

innovus[®]

Coloured MDF



Recommendations & instructions for lacquering Innovus Coloured MDF

RECOMMENDATIONS BEFORE LACQUERING

Innovus Coloured MDF is delivered with smooth surfaces, sanded with a 150 grain. If there is a very high quality demand, e.g. as in lacquering, we recommend to sand the boards with a grain of 150 and reground with a 180 or 220 grain.

Before lacquering please consider:

• Deviations in colour are unavoidable due to production-related reasons, so it is important to consider possible deviations between production

batches and thicknesses. Assess the colour deviation and decide if the material can be mixed in the same production.

- Despite the use of light-fast pigments in Innovus Coloured MDF, direct irradiation of sunlight can cause discoloration (colour changes) of the fibres.
- Avoid harsh edges - edges should be rounded if possible.

GENERAL LACQUERING INSTRUCTIONS

Please consider the following generic lacquering instructions:

- All commercially available lacquers and waxes that are recommended for MDF applications can also be used in Coloured MDF.
- Excessive dilution and/or incorrect dosage (grammage) of the lacquer can lead to a negative lacquering result.

- Before lacquering, please ensure that the surface is completely free of grease, silicone and dust.
- In general, it is recommended to undertake a lacquering test to check conditions before start production.
- The best results will be achieved when lacquering crosswise and lengthwise (as a cross).

PROPERTIES



EASY TO MILL



LOW EMISSIONS



LIGHT RESISTANT



PERFECT LACQUERING



FORMALDEHYDE-FREE

RECOMMENDED PROCEDURE TO BE FOLLOWED WHEN LACQUERING

Isolating (especially on the edges):

A thorough isolation can prevent the board itself and the edges from cracks in the lacquer later on. It is also recommended to repeat the work process after an intermediate grinding.

Priming:

The isolation is followed by applying a priming coat with the corresponding intermediate grinding. For high quality surfaces it is recommended to repeat the priming coat after another intermediate grinding.

Final lacquering:

After the grinding of the priming coat, the final lacquer can be applied crosswise and lengthwise.

There are numerous different lacquers suitable for Innovus Coloured MDF. In general the processing instructions of the coating-manufacturer should be followed!

Innovus Coloured MDF

LACQUERING RECOMMENDATIONS BY LACQUER SUPPLIERS

LACQUERING WITH PRODUCTS BY HESSE LIGNAL



HIGH GLOSS LACQUERING

SANDING
180 grain

APPLY PRIMER
Hesse PUR-Grund DG 4717-0005 (pure priming)
Mixing ratio 5: 1 with hardener DR 4070

DRYING AND SANDING
320 grain

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Hesse PUR-Grund DG 4717-0005 (pure priming)
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DRYING AND SANDING
320 grain

APPLY PRIMER
Hesse PUR-Grund DG 4717-0005 (pure priming)
Mixing ratio 5: 1 with hardener DR 4070

LACQUER GRINDING
500 grain

APPLY PURE COATING LACQUER
Hesse PUR-Schichtlack DE 42599
Mixing ratio 10 : 1 with hardener DR 4070

DRYING

MATT LACQUERING

SANDING
180 grain

APPLY PRIMER
Hesse PUR-Schichtlack DE 45002
Mixing ratio 10 : 1 with hardener DR 4070

DRYING AND SANDING
400 grain

APPLY PURE COATING LACQUER
Hesse PUR-Schichtlack DE 45002
Mixing ratio 10 : 1 with hardener DR 4070

DRYING

LACQUERING WITH PRODUCTS BY 3H-LACKE



HIGH GLOSS LACQUERING

SANDING
180 grain

APPLY PRIMER
R 421 DD priming for isolation – 100%
RLH 6529 hardener – 50%
V 768 delayer – 30%

DRYING AND SANDING
400 grain

APPLY PURE COATING LACQUER
R 58090 DD high gloss lacquer colourless – 100%
RLH 6529 hardener – 50%
V 768 delayer – 30%
Apply twice with quick intermediate drying

DRYING
In the end: polishing

MATT LACQUERING

SANDING
180 grain

APPLY PRIMER
R 421 DD priming for isolation – 100%
RLH 6529 hardener – 50%
V 768 delayer – 30%

DRYING AND SANDING
400 grain

APPLY PURE COATING LACQUER
R 577-05 DD matt lacquer colourless – 100%
RLH 6110 hardener – 50%
V 721 dilution – 10-20%

DRYING

MATERIAL BY HESSE LIGNAL AND EFFECT PIGMENT BY BASF



HIGH GLOSS LACQUERING

SANDING
180 grain

APPLY PRIMER
Hesse PUR priming DG 4716-0001
Mixing ratio 2 : 1 with hardener DR 4070
Addition: 15% thinner DV 4900
Varnish two times (wet/wet) with 30 minutes intermediate drying

DRYING
Drying during the night

SANDING
320 grain

APPLY PRIMER
Hesse PUR priming DG 4716-0001
Mixing ratio 2 : 1 with hardener DR 4070
Addition: 15% thinner DV 4900

DRYING
Drying during the night

SANDING
400/600 grain

APPLY COATING LACQUER
Hesse PUR acrylic brilliant lacquer DU 45229
Mixing ratio 2 : 1 with hardener DR 4005
Addition: 25% thinner DV 4935
Addition: 3% effect master batch (mixture of 90% Hesse PUR acrylic brilliant lacquer DU 45229 and 10% BASF effect pigment)

DRYING
20 minutes intermediate drying

APPLY COATING LACQUER
Hesse PUR acrylic brilliant lacquer DU 45229
Mixing ratio 2 : 1 with hardener DR 4005
Addition: 25% DV 4935

Notes:

Even in lacquered finish Innovus Coloured MDF Black FR meets the high European fire protection standards. Coated with the clear lacquer "R580-20" 2K-acrylic lacquer satin-finished by the company 3H-lacquers or with the "PUR SL-210/30" - coating lacquer half-matt by the company Remmers, the board is proven to achieve the classification B-s2, d0 according to DIN EN 13501-1. In this regard it should be noted that the lacquer must be applied with a cup gun, in order to avoid negative impact on the fire protection characteristics of the board.

Wood is a natural raw material; therefore it is possible that minor deviations in colour appear during the manufacturing of Innovus Coloured MDF. We recommend not to mix boards from different batches in order to obtain a colour as homogeneous as possible.