



Drylac®

**Dormant Transparent
Series 49**

A brilliant deep metallic looking powder coating in a exclusive finish

Based on Polyester TGIC

TIGER Drylac® U.S.A., Inc.

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Typical applications

Sporting goods

Bicycle equipment

Snowmobiles

Commodities not permanently
exposed to UV-light



Underwriters Laboratories Inc.
(UL) Recognition

Standard Packaging

44 [lb] boxes
and 5.0 [lb] Minipack

20 [kg] cartons
and 2.5 [kg] Minipack

Specific Gravity (ASTM D792)

approx. 1.2 – 1.8
depending on pigmentation

Theoretical Coverage

at specific gravity 1.5 and film thickness
of 2.5 [mils] / 60 [µm]:

51.5 [sq ft/lb] / 11.1 [m²/kg]

*(also please refer to data sheets
4001 & 4002 in the latest edition)*

Storage Stability

6 months
at no more than 77 °[F] / 25 °[C]

Features

- Good mechanical properties
- Very smooth flow
- High transparency effect
- No special metal preparation required to achieve transparency

Finish | Colors

- Smooth flow-glossy 80 - 90+

Basecoat-Dormant Transparent

- Blue 49/40490
- Violet 49/41100
- Sparkle New Red 49/30028
- Sparkle Granny Smith 49/50032
- Sparkle Green 49/50024
- Sparkle Sky Blue 49/40074
- Sparkle Copper 49/25002
- Sparkle Light Orange 49/25006

Topcoat-Clear

TIGER Drylac® Series 49, 39,16, 69 or 89 glossy, semi gloss, matte, flat matte or rough texture glossy

TIGER Drylac® Series 49 Glitters

For general information please refer to product data sheet for TIGER Drylac® Series 49 exterior & interior applications.



Pretreatment (alternatives)

The following table reflects the common methods of pretreatment with regards to various substrates and applications. In selecting the proper type of pretreatment please observe the suitability of the type of powder coating for a desired application according to the guidelines on page one of this Product Data Sheet.

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

- I** interior
- E** exterior
- A** architectural
- S** steel construction

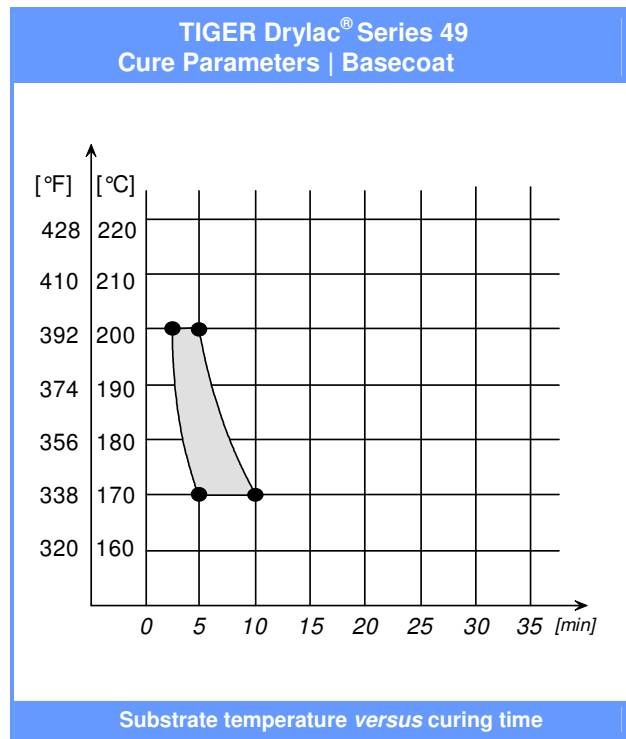
- ¹⁾ acc. to ASTM B 449
- ²⁾ acc. AAMA 2603-02 quality and test regulations
- ³⁾ only for zinc coated parts >45 [µm] / >1.8 [mils]
- ⁴⁾ for a two-coat process / TIGER Shield

Processing

Corona

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

Cure parameters (substrate temperature)



Please observe cure parameters closely since mechanical properties will develop before full cross-linking.

Two coat application

For best results we recommend to substantially cure the base coat and then apply the required clear topcoat. An insufficient cure of the Dormant basecoat can result in a 'crackled' appearance of the metallic effect. Excessive curing of the base coat can cause inter coat adhesion problems.

It is necessary to assure good ground of the coated substrates to allow proper spraying of the clear topcoat.



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 which may damage the finish. Prior to coating, a suitability test at the applicator is therefore highly recommended.

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

Read and understand the Material Safety Datasheet (MSDS) before using.

Test results

Checked on iron phosphated steel test panel Bonderite B-1000 or equivalent. Cure conditions 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 result	Test method	Series 49 Dormant Transparent
Film thickness		3.5 - 4.5 [mils] 75 - 100 [µm]
Cross cut tape test	<i>ASTM D3359 Method B</i>	5B
Impact test 80 [in/lb]	<i>ASTM D2794</i>	no appearance of cracks
Pencil hardness	<i>ASTM B3363</i>	2H (min)
Humidity resistance 500 [h]	<i>ASTM D2247</i>	Max. undercutting 1 [mm] No blistering
Salt spray resistance 500 [h]	<i>ASTM B117</i>	Max. undercutting 1 [mm] No blistering

Cleaning recommendations: Please refer to our data sheet in the latest edition.



Chemical resistance

The required chemical resistance of a powder coating depends among other things on its formulation. Chemical resistance requirements therefore must be considered according to processing conditions and final use of the finished product. This is best already 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.

As a part of our product information program our product data sheets are periodically updated. Therefore, please check our website for the latest edition. Our verbal and written recommendations for the use of our products are based upon experience and in accordance with present technological standards. These are given 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 our products for the intended application.

This product data sheet substitutes any and all previous product data sheet and notes for customers published on this subject matr.



Member of the Powder Coating Institute

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