



Super Durable
Series 68

Super weather resistant powder coating for
high performance application
based on polyester (TGIC-free)

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Typical applications

- Metal facades & Steel construction
- Stadium seating
- Residential windows and doors
- Patio furniture & garden equipment
- Railing
- Playground equipment
- Agriculture



Underwriters Laboratories Inc.
(UL) Recognition

Features

- ▶ Excellent weather resistance
- ▶ Excellent UV-light resistance
- ▶ AAMA 2604-98 conforming
- ▶ 5 years south Florida exposure
TIGA-2-A-14 Atlas Material Testing Technology Inc.
- ▶ Very smooth flow
- ▶ Good storage stability
- ▶ Good yellowing stability

Finish | Colors

- ▶ Smooth flow - glossy surface, approx. 80 – 95+ *
- ▶ Smooth flow - semi gloss surface approx. 60 ± 5 *

Available from stock in 18 colors in a smooth glossy and semi gloss surface.

Limited colors can be custom matched (minimum order and color limitation applies)

*Gloss level acc. to ASTM 523 / 60° angle.

Standard Packaging	in 20 [kg] boxes
	in 44 [lb] boxes
Specific Gravity (ASTM D792)	approx. 1.2 – 1.8 [g/cm ³] 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] <i>(also please refer to data sheets # 4001 & 4002 in the latest edition)</i>
Storage Stability	6 months at no more than 25°C / 77°F



Pretreatment (alternatives)

The following table reflects the common methods of pre-treatment 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	○	○	○							
³⁾ Chrome free	○	○	○	○	○					
Iron Phosphating								○	○	
Zinc Phosphating				○	○	○	○	○	○	○
Blasting								○	○	○
³⁾ Sweeping				○	○	○	○			
	I	E	A	I	E	A	S	I	E	S

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

- 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

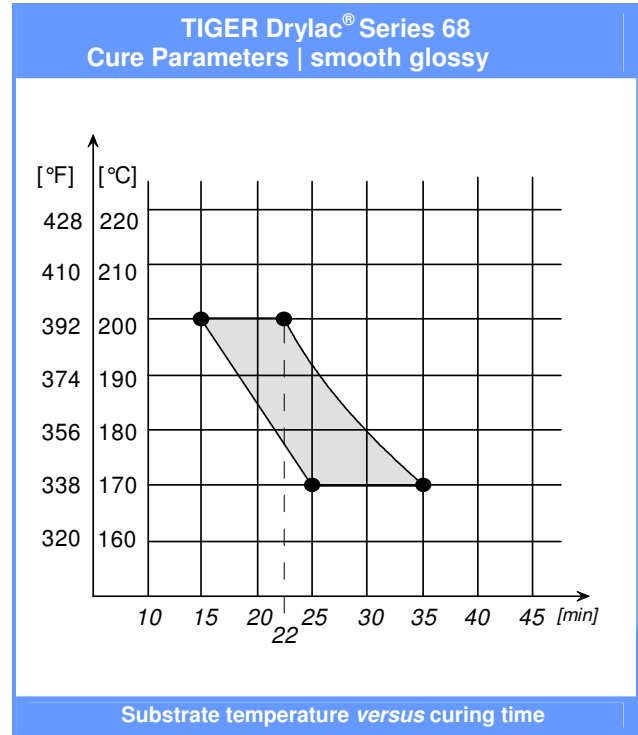
Processing

Corona

Tribo*

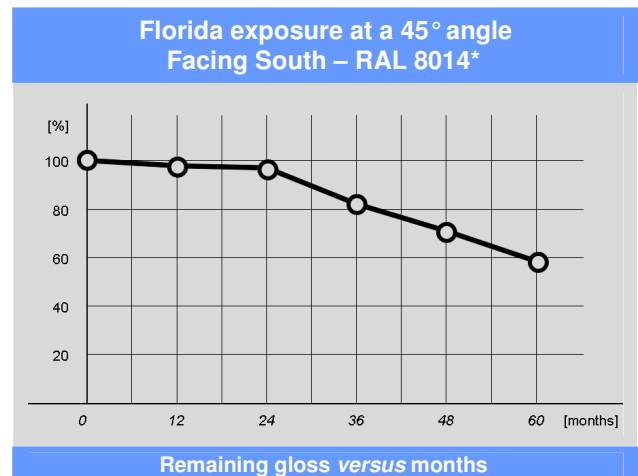
* Suitability of metallic effects for tribo processing must be verified prior to application. Please consult our latest edition of relevant information sheets.

Cure parameters (substrate temperature)



Observe cure parameters closely since mechanical properties and weatherability will develop before full cross-linking.

Weather Resistance



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The remaining gloss values that can be expected may vary depending on the original gloss level and color. A reasonable degree of loss of gloss and color variation due to long-term-UV Exposure can be expected.



Test results

Checked under laboratory conditions on a chromated aluminum test panel, which is 0.7 [mm] thick. 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

Test result	Test method	TIGER Drylac® Series 68 Smooth glossy
Film thickness	<i>ISO 2360</i>	60-80 [µm] / 2.5 –3.5 [mils]
Gloss– 60[°]	<i>ASTM D523</i>	80 – 95 ⁺
Cross hatch adhesion test	<i>ASTM D3359 Method B</i>	5B
Mandrel bending test	<i>ASTM D522</i>	3 [mm] (1/8 in)
Impact test	<i>ASTM D2794</i>	Up to 80 [in/lb.] Cracking at the perimeter of the concave area, but no cracking pick off
Pencil hardness	<i>ASTM B3363</i>	2H (minimum)
Weathering	<i>EN 20105 – A02</i>	≥ 4
Light fastness	<i>EC ISO 105 – B02</i>	≥ grade 7
Humidity resistance 1,000 [h]	<i>ASTM D2247</i>	max. blistering 1 [mm]
Acid Salt spray resistance 1,000 [h]	<i>ASTM B117</i>	max. undercutting 1 [mm]
Florida Exposure 5 years [Certificate #: TIGA-2-A-14 • Atlas Material Testing Technology Inc.]		
Color change	<i>ASTM D2244</i>	≤ Δε 5.0 [Hunter]
Gloss retention	<i>ASTM D523</i>	≥ 30 [%]

Please note

Due to the reduced availability of super durable pigments, please observe limited hiding properties and over bake stability for bright yellow and orange colors. Recommended minimum film thickness for those colors is 4.0 [mils]

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.



Special applications

Objects that are directly exposed to the salt/fog conditions of a marine environment or need a heavy corrosion protection must be coated with the TIGER Shield® system. Please observe the latest edition of our relevant product datasheets.

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 EN ISO 2812-1 "Lacquers and Paint Products. Test Methods for Surface Resistance to Liquids". Furthermore, the test duration, reactive time and concentration of the test media need to be agreed upon.

Cleaning recommendations

Please see our Information Sheet latest edition.

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 matter.



Member of the Powder Coating Institute

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