TIGER DRYLAC®

metallic

powder coatings

TIGER Drylac®
Powder Coatings

metallics

Silver

RAL 9007 Gloss One Coat
09/90460 •

Standard Silver
49/90380 •

RAL 9007
49/92880 •

Silver Fine Texture
09/90530 •

Mirror Silver
49/91260 •

RAL 9006 Gloss One Coat
49/92890

Marine Silver
38/90010

No-Smudge Silver
49/92790 •

Silver Glossy One Coat
49/92900

Silver
39/90000 •

Silver Matte One Coat
49/92380

RAL 9006 Gloss One Coat
49/92910

Silver Matte
49/90500 •

Silver Semigloss One Coat
49/92420

RAL 9006 One Coat
59/93370

Antique/Vein

Epoxy Matte
69/91390 •

White Hybrid
09/90160 •

Copper Hybrid
09/90180 •

Grey Hybrid
09/90170 •

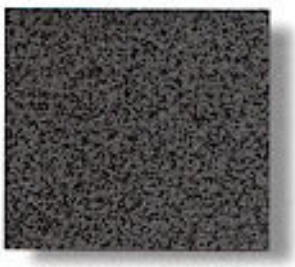
Silver Hybrid
09/90190 •

Gold Hybrid
09/90200 •

White
49/10363

Copper
49/90620

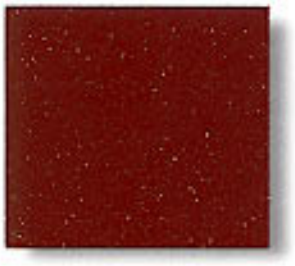
Grey
49/10364



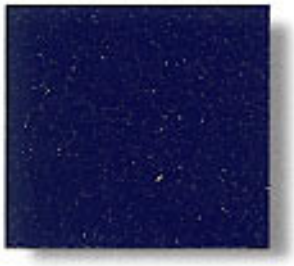
Silver
49/93240

Gold
49/91190

Glitter



Gold 49/00310
RAL 3005 Basecoat 49/31900



Silver 49/00320
RAL 5003 Basecoat 49/42230

Red 49/00330
Black Basecoat 49/82830

Blue 49/00340
Black Basecoat 49/82830

Green 49/00350
Black Basecoat 49/82830

Metallic/Gold

Night Blue 49/00370
Black Basecoat 49/82830

Jeans Metallic
09/40670 •

Anthracite Metallic
09/80170 •

Bronze C34 One Coat
49/66220

Starlight 49/00380
Black Basecoat 49/82830

Green Metallic
09/50530 •

Grey Metallic
09/80340 •

Brown C33 One Coat
49/66230

Twilight 49/00390
Black Basecoat 49/82830

Purple Metallic
09/45590 •

Sungold Metallic
09/90140 •

Bronze Metallic
09/60600 •

Copper Metallic
49/92780 •

Beige Metallic
09/60610 •

Beige C32 One Coat
49/15240

Iron Glimmer

Exterior grade Iron Glimmers have that metallic look but no metallic content, making this product a perfect 1-coat finishing solution. Iron glimmers can be produced in any color as a custom order.

DB 703
49/83510

P 6
49/70210

DB 501
49/46430

P 2
49/70190

P 7
49/80190

DB 502
49/46440

P 3
49/70200

P 14
49/70230

DB 601
49/50100

P 4
49/70220

DB 702
49/77790

P 5
49/80180

Notes

• Products labeled with this mark should be top coated with a clear coat to increase durability and chemical resistance. Please refer to our **Standard Product Catalog** for selections of clear coats available.

Colors and textures have been matched as closely as possible. Paper and ink limitations as well as influence of heat and light account for differences from actual coatings.

Offices and Warehouses

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1251 E. Belmont Street
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South
339 Exchange Drive
Arlington, TX 76011
Phone: (817) 277-7995
Fax: (817) 277-1931

TIGER Drylac® Powder Coatings

notes

Notes

Bonded Metallics: All of our metallic powder coatings are bonded. The bonding of metallic pigments to the base material offers unique advantages over conventional dry blending. This process, though costly, affords an even distribution of pigments for a more uniform finish, overcomes particle segregation during transport and storage and greatly eases powder application. Plus it changes the metallic powder into a recycling consistent material, suitable for reclaim (see application guidelines for metallic powder coatings).

Data Sheets: Periodically updated data sheets, showing cure parameters, test results, pretreatment information and more are available for all products in this chart. Please contact your local Tiger Drylac office or download the latest version from our web site www.tiger.at

RAL Numbers: All RAL numbers are approximate to the RAL Standard.

Custom Colors: Custom colors are available in 10 working days or less with a minimum order of 220 lb.

