



SERIES 69

A POWDER COATING FOR DECORATIVE AND FUNCTIONAL APPLICATION FOR INTERIOR USE
BASED ON EPOXY

Typical application

- lab equipment
- automotive accessories
- steel pipes
- steel cylinders

Standard Packaging in 20 kg cartons,
2,5 kg minipack

Specific Gravity (ISO 8130-2) 1.3 -1.7 g/cm³
depending on pigmentation

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 6 months from date of
delivery 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

- very good chemical resistance
- very good mechanical properties
- very smooth flow
- good storage stability

Finish | Colors

- smooth flow - glossy surface,
approx. 80-95*
- smooth flow - semi gloss surface,
approx. 55-65*
- smooth flow - matte surface,
approx. 15-25*
- fine texture
- rough texture - glossy surface
- rough texture - matte surface

Available from stock in a limited color
selection. Any other color can be custom
made with a minimum order of 60 kg. Fine
texture and rough texture finishes require a
200 kg minimum order.

* 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)

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 on page one of this Product Data Sheet.

	ALU-MINUM			GALVANIZED STEEL				STEEL		
Degreasing	○	○	○	○	○	○	○	○	○	○
¹⁾ Chromating	○	○	○	○	○	○	○			
²⁾ Anodizing	○	○	○							
²⁾ Chrome free	○	○	○	○	○					
Iron Phosphating								○	○	
Zinc Phosphating				○	○	○	○	○	○	○
Blasting								○	○	○
³⁾ Sweeping				○	○	○	○			
	Ⓡ	Ⓢ	Ⓜ	Ⓡ	Ⓢ	Ⓜ	Ⓢ	Ⓡ	Ⓢ	Ⓢ ⁴⁾

Application Ⓡ interior Ⓜ architectural
 Ⓢ exterior Ⓢ steel

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.

³⁾ only for zinc coated parts > 45 µm

⁴⁾ for a two-coat process / TIGER Shield

Processing

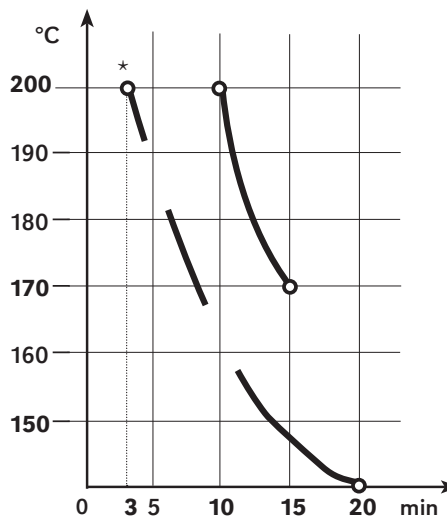
Corona, Tribostatic*

* Suitability of metallic effects for tribo processing must be verified prior to application. Please consult with the relevant Information Sheets, latest edition.

Cure parameters

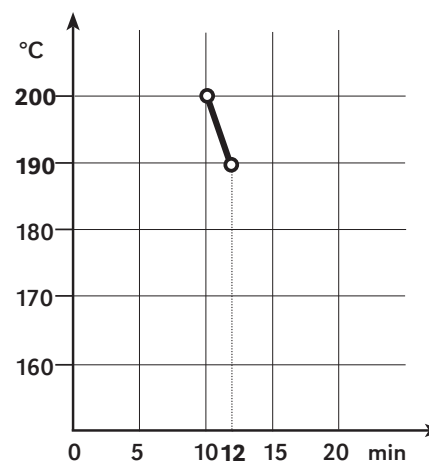
(substrate temperature)

TIGER Drylac® Series 69
smooth flow - glossy |
smooth flow - semi gloss
 * rapid-curing, glossy



substrate temperature versurs curing time

TIGER Drylac® Series 69
smooth matte | semi gloss



substrate temperature versurs curing time



Please note

Please mind the effect and color differences between a lab match versus an actual production.

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 69 smooth glossy	Series 69 smooth matte
film thickness	ISO 2360	60-80 µm	60-80 µm
gloss - 60°	ISO 2813	80-95	15-25
cross cut test 1 mm	ISO 2409	0	0
mandrel bending test	ISO 1519	≥ 5 mm	≤ 10 mm
cupping test	ISO 1520	≥ 7 mm	≥ 2,5 mm
impression hardness	ISO 2815	95-100	90
impact test 20 Inch pound	ASTM D 2794	no appearance of cracks down to the substrate	minor cracks
pencil hardness	ASTM D 3363	2 H	2 H
drill mill test		ok	ok
determination of resistance to humidity 500 h	ISO 6270-1	max. blistering 1 mm	max. blistering 1 mm
salt spray test 500 h	ISO 9227	max. undercutting 1 mm	max. undercutting 1 mm



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