



TCITM
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WORLD MATTERS

TruDurance

Architectural Powder Coatings

AAMA 2604 **10000 Series**

AAMA 2605 **11000 Series**

1/25/2023

To Order: 800.533.9067 • 229.937.5411
For More Information: www.tcipowder.com

Specification Comparison Chart

Test Parameter	9000 Series AAMA 2603-22	10000 Series AAMA 2604-22	11000 Series AAMA 2605-22
	1-Year	5-Year	10-Year
Pretreatment	Multi stage cleaning and pretreatment system	Multi stage cleaning and pretreatment system, chrome and non-chrome	Multi stage cleaning and pretreatment system, chrome and non-chrome
Pretreatment Coating Weight	Non specified	Chrome 30mg/ft ² minimum	Chrome 40mg/ft ² minimum
Film Thickness	2-4 mils	2-4 mils	2-4 mils
Repairability	See film touch up and repair procedures		
Sealant Compatibility	Meet performance requirements of AAMA 800 sealant specification		
Hardness	H-2H	H-2H	H-2H
	Values represent TCI product characteristics		
Dry Adhesion	No loss of adhesion		
Wet Adhesion	No loss of adhesion		
Boiling Water Adhesion	No loss of adhesion		
Impact Resistance	No film removal on min. 3 mm deformation		
Abrasion Resistance	N/A	Abrasion coefficient \geq 20 min	Abrasion coefficient \geq 40 min
Muriatic Acid	No change after 15 minute spot test		
Mortar Resistance	No adhesion loss or appearance change after 24 hour pat test		
Nitric Acid Resistance	N/A	5 DE max color change after 30 minute vapor exposure	
Detergent	No change or adhesion loss after 72 hour immersion		
Window Cleaner	N/A	No change or adhesion loss after 24 hour spot test	
Humidity Resistance	1,500 hours: no more than "few" blisters size 8, figure #4 ASTM D 714	3,000 hours: no more than "few" blisters size 8, figure #4 ASTM D 714	4,000 hours: no more than "few" blisters size 8, figure #4 ASTM D 714
Corrosion Resistance	1,500 hours of salt solution: minimum rating of 7 on scribe or cut edges: minimum blister rating of 8 in the field (ASTM D 1654) ASTM D 714	1,500 hours of cyclic corrosion per ASTM G85, Annex 5: minimum rating of 7 on scribe or cut edges: minimum blister rating of 8 in the field (ASTM D 1654)	2,000 hours of cyclic corrosion per ASTM G85, Annex 5: minimum rating of 7 on scribe or cut edges: minimum blister rating of 8 in the field (ASTM D 1654)
Outdoor Resistance	1 year south Florida: maintain film integrity; no adhesion loss, slight chalking or fading	5 years south Florida: maintain film integrity; 5 DE (Hunter) maximum color change; chalking (ASTM D 4214) \leq 8; gloss retention \geq 30%; erosion resistance less than 10% film loss	10 years south Florida: maintain film integrity; 5 DE (Hunter) maximum color change; chalking (ASTM D 4214) \leq 8; gloss retention \geq 50%; erosion resistance less than 10% film loss

For more information please contact your TCI Sales Representative.

Product Formula Legend

First Number = Resin Type , 9801-1000 (example)

1 = Low Cure	7 = Epoxy
2 = Acrylic	8 = Urethane
3 = High Temperature	9 = TGIC Polyester
4 = Specialty	10 = Super Durable TGIC
5 = HAA (TGIC-Free)	11 = Fluoropolymer
6 = Hybrids	

Second Number = 60° Gloss Reading, 9801-1000 (example)


0 = 0-9	5 = 50-59
1 = 10-19	6 = 60-69
2 = 20-29	7 = 70-79
3 = 30-39	8 = 80-89
4 = 40-49	9 = 90+

Third Number = Cure Response, 9801-1000 (example)

Time at metal temp for full cure

0 = 12 min. @ 400° F	5 = 10 min. @ 300° F
1 = 10 min. @ 400° F	6 = 10 min. @ 275° F
2 = 10 min. @ 375° F	7 = 10 min. @ 250° F
3 = 10 min. @ 350° F	8 = Fast Cure - See TDS
4 = 10 min. @ 325° F	for recommended cure

Surface Type

	←	S Smooth
		T Textured
		A Anodized
		M Metallic

Fourth Number = Surface Appearance, 9801-1000 (example)

0 = Smooth	4 = Vein
1 = Metallic	5 = Hammertone
2 = Sand	6 = Multi-Color
3 = Orange Peel	7 = Wrinkle

