

<b>Processing notes for melamine faced wood- based boards</b>	Kaindl Info
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Kaindl wood-based panels with a factory-applied primer film are suitable for subsequent painting due to their special properties.

In order to achieve an optimised lacquer result, the following processing notes must be observed.

#### **General notes:**

- All lacquers approved by the lacquer manufacturer with suitability for wood- based materials with a primer film can be used. Observe the manufacturer's lacquer recommendations.
- Strongly thinning and/or low application quantities have a negative effect on the lacquer result.
- Surfaces must be absolutely clean, load-bearing, free of wax, grease, silicone and dust.
- In any case, a colour or compatibility sample shall be prepared.

#### **Surface pre-treatment:**

- The surfaces of wood-based panels with primer film must always be sanded (cleaning sanding), e.g. with sanding paper grain 240.
- Dirt, greasy and oily residues must be removed from the surface.
- For board edges of MDF core boards a smooth sanding with e.g. grain 180 - 220, as well as a clean sanding with e.g. grain 240 is mandatory.  
Attention: When sanding, use dust filters (dust masks).

## Processing notes for melamine faced wood- based boards

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### Further processing:

#### Pre- insulation

- Apply primer (pre-insulation).  
For edges of MDF boards absolutely necessary!
- Drying and intermediate lacquer sanding, e.g. grain 320 - 400 (observe drying time of approx. 12h).

#### Primer coat

- Apply filler (if necessary)
- Drying and intermediate lacquer sanding, e.g. grain 320 - 400 (observe drying time of approx. 12h).

#### Lacquer application

- Colour lacquer
- Drying and intermediate lacquer sanding, e.g. grain 320 - 400 (observe drying time of approx. 12h).
- Top coat
- Drying

#### Note:

The cleaned and sanded surface must be processed with a coordinated lacquer system in accordance with the processing guidelines of the lacquer manufacturer.

#### Attention:

- Please note the drying times and requirements for intermediate sanding / smoothing according to the lacquer producer's instructions!
- In any case, a processing/compatibility sample must be prepared in order to avoid possible surface defects.

In case of non- observance, **no subsequent warranty claims can be made.**