

APPLICATION GUIDELINES



Reflective Surface Metallics

49/90177 Extreme Chrome
49/91260 Mirror Silver

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This datasheet is meant to supplement our data sheet 4006 which provides guidance on general processing of metallic effect powder coatings. Our 49/90177 Extreme Chrome and 49/91260 Mirror Silver are high performance products with very good smoothness and reflective properties. They do require extra steps to be taken to assure that the benefits of these products can be fully realized.

The extreme brilliance of this type of coating relies on the high flow and good smoothness of the base powder, and the perfect alignment of the metallic particles at the surface. It is clear that cleanliness is absolutely critical, for any disruptions of the surface will be very visible. Even low levels of contamination by other powder coatings can produce voids in the coating that will be visible as dark spots, usually the size of the head of a pin. Equally important is adequate cleaning of the surface, any kind of metal shavings and other dirt that is left on the surface will cause a very noticeable protrusion.

49/90177 Extreme Chrome and 49/91260 Mirror Silver do require a clear coat in order to protect the thin layer of Aluminum. Experience has shown that it is important to observe the following:

- 1) Film thickness of these products should be between 2.5 and 3.5 mils. If the film thickness is higher, the product may become a bit smoother yet, but there is a possibility of the coating sagging, and cracks to occur in the metallic layer. If the film thickness gets much lower than the minimum, smoothness will be compromised greatly.
- 2) Typically we recommend for 2 coat systems to use a 5 min @ 392 F gel cycle, followed by application of the clear coat and a full bake cycle. With 49/90177 Extreme chrome and 49/91260 Mirror Silver a 10 min @ 392 F schedule is recommended to fully set the coating and avoid the appearance of small, dark cracks. (The time recommended refers to metal temperature)
- 3) Caution should also be taken during electrostatic spraying. The Voltage on the gun should not be too high, otherwise dark spots in the coating may appear.
- 4) Best results are achieved with our Clear coat 38/00001 – film thickness should be kept low, close to 2.5 mils. Recommended bake for 38/00001 is 15 min @ 392 F metal temp.

If these simple steps are followed, the applicator should be able to realize the best possible appearance of this product.

As a part of our product information program our product data sheets are periodically updated. Therefore, please check our webpage 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.

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