



Drylac®

Series 44 Motivo

PC

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A powder coating suited for a subsequent sublimation process for interior and exterior applications based on polyester

Typical applications

Wood-grain, natural stone and fantasy effects

Features

- ▶ Easy Removability of Transfer Foils from Coated Metal
- ▶ UV Stability is Dependent on the Type of Foils used
- ▶ Very Smooth Flow
- ▶ Good Mechanical Properties
- ▶ Good Storage Stability

Finish | Colors

Smooth flow – glossy surface, approx. 80–95*
Smooth flow –semi gloss surface, approx. 60–75*

Available in white for natural stone effects and in several brown shades for wood-grain effects. Custom colors with a minimum order of 200 kg.

* Gloss level acc. to ISO 2813/60° angle. (The measured gloss level of metallic and texture effect powder coatings can diverge from the details given in this product datasheet. The creation of tolerance samples is urgently recommended)

Standard Packaging	in 20 kg cartons
Specific Gravity (ISO 8130-2)	1.1–1.3 g/cm ³ depending on pigmentation
Theoretical Coverage	at 60 µm film thickness: 12.8–15.1 m ² /kg depending on specific gravity (please see also Information Sheet no. 1072 – latest edition)
Storage Stability	6 months at no more than 25°C



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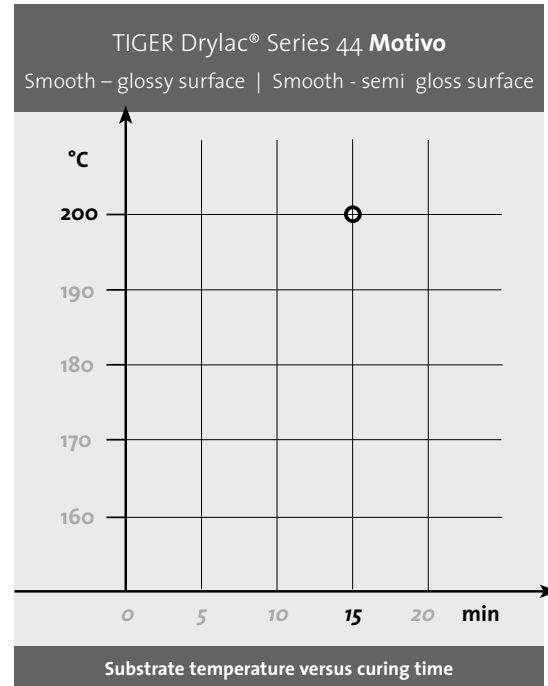
Pretreatment (alternatives)

The following table reflects the common methods of pretreatment with regards to various substrates and applications. In selecting the proper type of pretreatment please observe the suitability of the type of powder coating for a desired application according to the guidelines on page one of this Product Data Sheet.

	ALUMINUM		GALVANIZED STEEL			STEEL		
Degreasing	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
1) Chromating	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
2) Anodizing	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
2) Chrome free	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Iron Phosphating	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Zinc Phosphating	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Blasting	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
3) Sweeping	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	I	E	I	E	S	I	E	S ⁴⁾

- Application
- I** interior
 - E** exterior
 - S** steel
- ¹⁾ acc. to DIN 50939
²⁾ acc. to GSB quality and test regulations
³⁾ only for zinc coated parts > 45 µm
⁴⁾ for a two-coat process / TIGER Shield

Cure parameters (substrate temperature)



Attention
Underbaking may impair the removability of the transfer foil from the coated metal!

Please note

UV stability is dependent on the type of foils used, thus an architectural application is not permitted.

Processing

- Corona
- Tribostatic



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Guidelines for Application

The powder coating is cured by applying the cure parameters as set forth on page 2 and subsequent thermo-printing with an effect producing transfer foil. This process is based upon the principle of sublimation of the dye containing foil into the powder coating at temperatures of 190 to 200 °C. This process requires an individually cycle time adapted to the coating object. In order to achieve consistent and unobjectionable effects the foil must wrap around the metal precisely necessitating special machinery for parts with a more sophisticated configuration (e. g. aluminum extrusion parts). Post-bending may result in mechanical insufficiencies and damages.

Please note

Being the manufacturer of the base-coat powder coating only, TIGERWERK has no influence over the visual and qualitative properties of the foil. It therefore can neither warrant the light fastness, weather and chemical resistance of the foil, nor can it be held liable for the mechanical properties (e.g. postbending), the reproducibility of the color and/or effect and the cleanability of the thermo-processed powder-and-foil-system.

Test results

Checked under laboratory conditions on a 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. The test results refer to the base-coat only.

Test results	Test method	Series 44
		Smooth - glossy surface / Smooth - semi gloss surface
Film thickness	ISO 2360	60–80 µm
Gloss – 60°	ISO 2813	60–95
Cross cut test 1 mm	ISO 2409	0
Mendrel bending test	ISO 1519	≤ 10 mm
Cupping test	ISO 1520	≥ 3 mm
Impression hardness	ISO 2815	> 90
Impact test 20 inch-pound	ASTM D 2794	minor cracks down to the substrate
Humidity resistance 500 h	ISO 6270-1	max. undercutting 1 mm
Salt spray resistance 500 h	ISO 9227	max. undercutting 1 mm



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Chemical resistance

The chemical resistance of a powder coating depends among other things on its formulation. Chemical resistance requirements therefore must be considered according to processing conditions and final use of the finished product. This is best already established during the product specification process. Agreement between all parties involved must be reached about the chemical resistance test method, which may be performed in accordance with EN ISO 2812-1 „Lacquers and Paint Products. Test Methods for Surface Resistance to Liquids“. It is necessary to also have a common understanding of the requirements for such chemical resistance, such as test duration, test method, reactive time and concentration of the test media.

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. We warrant that our products are free of flaws and defects to the extent as stipulated in our Terms of Delivery and Payment.

As a part of our product information program each of our Product Data Sheets are periodically updated, so that the latest version shall prevail. Therefore, please contact our sales department to make sure that this Product Data Sheet is the most current version. The information in our Product Data Sheets is subject to change without notification.

This Product Data Sheet substitutes any and all previous Product Data Sheets and notes for customers published on this subject matter and is only intended to give a general product overview. Please request specific information for products outside of our standard product list (latest version).

The Technical Information Sheets and the Terms of Delivery and Payment each in their latest version form an integral part of this Product Data Sheet.



certified
according to
EN ISO 9001 / 14001

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