

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](http://www.enviral.eu).

## DATA SHEET

## ENV 401 – Powder coating in industrial quality

|                                |  |
|--------------------------------|--|
| <b>Substrate material:</b>     | <b>STEEL, STEEL galvanized and ALUMINUM</b> mill finished (aluminum profiles, aluminum sheets, aluminum constructions)   |
| <b>Component measurements:</b> | up to l = 7,000 x w = 1,000 x h = 2,000 mm (in hung condition)   |
| <b>Component weight:</b>       | up to 2,000 kg   |
| <b>Process:</b>                | Degreasing and Powder Coating  |
| <b>Product description:</b>    | Surface pre-treatment and surface coating on a lead-, chromium-, cadmium- and solvent-free basis. This industrial coating is intended for those projects that do not require the high quality ENVIRAL <sup>®</sup> powder coating described in the other ENVIRAL <sup>®</sup> data sheets. |
| <b>Process restrictions:</b>   | Cavities, sharp edges and concealed areas (e.g. doublings) cannot be protected. Parts must be free of rust and scale on delivery, otherwise blasting in accordance with data sheet ENV 700 will be necessary. The above-mentioned restrictions do not apply to stainless steel.            |

Galvanized parts must be delivered free from white rust and zinc spray otherwise sweep blasting will be necessary.

Galvanized surfaces must be in perfect condition and have a coatable surface, in other words free of zinc corrosion, water-soluble salts, passivation, zinc sprays, zinc pastes or similar separation layers. Nevertheless, outgassing and bubble formation may occur due to the thermal treatment after coating.

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<sup>®</sup> 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 satin finish

**Process description:**

- Degreasing / Phosphating
- Rinsing with fully demineralized water
- Drying
- Powder coating
- Curing

**Assessment of the surface:** The finished coated surface is viewed at a distance of 5 meters, 90° viewing angle and diffuse light, 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<sup>®</sup>.

**Warranty:** The warranty of the coating is limited to 6 months from completion / handover by mutual agreement. The warranty liability is limited to the net coating turnover of the order.

**Packaging:** according to agreement with the customer (demand/effort = charged separately)

**Repair:** minor touch-ups using wet paint are allowed

**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