

Unique Technology. Outstanding Color. Lasting Results.

MDF POWDER COAT PERFORMANCE DATA:

Shrinkage and Heat Resistance	KCMA 9.1	Delta E of up to 1.5 units
Hot and Cold Check Resistance	KCMA 9.2	No effect
Chemical Resistance	KCMA 9.3	No effect under vinegar, lemon juice, orange juice, catsup, coffee, olive oil, 100% proof alcohol, detergent, and mustard.
Crosshatch Adhesion	ASTM D3359	5B
Humidity Test	ASTM D2247-94	No change after 2,000 hours
QUV	ASTM G-53-88	No gloss or color change after 1,000 hrs exposure
Pencil Hardness	ASTM D3363	2H (scratch) 6H (gouge)
Hoffman Scratch	MPTM	Pass 500-70
Taber Abrasion Resistance	NEMA LD3-3.13	90 to 120 mg / 100 cycles
Solvent Resistance	MEK, 50 double rubs	No effect
Boiling Water	Nema LD3 3.5	No effect
Heat Aging	MPTM	No effect

APPLICATION PARAMETERS:

Substrate MDF Application:	Corona
Spray Coating Thickness:	2 to 8 mils (measured by Tooke Gauge)
Cure Conditions:	Dwell times of 5 to 15 minutes depending on oven type and temperature settings. Typically, part temperatures do not exceed 270°F.

CLEANABILITY/STAIN TEST:

Coffee	Nema LD3 3.4	No effect
Household Detergent	Nema LD3 3.4	No effect
VM&P Naphtha	Nema LD3 3.4	No effect
Tea	Nema LD3 3.4	No effect
Grape Juice	Nema LD3 3.4	No effect
Ink Felt Pen, (non-perm black)	Nema LD3 3.4	No effect
Citric Acid Solution	Nema LD3 3.4	No effect
Household Ammonia (non-sudsing)	Nema LD3 3.4	No effect
Vegetable Cooking Oil	Nema LD3 3.4	No effect
Mustard	Nema LD3 3.4	No effect
Catsup	Nema LD3 3.4	No effect

NOTE: Powder Coatings may vary depending on board quality and process conditions.

For more information contact us at:

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