

## Series 59 weather resistant

POWDER COATING FOR EXTERIOR (NON-ARCHITECTURAL) APPLICATIONS  
AND STEEL CONSTRUCTION

BASIS: POLYESTER

**THIS PRODUCT DATA SHEET DOES NOT EXTEND TO NEON/DORMANT/FLIP-FLOP EFFECTS**

### Typical application

- ACE (agricultural and construction equipment)
- Patio furniture
- Garden equipment
- Sporting goods

### Product details

**Standard Packaging** In original boxes of 20 kg each as well as in Minipacks of 2.5 kg each

**Specific Gravity (ISO 8130-2)** 1.2-1.7 g/cm<sup>3</sup> depending on pigmentation

**Theoretical Coverage** at 60 µm film thickness: 9.8-13.8 m<sup>2</sup>/kg depending on specific gravity (please see also Information Sheet no. 1072 - latest edition)

**Storage Stability** Use before: see printed date on product label; under dry conditions at no more than 25 °C, avoid direct and extended heat exposure

(The shelf life of custom made blanket orders or other stock agreements which by their nature are stored over longer periods is determined by the original production date.)

### Features

- good weather resistance (for architectural applications products of Series 29 or 14 must be used)
- good mechanical properties
- good flow properties
- good storage stability

### Finish

| Finish                      | Gloss    |
|-----------------------------|----------|
| smooth <i>glossy</i>        | 80 – 95* |
| smooth <i>semi glossy</i>   | 65 – 75* |
| smooth <i>matte</i>         | 20 – 35* |
| fine texture <i>matte</i>   | –        |
| rough texture <i>glossy</i> | –        |

\* Gloss level acc. to ISO 2813/60° angle (doesn't apply to metallic effect powder coatings). The measured gloss level of effect powder coatings can diverge from the details given in this product datasheet. The creation of tolerance samples is urgently recommended)

### Pre-treatments

The following table reflects the common methods of pretreatment with regards to various substrates and applications. In selecting the proper type of pretreatment please observe the suitability of the type of powder coating for a desired application according to the guidelines of this Product Data Sheet.

|                             | Alu-minum |   | Steel |                 | Galvanized Steel |                 |
|-----------------------------|-----------|---|-------|-----------------|------------------|-----------------|
| Degreasing                  | ○         |   | ○     |                 | ○                |                 |
| <sup>1) 2)</sup> Chromating | ○         | ○ |       |                 | ○                | ○               |
| <sup>2)</sup> Pre-Anodizing | ○         | ○ |       |                 |                  |                 |
| <sup>2)</sup> Chrome free   | ○         | ○ |       |                 | ○                | ○               |
| Iron Phosphating            |           |   | ○     |                 |                  |                 |
| Zinc Phosphating            |           |   | ○     | ○               | ○                | ○               |
| Blasting                    |           |   | ○     | ○               |                  |                 |
| <sup>3)</sup> Sweeping      |           |   |       |                 | ○                | ○               |
|                             | I         | E | I     | E <sup>4)</sup> | I                | E <sup>4)</sup> |

Application: I = interior; E = exterior

<sup>1)</sup> acc.to DIN 12487

<sup>2)</sup> acc. to GSB and QUALICOAT quality and test regulations.

<sup>3)</sup> only for zinc coated parts > 45 µm

<sup>4)</sup> for a two-coat process TIGER Series 270 / 271 / 272 / 273

### Application | Processing

**Standard stock item: Corona and Tribostatic\***

**Custom order product: Corona; Tribostatic\* available upon inquiry**

\* Suitability for tribo processing must be verified prior to actual application. Please consult with the relevant application guidelines for metallic effect powder coatings, latest edition.

