

TEXTURED FINISHES | FINE, ROUGH, ANTIQUE & HAMMERTONE

Film thickness

To achieve an optimum effect and to reduce the chance of voids exposing the bare metal, it is recommended that textured powder coating be applied at a minimum film thickness of 80-100 µm (3.0-4.0 mils).

Cure cycle

Variations in the cure cycle will have a direct impact on the effect achieved (large, small 'fish eyes'). A slow heat-up cycle; especially on heavy mass parts, will result in a smaller pattern (smaller 'fish eyes'). A larger pattern (larger 'fish eyes') will result from a quick heat-up cycle especially with a thin wall application. Reaching the required substrate temperature quickly results in an optimum pronounced texture effect. Parts made of a combination of heavy and light materials require special attention, as this combination may cause variations in the required texture effect.

Application

The textured appearance may be influenced by spraying equipment from various manufacturers as well as by the difference in charging between electrostatic and Tribostatic application equipment.

Exterior applications

When using TIGER Drylac® textured finishes for exterior applications, it is required to use a minimum film thickness of 3.0 mils (80 µm) and the optimum film thickness is 3.0-4.0 mils (80-100 µm). Applying above 4.0 mils (100 µm) may affect the texture of the finished product.

Recoating

Recoating a textured powder coating system with the same finish will result in a different textured effect. Check for intercoat adhesion.

Reclaim

Feed reclaim and virgin powder coatings consistently into the system. When textured effect powder coating pass through cyclones; especially larger diameter cyclones, the powder coating particles are broken up, this will result in a different effect. Changes in the effect due to reclaim can be overcome by adding additional virgin powder coating.

Hammertone

The hammertone effect in powder coating has a tendency to be duller and darker when compared to hammertone effects commonly achieved in liquid coating. An essential difference can be found in the reflective light due to the different floating activities of the silver flakes contained in powder versus liquid coatings.

Rough textured

Rough textured formulations are very sensitive to contamination at the applicator's site as well as during the manufacturing process. Contamination will always 'float' on the top of the textured surface. Clean application equipment and clean spraying environment are essential.

Vein|Antique

It is not possible to reclaim vein|antique effect powder coatings. The powder coating particles will be separated from the metallic