

# Product Data Sheet

## AkzoNobel Powder Coatings

### Interpon Woodcote UV

#### Product Description

Interpon Woodcote UV is a range of ultra violet curing polyester powder coatings, which have been designed for use as finish coat for engineered wood products, specifically MDF. The product provides a tough durable alternative to the organic coatings, paper foils and vinyl laminates currently used for MDF. Interpon Woodcote UV powders are available in a range of gloss, colours and special finishes or can be matched to the users requirements.

#### Powder Properties

<b>Chemical type</b>	Polyester
<b>Particle Size</b>	Suitable for electrostatic spray
<b>Specific gravity</b>	1.2-1.7 g/cm <sup>3</sup> depending on colour
<b>Storage</b>	Dry cool conditions below 25°C
<b>Shelf life</b>	3 months
<b>Stoving schedule</b> (object temperature)	The powder is subjected to an IR heat source until the powder has melted and flowed to the desired level. It is then passed under a high intensity UV lamp. The lamps are typically mercury (H) lamps for clearcoats 1500 - 2000mJ/cm <sup>2</sup> (UV - A) and doped (V or D) lamps for pigmented 2000mJ/cm <sup>2</sup> (UV - A)

#### Test Conditions

The results shown below are based on mechanical and chemical tests which (unless otherwise indicated) have been carried out under laboratory conditions and are given for guidance only. Actual product performance will depend upon the circumstances under which the product is used.

<b>Substrate</b>	18mm Medium Density Fibreboard
<b>Preconditioning</b>	30 pecs LWIR
<b>Film Thickness</b>	75 µm
<b>Stoving Schedule</b>	60 seconds melt under IR followed by a high intensity UV lamp to cure

#### Mechanical Tests

<b>Adhesion</b> (2mm Crosshatch)	BS3962: Part 6: 1980 ATSM D3359-95	4 – 5 4B - 5B
<b>Pencil Hardness</b> (gouge)	ASTM D3363-92	>4H
<b>Taber Abrasion</b>	ASTM D4060-95	No exposure at 2000 cycles Weight loss @ 1000 cycles <70mg

#### Chemical and Durability Tests

<b>Solvent Resistance</b>	MEK double rubs	50 No softening
<b>Cleanability/ Stain Resistance</b>	DIN68861	Test 1 Pass Group B – working surface (excluding kitchen worktops)
<b>Distilled Water Immersion</b> (240 hours)	BS3900-F7	Not recommended for exterior use

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## Pre-treatment

The MDF is not subjected to any chemical pretreatments. The use of heat prior to application provides an even earthing of the substrate for deposition of the powder. Infra-Red and convection heat can be used. The MDF board is typically heated for 1 to 3 minutes depending on the thickness of the MDF. The surface temperature of the board should be in the range of 60-75°C if the board is overheated it will have poor application properties, typically low film build or no edge coverage. The edge of the board may display cracking if it is overheated or contains too high a level of moisture so the temperature or duration should be decreased until it does not occur.

### MDF machining

MDF surfaces to be coated must be clean and free from dust. The edges of the board are typically routed to produce rounded edges and the surface of the board is sanded to give a smooth finish.

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## Application

Interpon Woodcote UV powders can be applied by manual or automatic electrostatic spray equipment. Unused powder can be reclaimed using suitable equipment and recycled through the coating system.

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## Additional Information

There are many suppliers and types of MDF grades available and it is therefore advisable for the end user to determine which will produce the optimum results on the equipment available to them. As a guide the grades most suitable have a minimum density of 750Kg/m<sup>3</sup> and moisture content of 6-8%.

For further details on powder properties and film performance of Interpon Woodcote UV please contact AkzoNobel.

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## Safety Precautions

Please consult the Material Safety Datasheet (MSDS)

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## Disclaimer

**IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.**

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