



Oberflächenveredelung GmbH

ENVIRAL® Oberflächenveredelung GmbH · Altdorfer Weg 6 · D-14823 Niemegek

Wir danken für Ihr Vertrauen!

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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 101 – Powder coating

Substrate material:	ALUMINIUM mill finished (aluminum profiles, aluminum sheets, aluminum constructions)
Component measurements:	up to l = 6,500 x w = 800 x h = 1,800 mm Exterior and interior application (for large part coating see data sheet ENV 102)
Component weight:	up to 250 kg (for higher unit weights see data sheet ENV 102)
Process:	Chromium-free pre-treatment and powder coating
Product description:	Surface pre-treatment and surface coating on a lead-, chromium-, cadmium- and solvent-free basis in facade quality
Properties:	Pre-treatment chemistry and powder coating are tested and approved by the "Gütegemeinschaft für Stückgutbeschichtung". <ul style="list-style-type: none">• Highest weather resistance• Best mechanical properties• Good flow• Chromium-, lead-, cadmium- and solvent-free
Application:	Coating of aluminum profiles, aluminum sheets and aluminum constructions for interior and exterior application
Process restrictions:	Cavities and concealed areas (e.g. doublings) cannot be protected.

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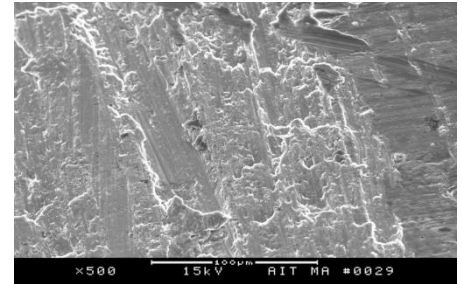
Geschäftsführer Ing. Rainer Rogovits
Amtsgericht Potsdam HRB 7819
Ust.-IdNr. DE 166554396
St.-Nr. 048/108/03245

Bankverbindungen Berliner Sparkasse · BIC BELADEVXXX
IBAN DE79 1005 0000 6610 0036 86
VR-Bank Fläming eG · BIC GENODEF1LUK
IBAN DE37 1606 2008 4105 6930 00



- 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:**
- Acid mordant
 - Rinsing with fully demineralized water
 - Chromium-free pretreatment
 - Drying
 - Powder coating
 - Curing



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 AL.02, status August 2016 (Visual assessment of organically coated aluminum surfaces) and delivered in this quality. Requirements going beyond this, including standard requirements or requirements of performance 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.