg CO<sub>2</sub>-eq (A1-C4). The carbon footprint (GWPT) of production of this product, cradle-to-gate, is 9,58E+1 kg CO<sub>2</sub>-eq (A1-A3).

**Table 7:** Resource use

	A1-A3	A4	A5	C1	C2	C3	C4	D
PERE [MJ]	3.21E+02	1.47E-01	2.48E-01	0.00E+00	1.11E-02	1.27E+00	3.80E-01	-5.09E+00
PERM [MJ]	9.00E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PERT [MJ]	3.22E+02	1.47E-01	2.48E-01	0.00E+00	1.11E-02	1.27E+00	3.80E-01	-5.09E+00
PENRE [MJ]	1.19E+03	3.36E+01	4.26E+00	0.00E+00	3.37E+00	1.75E+01	4.17E+00	-5.92E+01
PENRM [MJ]	5.76E-01	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
PENRT [MJ]	1.19E+03	3.36E+01	4.26E+00	0.00E+00	3.37E+00	1.75E+01	4.17E+00	-5.92E+01
SM [kg]	2.75E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
RSF [MJ]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
NRSF [MJ]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
FW [m3]	3.87E-01	1.93E-04	5.86E-04	0.00E+00	1.78E-05	1.39E-03	5.89E-04	-3.72E-02

**Table 8:** Resource use indicator descriptions

Acronym	Unit	Indicator
PERE	MJ	Use of renewable primary energy excluding renewable primary energy resources used as raw materials
PERM	MJ	Use of renewable primary energy resources used as raw materials
PERT	MJ	Total use of renewable primary energy resources (primary energy and primary energy resources used as raw materials)
PENRE	MJ	Use of non-renewable primary energy excluding non-renewable primary energy resources used as raw materials
PENRM	MJ	Use of non-renewable primary energy resources used as raw materials
PENRT	MJ	Total use of non-renewable primary energy resources (primary energy and primary energy resources used as raw materials)
SM	kg	Use of secondary material
RSF	MJ	Use of renewable secondary fuels
NRSF	MJ	Use of non-renewable secondary fuels
FW	m <sup>3</sup>	Net use of fresh water

**Table 9:** Waste categories and output flows

	A1-A3	A4	A5	C1	C2	C3	C4	D
HWD [kg]	1.70E-06	1.06E-10	1.43E-10	0.00E+00	2.31E-11	5.41E-11	6.55E-11	-2.31E-04
NHWD [kg]	5.86E+01	3.07E-03	1.15E+00	0.00E+00	3.37E-04	2.67E-03	1.14E+01	1.05E-01
RWD [kg]	1.53E-02	3.95E-05	2.55E-05	0.00E+00	3.60E-06	3.27E-05	2.84E-05	-5.24E-05
CRU [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
MFR [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	1.14E+01	0.00E+00
MER [kg]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
EEE [MJ]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00
EET [MJ]	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00	0.00E+00

**Table 10:** Waste category and output flow descriptions

Acronym	Unit	Indicator
HWD	kg	Hazardous waste disposed
NHWD	kg	Non-hazardous waste disposed
RWD	kg	Radioactive waste disposed
CRU	kg	Components for reuse
MFR	kg	Materials for recycling
MER	kg	Materials for energy recovery
EEE	kg	Exported energy (electrical)
EET	kg	Exported energy (thermal)

**Table 11:** Additional indicators\*

	A1-A3	A4	A5	C1	C2	C3	C4	D
PM [Disease incidences]	1.79E-05	1.65E-06	1.19E-08	0.00E+00	4.44E-09	5.18E-08	1.98E-08	-2.71E-07
IRP [kBq U235 eq.]	1.69E+00	5.65E-03	3.35E-03	0.00E+00	5.10E-04	4.88E-03	3.34E-03	5.30E-03
ETPfw [CTUe]	3.99E+02	2.34E+01	3.54E+00	0.00E+00	2.44E+00	1.24E+01	2.64E+00	-3.40E+01
HTPc [CTUh]	1.20E-06	4.31E-10	1.01E-10	0.00E+00	4.53E-11	2.54E-10	2.18E-10	-3.04E-08
HTPnc [CTUh]	1.51E-06	1.98E-08	9.75E-09	0.00E+00	1.98E-09	1.59E-08	2.25E-08	-3.11E-08
SQP [Pt]	4.75E+02	1.10E-01	6.05E-01	0.00E+00	8.60E-03	7.28E+00	5.61E-01	-3.76E+00
GWP-GHG [kg CO2 eq.]	9.98E+01	7.21E+00	3.00E-01	0.00E+00	2.33E-01	1.31E+00	3.02E-01	-2.37E+00

**Table 12:** Optional indicator descriptions

Acronym	Unit	Indicator
PM	Disease incidence	Potential incidence of disease due to particulate matter emissions
IRP**	kBq U235 eq.	Potential human exposure efficiency relative to U235
ETPfw*	CTUe	Potential Comparative Toxic Unit for Ecosystems (freshwater)
HTPc*	CTUh	Potential Comparative Toxic Unit for humans (cancer)
HTPnc*	CTUh	Potential Comparative Toxic Unit for humans (non-cancer)
SQP*	Dimensionless	Potential soil quality index
GWP-GHG	kg CO2 eq.	Carbon footprint – greenhouse gases

\**Disclaimer for ADPE, ADPF, WDP, ETPfw, HTPc, HTPnc, SQP:* The results of these environmental impact indicators shall be used with care as the uncertainties on these results are high or as there is limited experience with the indicator.

\*\**Disclaimer for ionizing radiation:* This impact category deals mainly with the eventual impact of low dose ionizing radiation on the human health of the nuclear fuel cycle. It does not consider effects due to possible nuclear accidents, occupational exposure nor radioactive waste disposal in underground facilities. Potential ionizing radiation from the soil, from radon, and some construction materials is also not measured by this indicator.

ANNEX

This EPD covering multiple sales code is the following. The representative code (023U1202) of the bunch is the heaviest amongst and chosen to represent the worst-case scenario covering the lighter products (sales code). This code (023U1202) was also used to calculate the EPD results.

**Table 13:** Products covered by this EPD

S.No	FG Code	Description	Cores
1	023U0997	DCR Filter for CO <sub>2</sub> ODF 1 5/8 I/12	2
2	023U1000	DCR filter for CO <sub>2</sub> DN 40 I/12	2
3	023U1003	DCR filter for CO <sub>2</sub> ODF 2 1/8 I/12	2
4	023U1006	DCR filter for CO <sub>2</sub> DN50 I/12	2
5	023U1203	DCR filter for CO <sub>2</sub> DN50 (G - 1/2) I/12	2
6	023U0996	DCR filter for CO <sub>2</sub> ODF 1 5/8	2
7	023U0999	DCR filter for CO <sub>2</sub> DN 40	2
8	023U1002	DCR filter for CO <sub>2</sub> ODF 2 1/8	2
9	023U1005	DCR filter for CO <sub>2</sub> DN50	2
10	023U1202	DCR filter for CO <sub>2</sub> DN50 (G - 1/2)	2

## References

- CEN (2019). *EN 15804:2012+A2:2019: Sustainability of construction works – Environmental product declarations – Core rules for the product category of construction products*. Brussels, Belgium: European Committee for Standardization.
- Danfoss (2022). *Danfoss Product Category Rules: Environmental Product Declarations for Danfoss Products*. Nordborg, Denmark: Danfoss A/S.
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