

# SERIES 39 - interior and exterior applications

POLYESTERTGICWEATHERRESISTANTPOWDERCOATINGFORINTERIORANDEXTERIORAPPLICATIONS

## Typical applications

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

## Product details

**Standard packaging** in original 22, 44 & 55\* lb (10, 20 & 25\* kg) boxes and 5 lb (2.5 kg) minipack

\*Available while quantities last

**Specific gravity (ASTM D792)** approximately 1.2-1.8 g/cm<sup>3</sup> depending on pigmentation

**Theoretical coverage** at 2.5 mils (60 µm) film thickness: **51.5 ft<sup>2</sup>/lb (11.1 m<sup>2</sup>/kg)**. Refer also to "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric)

**Storage stability** 12 months at no more than 77 °F (25 °C) avoid direct and extended exposure to heat

## Features

- good weather resistance
- good mechanical properties
- good flow
- good coverage
- good storage stability
- Underwriter Laboratories recognized component (UL approved) for non-metallic finishes



Underwriters Laboratories Inc., (UL) Recognition.

## Finish

finish	gloss
smooth <i>glossy</i>	80-95+*
smooth <i>semi-gloss</i>	55-65*
smooth <i>matte</i>	15-25*
fine texture and wrinkle**	visual
clear	visual
metallic and other special effects	visual

\* Gloss level according to ASTM 523 at 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 Data Sheet. The creation of tolerance samples is recommended.

\*\* For best results, TIGER recommends the use of a primer when using this system. Ask your local sales representative about which primers are available.

Available as stock product in a selection of colors and finishes (see color charts). It can be made to order in non-stock colors (minimum order quantity applies).

## Pretreatment

The following table reflects the common methods of pre-treatment with regards to various substrates and applications. In selecting the proper type of pretreatment, the suitability of the type of powder coating for a desired application according to the guidelines on this page should be observed.

	Aluminum			Galvanized Steel			Steel		
Degreasing	○			○			○		
1) 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) according to ASTM B 449

2) according 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

3) only for zinc coated parts >1.8 mils (>45 µm)

4) for a two-coat process/TIGER Shield

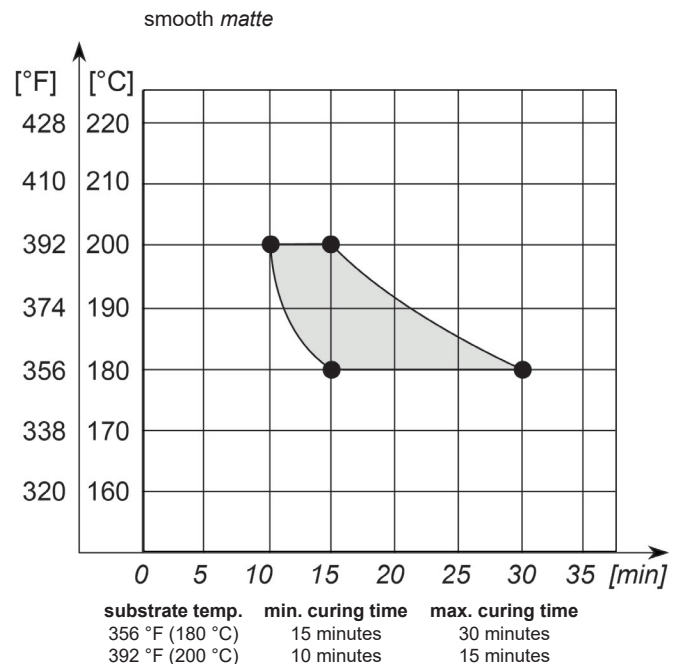
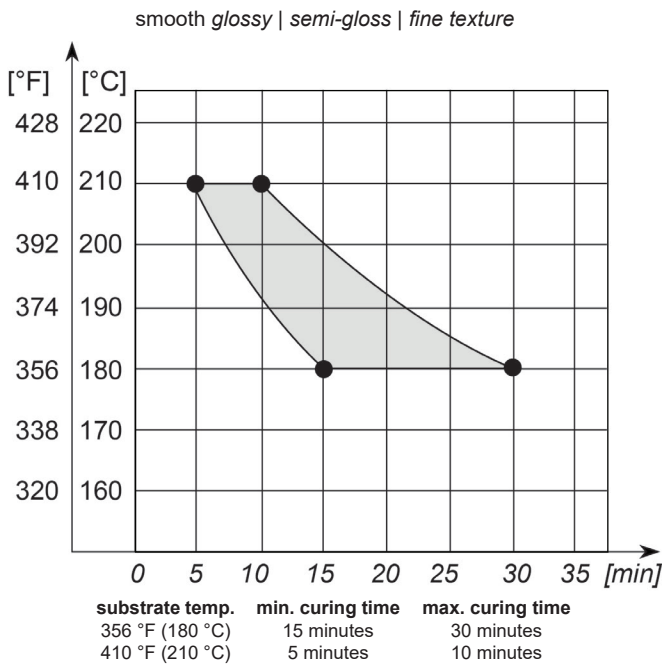
## Processing

### Corona

Since not all powder coatings are suitable for recycling/reclaim, please verify before ordering.

