

SERIES 69 - clear - BHMA

EPOXY POWDER COATING FOR INTERIOR APPLICATIONS THAT REQUIRE COMPLIANCE TO THE BUILDERS HARDWARE MANUFACTURERS ASSOCIATIONS SPECIFICATIONS

Typical applications

- hardware
- faucets
- surfaces where increased chemical resistance or surface hardness is required

Product details

Standard packaging	in original 55 lb (25 kg) box and 5 lb (2.5 kg) minipack
Specific gravity (ASTM D792)	approximately 1.35 g/cm ³ depending on pigmentation
Theoretical coverage	at 2.0 mils (50 µm) film thickness: 72 ft²/lb (14.5 m²/kg) . Refer also to the latest edition of "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric)
Storage stability	6 months at no more than 77 °F (25 °C) avoid direct and extended exposure to heat

Finish

finish	gloss
clear smooth <i>glossy</i>	80-95+*
clear smooth <i>semi-gloss</i>	50-60*

* 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 only as custom product. It can be made to order in an opaque version in all industry colours when tinted.

Features

- very good mechanical properties
- excellent chemical resistance
- good resistance to corrosion
- good flow properties
- excellent coverage
- 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	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

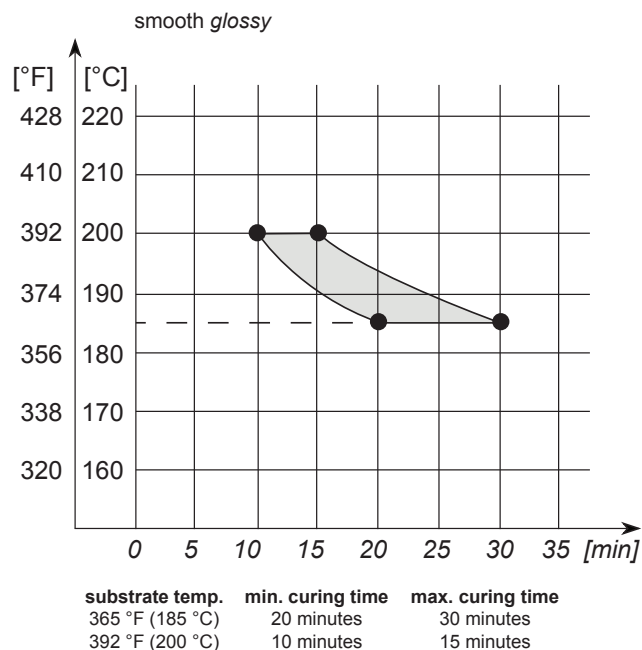
Corona and Tribostatic*

* 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

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 69 smooth glossy	Series 69 smooth semi-gloss
ISO 2360	recommended film thickness	2.5-3.5 mils (60-80 µm)	2.5-3.5 mils (60-80 µm)
ASTM D523	gloss - 60°	80-95+	50-60
ASTM D3359 method B	cross cut tape test 1mm cutting distance	5B	5B
ANSI/BHMA A156.18-2012	perspiration test	4 cycles, pass	4 cycles, pass
ANSI/BHMA A156.18-2012 ASTM G-53	QUV/Condensation 144 hours	no visual change	no visual change
ANSI/BHMA A156.18-2012	pencil hardness	4H	4H
ANSI/BHMA A156.18-2012 ASTM D1735	determination of resistance to humidity 240 hours	pass	pass
ANSI/BHMA A156.18-2012	salt spray resistance 96 hours	pass	pass

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.

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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