



Drylac®

Series 49 Exterior

A weather resistant powder coating based on polyester TGIC

Tiger Drylac U.S.A., Inc
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Typical applications

- Residential Windows and Doors
- Patio Furniture
- Lawnmowers and Garden Equipment
- Automotive Accessories
- Bicycles and Motorcycles
- Aircraft Components
- Agricultural Machinery
- Hand Railing

Standard Packaging	44 or 55 lb cartons 5 lb Minipack
Specific Gravity (ISO 8130-2)	1.2 – 1.7 g/cm ³ depending on pigmentation
Theoretical Coverage	1 lb coats appr. 50 Sq. ft. at 3 mils avg. Depending on processing conditions and pigmentation. Product is normally applied at 2.5 to 3.5 mils (60- 90µ). Some Silvers and other metallic colors must be protected with a clear topcoat (exception: one coat metallics and iron glimmers – see Metallic Chart).
Storage Stability	6 months at no more than 77° (F)

As a part of our product information program our Product Data Sheets are periodically updated. If the version date on this literature exceeds 12 months please contact our sales department to receive updated information this product. 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 Sheets and notes for customers published on this subject matter.

Features

- ▶ High Mechanical Properties
- ▶ Good Weather Resistance
- ▶ Good Coverage
- ▶ Very Smooth Flow
- ▶ Good Storage Stability

Finish | Colors

Standard Series 49:

- ▶ Smooth glossy 80°- 90°
- ▶ Available from stock in all RAL colors on the Color Chart. Any other color may be custom matched (minimum order applies)

Special Series 49:

- ▶ Smooth semi-gloss 55°- 65° *
 - ▶ Smooth low semi-gloss 36°- 54° *
 - ▶ Smooth matte gloss 20°- 25° *
 - ▶ Rough texture
 - ▶ Fine Texture
 - ▶ Fluorescent
 - ▶ Glitter
 - ▶ Metallic
 - ▶ Iron Glimmer Effects
 - ▶ OGF- Out Gassing Forgiving
 - ▶ Transparents & Dormant Transparents
 - ▶ Anodizing Colors
- * Gloss According to Gardener 60° ASTM D523



Drylac®

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Exterior

Pretreatment (alternatives)

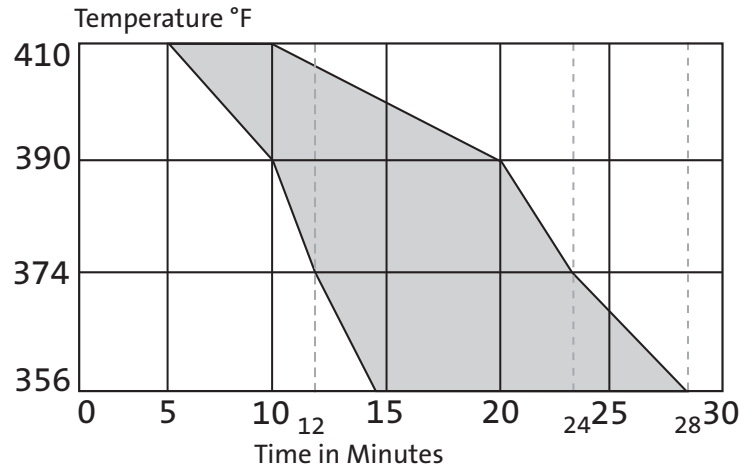
The following table reflects the common methods of pretreatment with regards to various substrates and applications.

	ALUMINUM			GALVANIZED STEEL				STEEL		
Degreasing	○	○	○	○	○	○	○	○	○	○
1) Chromating	○	○	○	○	○	○	○	○	○	○
2) Anodizing	○	○	○	○	○	○	○	○	○	○
2) Chrome Free	○	○	○	○	○	○	○	○	○	○
Iron Phosphating				○	○	○	○	○	○	○
Zinc Phosphating				○	○	○	○	○	○	○
Blasting				○	○	○	○	○	○	○
3) Sweeping				○	○	○	○	○	○	○
	I	E	A	I	E	A	S	I	E	S

- Application **I** interior 1) acc. to DIN 50939
E exterior 2) acc. to GSB quality and test regulation
A architectural 3) only for zinc coated parts > 1.8 mils
S steel 4) for a two-coat process/TIGER Shield

Cure parameters (substrate temperature)

Cure Window Series 49



Processing:

Corona or Tribostatic

Please Note: For Tribo/Airstatic Powders please confirm when ordering. Metallic products are Electrostatic application only.

Test results

Checked on a chromated aluminum test panel 0.7 mm/(0.03 in.) thick. Cure conditions according to recommendations.

Test results	Glossy	Semi gloss	Low Semi gloss	Matte	OGF
Film thickness	4 mils	2.5 – 3.5mils	2.5 – 3.5mils	2.5 – 3.5mils	2.5 – 5.0 mils
Gloss according to gardener 60° ASTM D523	80-90°	55-65°	36-54°	20-25°	55-70°
Cross hatch adhesion test ASTM D3359	5B	5B	5B	5B	5B
Mandrel bending test ASTM D522	3 mm (1/8 in)	4 mm (5/32 in)	5 mm (3/16 in)	5 mm (3/16 in)	4 mm (5/32 in)
Impact test 1/10 Dist. ASTM D2794	Up to 160 in-lb.	Up to 120 in-lb.	Up to 120 in-lb.	Up to 120 in-lb.	Up to 160 in-lb.
Pencil hardness ASTM B3363	2H (min)	2H (min)	2H (min)	2H (min)	2H (min)
Humidity resistance 1500 [h] ASTM D2247	max. blistering 1 mm/0.04 in.	max. blistering 1 mm/0.04 in.	max. blistering 1 mm/0.04 in.	max. blistering 1 mm/0.04 in.	max. blistering 1 mm/0.04 in.
Acid Salt spray resistance 1500 [h] ASTM G85	max. undercutting 1 mm/0.04 in.	max. undercutting 1 mm/0.04 in.	max. undercutting 1 mm/0.04 in.	max. undercutting 1 mm/0.04 in.	max. undercutting 1 mm/0.04 in.