Series 16/00108 transparent

POWDER COATING BASED ON ACRYLIC RESIN (GMA)

Typical application

- automotive components
- alu-wheels
- top coat to TIGER's CFC System
- bicycle and sporting industry
- handles
- bathroom equipment
- lamps
- metal furniture

Product details

Standard Packaging	In 18 kg cartons
Specific Gravity (ISO 8130-2)	1.15 ± 0.03 g/cm³
Theoretical Coverage	at 60 µm film thickness: 9.8 - 13.8 m²/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 below 20 °C (±2°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

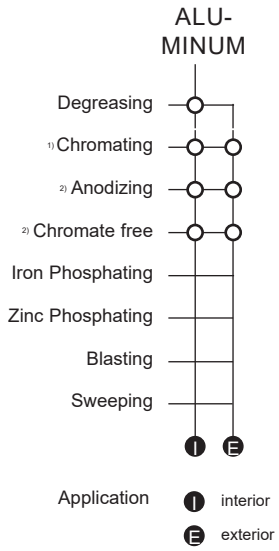
- very smooth flow
- excellent weather resistance
- highly transparent
- no cracking

Finish | Colors

- smooth glossy

Pre-treatments (alternatives)

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.



1) acc.to DIN 50939

2) acc. to GSB quality and test regulations. The suitability of this type of pretreatment needs to be established through a boiling water test and subsequent cross-hatch adhesion and adhesive tape removal test.

Processing

Corona, Tribostatic*

Product data sheet

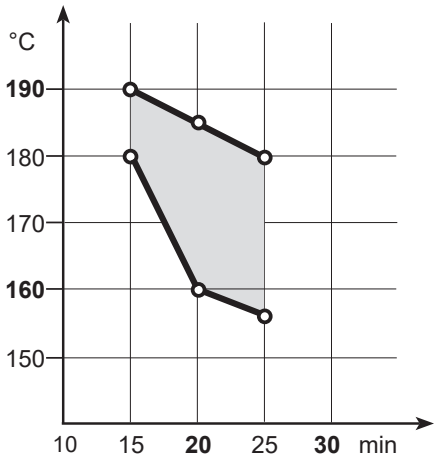
Cure parameters

(Substrate temperature)

Please observe cure parameters closely!

Metal temperatures shall not exceed 190° C. Please verify the suitability of direct gas-fired and IR oven equipment under actual production conditions for the intended application.

TIGER Drylac® Series 16/00108 smooth glossy



Substrate temperature versus curing time

PLEASE BE SURE TO OBSERVE THE FOLLOWING INSTRUCTIONS:

General instructions

TIGER Drylac® GMA acrylic resin based powder coatings have extremely high weather resistance combined with excellent flow and lasting lustre.

Handling

The product has high contamination potential (risk of surface defects). For this reason, it must be handled and stored separately, and applied in a separate paintshop from any conventional coatings!

TIGER Drylac® acrylate powder coatings should be processed at a temperature of 20°C (± 2°C) and relative humidity of 40-60%. If processing is carried out at higher temperatures than this, there is a risk of agglomerations and of powder sintering in the delivery hoses, nozzles and injectors. The product's suitability for direct gas-fired ovens must be verified separately.

When the product is applied as a top coat, sufficient inter-coat adhesion must be ensured!

Storage and transport

Store at a temperature of 20°C (± 2°C). At this temperature, the product has a storage life of 3 months. If this storage period is exceeded, the product's workability must be verified on a case-by-case basis. Always use separate pallets and containers for in-factory transport of this product!

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Test results

Checked under laboratory conditions on a chromated aluminum test panel which is 0.7 mm thick. 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 results	test method	Series 16 smooth glossy
film thickness	ISO 2360	60-80 µm
gloss - 60°	ISO 2813	> 100
cross cut test 1 mm	ISO 2409	o.k.
impression hardness	ISO 2815	87
mandrel bending test	ISO 1519	3 mm
cupping test	ISO 1520	> 5
impact test 20 inch/pound	ASTM D 2794	cracks
mortar resistance	ASTM D 3260	o.k.
drill mill test		o.k.
Kesternich-test 30 cycles	ISO 3231	o.k.
determination of resistance to humidity 1000 h	ISO 6270-1	o.k.
salt spray test NSS 1000 h	ISO 9227	o.k.

Processing instructions

The guidelines for application (datasheet 1213) must be strictly observed.
The Product Data Sheets, Technical Information Sheets and the guidelines for application each in their latest version, available as a download at www.tiger-coatings.com.

Disclaimer

Our verbal and written recommendations for the use of our products are based upon experience and in accordance with present technological standards. These are given in order to support the buyer or user. They are non-committal and do not create any additional commitments to the purchase agreement. They do not release the buyer from verifying the suitability of our products for the intended application. We warrant that our products are free of flaws and defects to the extent as stipulated in our Terms of Delivery and Payment.
As a part of our product information program each of our Product Data Sheets are periodically updated, so that the latest version shall prevail. Therefore, please visit the download area of www.tiger-coatings.com to make sure you have the most current version of this Product Data Sheet. The information in our Product Data Sheets is subject to change without notification.

This Product Data Sheet substitutes any and all previous Product Data Sheets and notes for customers published on this subject matter and is only intended to give a general product overview. Please request specific information for products outside of our standard product list (latest version).
The Technical Information Sheets and the Terms of Delivery and Payment each in their latest version, available as a download at www.tiger-coatings.com, form an integral part of this Product Data Sheet.

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certified according to
EN ISO 9001 / 14001
IATF 16949

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