

## Surface Treatments

### ProCoat™ Color Powder Coated Ductwork



Custom coating applied to outside of duct. Refer to “ProCoat Plus” for performance information. ProCoat is an epoxy-based powder coating with an average thickness of 4 mils outside to meet or exceed 3,000 hour salt spray test per ASTM B117-97.

Powder coating uses 100% dry resin that is electrostatically applied to the surface and then baked in an oven to fuse the coating. The coating system used is manufactured by Tiger Drylac a zinc epoxy primer and a polyester/TGIC glossy top coat. A total finished film thickness of 4 mils (0.004 inches) on the outside of the ductwork is standard. ProCoat / ProCoat Plus shall have a minimum surface hardness of 2H when tested per ASTM D3363-92A with average thickness of 4 mils outside (ProCoat Plus inside and outside).

The powder coating is applied to the base metal after fabrication, however, the resulting ductwork is not free of scratches and other small areas of exposed metal. If touch up paint needs to be applied to repair minor damage to the coating, use a good automotive quality spray acrylic lacquer.

Green  Red  Blue  Black  Orange  Gray  White

RAL# \_\_\_\_\_

### ProCoat Plus™

ProCoat Plus uses the same technology as ProCoat, but is designed for environments requiring added protection or chemical resistancesystem. The coating system is manufactured by Tiger Drylac and is comprised of a Series 69 zinc epoxy primer and a Series 49 polyester/TGIC glossy white top coat. A total finished film thickness of 4 mils (0.004 inches) inside and 4 mils (0.004 inches) outside is standard.

#### **Coating Performance: Tiger Drylac Zinc rich primer 69/90350 + Tiger Drylac Series 49 glossy**

Film thickness	ISO 2409	4 mil (0.004 inch)
Cross cut tape resistance	ASTM D2247	B5
Humidity resistance 1,000 hour	ASTM B117	1 mm max. undercutting (no blistering)
Salt spray resistance 3,000 hour	ASTM D3258	1 mm max. undercutting (no blistering)
Porosity of Paint films	ASTM D523	non-porous
Gloss-60	ASTM D522	80 - 90+
Mandrel bending	ASTM D2794	≤ 3 mm
Impact test (80 in-lb)	ASTM B3363	no appearance of cracks
Pencil hardness		2H (minimum)