

APPLICATION GUIDELINES



Fine- & Rough Textures,
Antiques, Hammertone
Textures

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FILM THICKNESS:

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

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 with 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 effect.

APPLICATION:

Spray equipment from various manufacturers as well as the difference in charging between electrostatic and tribo / airstatic application equipment may influence the texture appearance.

EXTERIOR:

When using TIGER Drylac® Textures for exterior applications, it is always required to observe the minimum film thickness of 3.5 [mils] / 90 [µm]. It is important to verify the suitability of TIGER Drylac® Textures for the intended exterior application.

RECOATING:

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

RECLAIM:

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

HAMMERTONE:

The Hammertone effect in powder has a tendency to be more dull and darker as opposed to Hammertone effects commonly achieved in liquid coating. Another 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 TEXTURE:

Rough texture formulations are very sensitive to contamination at the applicator as well as during powder manufacturing. Contamination will always "float" on the top of the texture surface. Clean application equipment as well as clean spraying environment is essential.

VEIN / ANTIQUE:

It is not possible to reclaim Vein/Antique powder coating. The powder particles will be separated from the metallic flakes, this will result in a different effect.

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.

Data Sheet 4005 Version 04-07