



SERIES 44 MOTIVO

A POWDER COATING SUITED FOR A SUBSEQUENT SUBLIMATION PROCESS FOR INTERIOR AND EXTERIOR APPLICATIONS BASED ON POLYESTER

Typical applications

wood-grain, natural stone and fantasy effects on aluminium and steel substrate

Standard Packing	in 20 kg cartons
Specific Gravity (ISO 8130-2)	1,1–1,3 g/cm ³ depending on pigmentation
Theoretical Coverage	at 60 µm thickness: 12,8–15,1 m ² /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

- easy removability of transfer foils from coated metal
- UV-stability is dependent on the type of foils used
- very smooth flow
- good mechanical properties
- good storage stability

Finish | Colors

smooth flow - glossy surface approx. 80-95*
smooth flow - semi gloss surface approx. 60-75*

Available in white for natural stone effects and in several brown shades for wood-grain effects. Custom colors with a minimum order of 200 kg.

* 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	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
¹⁾ Chromating	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
²⁾ Anodizing	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
²⁾ Chrome free	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Iron Phosphating	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Zinc Phosphating	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Blasting	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
³⁾ Sweeping	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Application	<input checked="" type="checkbox"/> I <input checked="" type="checkbox"/> E	<input checked="" type="checkbox"/> I <input checked="" type="checkbox"/> E <input checked="" type="checkbox"/> S	<input checked="" type="checkbox"/> I <input checked="" type="checkbox"/> E <input checked="" type="checkbox"/> S ⁴⁾

Application **I** interior
 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

Please note

UV-stability is dependent on the type of foils used, thus an architectural application is not permitted.

Processing

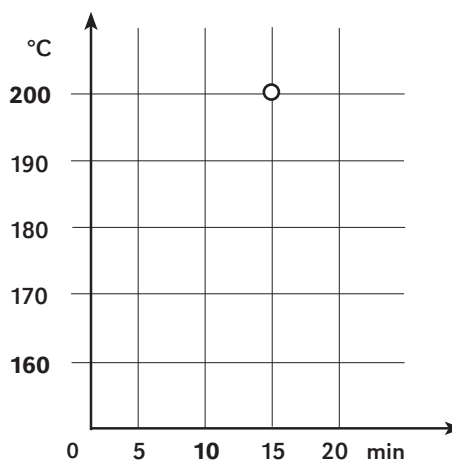
Corona, Tribostatic*

* 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 44 Motivo smooth-glossy | smooth semi-gloss



substrate temperature versus curing time

Attention

Underbaking may impair the removability of the transfer foil from the coated metal.

Guidelines for application

The powder coating is cured by applying the cure parameters as set forth on page 2 and subsequent thermo-printing with an effect producing transfer foil. This process is based upon the principle of sublimation of the dye containing foil into the powder coating at temperatures of 190 to 200 °C. This process requires an individually cycle time adapted to the coating object. In order to achieve consistent and unobjectionable effects the foil must wrap around the metal precisely necessitating special machinery for parts with a more sophisticated configuration (e. g. aluminum extrusion parts). Post-bending may result in mechanical insufficiencies and damages.



Please note

Being the manufacturer of the base-coat powder coating only, TIGER Coatings GmbH & Co. KG has no influence over the visual and qualitative properties of the foil. It therefore can neither warrant the light fastness, weather and chemical resistance of the foil, nor can it be held liable for the mechanical properties (e.g. postbending), the reproducibility of the color and/or effect and the cleanability of the thermo-processed powder-and-foil-system.

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. The test results refer to the base-coat only.

test results	test method	Series 44	
		smooth glossy	smooth semi gloss
film thickness	ISO 2360	60-80 µm	
gloss level - 60°	ISO 2813	60-95	
cross cut test - 1 mm	ISO 2409	0	
mendrel bending test	ISO 1519	≤ 10 mm	
cupping test	ISO 1520	≥ 3 mm	
impression hardness	ISO 2815	> 90	
impact test - 20 inch-pound	ASTM D 2794	minor cracks down to the substrate	
determination of resistance to humidity - 500 h	ISO 6270-1	max. undercutting 1 mm	
salt spray test - 500 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.



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EN ISO 9001 / 14001



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