Fifth Series = RAL Color System, 9801-1000 (example)

0 = Clears & Metallics	5 = Blues
1 = Yellows & Beiges	6 = Greens
2 = Oranges	7 = Grays
3 = Reds	8 = Browns
4 = Violets	9 = Blacks and Whites

Extension = Fill Size, 9801-1000-BX55 (example)

-BX25 = 25lb. Box
-BX50 = 50lb. Box
-BX55 = 55lb. Box

**Alternate fill sizes may be available, reach out to your local sales representative to learn more*



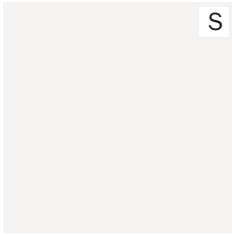
TCI's TruDurance architectural powder coatings have outstanding long-term durability, including excellent color and gloss retention. In addition, these products exhibit impressive corrosion, mar, and scratch resistance as well as over-bake stability on the applicators line. Our products are environmentally responsible and offer a great alternative to other coating options. The 10,000 series products are AAMA 2604 quality, 11,000 series are AAMA 2605 and products can be matched in TGIC-free chemistry at your request. TCI also offers quick turnaround times on color matches and small batch orders.



For more information please contact your TCI Sales Representative.

Matching AAMA 2604 & 2605* Colors

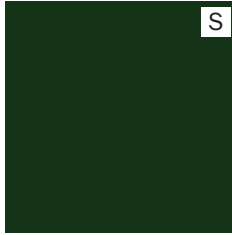
Product Name
AAMA 2604 Code
AAMA 2605 Code
Gloss Range



White
10710-91840-BX55
11710-92950-BX55
65-75



Redwood II
10410-30668-BX55
11410-30698-BX55
40-49



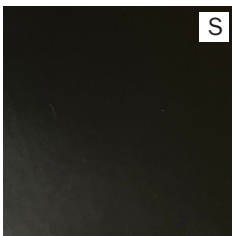
Holly Green II
10410-62009-BX55
11410-62073-BX55
40-49



MR GW Bronze
10310-82279-BX55
11210-82371-BX55
25-35



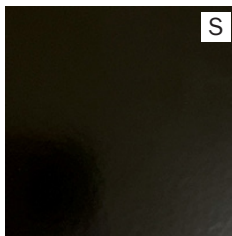
Earthtone
10410-81103-BX55
11410-81963-BX55
35-45



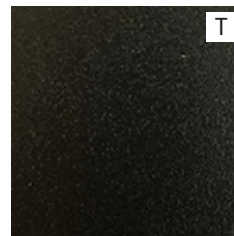
Resemble Black
10010-93613-BX55
11010-93562-BX55
9-15



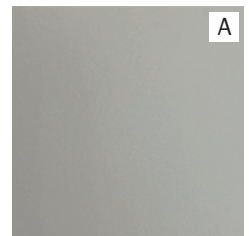
Dark Bronze
10410-81104-BX55
11410-81999-BX55
35-45



Coal Black II
10410-92910-BX55
11510-92940-BX55
44-55

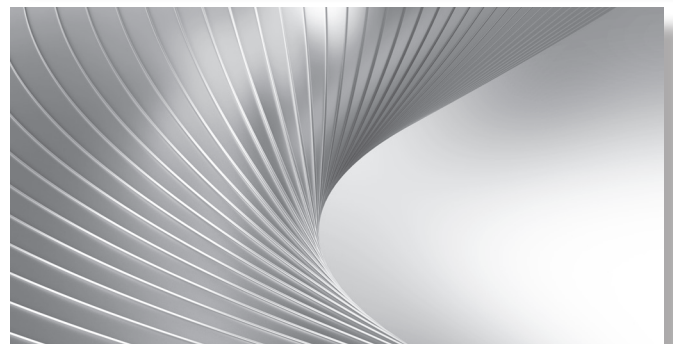


Black Tex
10012-91616-BX55
11012-91468-BX55
3-7



Bonded Anodized Silver
10211-02558-BX55
11311-02559-BX55
20-35

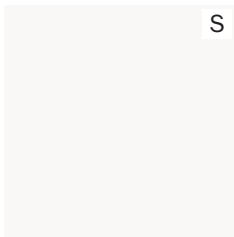
*Non-bonded 2605 orders up to 275lbs have a 10 working day turnaround time



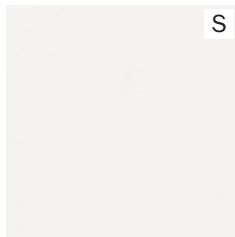
This digital color card is for reference only and variations between colors shown here and the actual product may exist.
Please reach out to your TCI Sales Representative for product samples.

