

# SERIES 69 - SEFA Compliant

EPOXY BASED POWDER COATING FOR INTERIOR APPLICATIONS COMPLIANT TO SEFA 8M-2016, SECTION 8.0 WITH EXCELLENT CHEMICAL RESISTANCE FOR SCIENTIFIC EQUIPMENT & LABORATORY FURNITURE APPLICATIONS

## Typical applications

- fume hoods
- laboratory furniture
- scientific equipment
- laboratory metal casework
- surfaces where increased chemical resistance is required

## Product details

|                                     |                                                                                                                                                                                                                             |
|-------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Standard packaging</b>           | in original 22 & 44 lb (10 & 20 kg) boxes and 5 lb (2.5 kg) minipack                                                                                                                                                        |
| <b>Specific gravity (ASTM D792)</b> | approximately 1.2-1.8 g/cm <sup>3</sup> depending on pigmentation                                                                                                                                                           |
| <b>Theoretical coverage</b>         | at 2.5 mils (60 µm) film thickness:<br><b>51.5 ft<sup>2</sup>/lb (11.1 m<sup>2</sup>/kg)</b> . Refer to the latest edition of "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric) |
| <b>Storage stability</b>            | 6 months at no more than 77 °F (25 °C) avoid direct and extended exposure to heat                                                                                                                                           |

## Features

- very good mechanical properties
- excellent chemical resistance
- good resistance to corrosion
- good flow properties
- excellent coverage
- good storage stability

## Finish

| finish                   | gloss <sup>†</sup> |
|--------------------------|--------------------|
| smooth <i>glossy</i>     | 80+*               |
| smooth <i>semi-matte</i> | 30 - 60            |

<sup>†</sup> Some gloss levels may vary. Please consult individual Technical Data Sheets for specific gloss levels.

\* 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.

## 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                  | ○        |   |   | ○                |   |   |   | ○     |   |                |
| <sup>1)</sup> Chromating    | ○        | ○ | ○ | ○                | ○ | ○ | ○ |       |   |                |
| <sup>2)</sup> Pre-Anodizing | ○        | ○ | ○ |                  |   |   |   |       |   |                |
| <sup>2)</sup> Chrome free   | ○        | ○ | ○ | ○                | ○ |   |   |       |   |                |
| Iron Phosphating            |          |   |   |                  |   |   |   | ○     | ○ |                |
| Zinc Phosphating            |          |   |   | ○                | ○ | ○ | ○ | ○     | ○ | ○              |
| Blasting                    |          |   |   |                  |   |   |   | ○     | ○ | ○              |
| <sup>3)</sup> 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.
- 3) only for zinc coated parts >1.8 mils (>45 µm)
- 4) for a two-coat process/TIGER Shield

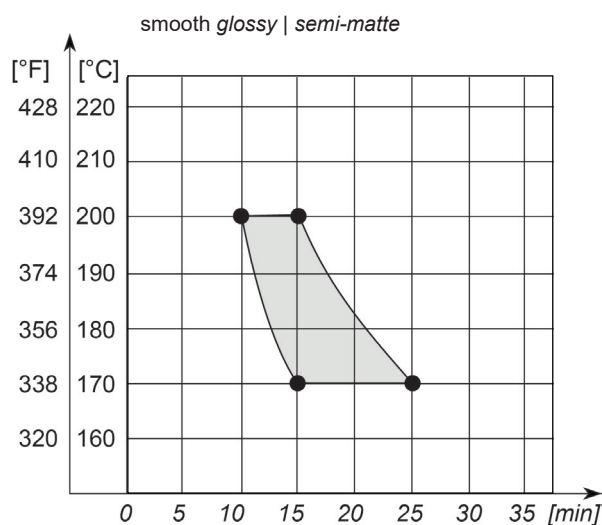
## Processing

### Corona

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

## Cure parameters

(substrate temperature versus curing time)



| substrate temp. | min. curing time | max. curing time |
|-----------------|------------------|------------------|
| 338 °F (170 °C) | 15 minutes       | 25 minutes       |
| 392 °F (200 °C) | 10 minutes       | 15 minutes       |

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

## Test results

Non-SEFA 8M-2016 tests checked under laboratory conditions on iron phosphated steel test panels Bonderite B-1000 or equivalent. SEFA 8M-2016 tests checked under specification conditions on cold rolled steel panels. 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 69<br>smooth glossy                                             | Series 69<br>smooth semi-matte                                         |
|---------------------------------------------|------------------------------------------------|------------------------------------------------------------------------|------------------------------------------------------------------------|
| ISO 2360                                    | <b>recommended film thickness</b>              | 2.5-3.5 mils<br>(60-80 µm)                                             | 2.5-3.5 mils<br>(60-80 µm)                                             |
| ASTM D523                                   | <b>gloss - 60°</b>                             | 80+                                                                    | 30 - 60                                                                |
| SEFA 8M-2016 8.1                            | <b>chemical spot test</b>                      | forty nine chemical reagents tested<br>achieving SEFA 8M-2016 criteria | forty nine chemical reagents tested<br>achieving SEFA 8M-2016 criteria |
| SEFA 8M-2016 8.2                            | <b>hot water test</b>                          | no visible effect due to hot water<br>(1,000 mL at 94°C for 5 minutes) | no visible effect due to hot water<br>(1,000 mL at 94°C for 5 minutes) |
| SEFA 8M-2016 8.3                            | <b>ball impact test</b><br>cracking of coating | 100 in/lb<br>no checks or cracks down to the<br>substrate              | 100 in/lb<br>no checks or cracks down to the<br>substrate              |
| Modified ASTM D3359<br>per SEFA 8M-2016 8.4 | <b>cross cut tape test</b>                     | 5B                                                                     | 5B                                                                     |
| Modified ASTM D3363<br>per SEFA 8M-2016 8.5 | <b>pencil hardness</b>                         | 4H                                                                     | 4H                                                                     |

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

## Please note

Epoxy powder coatings have a tendency to color shift and gloss variations due to changes in curing conditions. It is recommended to closely observe the curing parameters for TIGER Drylac® Series 69.

Please consult the manufacturer before applying any 2-coat systems that feature a primer or e-coat as base 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.

In general, whites and 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.

Product is certified under SEFA 8M-2016. Tests were conducted using Section 8.1 Chemical Spot Test where forty nine chemical reagents were left on the panel for a period of one hour. Out of forty nine chemicals tested, there were no more than four Level 3 conditions observed. Some chemicals that passed include: Acetone, 60% Chromic Acid, Gasoline, 37% Hydrochloric Acid, 30% Hydrogen Peroxide, Methyl Ethyl Ketone, 70% Nitric Acid, 85% Phosphoric Acid, and 96% Sulfuric Acid.

## 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.

As part of TIGER product information program, each Product Data Sheet is updated periodically. The latest version shall prevail. It is recommended to always check for the latest editions on TIGER's website download area [www.tiger-coatings.com](http://www.tiger-coatings.com) to make sure you have the most current version of this Product Data Sheet. The information on TIGER's Product Data Sheets are subject to change without notification.

This Product Data Sheet supersedes and replaces all previous Product Data Sheet versions and notes to customers published in relation to this product and is only intended to provide a general overview on the product.

Latest versions of Technical Information Sheets and Terms of Delivery and Payment are downloadable from [www.tiger-coatings.com](http://www.tiger-coatings.com) and form an integral part of this Product Data Sheet.

Certified according to  
ISO 9001 | 14001

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