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## DATA SHEET

## ENV 203 – Powder coating

### Substrate material:

**STEEL and STAINLESS STEEL**

### Component measurements:

up to l = 13,600 x w = 2,500 x h = 4,000 mm  
up to l = 17,500 x w = 1,000 x h = 2,000 mm  
(in hung condition)

### Exterior application

### Component weight:

up to 3,000 kg

### Process:

Blasting, ENVIRAL<sup>®</sup> curing primer and powder coating

### Product description:

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

### Properties:

The powder coating is 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 profiles, sheets and constructions made of steel and stainless steel for exterior application

**Process restrictions:** Cavities, sharp edges and concealed areas (e.g. doublings) cannot be protected. These restrictions only apply to steel components, not to stainless steel.

When producing the parts, it is necessary to ensure that machining fluids and greases are removed - especially around non-visible areas, unavoidable doublings, blind holes, threads, etc. - as these cannot be completely cleaned off by the blasting process and therefore have a negative effect on the powder coating layer and durability during the curing process.

**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:**

- Blasting (compare data sheet ENV 700)
- Dust removal
- Priming with ENVIRAL curing primer
- Curing
- Powder coating
- Curing

**Notes:** **Residues of blasting media in component cavities are to be expected! These cannot be completely removed. - Please take this into account when further processing and completing your components (e.g. protection of mechanical/movable built-in parts).**

**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 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®.

**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.