

# SERIES 49 - dormant transparent effect

POLYESTER TGIC POWDER COATING WITH EXCLUSIVE BRILLIANT DEEP METALLIC EFFECT

## Typical applications

- sporting goods
- bicycle equipment
- snowmobiles
- surfaces not exposed permanently to UV-light

## Product details

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

**Specific gravity (ASTM D792)** approximately 1.2-1.8 g/cm<sup>3</sup> depending on pigmentation

**Theoretical coverage** at 2.5 mils (60 µm) film thickness: **51.5 ft<sup>2</sup>/lb (11.1 m<sup>2</sup>/kg)**. Refer also to "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric)

**Storage stability** 12 months at no more than 77 °F (25 °C)  
Avoid direct and extended exposure to heat

## Features

- good mechanical properties
- very smooth flow
- high transparency effect
- no special metal preparation required to achieve transparency
- Underwriter Laboratories recognized component (UL approved)



Underwriters Laboratories Inc., (UL) Recognition.

## Finish

Two-coat system achieved by using a TIGER Drylac® Dormant Transparent base coat and a TIGER Drylac® Clear top coat (refer also to the color chart). Durability and chemical resistance can only be obtained by using the complete two-coat system.

finish	gloss
smooth glossy	80-90+*

\* 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).

base coat product description	product ID
Blue	49/40940
Sparkle Sky Blue	49/40074
Sparkle Electric Blue	49/40233
Violet	49/41100
Sparkle New Red	49/30028
Sparkle Burgundy	49/30193
Sparkle Copper	49/25002
Sparkle Bomber Orange	49/23531
Sparkle Light Orange	49/25006
Sparkle Granny Smith	49/50032
Sparkle Green	49/50024

**Clear top coat** - TIGER Drylac® Series 49, Series 49 Glitters, Series 39, Series 16, Series 69 or Series 89 in glossy, semi-gloss, matte, flat matte or rough texture glossy are suitable as top coat.

For further information on this product, refer to TIGER Drylac® Series 49 Product Data Sheet for interior and exterior applications.

## 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	○		○				○	
<sup>1</sup> Chromating	○	○	○	○	○	○		
<sup>2</sup> Pre-Anodizing	○	○	○					
<sup>2</sup> Chrome free	○	○	○	○				
Iron Phosphating							○	
Zinc Phosphating			○	○	○	○	○	○
Blasting							○	○
<sup>3</sup> Sweeping			○	○	○	○		
	I	E	A	I	E	A	S	I
								S <sup>4</sup>

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

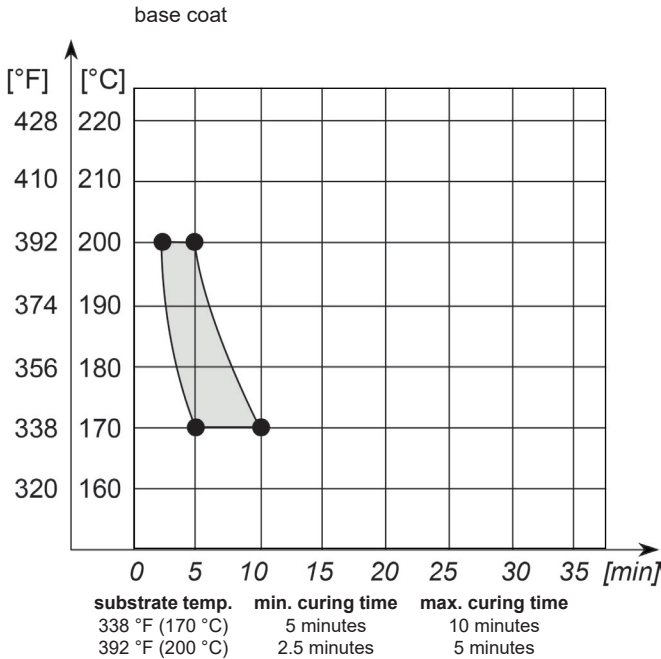
## Processing

### Corona

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

## Cure parameters

(substrate temperature versus curing time)



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

## Two-coat application

For best results, it is recommended to substantially cure the base coat and then apply the required clear top coat. An insufficient cure of the Dormant Transparent base coat can result in a 'crackled' appearance of the metallic effect. Excessive curing of the base coat can cause intercoat adhesion problems. For a proper spraying of the clear top coat, it is necessary to ensure good ground of the coated substrate.

## Test results

Checked under laboratory conditions on iron phosphated steel test panels Bonderite B-1000 or equivalent. Cure conditions are according to the cure curves. 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. When used as a two-coat system, the increase in film thickness will result in a decrease of mechanical properties.

test method	test	Series 49 dormant transparent
ISO 2360	<b>recommended film thickness</b>	3.5-4.5 mils (75-100 µm)
ASTM D523	<b>gloss - 60°</b>	80-90
ASTM D3359 method B	<b>cross cut tape test</b> 1mm cutting distance	5B
ASTM D2794	<b>ball impact test</b> cracking of coating	80 in/lb no appearance of cracks down to the substrate
ASTM D3363	<b>pencil hardness</b>	2H minimum
ASTM D2247	<b>determination of resistance to humidity</b> 500 hours	maximum undercutting 1/32 inch (1 mm), no blistering
ASTM B117	<b>salt spray resistance</b> 500 hours	maximum undercutting 1/32 inch (1 mm), no blistering

**Cleaning recommendations:** refer to the latest edition of TIGER "Cleaning Recommendations" information sheet, Version 00-1005.

## Please note

It is the responsibility of the buyer/applicator to determine whether the UV stability of the TIGER Drylac® Series 49 Dormant Transparent powder coating is appropriate for the intended end use. Due to the inherent limitations of pigments used to generate the Dormant Transparent effect, the UV stability is reduced in comparison to standard opaque colors, such as the RAL range. This reduction can vary from color to color.

For metallic finishes, it is recommended to observe the guidelines published in the latest edition of TIGER Drylac® "Application guidelines for metallic effect powder coatings".

Please consult the manufacturer before applying any 2-coat systems that feature (i) a primer or e-coat as base coat and (ii) a metallic effect powder coating as a top coat.

Top coating with a clear exterior grade powder coating over an interior grade powder coating does not result into a weather resistant coating system.

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

TIGER's verbal and written recommendations for the use of its products are based upon experience and in accordance with current technological standards. These are provided 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 TIGER products for the intended application. TIGER warrants that its products are free of flaws and defects to the extent stipulated in the Terms of Delivery and Payment.

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