AAMA 2604 Colors

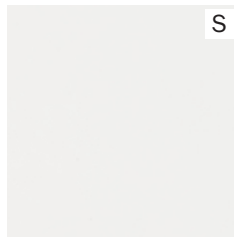
Product Name AAMA 2604 Code Gloss Range



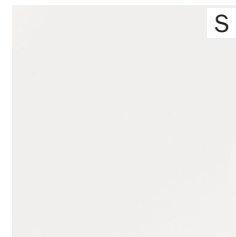
AB White
10810-93259-BX55
75-85



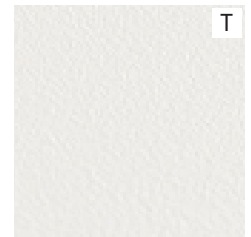
KL HG White
10820-93171-BX55
85-95



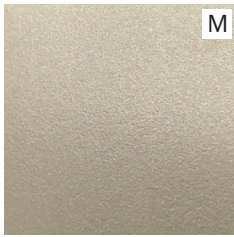
Bone White
10310-91095-BX55
35-45



MR GW White
10610-93471-BX55
60-69



KL White Tex
10022-93172-BX55
3-5



Anodized Champagne LR
100110-01993-BX55
5-10



Satin Creme
10410-12088-BX55
40-49



Tan II
10510-13476-BX55
45-55



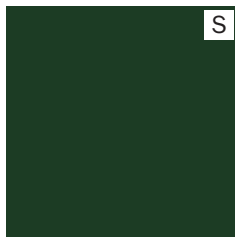
Beige
10610-12080-BX55
60-69



Toffee
10510-81101-BX55
45-55



Teal
10310-61545-BX55
30-39



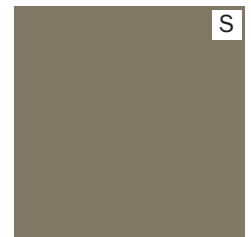
Moss Green
10310-62208-BX55
30-39



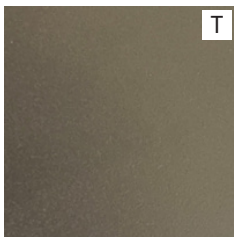
Bonded Grey Metallic III
10511-02370-BX55
50-60



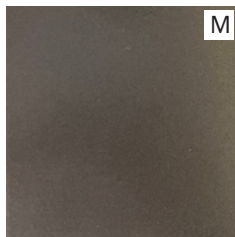
7500N Grey
10310-72798-BX55
30-39



Slate Grey
10410-74084-BX55
35-45



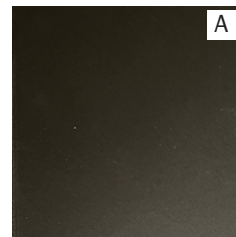
Bonded Tex Bronze
10021-02630-BX55
5-10



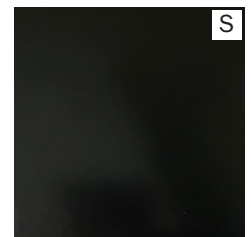
Bonded MR Bronze
10421-02272-1-BX55
30-40



