



Oberflächenveredelung GmbH

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

*Wir danken für Ihr Vertrauen!*

Altdorfer Weg 6 | info@enviral.de  
D-14823 Niemege | www.enviral.de

Telefon +49 (0) 33843 642-04  
Telefax +49 (0) 33843 642-24

kostenlose Servicenummer  
0-800/ENVIRAL 0-800/368 47 25

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## DATA SHEET

## ENV 202 – Powder coating

**Substrate material:**

**STEEL and STAINLESS STEEL**

**Component measurements:**

larger l = 6,500 x w = 800 x h = 1,800 mm  
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

### **Interior application**

(for smaller parts see data sheet ENV 201)

**Component weight:**

up to 3,000 kg

**Process:**

Blasting and powder coating

**Product description:**

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

**Properties:**

- Best mechanical properties
- Good flow
- Chromium-, lead-, cadmium- and solvent-free
- large selection of effects

**Application:**

Coating of profiles, sheets and constructions made of steel and stainless steel for interior application

**Process restrictions:**

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

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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 BELA2333  
IBAN DE79 1005 0000 6610 0036 86  
VR-Bank Fläming eG · BIC GENODEF1LUK  
IBAN DE37 1606 2008 4105 6930 00



When producing the parts, it is necessary to ensure that machining fluids and greases (especially around non-visible areas, unavoidable doublings, blind holes, threads, etc.) are removed, as these cannot be completely cleaned off by the sweeping/fine 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
  - 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 steel 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.