



Oberflächenveredelung GmbH

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

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 204 – Powder coating with SmartCorr®-P

Substrate material:

STEEL, STAINLESS STEEL and ALUMINIUM

Component measurements:

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
Exterior application



Component weight:

up to 3,000 kg

Process:

Blasting, SmartCorr®-P powder coating

Product description:

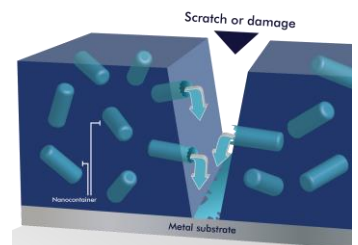
Surface pre-treatment and surface coating on a lead-, chromium-, cadmium- and solvent-free basis in facade quality

Properties:

SmartCorr®-P RAL standard powder coatings are tested and approved by the "Gütegemeinschaft für Stückgutbeschichtung". Special products upon request.

- 1-layer structure on steel up to C3 long without primer
- Highest weather resistance
- Best mechanical properties
- Good flow
- Chromium-, lead-, cadmium- and solvent-free

FUNCTION



Application:

Coating of profiles, metal sheets and constructions made from steel, stainless steel and aluminum for interior and exterior application

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ENV 204 / page 1

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

Bankverbindungen Berliner Sparkasse · BIC BELADEV333
IBAN DE79 1005 0000 6610 0036 86
VR-Bank Fläming eG · BIC GENODEF1LUK
IBAN DE37 1606 2008 4105 6930 00



Restrictions: Cavities, sharp edges and concealed areas (e.g. doublings) cannot be protected.
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 700)
- Dust removal
- Powder coating SmartCorr®-P
- Curing

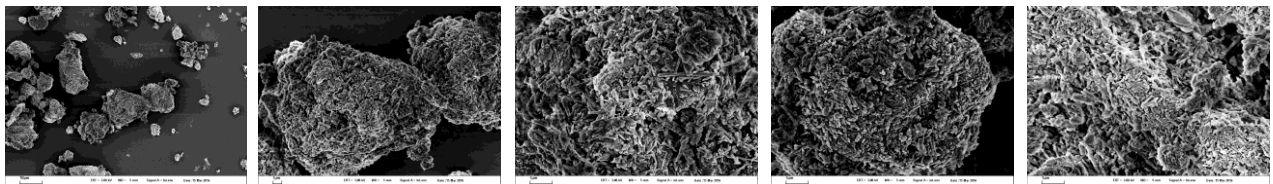


Fig. 1-5: REM image of the pure SmartCorr®-P corrosion protection additive.

Notes: **Residues of blasting media in component cavities are to be expected! These cannot be completely removed. - Please take this into account during further processing and completion of 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 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