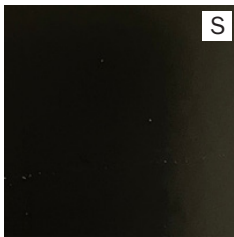
AB Bronze
10210-82186-BX55
20-29



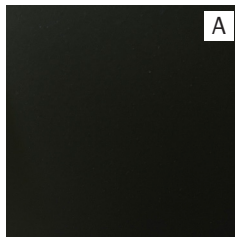
Anodized DK Bronze
10010-82174-BX55
3-5



MR Satin Black
10620-92514-BX55
60-69



Matte Black
10410-92435-BX55
30-40



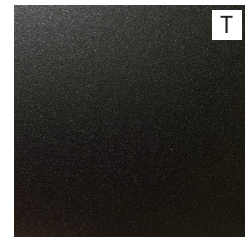
Anodized Black
10010-93242-BX55
3-5



SG Fence Black
10410-93175-BX55
35-45



Black Pearl
10610-93628-BX55
60-69

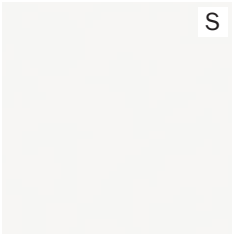


Black Mountain Tex
10012-93130-BX55
5-10

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AAMA 2605* Colors

Product Name
AAMA 2605 Code
Gloss Range



Sky White II
11710-92256R-BX55
70-80



New Bone White
11510-92253R-BX55
50-59



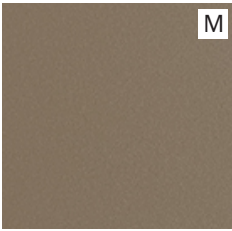
Light Breeze
11410-13543-BX55
40-49



Delrey Beige
11410-13663-BX55
40-49



Dalco Desert
11410-13639-BX55
40-49



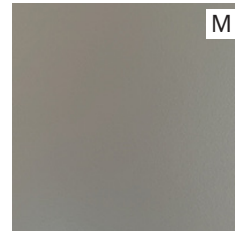
Golden Bronze
11211-02657-BX55
20-30



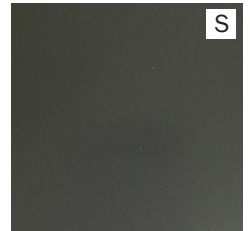
SG Brown
11410-82341-BX55
40-49



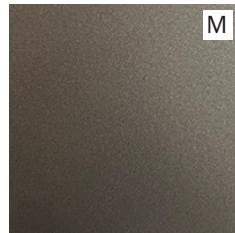
UVC Cabinet Grey
11710-71895-BX55
70-75



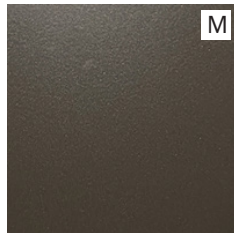
Bonded Sterling Metallic
11321-02758-BX50
35-45



Black Grey
11410-74541-BX55
40-49



Bonded Charcoal Metallic
11411-02613-BX55
35-45



Sunstorm Bronze
11311-02881-BX55
30-40



KL Bronze Tex
11011-02574-BX55
3-6

*Non-bonded 2605 orders up to 275lbs have a 10 working day turnaround time















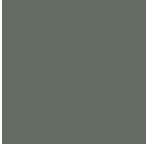




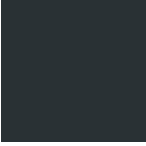
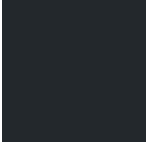








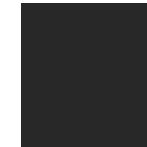






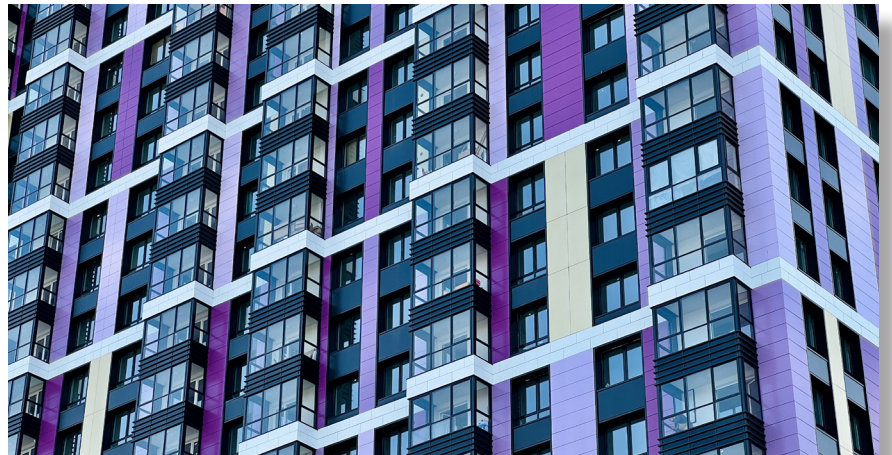
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Stock AAMA 2604 RALs

RAL Number
Product Name
Product Code

These RAL products meet the AAMA 2604 specification. Stock options subject to change, please check with your local TCI sales representative for MTO lead times.

