



Clear Flat Matte  
Series 16/00030

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**Transparent powder coating in  
a flat matte finish**  
Based on Polyester

**Typical applications**

- Top coating of Metallic Effects
- Sporting Goods
- Metal Construction
- Automotive Accessories
- Patio Furniture
- Light Fixture

**Features**

- Good Weather Resistance
- Very Smooth Flow
- Good storage stability
- Ice Finish

**Finish | Colors**

- Smooth flow-flat matte
- TIGER Drylac 16/0030 transparent

**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

**Theoretical Coverage**

at specific gravity 1.2 and film thickness  
of 2.5 [mils] / 60 [µm]:  
**67.1 [sq ft/lb] / 13.9 [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



## Pretreatment (alternatives)

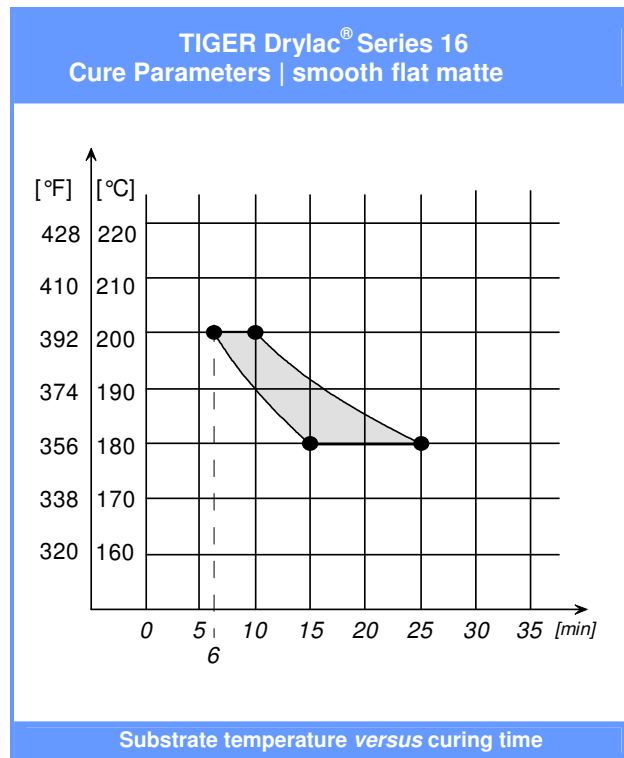
The following table reflects the common methods of pre-treatment with regards to various substrates and applications. In selecting the proper type of pretreatment please observe the suitability of the type of powder coating for a desired application according to the guidelines on page one of this product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

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

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

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

## Cure parameters (substrate temperature)



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

## Processing

Corona

Tribo\*

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



## Please note

Top coating with a clear exterior grade powder coating over an interior grade powder coating does not produce 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 which may damage the finish. Prior to coating, a suitability test at the applicator is therefore highly recommended.

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 16 clear flat matte
Film thickness		2.5 – 3.5 [mils] 60 – 80 [µm]
Cross cut tape test	ASTM D3359 Method B	5B
Mandrel bending test	ASTM D522	≤ 5 [mm] ≤ 1/8 [inches]
Impact test 80 [in/lb.]	ASTM D2794	no appearance of cracks down to the substrate
Pencil hardness	ASTM B3363	2H [minimum]
Humidity resistance 500 [h]	ASTM D2247	Max. undercutting 1 [mm] No blistering
Salt spray resistance 500 [h]	ASTM B117	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 matter.**



Member of the Powder Coating Institute

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