

Product Datasheet



BU Powder Coatings Interpon Woodcote

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Product Description

Interpon Woodcote is a low temperature cure powder coating designed for use as a finish coat for heat sensitive substrates such as medium density fibreboard (MDF). The product provides an alternative to organic coatings, paper foils and vinyl laminates currently used for MDF. **Interpon Woodcote** is especially suited for domestic and commercial furniture applications (excluding kitchen worktops) and meets the performance requirements of International Standards including FIRA 6250 and DIN 68861.

Interpon Woodcote powder coatings are available in a range of colours and special finishes or can be matched to the user's requirements. **Interpon Woodcote** powder coatings are designed for internal applications only.

Powder properties*

Chemical type	Low Bake Epoxy
Particle size	Suitable for electrostatic spray
Specific gravity	1.2-1.7 g/cm ³ depending on colour
Storage	Dry cool conditions below 20°C
Shelf life	6 months
Sales Code	B-series
Stoving schedule	10 minutes at 120°C (surface temperature)

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.

Substrate	18mm Medium Density Fibreboard
Pre-conditioning	3 mins at 170°C (air temperature)
Film Thickness	100 - 120 µm
Stoving	12 minutes at 170°C (air temperature)

Performance Results*

Adhesion	AS/NZS 1580.408.4 (2mm Crosshatch)	Class 0
Chemical Resistance	DIN EN 12720	

Test Solution	Test Period	Result
Acetone	10 sec	5
	1 hr	4
Acetic acid	1 hr	5
Ethanol	1 hr	5
Disinfectant	24 hr	5
Ammonia (10%)	24 hr	5
Red Wine	24 hr	5
Coffee	24 hr	5
Blackcurrant Juice	24 hr	5
Detergent	24 hr	5

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AkzoNobel Coatings Ltd
686 Rosebank Road
Avondale Auckland 1007
New Zealand
Ph: 0800 801 342
Fax: 0800 809 679
Email: salesnz@Interpon.com
Web: www.Interpon.co.nz

AkzoNobel Pty Limited
51 McIntyre Road
Sunshine Victoria 3020
Australia
Ph: 1800 630 516
Fax: 1800 650 786
Email: salesoz@Interpon.com
Web: www.Interpon.com.au

Interpon
powder coatings
EVERY COLOR IS GREEN

Hardness	AS/NZS 1580.405.1	Pass F
Impact Resistance	AS 1580.406.1	Pass 5 Nm
Abrasion Resistance	DIN 68861-2	2B
Scratch Resistance	DIN 68861-4	4A
Dry Heat Resistance	DIN EN 12722	200°C, Rating 4 180°C, Rating 5
Wet Heat Resistance	DIN EN 12721	100°C, Rating 5

Pre-treatment

The MDF is not subjected to any chemical pre-treatment. The use of heat prior to application provides an even "earthing" of the substrate for deposition of powder coating. 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 75-85°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 D1000 powder coatings can be applied by manual or automatic electrostatic spray equipment.

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 750 kg/m³ and moisture content of 6-10%.

Interpon Woodcote is formulated to cure at low temperatures. As such the powder is more reactive than standard powder coatings and must be kept below 20°C during storage and use. Exposure to temperatures in excess of 25°C can cause the powder to cake. The use of heat-affected powder may give rise to changes in appearance and performance of the cured film. For further details on powder coating properties and film performance of **Interpon Woodcote** please contact your local Akzo Nobel sales office.

Safety Precautions

This product is intended for use only by professional applicators in industrial environments and should not be used without reference to the relevant health and safety data sheet, which AkzoNobel has provided to its customer. If for any reason a copy of the relevant health and safety data sheet is not immediately available the user should contact AkzoNobel to obtain a copy before using the product. Minimum safety precautions in dealing with all powder coatings are as follows. All dusts are respiratory irritants. Therefore, inhalation of the dust or of the vapors resulting from the cure should be avoided. Take steps to prevent skin contact, but should contact occur, wash skin with soap and water. In case of eye contact flush immediately with clean water and seek medical advice. Dust clouds of any finely divided organic material can be ignited with an electric spark or open flame. Dust and powder should not be allowed to build up on surfaces or ledges. Dust collection equipment should be used which has provision for adequate explosion release. All equipment should be electrically earthed to prevent build up of static. Users are recommended to follow the guidelines laid down in AS3754:1990, "Safe Application of Powder Coatings by Electrostatic Spraying".

Disclaimer

Unless otherwise agreed by us in writing, any contract to purchase products referred to in this brochure and any advice which we give in connection with the supply of products are subject to our standard conditions of sale. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

* Typical minimum specifications. Performance may vary slightly between individual products.

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New Zealand
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Fax: 0800 809 679
Email: salesnz@[Interpon.com](mailto:salesnz@Interpon.com)
Web: www.Interpon.co.nz

AkzoNobel Pty Limited
51 McIntyre Road
Sunshine Victoria 3020
Australia
Ph: 1800 630 516
Fax: 1800 650 786
Email: salesoz@[Interpon.com](mailto:salesoz@Interpon.com)
Web: www.Interpon.com.au