## Cure parameters

(substrate temperature versus curing time)



Cure parameters must be closely observed since mechanical properties will develop before full cross-linking.

**Wrinkle** finishes require a quick heat up rate. A slow heat up rate or heavy mass of parts will result in a flatter, less pronounced texture. Do not cure below 392 °F (200 °C).

## Test results

Checked under laboratory conditions on iron phosphated steel test panels Bonderite B-1000 or equivalent. Cure conditions are according to the cure curves. 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. When used as a two-coat system, the increase in film thickness will result in a decrease of mechanical properties.

test method	test	Series 39 smooth glossy   semi-gloss	Series 39 smooth matte	Series 39 fine texture flat matte
ISO 2360	<b>recommended film thickness</b>	2.5-3.5 mils (60-80 µm)	2.5-3.5 mils (60-80 µm)	3.0-4.0 mils (75-110 µm)
ASTM D523	<b>gloss - 60°</b>	80-95+   55-65	55-65	15-25
ASTM D3359 method B	<b>cross cut tape test</b> 1mm cutting distance	5B	5B	5B
ASTM D522	<b>mandrel bending test</b> cracking of coating	≤1/8 inch (≤3 mm)	≤5/32 inch (≤4 mm)	≤3/16 inch (≤5 mm)
ASTM D2794	<b>ball impact test</b> cracking of coating	80 in/lb no appearance of cracks down to the substrate	80 in/lb no appearance of cracks down to the substrate	80 in/lb no appearance of cracks down to the substrate
ASTM D3363	<b>pencil hardness</b>	2H minimum	2H minimum	2H minimum
ASTM D2247	<b>determination of resistance to humidity</b> 500 hours	maximum undercutting 1/32 inch (1 mm), no blistering	maximum undercutting 1/32 inch (1 mm), no blistering	maximum undercutting 1/32 inch (1 mm), no blistering
ASTM B117	<b>salt spray resistance</b> 500 hours	maximum undercutting 1/32 inch (1 mm), no blistering	maximum undercutting 1/32 inch (1 mm), no blistering	maximum undercutting 1/32 inch (1 mm), no blistering

**Cleaning recommendations:** refer to the latest edition of TIGER "Cleaning Recommendations" information sheet, Version 00-1005.

## Please note

For metallic finishes, it is recommended to observe the guidelines published in the latest edition of TIGER Drylac® "Application guidelines for metallic effect powder coatings".

Please consult the manufacturer before applying any 2-coat systems that feature (i) a primer or e-coat as base coat and (ii) a metallic effect powder coating as a top coat.

Top coating with a clear exterior grade powder coating over an interior grade powder coating does not result into a weather resistant coating system.

Post-bending properties of any part must be verified prior to application. Minor cracks in the coated surface may lead to corrosion.

Joint sealants and any other auxiliary products, such as glazing aids, gliding waxes, drilling and cutting lubricants, which come in contact with the coated surface, must be pH-neutral and free of substances that may damage the finish. Therefore, a suitability test at the applicator's end, prior to coating, is highly recommended.

In general, colors in the red, orange and yellow range may require an increased film thickness to achieve full hiding.

Please read and understand the Safety Data Sheet (SDS) before use.

## Chemical resistance

The required chemical resistance of a powder coating depends, among other things, on its formulation. Chemical resistance requirements must be considered according to processing conditions and final use of the finished product. This is best established during the product specification process. Agreement between all parties involved must be reached about the requirements for such chemical resistance as well as the test method, which may be performed in accordance with PCI test method #8 "Solvent Cure Test". Furthermore, the test duration and concentration of the test media need to be agreed upon.

## Disclaimer

TIGER's verbal and written recommendations for the use of its products are based upon experience and in accordance with current technological standards. These are provided 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 TIGER products for the intended application. TIGER warrants that its products are free of flaws and defects to the extent stipulated in the Terms of Delivery and Payment.

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