

SERIES 09

A POWDER COATING FOR INTERIOR APPLICATION
BASED ON AN EPOXY-POLYESTER BLEND - STANDARD LINE OF PRODUCTS

Typical applications

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

Product details

Standard Packaging	in 20 kg cartons, 2.5 kg minipack
Specific Gravity (ISO 8130-2)	1.2-1.7 g/cm ³ depending on pigmentation
Theoretical Coverage	at 60 µm film thickness: 9.8-13.8 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

- very good mechanical properties
- good flow properties
- good storage stability

Finish I Colors

- smooth flow - glossy surface, approx. 80-95*
- smooth flow - matte surface, approx. 15-30*
- rough texture - matte surface
- hammertone
- antique (for e-static application only)
- metallic - recycling consistent (for e-static application only)
- silver and gold metallic - recycling consistent (for e-static application only)

Available from stock in all RAL colors in a smooth glossy surface. Any other color can be custom made with a minimum order of 60 kg; textured and matte 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	● architectural
	● exterior	● 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

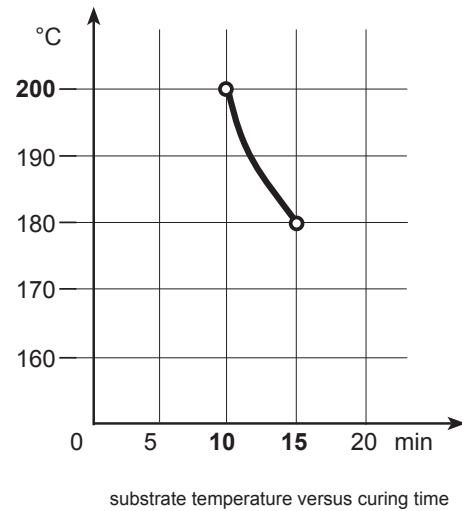
Corona, Tribostatic*

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

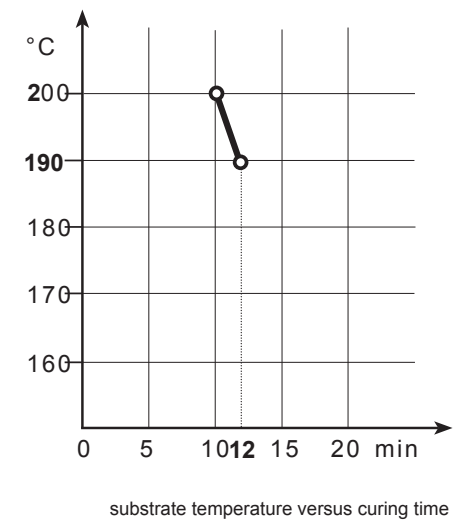
Cure parameters

(substrate temperature)

TIGER Drylac® Series 09 smooth flow - glossy surface



TIGER Drylac® Series 09 rough texture - matte surface I smooth flow - matte surface



Rough Texture Matte finish and Hammertones

Any deviation from and modification of the recommended application parameters (e. g. film thickness, cure conditions, different application equipment) may lead to variations in the texture. Rough Texture formulations are very sensitive to contamination at the applicator as these contaminations will always "float" to the top of the textured surface. Clean application equipment as well as a clean spraying environment is of the essence.

It is recommended to apply Hammertone effects at an increased film thickness of 100-120 µm. A variation in the cure parameters as well as heavy mass parts may result in different effects. As the effect producing agents in powder coatings float differently from those in wet paint, the effects are reproducible only to a limited extent. For an optimum coating and effect result it is recommended to consistently add virgin powder.

Please note

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

Two-coat systems: first coat: apply only half of the curing time acc. to the corresponding Product Data Sheet (provided that no other information is given therein). Second coat: requires then full cure acc. to the relevant Product Data Sheet. Please note, the exact cure conditions (curing time and cure temperature) need to be established individually based on the application and the coating line. Check continuously for intercoat-adhesion!

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 09 glossy surface	Series 09 matte surface	Series 09 rough texture matte surface
film thickness	ISO 2360	60-80 µm	60-80 µm	90-120 µm
gloss - 60°	ISO 2813	80-95	15-30	n.a.*
cross cut test 1 mm	ISO 2409	0	0	0
mandrel bending test	ISO 1519	< 5 mm	< 10 mm	< 30 mm
cupping test	ISO 1520	> 5 mm	> 3 mm	> 2 mm
impression hardness	ISO 2815	> 90	> 90	n.a.*
impact test 20 Inch-pound	ASTM D 2794	no appearance of crack down to the substrate	minor cracks	appearance of cracks down to the substrate
pencil hardness	ASTM D 3260	H	H	n.a.*
drill mill test		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
salt spray test 500 h	ISO 9227	max. undercutting 1 mm	max. undercutting 1 mm	max. undercutting 1 mm

*not available

certified according to
EN ISO 9001 / 14001



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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.

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