



## SERIES 59 DORMANT

A TWO-COAT METALLIC POWDER COATING  
BASED ON POLYESTER

### Typical applications

- sporting goods
- parts not permanently exposed to UV light

### Product details

**Standard Packaging** in 20 kg cartons 2.5 kg minipack

**Specific Gravity (ISO 8130-2)** 1.2-1.7 g/cm<sup>3</sup> depending on pigmentation

**Theoretical Coverage** at 60 µm film thickness: 9.8-13.8 m<sup>2</sup>/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

- high transparency effect
- good flow properties

### Finish | Colors

**1. base-coat - dormant:**  
as customer order only

**2. top-coat - transparent:**  
clear, glossy - Series 59, 17, 47  
glitter, glossy - Series 47  
clear, flat matte - Series 16

## 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	○	○	○
<sup>1)</sup> Chromating	○	○	○
<sup>2)</sup> Pre-Anodizing	○	○	○
<sup>2)</sup> Chrome free	○	○	○
Iron Phosphating			○
Zinc Phosphating		○	○
Blasting		○	○
<sup>3)</sup> Sweeping		○	○

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

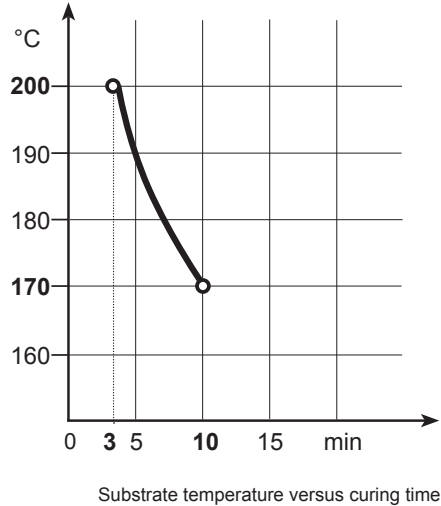
Corona, Tribostatic\*

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

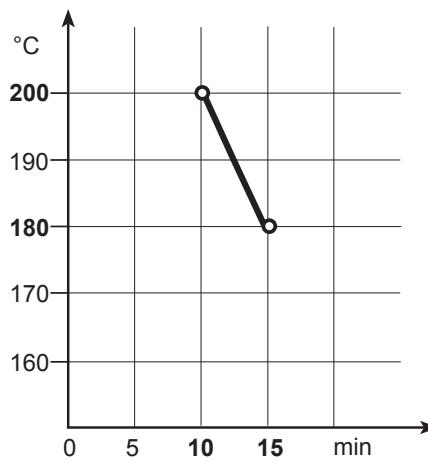
## Cure parameters

(substrate temperature)

## TIGER Drylac® Series 59 Dormant base-coat



## TIGER Drylac® Series 59 transparent top-coat



Substrate temperature versus curing time

Please observe cure parameters closely since mechanical properties will develop before full cross-linking! Since a variation in curing time and curing temperature may result in a color deviation, always apply the same curing agenda to the same color. Furthermore, a consistent film thickness is of importance.

Thanks to their different chemistry do not mix different product lines (Series) with each other. Clean the line thoroughly when changing from one product line or manufacturer to another.



## Please note (clear and transparent coatings)

A change of color should always be preceded by a thorough cleaning of the entire coating line. Additionally, extended oven ventilation is recommended, as otherwise slight discolorations of subsequent coatings may occur.

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.

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 59 Dormant Series 59/47 clear glossy
film thickness	ISO 2360	120-160 µm
cross cut test - 1mm	ISO 2409	0
mortar resistance	ASTM D 3260	ok
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



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EN ISO 9001 / 14001



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