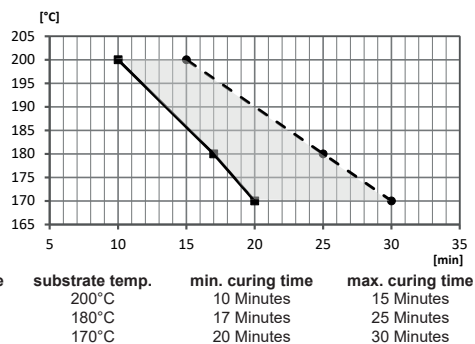
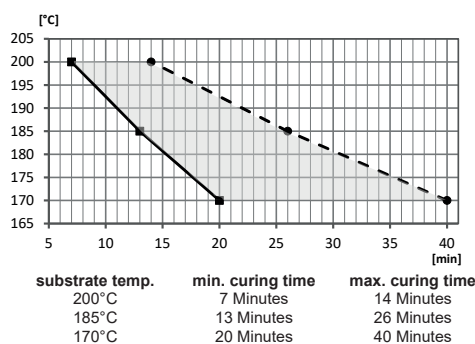
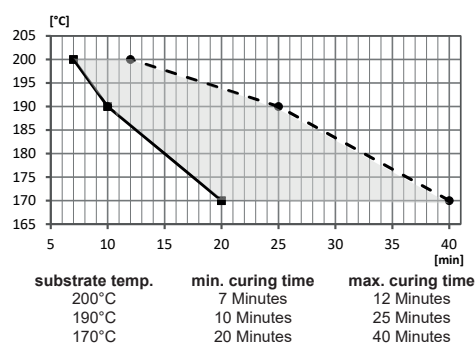
## Cure parameters

(Substrate temperature versus curing time)

smooth *glossy* | rough texture *glossy*

smooth *semi gloss*

smooth *matte* | fine texture *matte*



Please observe cure parameters closely!

## Test results

Checked under laboratory conditions on 0.7 mm thick, chrome-free pretreated aluminum sheets (AQT-36). The powder coatings were cured according to the corresponding baking conditions. Actual product performance may vary due to product specific properties such as gloss, color, effect and finish as well as application related and environmental influences.

| test method | test                                                    | Series 59<br>smooth <i>glossy</i>   smooth <i>matte</i><br>smooth <i>semigloss</i> | Series 59<br>fine texture <i>matte</i>  | Series 59<br>rough texture <i>glossy</i> |
|-------------|---------------------------------------------------------|------------------------------------------------------------------------------------|-----------------------------------------|------------------------------------------|
| ISO 2360    | <b>film thickness recommended</b>                       | 60-80 µm                                                                           | 70-90 µm                                | 90-120 µm                                |
| ISO 2813    | <b>gloss - 60°</b>                                      | gl. 80-95   sgl. 65-75   <i>matte</i> 20-35                                        | visual <i>matte</i>                     | visual <i>glossy</i>                     |
| ISO 2409    | <b>cross cut test/adhesion</b><br>1 mm cutting distance | 0                                                                                  | 0                                       | 0                                        |
| ISO 1519    | <b>mandrel bending test</b><br>cracking of coating      | gl./sgl. ≤ 5 mm   <i>matte</i> ≤ 6 mm<br>not permitted                             | ≤ 10 mm<br>permitted                    | ≤ 10 mm<br>permitted                     |
| ISO 1520    | <b>cupping test</b><br>cracking of coating              | ≥ 5 mm<br>not permitted                                                            | ≥ 3 mm<br>permitted                     | ≥ 3 mm<br>permitted                      |
| ASTM D 2794 | <b>ball impact test</b><br>cracking of coating          | 20 Inch/pound<br>not permitted                                                     | 20 Inch/pound<br>permitted              | 20 inch/pound<br>permitted               |
| ISO 6270-1  | <b>determination of resistance to humidity</b> 500 h    | delamination around scribe<br>max. 1 mm                                            | delamination around scribe<br>max. 1 mm | delamination around scribe<br>max. 1 mm  |
| ISO 9227    | <b>salt spray test</b><br>500 h                         | delamination around scribe<br>max. 1 mm                                            | delamination around scribe<br>max. 1 mm | delamination around scribe<br>max. 1 mm  |

## Processing instructions

The guidelines for application (datasheet 1213) and processing guidelines for powder coatings with metallic effect No. 36 and processing guidelines for powder coatings with metallic effect for application categories A-D No. 44 must be strictly observed.

The Product Data Sheets, Technical Information Sheets and the guidelines for application each in their latest version, are available for download on [www.tiger-coatings.com](http://www.tiger-coatings.com).

## Disclaimer

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EN ISO 9001 / 14001  
IATF 16949



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Series 59