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SERIES 75

UNIQUE POWDER COATING OFFERING SUPERIOR
WEATHERABILITY FOR ARCHITECTURAL APPLICATIONS
DESIGNED TO MEET THE PERFORMANCE LEVELS DESCRIBED IN AAMA 2605-11

Typical applications

- highest performance architectural coatings
- metal facades
- curtain walls
- window frames
- railings
- light poles

Application by Certified Applicators only

Product details

Standard Packaging	20 kg boxes | 44 lb boxes
Specific Gravity (ISO 8130-2)	approx. 1.4 - 1.8 g/cm^3 depending on pigmentation
Theoretical Coverage	at 60 µm film thickness: 9,8 –12,8 m^2/kg on specific gravity (please see also Information Sheet no.1072 - latest editon)
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

- outstanding resistance to fading
- outstanding resistance to chalking
- good chemical resistance
- good storage stability
- batch consistency of RAL colors acc. to VdL guidance no. 10

Finish | Colors

- smooth flow - matte surface approx. 30 - 50*
- solid colors and special effects

Custom colors are available upon request (minimum order quantity applies)

* 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)

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Pretreatment (on aluminum)

- Yellow chromating acc. to DIN 50939
- Green chromating, pre-anodization and chrome free pre-treatment must not be used.

Please verify the suitability of the pre-treatment acc. to the test specification of AAMA 2605-11 point 8.8.1. and 8.8.2.

Health and Safety Environment

For HSE relevant information please consult Material Safety Datasheet. Work place regulations are the responsibility of the applicator.

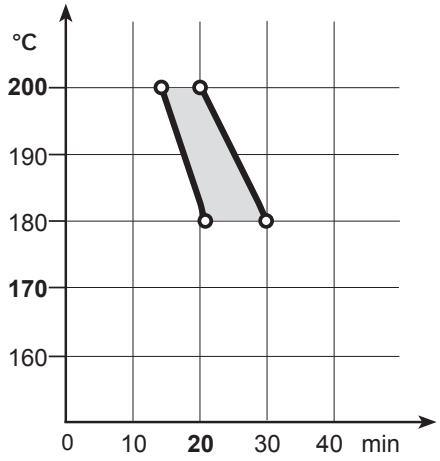
Processing

Corona

Cure parameters

(substrate temperature)

TIGER Drylac® Series 75 Cure Parameters - smooth matte



Substrate temperature versus curing time

Observe cure parameters closely since mechanical properties and weatherability will develop before full cross-linking.

Please Note

A top-coat with a clear Series 75 powder coating over an interior grade powder coating does not produce a weather resistant coating.
In case a two coat system consisting of an epoxy primer for corrosion protection and a Series 75 top-coat is applied, UV transmission of the top-coat has to be controlled by pigmentation and film thickness. TIGER Drylac® Series 75 is slightly incompatible with other powder coatings. It is therefore highly recommended to thoroughly clean the entire coating line prior to and after the powder application.
The curing of TIGER Drylac® Series 75 will result in the emission of small doses of ε-caprolactam, which may cause minor smoke and odor. Provide sufficient ventilation and observe maximum allowable concentration guidelines.

The adhesion of sealants to the powder coated surface may be limited. Therefore their suitability needs to be verified and established separately through testing.

Please mind the effect and color differences between a lab match versus an actual production.
Please consult with the relevant Information Sheets, latest edition.
Fine Texture Effects: Top and re-coating (with the same fine texture effect or otherwise) may change the finish.
Metallic-effect powder coatings: to help users exploit the benefits of the new generation of metallics to the full, we have divided our metallic effect powder coatings into the application categories A, B, C and D. For more detailed information on this subject, please refer to the Application Guidelines for Powder Coatings with Metallic Effects, ofi data sheet no. 44.

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Performance data on Aluminum

Checked under laboratory conditions on a yellow 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 result	test method	TIGER Drylac® Series 75 smooth matte
film thickness (**1**-coat system)	ISO 2360	50-65 µm
gloss - 60°	AAMA 2605-11 / section 8.2	40+10
dry adhesion	AAMA 2605-11 / section 8.4.1.1	no removal
impact resistance	AAMA 2605-11 / section 8.5	cracking, but no lift off
determination of resistance to humidity 4000 h	AAMA 2605-11 / section 8.8.1	no more than a few blisters size no. 8
salt spray test 4000 h	AAMA 2605-11 / section 8.8.2	< 2mm creepage, minimum blister rating no. 8

Please Note

Experience has shown that degradation similar to 10 years Florida exposure can be expected with 11,000 hours of accelerated weathering with UV-A lamps or 3,000 hours of UV-B lamps.

At this point we cannot claim full AAMA compliance, since some of the tests required - most notably Florida exposure - have an extended duration. Performance can be reasonably anticipated based on accelerated weathering data with QUV-A and B tests, as well as references with related coating technologies using comparable polymer systems. It is well known that Fluoropolymers are offering superior performance, and all the coating systems that are available for compliance with AAMA 2605-11 are based on these materials.

Please note that due to the extreme durability requirements there are limitations regarding the colors that can be achieved. Bright colors are difficult or impossible to formulate with appropriate durability. This applies to the majority of the color spectrum.

Due to the chemical make up of the coating, flexibility is decreased when compared to polyester based products. Post-forming operations need to be verified beforehand for feasibility. Cracks in the coating can lead to corrosion.

Joint sealants and any other auxiliary products, such as glazing aids, gliding waxes, drilling and cutting lubricants, which come in contact with the coated surface, must be pH-neutral and free of substances which may damage the finish. Prior to coating a suitability test at the applicator is therefore highly recommended.

Chemical resistance

The required 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 requirements for such chemical resistance, as well as the test methods, which may be performed. Furthermore, the test duration, reactive time and concentration of the test
media need to be agreed upon.

Cleaning recommendations

Please see our Information Sheet latest edition.

Our verbal and written recommendations for the use of our products are based upon experience and in accordance with present technological standards. These are given in order to support the buyer or user. They are non-committal and do not create any additional commitments to the purchase agreement. They do not release the buyer from verifying the suitability of our products for the intended application. We warrant that our products are free of flaws and defects to the extent as stipulated in our Terms of Delivery and Payment.
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 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.

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.

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zertifiziert nach
EN ISO 9001 / 14001

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