All of our metallic products can be custom made in an “OGF” or out-gassing forgiving formulation for porous or out-gassing prone substrates, like forged, cast, hot galvanized or aluminum flame sprayed parts as well as fired clay and ceramic products.

Standard Product Catalog: For other colors and finishes available please refer to our Standard Product Catalog of more than 1200 powder coatings.

Guidelines for Application

The following information is intended as a guide for the applicator, informing the user of parameters, which considerably affect the quality of the finish. Caution must be exercised when working with metallic effect powder coatings. Prior to application, the suitability of the entire coating system must be established by comparison with the powder manufacturers’ reference samples in order to ensure the shade and the metallic effect. The following recommendations are necessary for satisfactory results:

Color: Powder coatings are formulated to meet color standards; i.e. the RAL standard. Despite the stringent quality control measures exercised during production, a complete batch to batch consistency cannot be guaranteed. Upon request the manufacturer therefore supplies production panels of individual batches. Batch to batch consistency is comparable to that of non-metallic powder coatings. However, application process and equipment also are a factor in the final color/effect of the coating. An acceptance test must be performed on the actual application equipment before processing. Those color/effect variables, particularly when powder is recycled, must first be established by producing an upper and lower tolerance sample. To largely eliminate color/effect differences caused by the coating system, an entire coating job must be processed on the same coating line, without parameter fluctuations, preferably without interruptions and with consistent recycling percentages. Manual coating is likely to produce variations of color and/or effect due to inconsistent film thickness. Manual coating must therefore be adjusted to automatic processing with respect to color and effect. Coating thickness is of importance as variations will cause color/effect differences.

and guidelines

Color/effect variations inherent to metallic coatings can be directly linked to content of metallic pigments. Generally fine flakes of metallic pigment are used. Positioning of those flakes within the applied coat determines the metallic effect and color. Experience shows that all parameters of application may influence the position of the flakes and thus also color/effect. It is therefore important that throughout an entire coating job all equipment is left at precisely the same settings. Coating one entire job with a variety of equipment should be avoided, or else considered only after exact adjustments and comparisons produce identical test results with different equipment.

Application Equipment: Different powder coating guns, systems and spray parameters are often the cause for varying results. It is very important to only work with nozzles suitable for metallic powder application. Depending on the type of object to be coated, powder should be applied with a flat-spray type nozzle respectively with an aerated impact disk, in an even cloud pattern.

Reclaim: Generally metallic powder coatings are suitable for reclaim. To achieve a consistent color/effect it is important for the coater to establish a ratio of reclaim and virgin powder and adhere to this ratio. Repeated or exclusive use of reclaimed powder is not advisable. Using reclaimed powder without introduction of virgin powder will not produce satisfactory results. Since not all metallic effect powders are equally reclaim-consistent, the virgin powder percentage must be established via upper and lower tolerance samples.

Processing: Very few metallic powder coatings are suitable for tribo/airstatic processing. Suitability must be verified prior to application. Due to differing charging characteristics of powder coatings and metallic flakes, not all metallic flakes are transported to the work piece, thus possibly causing a shift in color/effect. Changeover from tribo/airstatic to electrostatic is not advisable. Cleanliness of the application system is most important, since arcing may cause short circuiting at the gun.

Grounding: When working with metallic powder coatings proper grounding of equipment as well as work piece is very important. This contributes to a high degree of color/effect consistency and transfer efficiency.

Coating Durability: Observe manufacturers guidelines for one and two coat systems, when coating architectural or curtain wall projects with metallic coatings. Longevity of metallic coatings cannot be generalized and must be discussed with the manufacturers representative prior to application, with particular reference to special requirements, such as wear and scratch resistance, cleaning recommendations, colorfastness and chemical resistance. The manufacturer needs complete information about all the requirements that the powder coating is subjected to in a project/application in order to give appropriate advice. In most cases top coating of metallic powder coatings with clear powder coatings is necessary to fend off outside intrusions which may affect the color or effect. Note that the clear coat may affect the color of the metallic coating underneath. Follow specific cure instructions for two coat systems.

General Recommendations: A pre-coating should be applied on parts that are difficult to coat prior to actual application, since a subsequent touch-up job may produce clouding. When both sides of a finished part must be coated, the side most visual in its final use should be coated last. The final orientation of curtain wall panels on a building must be established prior to coating and all panels must either be coated horizontal or vertical to achieve the same color/effect throughout a coating project. Variations in the heat-up period are to be avoided: parts of varying wall thickness cannot be coated at the same time. Please consult and observe the relevant data sheets.

Working with metallic effect powder coatings requires precision. All guidelines must be observed. Most important is proper communication between coater and the customer, but also between coater and coating manufacturer, to assure that all provisions are given for a quality finish.

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POWDER COATED TOUGH™

Member of the
Powder Coating Institute

3/99 • 2001/B