



TIGER Drylac®

series 75

fluoropolymer powder coatings

volume 2



Drylac®
Powder Coatings

TIGER Drylac® Series 75 – Exterior and Interior

A unique powder coating offering superior weatherability for architectural applications on aluminum based on Fluoropolymer

Features

Designed to meet the performance levels described in AAMA 2605-05

Highest performance architectural powder coating offering Superior Gloss and Color Retention
Outstanding Resistance to Fading
Outstanding Resistance to Chalking
Good Chemical Resistance
Good Edge Coverage
Good Storage Stability

Typical Applications

All Architectural and Construction Applications including:

Metal Facades	Window Frames
Marine Equipment	Railings
Curtain Walls	Light Poles

Standard Series 75

Smooth Glossy	Smooth Matte
Smooth Semigloss	Solid Colors and Metallics

Custom Colors

Other colors and finishes are available as custom colors with 220 lb minimum order quantity. However, due to the extreme durability requirements, organic pigments as a class cannot be used. This limits the colors to earth tone colors and colors of similar chromaticity in other parts of the spectrum, such as red, blue and green. Evaluations by our laboratory on a case to case basis are necessary.

Standard Packaging

44 lbs/20 kg cartons or 5 lb Minipacks

Specific Gravity

Approximately 1.4 – 1.8 (g/cm³) depending on pigmentation (ASTM D792)

Theoretical Coverage

at specific gravity 1.7 and film thickness of 2.5 mils / 60 µm:
45.2 sq ft/lb / 9.2 m²/kg

Processing

Corona and Tribo* manual or automatic

*Suitability of metallic effects for Tribo processing must be verified prior to application. Please consult our latest edition of relevant information sheets.

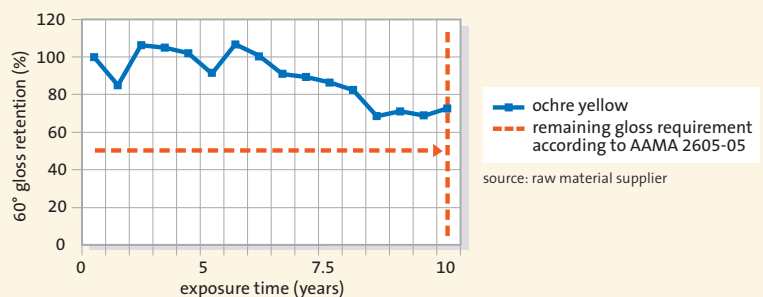
Dry Storage Stability

6 months at no more than 77° F / 25° C

Weather Resistance

Gloss Retention according to AAMA 2605-05 –

Remaining Gloss vs. Years



Note

A top-coat with a clear powder coating over an interior grade powder coating does not produce a weather resistant coating. In case a two-coat system consisting of an epoxy primer for corrosion protection and a Series 75 top coat is applied, UV transmission of the top coat has to be controlled by pigmentation and film thickness. TIGER Drylac® Series 75 is slightly incompatible with other powder coatings. It is therefore highly recommended to thoroughly clean the entire coating line prior to and after the powder application. The curing of TIGER Drylac® Series 75 will result in the emission of small doses of ϵ -caprolactam, which may cause minor smoke and odor. Provide sufficient ventilation and observe maximum allowable concentration guidelines.

Health & Safety Environment

For HSE relevant information please consult Material Safety Datasheet. Work place regulations are the responsibility of the applicator.

Performance Data on Aluminum

Checked under laboratory conditions on a yellow chromated aluminum test panel, which is 0.7 (mm) thick. Actual product performance may vary due to product specific properties such as gloss, color, effect and finish as well as application related and environmental influences.

Please note

Experience has shown that degradation similar to 10-year Florida exposure can be expected with 11,000 hours of accelerated weathering with UV-A lamps or 3,000 hours of UV-B lamps.

At this point we cannot claim full AAMA compliance, since some of the tests required – most notably Florida exposure – have extended duration. Performance can be reasonably anticipated based on accelerated weathering data with QUV-A and B tests, as well as references with related coating technologies using comparable polymer systems. It is well known that Fluoropolymers are offering superior performance, and all the coating systems that are available for compliance with AAMA 2605-05 are based on these materials.

Due to the chemical makeup of the coating, flexibility is decreased when compared to polyester-based products. Post-forming operations need to be verified beforehand for feasibility. Cracks in the coating can lead to corrosion.

Joint sealants and any other auxiliary products, such as glazing agents, gliding waxes, drilling and cutting lubricants, which come in contact with the coated surface, must be pH-neutral and free of substances which may damage the finish. Prior to coating a suitability test at the applicator is therefore highly recommended.

