TIGER Drylac® Powder Coatings

SERIES 69 – chemical agent resistant coating (CARC)

EPOXY BASED ZINC-FREE POWDER COATING DESIGNED TO BE USED AS ONE COAT OR AS A PRIMER IN TWO-COAT SYSTEM FOR CARC APPLICATIONS WITH SUPERIOR CORROSION PROECTION. COMPLIANT TO MIL-PRF-32348 TYPE I AND II

Typical applications

- heavy corrosion protection
- steel/aluminum constructions
- military equipment

Product details

Standard packaging in original 55 lb (25 kg) boxes and 5 lb (2.5 kg) minipack

Specific gravity (ASTM D792) approximately 1.6 g/cm^3 depending on pigmentation

Theoretical coverage at 2.5 mils (60 µm) film thickness: **51.5 ft²/lb (11.1 m²/kg)**. Refer also to "Theoretic Powder Coating Coverage Chart" version 00-1001 (imperial) version 00-1000 (metric)

Storage stability 6 months at no more than 77 °F (25 °C) avoid direct and extended exposure to heat

Features

- especially suited for blasted substrates
- very good corrosion protection
- very good mechanical properties
- good chemical resistance
- good storage stability
- very good edge coverage

Finish

finish	gloss
smooth *semi-gloss*	40±5*

* *Gloss level according to ASTM 523 at 60° angle (doesn't apply to metallic effect powder coatings). The measured gloss level of effect powder coatings can diverge from the details given in this Product Data Sheet. The creation of tolerance samples is recommended.*

Available as Type I coatings, MIL-PRF-32348 approved:

product description	product ID
White Fed Std 27875 QPL Q2044	69/70369

Available as Type II coatings, MIL-PRF-32348 approved:

product description	product ID
Gloss White Fed Std 17925 QPL Q2159	569/10101
Gray Fed Std 26622 QPL Q2155	569/71402
Seafoam Green Fed Std 24533 QPL Q2156	569/51401
Green Fed Std 24094 QPL Q2157	569/50201
Tan Fed Std 23446 QPL Q2158	569/15201

Can be made to order in non-stock colors (minimum order quantity applies).

Pretreatment

Refer to TT-C-490 for ferrous substrates and TT-C-490/MIL-C-5541F for non-ferrous substrates.

Processing

Corona and Tribostatic*

** For Tribostatic powder coatings, confirm before ordering. Suitability of metallic effects for Tribostatic processing must be verified prior to actual application. Please refer to the latest edition of the relevant application guidelines for metallic effect powder coatings.*

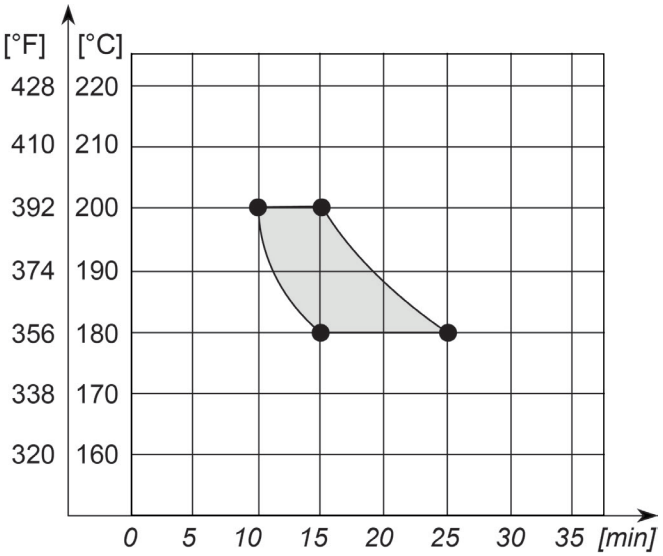
Since not all powder coatings are suitable for recycling/reclaim, please verify before ordering.

Product data sheet

Cure parameters

(substrate temperature versus curing time)

base coat



substrate temp.	min. curing time	max. curing time
356 °F (180 °C)	15 minutes	25 minutes
392 °F (200 °C)	10 minutes	15 minutes

Cure parameters must be closely observed since mechanical properties will develop before full cross-linking.

Film thickness

For best results, when used as primer the minimum film thickness should be <2.5 mil (60 µm) prior to top coating.

Test results

Results are checked on a 1/8 inch (3 mm) gauge zinc phosphated, steel panel. Cure conditions according to the cure curves.

test method	test	**Series 69** smooth *glossy*
ISO 2360	**recommended film thickness**	2.5-3.5 mils (60-80 µm)
ASTM D3359 method B	**cross cut tape test** 1mm cutting distance	5B
ASTM D2247	**determination of resistance to humidity** 1,000 hours	maximum undercutting 1/32 inch (1 mm), no blistering
ASTM B117	**salt spray resistance** 3,000 hours	maximum undercutting 1/32 inch (1 mm), no blistering
ASTM D3258	**porosity of paint film**	non-porous

Cleaning recommendations: refer to the latest edition of TIGER “Cleaning Recommendations” information sheet, Version 00-1005.

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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 that may damage the finish. Therefore, a suitability test at the applicator's end, prior to coating, is highly recommended.

Any post mechanical processing of already coated parts, such as sawing, drilling, milling, cutting and bending will result in damage of the coated surface and will subsequently weaken the corrosion protection.

In general, colors in the red, orange and yellow range may require an increased film thickness to achieve full hiding.

Please read and understand the Safety Data Sheet (SDS) before use.

Chemical resistance

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

Disclaimer

TIGER's verbal and written recommendations for the use of its products are based upon experience and in accordance with current technological standards. These are provided 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 TIGER products for the intended application. TIGER warrants that its products are free of flaws and defects to the extent stipulated in the Terms of Delivery and Payment.

As part of TIGER product information program, each Product Data Sheet is updated periodically. The latest version shall prevail. It is recommended to always check for the latest editions on TIGER's website download area www.tiger-coatings.com to make sure you have the most current version of this Product Data Sheet. The information on TIGER's Product Data Sheets are subject to change without notification.

This Product Data Sheet supersedes and replaces all previous Product Data Sheet versions and notes to customers published in relation to this product and is only intended to provide a general overview on the product.

Latest versions of Technical Information Sheets and Terms of Delivery and Payment are downloadable from www.tiger-coatings.com and form an integral part of this Product Data Sheet.

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