



SERIES 89

LOW CURE POWDER COATING FOR INTERIOR APPLICATION
 BASED ON EPOXY - POLYESTER BLEND

Typical applications

- home appliances
- ceiling paneling
- cladding components
- store fixtures and shelving
- office and school furniture
- radiators
- machinery parts
- metal toys

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

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

Finish | Colors

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

Available from stock in many RAL colors.
Special sanitary colors are available.

Custom colors are available upon inquiry
with a minimum order of 60 kg; fine 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				○	○	○	○			
	●	●	●	●	●	●	●	●	●	●
Application	● interior	● exterior		● architectural			● 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

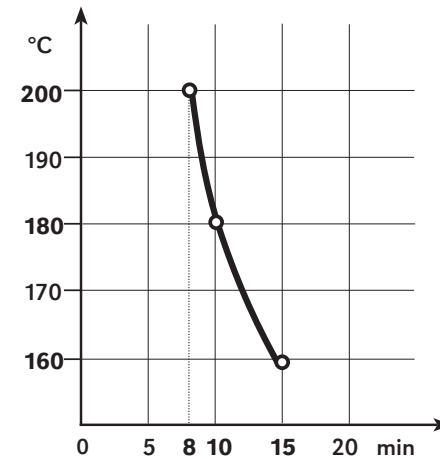
Corona, Tribostatic*

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

Cure parameters

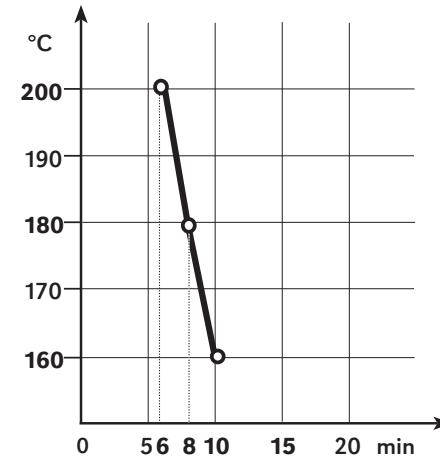
(substrate temperature)

TIGER Drylac® Series 89 smooth flow - glossy smooth flow - semi gloss



Substrate temperature versus curing time

TIGER Drylac® Series 89 fine texture I rough texture glossy



Substrate temperature versus curing time



Please note

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

Guidelines for application for rough texture glossy and fine texture finishes

Rough Texture formulations are very sensitive to contamination at these applicators as these contaminations will always “float” to the top of the textured surface. Clean applications equipment as well as a clean spraying environment is of the essence. The formulations of Fine Texture powder coatings have been modified for tribostatic spraying, however their suitability for the individual equipment has to be established by the coater. The suitability for silk screenings and the adhesives and their adhesion to the coated surface have to be verified prior to application.

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	Serie 89 smooth glossy	Serie 89 smooth semi gloss	Serie 89 rough texture glossy	Serie 89 fine texture
film thickness	ISO 2360	60-80 µm	60-80 µm	90-120 µm	70-90 µm
gloss - 60°	ISO 2813	80-95	55-65	n.a.*	n.a.*
cross cut test 1 mm	ISO 2409	0	0	0	0
impression hardness	ISO 2815	≥ 90	≥ 90	n.a.*	n.a.*
mandrel bending test	ISO 1519	≤ 5 mm	≤ 5 mm	≤ 10 mm	≤ 10 mm
cupping test	ISO 1520	≥ 5 mm	≥ 5 mm	≥ 4 mm	≥ 3 mm
impact test 20 Inch pound	ASTM D 2794	no appearance of cracks down to the substrate	no appearance of cracks down to the substrate	no appearance of cracks down to the substrate	no appearance of cracks down to the substrate
pencil hardness	ASTM D 3363	H	H	n.a.*	n.a.*
drill mill test		ok	ok	ok	ok
determination of resistance to humidity 500 h	ISO 6270-1	max blistering 1 mm	max blistering 1 mm	max blistering 1 mm	max blistering 1 mm
salt spray test 500 h	ISO 9227	max undercutting 1 mm	max undercutting 1 mm	max undercutting 1 mm	max undercutting 1 mm

* not available



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