

All technical recommendations for application we give to our clients to the best of our knowledge and according to the state of the art are not binding. According to our General Terms and Conditions of Business they do not establish any contractual legal relationship and no ancillary obligations resulting from the purchase contract. This does not release the client from his/her own responsibility to check our services, products and recommendations with regard to their suitability for the intended use. Our General Terms and Conditions of Business apply, which you can view at any time at www.enviral.eu.

DATA SHEET

ENV 201 – Powder coating

Substrate material:

STEEL and STAINLESS STEEL

Component measurements:

up to l = 7,000 x w = 1,000 x h = 2,000 mm

Interior application

(in hung condition)

(for larger parts, see ENV 202 data sheet)

Component weight:

up to 2,000 kg

(for higher unit weights see data sheet ENV 102)

Process:

Phosphating and powder coating

Product description:

Surface pre-treatment and surface coating on a lead-, chromium-, cadmium- and solvent-free basis

Properties:

- Best mechanical properties
- Good flow
- Chromium-, lead-, cadmium- and solvent-free
- Wide range of effects

Application:

Coating of profiles, sheets and constructions made of steel and stainless steel for interior application

Process restrictions:

Cavities, sharp edges and concealed areas (e.g. doublings) cannot be protected. Parts must be free of rust and scale on delivery, otherwise blasting according to data sheet ENV 700 will be necessary. The above restrictions do not apply to stainless steel.

Color tones:	<ul style="list-style-type: none"> • 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:	<ul style="list-style-type: none"> • Degreasing / phosphating • Rinsing with fully demineralized water • Drying • Powder coating • Curing
Assessment of the surface:	<p>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 ST.02, status August 2016 (Visual assessment of organically coated surfaces on steel) and delivered in this quality. Additional requirements, including standard requirements or requirements of service specifications, are only valid if they have been explicitly confirmed in writing by ENVIRAL®.</p>
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:	<p>Environmental Product Declaration according to ISO 14025 and EN 15804:</p> <p>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</p> <p>For this process exists a product qualification according to DBS 918 340 of Deutsche Bahn AG.</p>