

Primax Base

PRODUCT DESCRIPTION

Primax Base is a low temperature cure powder coating primer specifically developed to provide excellent adhesion and edge sealing of Medium Density Fibreboards (MDF).

For optimum coating results, the product is to be used in combination with Reveal Sand as topcoat.

Application areas

This product is recommended for interior use only.

Typical application areas:

Kitchen cabinets
Bathroom furniture
Office furniture
Home furniture
Children's furniture
Shop fittings

POWDER PROPERTIES

Property	Standard	Result
Specific gravity	Calculated	Typically $1.60 \pm 0.1 \text{ g/cm}^3$

Storage

Keep in a dry cool area. Storage time 6 months at maximum temperature $\leq 17 \text{ }^\circ\text{C}$. Maximum relative humidity 60 %. When transporting, the product must be kept at a temperature of $\leq 17 \text{ }^\circ\text{C}$.

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 and resistance 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 degrees 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

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

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

A fully cured film has to be reached in order to assure film properties. An inadequately cured film may end in film failure, e.g. edge cracking, especially when the board is subjected to environments with different humidity content.

Primax Base may be partially cured only when Reveal Sand is applied as topcoat.

Primax Base will then be fully cured as a part of the curing of the topcoat (refer to the TDS of Reveal Sand).

Light sanding of Primax Base may be required before applying Reveal Sand.

Recommended film thickness (μm): 50 - 100

Curing schedule	Object temperature	Time
Primax Base	130 °C	3-5 minutes

Equipment

Suitable for Corona charging equipment.

APPEARANCE

Colour

The product is available in a wide variety of colours. Custom requested colours are available upon technical approval.

Gloss

Semi gloss

Finish

Available in fine texture.

PERFORMANCE

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

Substrate Suitable MDF board

Substrate thickness (mm) 18

Film thickness (μm) 50-100

Typical values when tested.

Property	Standard	Result
Adhesion	EN ISO 2409 (2 mm)	Rating Gt 0
Water resistance test	Ledro swelling test - 48 hours	Pass

The primer Primax Base is to be used in combination with our topcoat, Reveal Sand. The performance of the 2-coat system can be found in the TDS of the topcoat.

Sustainability

Powder coating is applied in air-and-powder mix in a strictly controlled factory process using electrostatic gun and a high temperature curing oven to create film. Virtually no VOCs are released in the process compared to traditional liquid paints. Unused or oversprayed powder can be recycled with minimal wastage, and disposal is easy and safe. In addition, all Jotun Powder Coatings' products does not contain intentionally added lead.

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.