							
RAL 1019 Green Beige 9840-11916R-BX25	RAL 3005 Wine Red 9840-30191R-BX25	RAL 3009 Oxide Red 9840-30211R-BX25	RAL 5001 Green Blue 9840-50936R-BX25	RAL 5004 Black Blue 9940-50971R-BX25	RAL 5005 Signal Blue 9840-50920R-BX25	RAL 5008 Grey Blue 9840-50948R-BX25	RAL 5009 Azure Blue 9840-50910R-BX25
							
RAL 5017 Traffic Blue 9840-50955R-BX25	RAL 5019 Capri Blue 9840-50915R-BX25	RAL 5020 Ocean Blue 9840-50914R-BX25	RAL 5021 Water Blue 9840-50912R-BX25	RAL 6003 Olive Green 9840-61312R-BX25	RAL 6004 Blue Green 9840-61271R-BX25	RAL 6013 Reed Green 9840-61314R-BX25	RAL 6021 Pale Green 9840-61279R-BX25
							
RAL 7004 Signal Grey 9840-72034R-BX25	RAL 7005 Mouse Grey 9840-72045R-BX25	RAL 7006 Beige Grey 9840-71973R-BX25	RAL 7009 Green Grey 9840-72097R-BX25	RAL 7010 Tarpaulin Grey 9840-72096R-BX25	RAL 7012 Basalt Grey 9840-72011R-BX25	RAL 7013 Brown Grey 9840-72008R-BX25	RAL 7015 Slate Grey 9840-71996R-BX25
							
RAL 7016 Anthracite Grey 9840-72121R-BX25	RAL 7021 Black Grey 9840-72122R-BX25	RAL 7022 Umbra Grey 9840-71995R-BX25	RAL 7023 Concrete Grey 9840-72106R-BX25	RAL 7024 Graphite Grey 9840-72053R-BX25	RAL 7031 Blue Grey 9840-72112R-BX25	RAL 7037 Dusty Grey 9840-72007R-BX25	RAL 7039 Quartz Grey 9840-71972R-BX25
							
RAL 7042 Traffic Grey A 9840-71994R-BX25	RAL 7043 Traffic Grey B 9840-72047R-BX25	RAL 8019 Grey Brown 9840-81018R-BX25	RAL 8022 Black Brown 9840-81054R-BX25	RAL 8025 Pale Brown 9840-80985R-BX25	RAL 9004 Signal Black 9840-91793R-BX25	RAL 9005 Jet Black 9940-91748R-BX25	RAL 9006 White Aluminum 9841-01492R-BX25
							
RAL 9007 Grey Aluminum 9841-01493R-BX25	RAL 9011 Graphite Black 9840-91747R-BX25	RAL 9017 Traffic Black 9840-91743R-BX25					



TCI's RAL products have been matched to original RAL color master standards. They have a gloss range of 80-95° and are packaged in 25 lb. containers.

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9000 Series

AAMA 2603 Specification

TCI 9000 Series Polyester Systems have the broadest formulating range in color and gloss, and many will meet or exceed AAMA 2603 performance requirements. Products in this series have a 60° gloss range of 5-90° + and meet many decorative and functional requirements for chemical resistance, physical properties, color, gloss, and weatherability. High chroma colors are also available. Typical uses include aluminum extrusions, playground equipment, agricultural equipment, and machinery.



10000 Series

AAMA 2604 Specification

The TCI 10000 Series Superior Exterior Performance Polyester Systems are formulated to meet the requirements of the AAMA 2604 specification. Products in this series have a 60° gloss range of 5-90° + and are available in a wide selection of colors. Proper chrome or non-chrome pretreatment is critical for product performance. Chromium Chromate or chromium phosphate coating weights should be a minimum of 30 mg/ft². Alternative chrome and/or non-chrome conversion coatings should be maintained according to supplier's recommendations. A TCI technical representative must audit each application system to ensure products will meet the 2604 specification.



11000 Series

AAMA 2605 Specification

The TCI 11000 Series Highest Exterior Performance Organic Systems are formulated to meet the requirements of the AAMA 2605 specification. Products in this series, with the exception of anodized products, have a 60° gloss range of 25-70° + and are available in many colors. Proper amorphous chromium phosphate or amorphous chromate pretreatment is critical for product performance. Chromium chromate or chromium phosphate coating weights should be a minimum of 40 mg/ft². Alternative chrome and/or non-chrome conversion coatings should be maintained according to supplier's recommendations. A TCI technical representative must audit each application system to ensure products will meet the 2605 specification.



TruDurance

TCI Certified Applicator

TCI field technicians are trained to audit all aspects of the powder coating operation to determine the customer's ability to achieve AAMA requirements. TCI runs a variety of tests that evaluate the performance of our powder coatings in the customer's process and continues with bi-annual renewal audits to ensure the process parameters have not changed without notification. For TCI Certified Applicators, warranties are available for 2603, 2604, and 2605 applications.



300 Martin Marietta Drive, Americus, GA 31719

1/25/2023 Phone: 800.533.9067 Fax: 800.265.0404 Web: www.tcipowder.com