Test result	Test Method	TIGER Drylac® Series 75
Film Thickness (1-coat system)	ISO 2360	approx. 50-65 μm / approx. 2.0-2.5 mils*
Gloss – 60°	AAMA 2605-05 / Section 7.2	pass
Dry Adhesion	AAMA 2605-05 / Section 7.4.1.1	pass
Impact resistance 3 mm deformation	AAMA 2605-05 / Section 7.5	pass
Humidity Resistance 4,000 h	AAMA 2605-05 / Section 7.8.1	pass
Salt Spray Resistance 4,000 h	AAMA 2605-05 / Section 7.8.2	pass
QUV-B Resistance 3,000h	ASTM G-53	> 75 % gloss retention
QUV-A Resistance 11,000h	ASTM G-53	> 75 % gloss retention

* Above 2.5 mils the mechanical properties will degrade.

Florida Exposure 10 years – Florida Exposure 10 years based on fluoropolymer, which meets AAMA 2605-05		
Color retention	AAMA 2605-05 / Section 7.9.1.2	Less than 5 dE (Hunter)
Gloss retention	AAMA 2605-05 / Section 7.9.1.4	> 50%

Cleaning Recommendations

Please see information sheets (latest edition).

Chemical Resistance

Tested	According to AAMA	Test Duration	Results
Muriatic acid (10%)	AAMA 2605-05 / Section 7.7.1	15 min	no blistering or discoloration – pass
Mortar resistance	AAMA 2605-05 / Section 7.7.2	24 hrs	easy removal of mortar, no delamination, no discoloration – pass
Nitric Acid resistance (70%)	AAMA 2605-05 / Section 7.7.3	30 min	discoloration < 5dE – pass
Detergent resistance (3%)	AAMA 2605-05 / Section 7.7.4	72 hrs	no loss of adhesion, no blisters, no visual changes – pass
Window cleaner resistance	AAMA 2605-05 / Section 7.7.5	24 hrs	no blistering or change of appearance

Product Description

TIGER Drylac® Series 75 is a unique powder coating offering superior weatherability for architectural aluminum, based on fluoropolymer, which meets AAMA 2605-05 standards. Due to our 15 year warranty offered with this product line, it can only be applied by TIGER Drylac® Approved Applicators. A current listing of Approved Applicators is available upon request.

Specifiers:
Metal Constructor • Architect • Real Estate Developer



Sufficient communication before, during and after the process ensures a high performance finish.

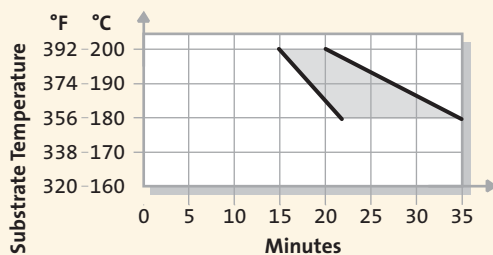
Pretreatment Requirements

A 5-stage pretreatment is highly recommended. Chromating according to ASTM B 449, Anodizing according to AAMA 2603-02 Quality and Test Regulations or Chrome-free according to AAMA 2605-05 are acceptable methods.

General Conditions

Under normal circumstances a single coat of Series 75 powder coating is sufficient. Powder Coating must be applied over a clean dry substrate, free of any contaminates and oxidation.

Cure Parameters



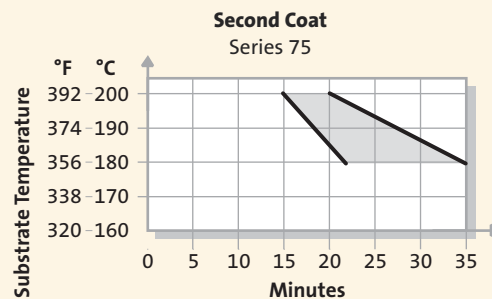
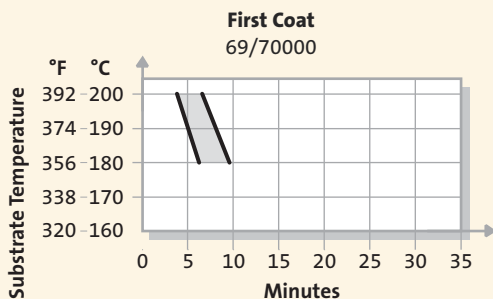
Special Applications — TIGER Shield System

In highly corrosive conditions, such as found in coastal regions (salt, fog) or industrial atmospheres, a 2-coat system of TIGER Drylac® Dryprotector Primer 69/70000 plus a topcoat of Series 75 is highly recommended. Both products are engineered to complement each other and offer an excellent corrosion barrier. This 2-coat system warrants an optimum non-porous film, as well as excellent UV protection. Base coat must be applied over a clean dry substrate, free of contaminates and oxidation. Note: Time lapse between application of Dryprotector Primer and Series 75 topcoat must not exceed 12 hours.

