

## Ultra One D F

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### PRODUCT DESCRIPTION

The product is a single-coat low temperature cure powder coating mainly developed for Medium Density Fiberboard (MDF) and other similar types of engineered wood substrates.

The product gives the powder coated MDF surface an outstanding finish that meets the mechanical and chemical requirements of the general furniture industry.

The product is an environmentally friendly and cost effective alternative to traditional surface coating technologies.

### Application areas

This product is recommended for interior use only.

Typical application areas are MDF furniture, including:

- Kitchen cabinets
- Bathroom furniture
- Office furniture
- Home furniture
- Children's furniture

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### POWDER PROPERTIES

#### Storage

Keep in a dry cool area. Maximum temperature 20 °C. Maximum relative humidity 60 %. If stored longer than 6 months a quality test is recommended. For transportation, air conditioned truck securing maximum temperature of 20 °C and maximum relative humidity of 60 % must be used.

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### APPLICATION

#### Pretreatment

The overall quality of the coating system is largely dependent on the type of MDF, the quality of the substrate preparation and the coating application line. Since there are many grades of MDF available in the market which can differ in moisture content, density profile, internal bond strength etc., it is recommended that the coater determines which grade of MDF will best achieve the desired quality according to powder application procedures.

The MDF surface must be clean and free from dust, grease, adhesive and loose MDF fibres. The MDF may need to be sanded in order to homogenize the surface to be coated. The edges should also be rounded and made smooth (minimum 1.5 degree radius). For best results, the moisture content of the MDF should be between 5 and 7 %.

MDF board should have a certain level of conductivity in order to attract and hold the electrostatically charged powder coating particles. In order to ensure that correct coating properties are achieved, preconditioning of the board to secure the correct moisture content will be necessary. This will enable good earthing to be achieved and therefore ensure the correct level of surface conductivity for coating. If in doubt, please seek advice from your Jotun technical service advisor.

When handling more porous MDF boards, alternative surface and edge preparation techniques such as thermo-smoothing and/or edge banding may be considered.

### Powder application

Infrared heating or a combination of infrared and convection heating is recommended.

Curing schedule	Object temperature	Time
<b>Ultra One D F (infrared curing oven)</b>	125 °C	5 minutes
	130 °C	3 minutes
	140 °C	2 minutes

**Note!** The exact curing conditions are dependent on the curing oven configuration, condition, and the substrate.

A fully cured film has to be reached in order to assure the correct film properties. An inadequately cured film (or prepared board) may result in film failure, e.g. edge cracking (especially when the board is subjected to environments with different humidity content), reduced chemical resistance and/or a sticky surface. Failure of this nature may appear a few hours after application as well as several months after application.

### Equipment

Suitable for Corona charging equipment.

## APPEARANCE

<b>Colour</b>	The product is available in a range of white shades. Other custom requested colours are available upon technical approval.	
<b>Gloss</b>	EN ISO 2813 (60°)	5-45
<b>Finish</b>	Fine texture	

If the significant surface is too small or unsuitable for the gloss to be measured with the glossmeter, the gloss should be compared visually with the reference sample (from the same viewing angle).

## PERFORMANCE

The technical data provided below are typical for this product when applied as follows:

Substrate	MDF board
Substrate thickness (mm)	15
Film thickness (µm)	80-150

Typical values when tested.

Property	Standard	Result
<b>Water</b>	EN12720	Pass
<b>Fat</b>	EN12720	Pass
<b>Coffee</b>	EN12720	Pass
<b>Alcohol</b>	EN12720	Pass
<b>Fat/Scratches (5N)</b>	SS839117	Pass
<b>Scratches (5N)</b>	SS839117	Pass
<b>Dry heat (70 °C)</b>	EN12720	Pass
<b>Wet heat (100 °C)</b>	EN12720	Pass
<b>Perspiration</b>		
<b>Acid resistance</b>	EN ISO 105 - E05	Pass
<b>Alkaline pH 8</b>	EN ISO 105 - E05	Pass

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<b>Scratch resistance</b>	ISO 1518-1/SIS 83 91 17	≤ 0.5 mm wide scratch at 5 N load having a hemispherical hard-metal tip of radius 0.5 mm
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*Ultra One D meets the Möbelfakta requirements, category 5, of the furniture industry. A certificate is available upon request. Descriptive numerical rating code. 1: Strong change; 5: No change*

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### Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.