SERIES 61 - flat matte anodized effects

POLYESTER TGIC-FREE SUPER DURABLE WEATHER RESISTANT POWDER COATING COMPLIANT TO AAMA 2604

Typical applications

- architectural applications
- curtain walls
- store fronts
- railings
- windows and doors
- architectural lighting
- outdoor and indoor light fixtures
- sporting goods
- metal construction
- automotive accessories
- patio furniture and garden equipment

Product details

Standard packaging in original 44 lb (20 kg) box and 5 lb (2.5 kg) minipack

Specific gravity (ASTM D792) approximately 1.2 g/cm^3 depending on pigmentation

Theoretical coverage at 2.5 mils (60 µm) film thickness: **67.1 ft²/lb (13.9 m²/kg)**. Refer also to the latest edition of "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric)

Storage stability 3 months at no more than 77 °F (25 °C) avoid direct and extended exposure to heat

Finish

finish	gloss
smooth *flat matte*	0-15*

* *Gloss level according to ASTM 523 at 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 Data Sheet. The creation of tolerance samples is recommended*

Available as stock-product in a selection of colors and finishes (see following table and color charts)

product description	product ID
Clear	61/00015
Champagne	61/78003
Light Bronze	61/78002
Medium Bronze	61/68002
Dark Bronze	61/68001
Black	61/80079

Features

- excellent weather resistance
- excellent UV-light resistance
- AAMA 2604 compliant
- very smooth flow
- good storage stability

Pretreatment

The following table reflects the common methods of pre-treatment with regards to various substrates and applications. In selecting the proper type of pretreatment, the suitability of the type of powder coating for a desired application according to the guidelines on this page should be observed.

	Aluminum			Galvanized Steel				Steel		
Degreasing	○			○				○		
[1] Chromating	○	○	○	○	○	○	○			
[2] Pre-Anodizing	○	○	○							
[2] Chrome free	○	○	○	○	○					
Iron Phosphating								○		
Zinc Phosphating				○	○	○	○	○	○	○
Blasting								○	○	○
[3] Sweeping				○	○	○	○			
	I	E	A	I	E	A	S	I	E	S[4]

Application: I = interior; E = exterior; A = architectural; S = steel

1) according to ASTM B 449
2) according 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 >1.8 mils (>45 µm)
4) for a two-coat process/TIGER Shield

Processing

Corona and Tribostatic*

** For Tribostatic powder coatings, confirm before ordering. Suitability of metallic effects for Tribostatic processing must be verified prior to actual application. Please refer to the latest edition of the relevant application guidelines for metallic effect powder coatings*

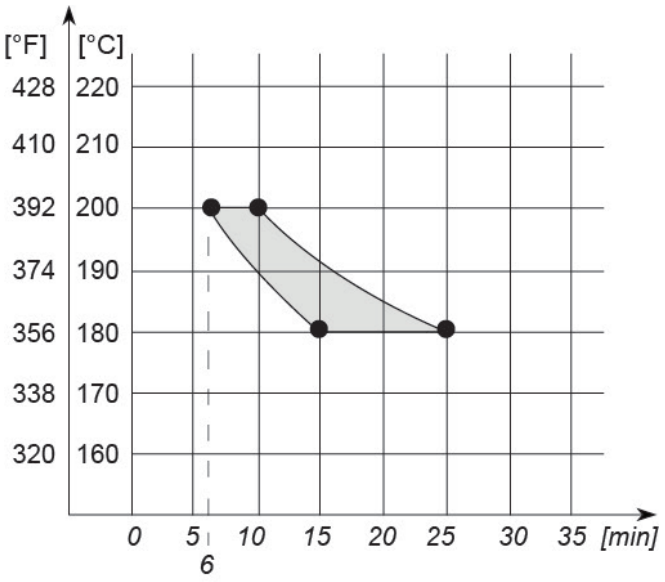
Since not all powder coatings are suitable for recycling/reclaim, please verify before ordering

Product data sheet

Cure parameters

(substrate temperature versus curing time)

smooth *flat matte*



substrate temp.	min. curing time	max. curing time
356 °F (180 °C)	15 minutes	25 minutes
392 °F (200 °C)	6 minutes	10 minutes

Application parameters for Clear Anodized Effect, TIGER Drylac® 61/00015, Champagne Anodized Effect, TIGER Drylac® 61/78003 and Dark Bronze Anodized Effect, TIGER Drylac® 61/68001 can vary depending upon the application equipment used and the gun settings. It is recommended to run tests and identify the specific gun adjustments prior to coating on the line.

Cure parameters must be closely observed since mechanical properties will develop before full cross-linking

Test results

Results are checked on 1/64 inch (0.7 mm) thick yellow chromated aluminum test panel. Cure conditions are according to the cure curves. When used as a two-coat system, the increase in film thickness will result in a decrease of mechanical properties.

test method	test	Series 61 smooth *flat matte*
ISO 2360	**recommended film thickness**	2.5-3.5 mils (60-80 µm)
ASTM D3359 method B	**cross cut tape test** 1mm cutting distance	5B
ASTM D522	**mandrel bending test** cracking of coating	≤1/2 inch (≤12.7 mm)
ASTM D3363	**pencil hardness**	H minimum
ASTM D2247	**determination of resistance to humidity** 3,000 hours	maximum undercutting 1/32 inch (1 mm)
ASTM B117	**salt spray resistance** 3,000 hours	maximum undercutting 1/32 inch (1 mm)
ASTM D2244	**natural weathering** in Florida 5 years	color change ≤Δε 5.0 (Hunter)
ASTM D523	**natural weathering** in Florida 5 years	gloss retention >30%

Cleaning recommendations: refer to the latest edition of TIGER “Cleaning Recommendations” information sheet, Version 00-1005

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Please note

Post-bending properties of any part must be verified prior to application. Minor cracks in the coated surface may 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 that may damage the finish. Therefore, a suitability test at the applicator's end, prior to coating, is highly recommended.

In general, colors in the red, orange and yellow range may require an increased film thickness to achieve full hiding.

Please read and understand the Safety Data Sheet (SDS) before use.

Chemical resistance

The required chemical resistance of a powder coating depends, among other things, on its formulation. Chemical resistance requirements must be considered according to processing conditions and final use of the finished product. This is best 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 method, which may be performed in accordance with PCI test method #8 "Solvent Cure Test". Furthermore, the test duration and concentration of the test media need to be agreed upon.

Disclaimer

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