

Interpon Woodcote T

Product Description: **Interpon Woodcote T** is a series of epoxy/polyester hybrid powder coatings, which have been designed for use as finish coat for engineered wood products, specifically MDF. The product provides an alternative to the organic coatings, paper foils and vinyl laminates currently used for MDF. A decorative finish can be produced, with excellent stain resistance to general household materials.

Interpon Woodcote T powders are available in a range of colours and special finishes or can be matched to the user's requirements.

Powder Properties:	Chemical type	Epoxy/Polyester
	Particle size	Suitable for electrostatic spray
	Specific gravity	1.2-1.7 g/cm ³ depending on colour
	Storage	Dry cool conditions below 25°C
	Shelf life	3 months
	Sales Code	F-series
	Stoving schedule (Air temperature)	10 – 15 minutes at 140°C

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.

Substate	18mm Medium Density Fibreboard
Pre-conditioning	3 mins at 120°C (convection)
Film Thickness	75 µm
Stoving	10 minutes at 140°C (air temperature)

Mechanical Tests:	Adhesion	BS EN ISO2409	Gt 0 (2mm Crosshatch)
	Hardness	BS EN ISO1518 (2000grams)	Pass - no penetration to the substrate
	Impact	BS3900-E3	2.5mm

Chemical and	Solvent Resistance	MEK double rubs	20 slight softening
	Stain Resistance	24 hours	generally excellent resistance to coffee, tea blackcurrent juice, olive oil, ketchup and mustard
	Exterior Durability		not recommended for exterior use
	Colour Stability at elevated temperatures		Good – satisfactory up to 125°C

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Pretreatment: 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 3–6 minutes depending on the thickness of the MDF. 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. 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.

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. The application of powder onto right angles is not recommended, as they tend to “dry out” in the conditioning stage and result in poor application performance.

Application: **Interpon Woodcote T** 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.

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/m³ and moisture content of 8-10%.

For further details on powder properties and film performance of **Interpon Woodcote T** please contact Akzo Nobel.

Safety Precautions: When using do not eat, drink or smoke. Do not breathe the dust. In case of insufficient ventilation wear suitable respiratory equipment. For further information please refer to the specific product Material Safety Data Sheet (MSDS).

Disclaimer: The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this 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. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.