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DATA SHEET

ENV 700 – Blasting

Substrate material:

ALUMINUM, STEEL, STAINLESS STEEL, STEEL galvanized

Component measurements:

- a) l = 13,600 x w = 2, 500 x h = 4, 000 mm, up to 3, 000 kg or
 l = 17,500 x w = 1,000 x h = 2,000 mm, up to 3,000 kg (for stainless steel with separate agreement)
- b) l = 17,500 x w = 1,000 x h = 2,000 mm, up to 3,000 kg
- c) l = 13,600 x w = 2,500 x h = 4,000 mm, up to 3,000 kg (in hung condition)

Process:

Blasting, sweeping/fine blasting or glass bead blasting

Product description:

Mechanical surface pre-treatment as preparation for powder coating, water-based coating, painting or galvanizing as well as as finished surface (e.g. glass bead blasting of stainless steel).

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).
Mechanical distortion is to be expected with thin-walled parts.

Blasting media:

- a) Iron-free regular corundum or garnet blasting media (or for stainless steel with glass beads)
- b) Steel shot
- c) Glass beads

Application:

- Paint stripping, rust removal and scale removal
- Mechanical pre-treatment of constructions made of aluminum steel, galvanized steel and stainless steel that cannot be wet-chemically pre-treated (sweeping)
- Finished surface (stainless steel)

Process description:

a) Pressure blasting system I:

- up to l = 13,600 x w = 2,500 x h = 4,000 mm, up to 3,000 kg
- for components made of aluminum, steel, galvanized steel, stainless steel
- with separate agreement stainless steel can also be blasted with glass beads as follows:
up to l = 17,500 x w = 1,000 x h = 2,000 mm, up to 3,000 kg
- iron-free regular corundum or garnet blasting media
- flexible machining by hand
- compressed air blast media mixture is applied to the parts by a pressure jet blower and produces abrasion
- fine blasting / sweeping possible (pressure variably adjustable 2 to 6 bar)
- blasting medium runs over magnetic separator

b) Wheel blast system:

- up to l = 17,500 x w = 1,000 x h = 2,000 mm, up to 3,000kg
- for steel components (smooth beams, tubes, etc.)
- steel shot
- automatic machining
- steel shot is accelerated to high speed by centrifugal wheels, thus applied to the parts, producing economic abrasion

c) Pressure blasting system II:

- up to l = 13,600 x w = 2,500 x h = 4,000mm, up to 3,000kg
- for components made of aluminum, stainless steel, glass
- glass beads
- attaining matte, satinized, visually very appealing surfaces on aluminum and stainless steel as well as matte surfaces on glass
- Note for parts made of aluminum and stainless steel: slight damage and tarnishing, e.g. caused by welding of the parts, cannot be removed by glass bead blasting

Quality assurance:

Visual inspections and, upon request, surface roughness measurement and documentation