Theoretic Coverage

The Specific Gravity of 69/70000 Dryprotective Primer is $1.6 \pm 0.1\text{g/cm}^3$. The TIGER Shield system (primer plus top coat) is normally applied between 4.0 and 5.0 mils / 90-125 microns.

Cure Parameters



Providing Environmentally Friendly Powder Coatings for a Sustainable World



TIGER Drylac® **Sea Shell White**
75/10130 30±5*



TIGER Drylac® **Taupe**
75/70070 30±5*



TIGER Drylac® **Koko Brown**
75/60018 30±5*



TIGER Drylac® **Aged Copper**
75/60006 20±5*



TIGER Drylac® **Bone White**
75/10070 20±5*



TIGER Drylac® **Sierra Tan**
75/15022 30±5*



TIGER Drylac® **Boysenberry**
75/30033 20±5*



TIGER Drylac® **Ivy Green**
75/50080 30±5*



TIGER Drylac® **Sky Grey (RAL 7035)**
75/70048 30±5*



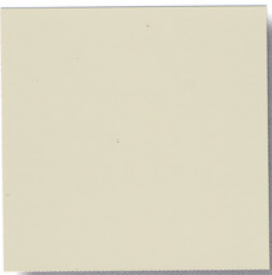
TIGER Drylac® **Ash Grey**
75/70025 30±5*



TIGER Drylac® **Redwood**
75/30041 30±5*



TIGER Drylac® **Classic Green**
75/50037 30±5*



TIGER Drylac® **Almond**
75/15013 30±5*



TIGER Drylac® **Slate Grey**
75/70019 30±5*



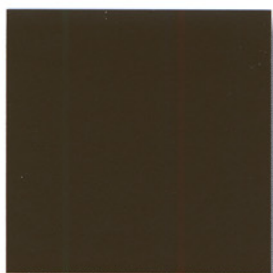
TIGER Drylac® **Brick Red**
75/30028 20±5*



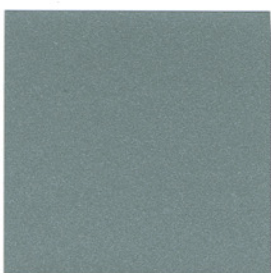
TIGER Drylac® **Hartford Green**
75/50110 30±5*



TIGER Drylac® **Sandstone**
75/15012 30±5*



TIGER Drylac® **Medium Bronze**
75/60014 30±5*

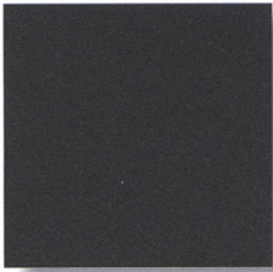


TIGER Drylac® **Seafoam Green
Metallic** 75/50035



TIGER Drylac® **Statuary Bronze**
75/60080 30±5*

*Gloss level according to Gardner 60° ASTM D523. Paper and ink limitations of color samples as well as influence from heat and light account for differences from actual powder coatings.



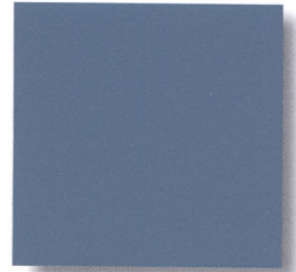
TIGER Drylac® **Medium Bronze Metallic** 75/60060



TIGER Drylac® **Bianco 750** 75/10001 68±7*



TIGER Drylac® **Deore 732 Metallic** 75/60003



TIGER Drylac® **Azzuro 781 Metallic** 78/40004



TIGER Drylac® **Interstate Blue** 75/40025 20±5*



TIGER Drylac® **Bianco 751** 75/10003 42±7*



TIGER Drylac® **Argento 706 Metallic** 75/15007



TIGER Drylac® **Champagne 772 Metallic** 75/15004



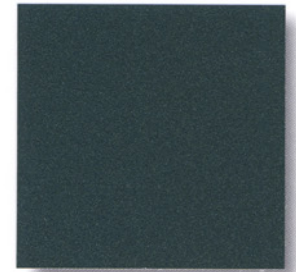
TIGER Drylac® **Military Blue** 75/40051 20±5*



