

Series 512 – Primer for MDF

HIGHLY REACTIVE POWDER COATING FOR THE FUNCTIONAL BASE COATING OF MDF AND OTHER WOOD MATERIALS

Typical application

Industrial coating of MDF (medium density fiberboard) and other heat sensitive wood and composite materials.

Product details

Standard Packaging	In original boxes of 20 kg each
Specific Gravity (ISO 8230-2)	1.4 - 1.6 g/cm ³ depending on pigmentation
Theoretical Coverage	at 90 µm coating thickness 7 - 8 m ² /kg depending on density, see guideline no.1072
Storage Stability	6 months from date of production under dry conditions at no more than 20 °C, avoid direct and extended heat exposure
Solid Content	100 %

Features

- highly reactive functional base coat
- very good mechanical properties
- very good elasticity
- very good filler properties
- good chemical resistance

Finish | Colors

- micro texture

Surface textures depend on powder coating formulation and may be influenced slightly by oven temperature settings. Custom colors are available after inquiry.

Safety

Safety instructions can be found in the material safety data sheet.

Pre-treatments

All surfaces to be coated should be free of dust and grease. The substrates should be pre-treated in an appropriate way to achieve optimum surface texture and adhesion. MDF and other wood materials should be carefully routed and sanded and possibly thermo-smoothened. Generally, the pre-treatment has to be individually checked in suitability tests.

MDF substrates should be electrically conductive to a certain degree allowing electrostatic powder application. Usually an electrical surface resistance of $10^{10} - 10^{11} \Omega/\square$ will be sufficient. In case the substrate material is not sufficiently conductive the coatability can be adjusted in many cases by a pre-heat process.

Jigging

The MDF is electrically grounded by the hook. It is important that the electrical contact between hook and MDF is well controlled.

TIGER Drylac® Wood Dual System

For achieving ideal and crack-free MDF coating qualities the TIGER Drylac® Wood Dual System is recommended. A primer powder coating of Series 512 and a topcoat powder coating of Series 530 define the TIGER Drylac® Wood Dual System. Both powder coatings are chemically matched to each other achieving a very good intercoat adhesion. The following coating thickness is advised:

- Primer Series 512: 90 – 130 µm
- Top-Coat Series 530: 60 – 90 µm

It is advised to always use the TIGER Drylac® Wood Dual System with Series 512 Primer, as the primer base layer is necessary in order to achieve an optimal edge cracking resistance in dual-layer applications. When applying TIGER Drylac® Wood Dual System it is generally advantageous not fully curing the base primer layer before overcoating with the top-coat. Depending on production line design the curing process has to be defined and adjusted case by case in order to achieve blister- and crack-free coating qualities.

Powder application

Corona guns with electronic control are used most commonly. The powder application should be performed using automatic guns, counter electrodes and substrate scanning systems. The applied coating thickness should be controlled within small tolerances.

Curing conditions

Depending on process and oven design different curing times may be reached. The here mentioned values are indicators only and have to be verified on the actual coating line. Due to the poor thermal conductivity of MDF, curing by IR ovens will lead to best results. Pure convection heat ovens did not prove suitable for MDF powder coating. The temperature values given here indicate the temperatures on the surface of the MDF or the actual temperature of the powder coating layer itself (object temperature):

- minimum 5 min dwell time at 135 °C or
- minimum 3 min dwell time at 150 °C

The curing conditions have to be controlled carefully on all sides of the MDF including the edges as resulting surface quality depends strongly on the degree of cure. Insufficiently cured powder coatings are brittle and tend to crack. Exceptional risk of cracks exists on the edges and routings especially during moisture treatment and swelling of the wood materials. Such type of cracks may sometimes occur after several months of use. For measurement of the degree of cure chemical resistance tests are not fully suitable and only of limited use. In addition to surface quality testing according to furniture standards, it is advised to perform additional moisture and aging tests on coated substrates containing drill holes for construction. Because of the manifold of wood materials and various oven technologies the detailed curing conditions have to be exactly defined case by case.

Primer application for liquid lacquering

TIGER Drylac® Series 512 may also be used as primer for liquid lacquering processes. For that purpose Series 512 has to be fully cured. The liquid lacquer can be applied directly on top of Series 512 or after sanding.

The resulting qualities have to be tested case by case according to valid standards. The suitability for the target application has to be tested carefully.

MDF Quality

MDF qualities have to be tested for suitability for the powder coating process. Properties such as thermal stability, density, density profile, internal bond strength, moisture content, type of binder and type of wood fiber play a crucial role. These properties have to be adjusted to the curing technology. Excessive thermal stress of the MDF during the coating process may cause edge cracking. Thermally damaged MDF may show edges cracking even several months after production. Depending on the application of the coated part, it is advised to use MDF qualities with low water swelling behavior to avoid edge cracking. Edge or surface cracking can be caused by dimensional changes due to moisture uptake from the surroundings.

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