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DATA SHEET ENV 101 – Powder coating

Substrate material: **ALUMINIUM** mill finished (aluminum profiles, aluminum sheets, aluminum constructions)

Component measurements: up to l = 7,000 x w = 1,000 x h = 2,000 mm
(in hung condition)
Exterior and interior application
(for large part coating see data sheet ENV 102)

Component weight: up to 2,000 kg
(for higher unit weights see data sheet ENV 102)

Process: Chromium-free pre-treatment and powder coating

Product description: Surface pre-treatment and surface coating on a lead-, chromium-, cadmium- and solvent-free basis in facade quality

Properties: Pre-treatment chemistry and powder coating are tested and approved by the "Gütegemeinschaft für Stückgutbeschichtung".

- Highest weather resistance
- Best mechanical properties
- Good flow
- Chromium-, lead-, cadmium- and solvent-free

Application: Coating of aluminum profiles, aluminum sheets and aluminum constructions for interior and exterior application

Process restrictions: Cavities and concealed areas (e.g. doublings) cannot be protected.

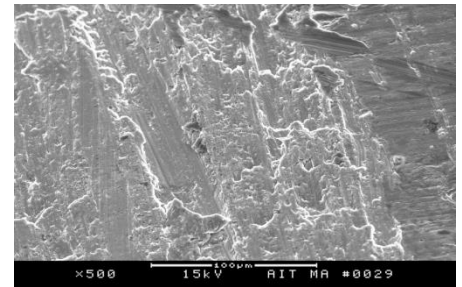
Due to chemical leakage from the hollow chambers and thermal ribs the profile edges (approx. 5-10cm) do not count as main visible surfaces and are to be considered as offcuts.

Color tones:

- Approx. 180 RAL colors (smooth glossy, smooth satin finish, smooth matt, (coarse) textured glossy)
- Standard RAL colors also available as ENV Antimicrobial
- Metallic, approx. P-tones, approx. DB metallic
- Pearlescent mica metallic
- Special color tones NCS; Sikkens or according to color samples
- Effect powder coatings: ENVnatuRAL Design, ENVTransparent, etc.

Process description:

- Acid mordant
- Rinsing with fully demineralized water
- Chromium-free pretreatment
- Drying
- Powder coating
- Curing



Assessment of the surface:

The finished coated surface is assessed in accordance with the Association of Window and Facade Manufacturers (Verband der Fenster- und Fassadenhersteller e.V.), VFF leaflet AL.02, status August 2016 (Visual assessment of organically coated aluminum surfaces) and delivered in this quality. Requirements going beyond this, including standard requirements or requirements of performance specifications, are only valid if they have been explicitly confirmed in writing by ENVIRAL®.

Suspension: According to our suspension recommendations (compare data sheet ENV 800)

Quality assurance: Continuing process control and order-specific quality assurance, destructive and non-destructive

Packaging: Noppa foam, air cushion film

Repair: According to our repair recommendations (compare data sheet ENV 802)

Cleaning: According to our cleaning recommendations (compare data sheet ENV 801)

Sealant adhesion: According to sealant adhesion on powder-coated surfaces of facades (compare data sheet ENV 803)

Approvals: Environmental Product Declaration according to ISO 14025 and EN 15804:

EPD-VDL-20160263-IAG1-EN:	Polyester	powder	coating
EPD-VDL-20160264-IAG1-EN:	Epoxy	powder	coating
EPD-VDL-20160265-IAG1-EN:	Hybrid	powder	coating
EPD-GDA-20190070-IBH1-EN:	Aluminum	profile	coated

For this process exists a product qualification according to DBS 918 340 of Deutsche Bahn AG.