

HAMMERTONE POWDER COATINGS

PROCESSING GUIDELINES

This data sheet is intended to provide assistance with the coating process and to provide the user with information on processing parameters which have a significant impact on the ultimate coating result. The color shade and gloss finish results which can be achieved with TIGER Drylac® Hammertone Powder Coatings cannot be measured using instruments.

Film thickness

In order to achieve an optimum effect and to prevent penetration to the base metal, we recommend a coating thickness of no less than 80 to 100 µm.

Curing parameters

The curing parameters are described in the product data sheets of the different series. The cure curve affects the appearance of the powder coating. By the way of illustration, with a flat curing curve, i.e. with thick-walled objects, the hammertone effect is not as marked. With a steep curing curve, as in the case of thin-walled objects, the hammertone effect is more marked.

Color shade

TIGER Drylac® Hammertone Powder Coatings are duller, darker and behave quite differently in light to liquid hammertone paints. This is due to the different way in which the metallic particles float to the surface. Note that RAL color shades cannot be custom made.

Processing

TIGER Drylac® Hammertone Powder Coatings can be used in powder recovery systems without major problems. To achieve a consistent color/effect it is important for the coater to establish a ratio of virgin and reclaim powder and adhere to this ratio during the entire coating process. The ratio of virgin powder should not fall short of 70%. Repeated or exclusive use of reclaimed powder is not advisable.

- keine kratzenden, abrasiven Mittel verwenden
- keine stark sauren oder alkalischen Reinigungs- und Netzmittel verwenden
- keine Reinigungsmittel unbekannter Zusammensetzung benutzen
- Die Reinigungsmittel dürfen maximal 25 °C aufweisen. Keine Dampfstrahlgeräte verwenden.
- Die Oberflächentemperatur der Fassadenelemente darf während der Reinigung ebenfalls 25 °C nicht übersteigen.
- Die maximale Einwirkzeit dieser Reinigungsmittel darf eine Stunde nicht überschreiten; nach wenigstens 24 Stunden kann - wenn nötig - der gesamte Reinigungsvorgang wiederholt werden.
- Unmittelbar nach jedem Reinigungsvorgang ist mit reinem, kaltem Wasser nachzuspülen.

Weitere Hinweise zur Wartung und Reinigung erhalten Sie unter anderem von:

- Aluminium-Zentrale Beratungs- und Informationsdienst in D-40003 Düsseldorf
- Gütegemeinschaft für die Reinigung von Metallfassaden e.V. (GRM) in D-90402 Nürnberg
- American Architectural Manufacturer's Association (AAMA) U.S.A., (AAMA 610-1979 Cleaning Procedures)

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. 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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Hammertone