

# Series 29 Interior and Exterior Application

A PRIMID TGIC-FREE POLYESTER POWDER COATING FOR METAL FACADES AND STEEL CONSTRUCTION BASIS

## Typical applications

- residential windows and doors
- lawn mowers and garden equipment
- patio furniture
- automotive accessories
- bicycles and motorcycles
- agricultural machinery
- sporting goods
- internal ship components

## Product details

**Standard packaging** in original 44 lb (20 kg) box and 5 lb (2.5 kg) minipack

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

**Theoretical coverage** at 2.5 mils - 3.5 mils (60 µm - 80 µm) film thickness: **9.8 - 13.8 m<sup>2</sup>/kg (47.8 - 67.4 ft<sup>2</sup>/lb)**. (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 77 °F (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

- highly weather resistant
- very good flow properties
- very good mechanical properties
- good storage stability
- batch consistency of RAL colors acc. to VdL guidance no. 10

## Finish

finish	gloss
smooth <i>glossy</i>	80-95*
smooth <i>semi-gloss</i>	70±5*
smooth <i>matte</i>	20-35*

\* 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)

Available in 50 RAL colors as stocked-product in smooth matte finish. Product can be custom-matched in limited colors in smooth: matte, semi-gloss and high-gloss finishes (minimum order quantity limitation applies).

## Pretreatment (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.

	Aluminum	Galvanized Steel	Steel
1)*2) Chromating	○ ○ ○	○ ○ ○	
2) Pre-Anodizing		○	
2) Chrome free	○ ○ ○	○ ○	
Iron Phosphating			○
Zinc Phosphating		○ ○ ○ ○	○ ○ ○
Blasting			○ ○ ○
3) Sweeping		○ ○ ○ ○	
	I E A	I E A S	I E S <sup>4</sup>

Application:

I = interior; E = exterior; A = architectural; S = steel

1) acc.to DIN 12487

2) acc. to GSB and QUALICOAT quality and test regulations.

3) only for zinc coated parts > 45 µm

4) for a two-coat process TIGER Shield

## Processing

### Corona and Tribostatic\*

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

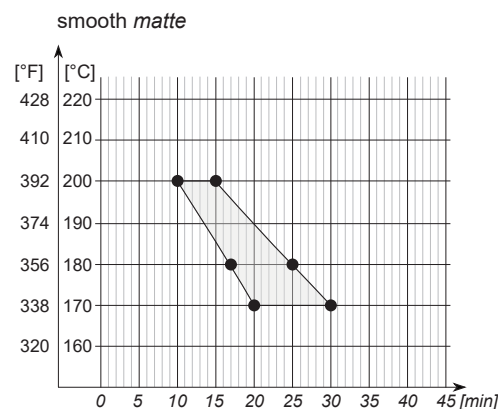
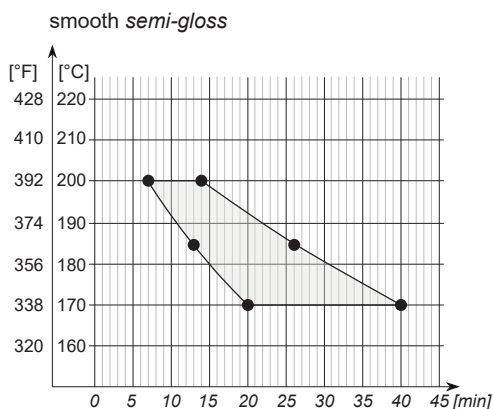
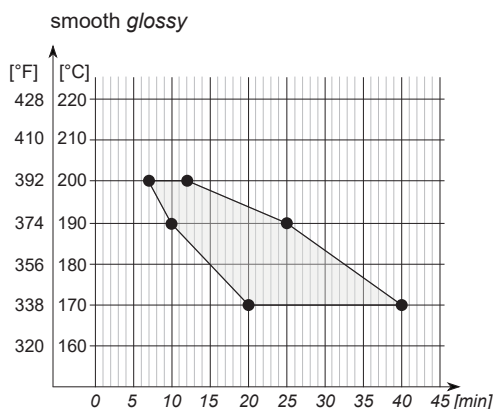
## Materials approvals for colors and metallic effects\*

finish	QUALICOAT Class 1	AAMA 2603
smooth <i>glossy</i>	P-1643	✓
smooth <i>semi-gloss</i>	P-1667	✓
smooth <i>matte</i>	P-1668	✓

\* Exemptions prevail

## Cure parameters

(substrate temperature versus curing time)



Please observe cure parameters closely since mechanical properties will develop before full cross-linking!

## Test results

Checked under laboratory conditions on a pretreated aluminum test panel which is 0.7 mm (1/64 inch) 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 method	test	Series 29 smooth glossy   smooth semigloss   smooth matte
ISO 2360	film thickness recommended	60-80 µm
ISO 2813	gloss - 60°	gl. 80-95   sgl. 70±5   matte 20-35
ISO 2409	cross cut test/adhesion 1 mm cutting distance	0
ISO 1519	mandrel bending test cracking of coating	≤ 5 mm not permitted
ISO 2815	impression hardness	≥ 80
ISO 1520	cupping test cracking of coating	≥ 5 mm not permitted
ASTM D 2794	ball impact test cracking of coating	20 Inch/pound not permitted
ISO 6270-1	determination of resistance to humidity 1000 h	Delamination around scribe max. 1 mm
ISO 9227	salt spray test 1000 h	Delamination around scribe max. 1 mm
acc. To EN ISO 16474-3	accelerated weathering UV-B (313 nm) 300 h *	residual gloss ≥ 50%
EN ISO 16474-2	accelerated weathering test xenon-arc radiation 1000 h **	residual gloss ≥ 50%
EN ISO 2810	natural weathering in Florida 12 month	residual gloss ≥ 50%

acc. to GSB AL 631 ([www.gsb-international.de](http://www.gsb-international.de)) \*\* acc. To QUALICOAT specifications ([www.qualicoat.net](http://www.qualicoat.net))

## 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.us](http://www.tiger-coatings.us).

## Disclaimer

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