

Duoprime[®] M (DPM1)

► Product description

Duoprime M is a primer with immediate adhesion to difficult melamine surfaces and is fully compatible with high performing UV-acrylate systems.

► Areas of application

| | |
|------------|---|
| Products | For high wear applications, for example flooring or table tops. |
| Substrates | Melamine based CPL, LPL and HPL laminates, melamine/wood composites |

► Preparations

| | |
|-------------------|--|
| Primer | Mix A and B components of Duoprime M in proportion specified on the buckets. Stir manually. |
| Substrate surface | Dust free surface, sanding typically not required for adhesion. |
| Roller-coater | Roller-coater, pump and tubes should be cleaned with a solvent not containing amines, hydroxyl groups or alkaline substances. |

► Application

| | |
|--------------------|-----------------------|
| Roller | 50-80 Shore A |
| Application amount | 6-12 g/m ² |

► Times

| | |
|--------------------|--|
| Curing | IR curing: 15-20 sec until surface reaches 85-110 °C. With a line speed of 14 m/min the IR-zone is about 4 meters. Reaction zone : 1-2 min reaction zone before application of next acrylate coating. |
| Comments on curing | Exact surface temperature depends on the chemical composition of the substrate. Longer IR-zone results in a shorter reaction zone. Adhesion reaches 90% of final performance within 30 min. |

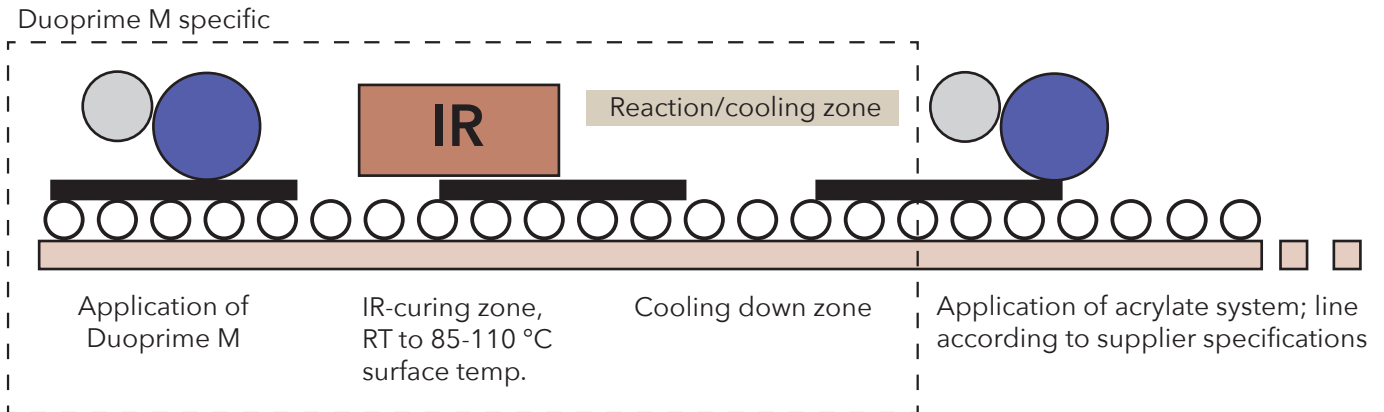
► Technical data

| | |
|---------------------------|--|
| Pot life | 24 hrs in machine after mixing the components at 25 °C. Keep process temperature below 35 °C in the machine. |
| Shelf life in weeks | 26 |
| Appearance | colorless when cured |
| Viscosity of mixed primer | Approx 5000 mPa.s |
| Content | 100% solid; 0% VOC, 0% isocyanates, 0% water |
| Storage temperature | 5-25 °C |
| Safety markings | irritant, hazardous for aquatic life |

Duoprime[®] M (DPM1)

► Sample process / line specifications

The coating process and the precise treatment parameters are adapted to the respective application and substrate, but general line characteristics are presented below. After the Duoprime M specific application process the subsequent acrylate layers are applied according to specifications from the supplier.



► General information

The next acrylate layer should be applied within 60 min to ensure interlayer adhesion. If off-line process is needed where the acrylate system is applied days to weeks after, a standard acrylate primer with isocyanate hardener is required on top of Duoprime M to achieve perfect interlayer adhesion.

► Ordering information

| | |
|----------------|--|
| Order number | DPM 201 |
| Container size | Component A: 5 kg, 20 kg Component B: 5 kg, 20 kg |