

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 303 – Powder coating

Substrate material:

STEEL galvanized

Component measurements:

up to l = 7,000 x w = 1,000 x h = 2,000 mm
 (in hung condition)

Exterior application

(for larger parts see data sheet ENV 304)

Component weight:

up to 2,000 kg
 (for higher unit weights see data sheet ENV 304)

Process:

Degreasing / phosphating, ENVIRAL[®] curing primer and powder coating

Product description:

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

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 galvanized steel profiles, steel sheets and steel constructions for exterior application

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

Parts must be free of white rust and zinc spray when delivered, otherwise sweep blasting is required. Galvanized surfaces must be in good condition and have a surface that is suitable for coating, free of zinc corrosion, water-soluble salts, passivation, zinc sprays, zinc pastes or similar separating layers. Nevertheless, the thermal treatment after coating may result in outgassing and the formation of bubbles.

In deviation from the DIN 55633 standard, **no** optical improvement of the zinc coating (no removal of thickenings and irregularities in the zinc coating) is carried out by ENVIRAL[®] before powder coating of galvanized surfaces. This is a chargeable additional service that requires an agreement and a separate written order by the customer.

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:

- Phosphating or Sweeping (compare with data sheet ENV 700)
- 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[®].

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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