TIGER Drylac® **Crème 761** 75/15003 42±7*



TIGER Drylac® **Champagne 770 Metallic** 75/15006



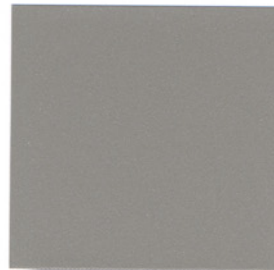
TIGER Drylac® **Highland 790 Metallic** 75/50004



TIGER Drylac® **Silver Grey (RAL 7045)** 75/70049 30±5*



TIGER Drylac® **Bianco 752** 75/10002 57±7*



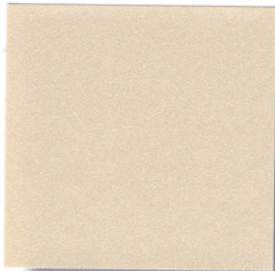
TIGER Drylac® **Champagne 771 Metallic** 75/15005



TIGER Drylac® **Rosso 791 Metallic** 75/30001



TIGER Drylac® **Jet Black (RAL 9005)** 75/80020 30±5*



TIGER Drylac® **Crème 762 Metallic** 75/15001



TIGER Drylac® **Azzuro 780 Metallic** 75/40001

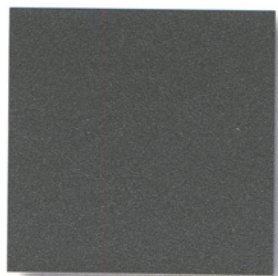


TIGER Drylac® **Rosso 792 Metallic** 75/30002

*Gloss level according to Gardner 60° ASTM D523. Paper and ink limitations of color samples as well as influence from heat and light account for differences from actual powder coatings.



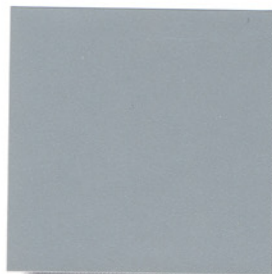
TIGER Drylac® **Grey Classic 721**
75/70003 57±7*



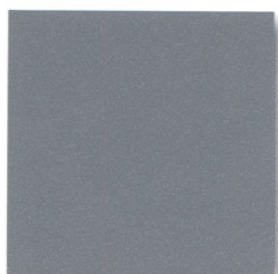
TIGER Drylac® **Argento 704**
Metallic 75/90003



TIGER Drylac® **Grey Classic 722**
Metallic 75/70001



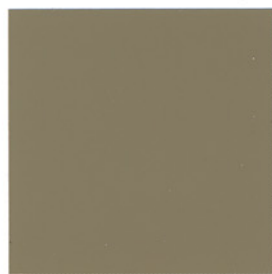
TIGER Drylac® **Argento 701**
Metallic 75/90004



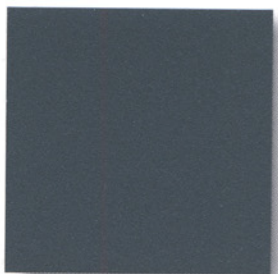
TIGER Drylac® **Argento 705**
Metallic 75/90002



TIGER Drylac® **Grey Classic 723**
75/70002 30±5*



TIGER Drylac® **Crème 760**
75/15002 30±5*



TIGER Drylac® **Mica 710 Metallic**
75/90006



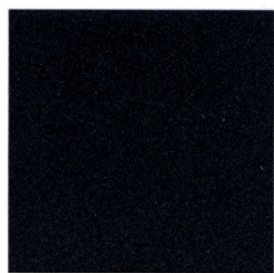
TIGER Drylac® **Deore 731 Metallic**
75/90009



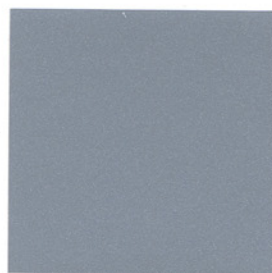
TIGER Drylac® **Argento 702**
Metallic 75/90012



TIGER Drylac® **Mica 711 Metallic**
75/90008



TIGER Drylac® **Carbon 741 Metallic**
75/80002



TIGER Drylac® **Argento 703**
Metallic 75/90013



TIGER Drylac® **Mica 712 Metallic**
75/90005



TIGER Drylac® **Carbon 742 Metallic**
75/80001

fluoropolymer

*Gloss level according to Gardner 60° ASTM D523.
Paper and ink limitations of color samples as well as influence from heat and light account for differences from actual powder coatings.

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