



SERIES 47 ROUGH TEXTURE, WEATHER RESISTANT

A POWDER COATING FOR EXTERIOR (NON-ARCHITECTURAL) APPLICATION
BASED ON POLYESTER

Typical applications

- sporting goods
- metal construction

Standard Packaging in 20 kg cartons,

Specific Gravity 1,2–1,7 g/cm³
(ISO 8130-2) depending on pigmentation

Theoretical Coverage 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 20 °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

- pronounced texture
- good weather resistance
- good storage stability

Finish | Colors

- textured - glossy surface
- textured - semi gloss surface

RAL 7035 TIGER Drylac® 47/70001

RAL 7032 TIGER Drylac® 47/70002

Any other color can be custom made with a minimum order of 60 kg.



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		
¹⁾ chromating	○	○	○	○	○	○	○			
²⁾ anodizing	○	○	○							
²⁾ chrome free	○	○	○	○	○	○				
iron phosphating								○	○	
zinc phosphating				○	○	○	○	○	○	○
blasting								○	○	○
³⁾ sweeping				○	○	○	○			
	I	A	F	I	A	F	S	I	A	S ⁴⁾

Application **I** interior **A** architectural
 E exterior **S** 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

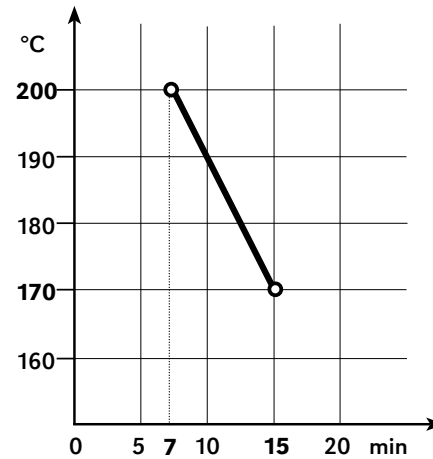
Corona, Tribostatic*

* 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 47 rough texture glossy | semi gloss



substrate temperature versus curing time

Please note

When used for exterior applications, please allow a minimum film thickness of 50 µm for proper coverage in the depressions of the texture.

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

Please note (clear and transparent coatings)

Non-colored coatings, e.g. clear coatings may be prone to stress cracks due to the difference in material tension between the substrate and the powder coating. In order to minimize the risk of stress cracks it is recommended to cure the clear and/or transparent top-coat only at the upper end of the relevant cure window as set forth in this Product Data Sheet.



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 47 Rough Texture
film thickness	ISO 2360	90-120 µm
cross cut test - 1 mm	ISO 2409	0
mandrel bending test	ISO 1519	≥ 10 mm
cupping test	ISO 1520	≥ 3 mm
drill mill test		ok
determination of resistance to humidity - 1000 h	ISO 6270-1	max. blistering ≤ 1 mm
salt spray test - 1000 h	ISO 9227	max. undercutting ≤ 1 mm

Chemical resistance

The chemical resistance of a powder coating depends among other things on its formulation. Chemical resistance requirements therefore must be considered according to processing conditions and final use of the finished product. This is best already established during the product specification process. Agreement between all parties involved must be reached about the chemical resistance test method, which may be performed in accordance with EN ISO 2812-1 "Lacquers and Paint Products. Test Methods for Surface Resistance to Liquids". It is necessary to also have a common understanding of the requirements for such chemical resistance, such as test duration, test method, reactive time and concentration of the test media.



certified according to
EN ISO 9001 / 14001



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This Product Data Sheet substitutes any and all previous Product Data Sheets and notes for customers published on this subject matter and is only intended to give a general product overview. Please request specific information for products outside of our standard product list (latest version).

The Technical Information Sheets and the Terms of Delivery and Payment each in their latest version, available as a download at www.tiger-coatings.com, form an integral part of this Product Data Sheet.

TIGER Coatings GmbH & Co. KG

Negrellistrasse 36

4600 Wels | Austria

T +43 / (0)7242 / 400-0

F +43 / (0)7242 / 650 08

E powdercoatings@tiger-coatings.com

W www.tiger-coatings.com