



# Trimatrix®

## Product Guide

|                    |  |                         |  |
|--------------------|--|-------------------------|--|
| <b>Colour</b>      | Made -to-order colours available only.                     | <b>Specific gravity</b> | 1.2 - 1.7 @ colour                             |
| <b>Gloss Level</b> | Usually available in a fine texture or a smooth matt grade | <b>Shelf life</b>       | 6 months when stored below 25°C/dry conditions |

## Application Data

|                             |  |              |  |
|-----------------------------|--|--------------|--|
| <b>Preheat Temperature</b>  | Using Trimatrix MDF the preheat stage may not be necessary. If preheating is required, the MDF substrate should be preheated to a surface temperature of between 60°C and 90°C before coating. |              |  |
| <b>Application Method</b>   | Electrostatic spray.   |              |  |
| <b>Clean Up</b>             | Dust or vacuum loose powder. Avoid use of compressed air.  |              |  |
| <b>Curing</b>               | Discuss with DGL Camel Powder Coatings the cure methods for MDF. Faster cure can be achieved using Infra Red (IR) combined with convection.  |              |  |
| <b>Metal Cure Schedule</b>  | Curing down to 110°C is possible   |              |  |
| <b>Cured Film Thickness</b> | Recommended:   | 130 µm       |  |
|                             | Range:   | 100 – 200 µm |  |

Note: The grade of MDF used is very important in achieving successful powder coating.

Trimatrix MDF grade (using DGL MDF board technology) is recommended in combination with 942 Trimatrix powder coating to give the best combination for successful coating of MDF.

The Trimatrix MDF board has excellent heat resistance (for dimensional stability of the MDF) and excellent and consistent transfer efficiency of 942 Trimatrix powder coating for successful powder coating.

### Theoretical spreading rate at recommended film thickness

A coverage rate of 4 - 8m<sup>2</sup>/kg is typical. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.

## Application Guide

### Surface Preparation

All MDF surfaces should be clean and free from dirt, oil or loose MDF fibres. Avoid touching the MDF board with bare hands (wear gloves)

### Application Procedure and Equipment

1. If required, preheat the MDF to the temperature recommended above.
- 2a) For fluidised hoppers, ensure uniform fluidisation of powder. Fluidised powder should resemble “simmering liquid”. Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly.
- 2b) For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer’s recommendations. Box feeders are not suitable for the application of pearlescent and metallic finishes
3. Apply by electrostatic spray.
4. Cure as per recommendations outlined above.
5. Test for cure of the coating by contact with a drop of Corsol PMA (available from DGL Camel Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.

