

# SERIES 16 - flat matte

## POLYESTER TGIC-FREE WEATHER RESISTANT POWDER COATING

### Typical applications

- topcoat for metallic effects
- sporting goods
- metal construction
- automotive accessories
- patio furniture
- light fixtures

### Product details

<b>Standard packaging</b>	in original 44 & 55 lb (20 & 25 kg) box and 5 lb (2.5 kg) minipack
<b>Specific gravity (ASTM D792)</b>	approximately 1.2 g/cm <sup>3</sup> depending on pigmentation
<b>Theoretical coverage</b>	at 2.5 mils (60 µm) film thickness: <b>67.1 ft<sup>2</sup>/lb (13.9 m<sup>2</sup>/kg)</b> . Refer also to the latest edition of "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric)
<b>Storage stability</b>	3 months at no more than 77 °F (25 °C) avoid direct and extended exposure to heat

### Finish

finish	gloss
smooth <i>flat matte</i>	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 colours and finishes (see following table and colour charts)

product description	product ID
Clear Flat Matte	16/00030
Olive Drab	16/50012
Desert Tan	16/15013

### Features

- good weather resistance
- 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 <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

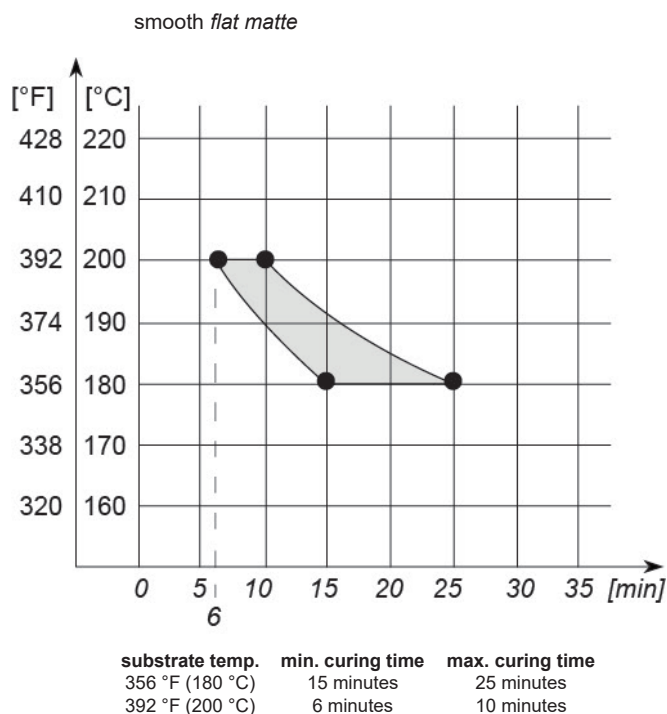
#### Corona and Tribostatic\*

\* 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

## Cure parameters

(substrate temperature versus curing time)



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

## 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, colour, 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 16 smooth flat matte
ISO 2360	<b>recommended film thickness</b>	2.5-3.5 mils (60-80 µm)
ASTM D3359 method B	<b>cross cut tape test</b> 1mm cutting distance	5B
ASTM D522	<b>mandrel bending test</b> cracking of coating	≤1/2 inch (≤12.7 mm)
ASTM D3363	<b>pencil hardness</b>	H 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

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, colours 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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