

## Product information

### Melamine faced chipboards Priming Film | Coating Recommendation

Melamine faced chipboards with primer film is a high-quality melamine coating that provides a surface prepared for subsequent lacquering.

Our primer films consist of base papers that are impregnated with special resin formulations.

#### **Melamine faced chipboards with primer film (W10700 / W10760)**

W10700 / W10760 are particularly suitable for nitro, SH and wet-on-wet lacquering. The dense surface of the melamine faced chipboards with W10700 / W10760 enables the lacquered structure to dry at high temperatures with intensive drying without bubble formation on the surface substrate. This results in a very high throughput speed and a corresponding economic efficiency of the lacquering systems.

Pfleiderer recommends cleaning by sanding with 280 grit or cleaning the surfaces with suitable solvents before lacquering. A pre-priming coat is not necessary.

For the lacquer types nitro combination lacquers, SH lacquers and PUR lacquers, application rates of 80 - 200 g/m<sup>2</sup> have proven successful.

#### **Melamine faced chipboards primer film (W10701)**

W10701 is a board with a special paint-active finish with a satin matt surface (SM) suitable for all paint systems. It is the "brush-ready" board for the craftsman with good machining and sanding properties, which are particularly suitable for paint lines with light pre-priming. If possible, the board should be pre-sanded with 280 - 320 grit.

In order to achieve an excellent lacquer surface with low lacquer application quantities, Pfleiderer recommends a light pre-priming with approx. 10 - 20 g/m<sup>2</sup> in the roller process and a lacquer application quantity of 80 - 200 g/m<sup>2</sup> pigmented lacquer for nitro combination lacquers, SH lacquers and PUR lacquers.

To obtain an even higher mechanical resistance (e.g. ring resistance), a colourless top coat with 50 - 80g/m<sup>2</sup> application quantity is recommended. A "wet on wet" lacquer application is particularly favourable.

Melamine faced chipboards with W10701 is suitable for polyester lacquers. Polyester lacquers are mostly used for high gloss effects. Due to the high layer thickness, it is absolutely necessary to coat all surfaces with polyester on both sides to prevent warping. The required application quantities are: 20 - 30 g/m<sup>2</sup> rollers, or pour 60 - 80 g/m<sup>2</sup> contact base, followed by 150 - 400 g/m<sup>2</sup> top coat.

## Melamine medium-density fibreboard - MDF (lacquering of edges and cut-outs)

MDF allows efficient, direct lacquering of the edges or the profiled areas. In any case, however, a special PUR lacquer (insulating primer) must be applied to the edges and milled-out areas.

Insulating fillers have also proven their worth in MDF pre-coating. The insulating fillers insulate and fill the MDF workpiece in only one work step. The colourless insulation process is no longer necessary.

This pigmented insulating primer has several tasks:

- It binds the wood fibres and thus prevents the fibres from standing up during subsequent lacquering.
- Furthermore, it closes the pores of the surface. This increases the water vapour diffusion resistance and thus improves the dimensional stability of the panel.
- Likewise, the insulation prevents the subsequent primer from „skimming“.  
If a larger part of the filler-binder is absorbed by the panel, the lacquer layer has less elasticity. A brittle lacquer layer with little binder cannot accommodate a dimensional change caused by climate change, and edge lacquer cracks develop.

To avoid edge lacquer cracks, 100 - 200 g/m<sup>2</sup> PUR insulation should be applied to the edges and profiled areas. It should be noted that this lacquer penetrates deep into the board. The PUR insulation can be sanded with 240 - 280 grit after 4 hours drying time at 20° C.

The filler (application quantity approx. 200 - 250 g/m<sup>2</sup>) has the task of creating a smooth surface. The filler should be sanded with 280 - 320 grit and should not be done before 5 hours drying time at 20° C. Better results are achieved if the drying time is overnight (at least 12 hours). The final coat is applied according to the finish on the surface.

### We recommend that the following basic rules be observed:

- The surface to be painted must be clean, free of grease, silicone, wax and dust.
- First make a processing sample
- All priming films must be sanded before application to roughen and clean the surface.
- Please observe the processing recommendations of the lacquer manufacturers. We recommend coordinated lacquer systems / components.
- Ensure the necessary personal protective equipment (e.g. dust masks) and sufficient ventilation.

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