

## SERIES 16/00108 TRANSPARENT

POWDER COATING BASED ON ACRYLIC RESIN (GMA)

### Typical application

- automotive components
- alu-wheels
- top coat to TIGER's CFC System
- bicycle and sporting industry
- handles
- bathroom equipment
- lamps
- metal furniture

#### Standard

**Packaging** in 18 kg cartons

#### Specific Gravity

(ISO 8130-2)  $1.15 \pm 0.03 \text{ g/cm}^3$

#### Theoretical Coverage

at 60  $\mu\text{m}$  film thickness:  
9.8 - 13.8  $\text{m}^2/\text{kg}$  (please see also Information Sheet no. 1072 - latest edition)

#### Storage Stability

3 months from date of delivery under dry conditions below 20 °C ( $\pm 2^\circ\text{C}$ ), avoid direct and extended heat exposure.

### Features

- very smooth flow
- excellent weather resistance
- highly transparent
- no cracking

### Finish | Colors

- smooth glossy

### 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 typical applications on page one of this Product Data Sheet.

ALU-MINUM	
Degreasing	<input checked="" type="checkbox"/>
<sup>1)</sup> Chromating	<input checked="" type="checkbox"/>
<sup>2)</sup> Anodizing	<input checked="" type="checkbox"/>
<sup>2)</sup> Chromate free	<input checked="" type="checkbox"/>
Iron Phosphating	<input type="checkbox"/>
Zinc Phosphating	<input type="checkbox"/>
Blasting	<input type="checkbox"/>
Sweeping	<input type="checkbox"/>
Application	<input checked="" type="checkbox"/> interior <input checked="" type="checkbox"/> exterior

<sup>1)</sup> acc. to DIN 50939

<sup>2)</sup> 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.

Please be sure to observe the instructions on page 2!



## Processing

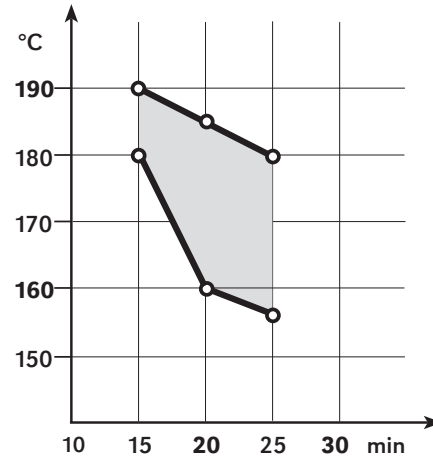
Corona, Tribostatic\*

## Cure parameters

(substrate temperature)

Please observe cure parameters closely since mechanical properties will develop before full cross-linking! Metal temperatures shall not exceed 190° C. Please verify the suitability of direct gas-fired and IR oven equipment under actual production conditions for the intended application.

## TIGER Drylac® Series 16/00108 smooth glossy



Substrate temperature versus curing time

## PLEASE BE SURE TO OBSERVE THE FOLLOWING INSTRUCTIONS:

### General instructions

TIGER Drylac® GMA acrylic resin based powder coatings have extremely high weather resistance combined with excellent flow and lasting lustre.

### Handling

**The product has high contamination potential (risk of surface defects). For this reason, it must be handled and stored separately, and applied in a separate paintshop from any conventional coatings!**

TIGER Drylac® acrylate powder coatings should be processed at a temperature of 20°C (± 2°C) and relative humidity of 40-60%. If processing is carried out at higher temperatures than this, there is a risk of agglomerations and of powder sintering in the delivery hoses, nozzles and injectors. The product's suitability for direct gas-fired ovens must be verified separately.

**When the product is applied as a top coat, sufficient inter-coat adhesion must be ensured!**

### Storage and transport

Store at a temperature of 20°C (± 2°C). At this temperature, the product has a storage life of 3 months. If this storage period is exceeded, the product's workability must be verified on a case-by-case basis. Always use separate pallets and containers for in-factory transport of this product!



## 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 16 smooth glossy
film thickness	ISO 2360	60-80 µm
gloss - 60°	ISO 2813	> 100
cross cut test 1 mm	ISO 2409	o.k.
impression hardness	ISO 2815	87
mandrel bending test	ISO 1519	3 mm
cupping test	ISO 1520	> 5
impact test 20 inch/pound	ASTM D 2794	cracks
mortar resistance	ASTM D 3260	o.k.
drill mill test		o.k.
Kesternich-test 30 cycles	ISO 3231	o.k.
determination of resistance to humidity 1000 h	ISO 6270-1	o.k.
salt spray test NSS 1000 h	ISO 9227	o.k.



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As a part of our product information program each of our Product Data Sheets are periodically updated, so that the latest version shall prevail. Therefore, please visit the download area of [www.tiger-coatings.com](http://www.tiger-coatings.com) to make sure you have the most current version of this Product Data Sheet. The information in our Product Data Sheets is subject to change without notification.

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EN ISO 9001 / 14001



## 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](mailto:powdercoatings@tiger-coatings.com)

W [www.tiger-coatings.com](http://www.tiger-coatings.com)