

(12) STANDARD PATENT
(19) AUSTRALIAN PATENT OFFICE

(11) Application No. **AU 2012243456 B2**

(54) Title
A powder mix and a method for producing a building panel

(51) International Patent Classification(s)
B32B 37/14 (2006.01) **B44C 5/04** (2006.01)
B32B 5/16 (2006.01) **E04B 5/00** (2006.01)
B32B 21/08 (2006.01)

(21) Application No: **2012243456** (22) Date of Filing: **2012.04.11**

(87) WIPO No: **WO12/141646**

(30) Priority Data

(31) Number	(32) Date	(33) Country
1150321-6	2011.04.12	SE
61/474,485	2011.04.12	US

(43) Publication Date: **2012.10.18**

(44) Accepted Journal Date: **2016.01.07**

(71) Applicant(s)
Valinge Innovation AB

(72) Inventor(s)
Ziegler, Goran;Rittinge, Rickard;Persson, Hans

(74) Agent / Attorney
Phillips Ormonde Fitzpatrick, L 16 333 Collins St, Melbourne, VIC, 3000

(56) Related Art
EP 1209199 A1
US 2010/030030 A1

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau



(10) International Publication Number
WO 2012/141646 A1

(43) International Publication Date
18 October 2012 (18.10.2012)

(51) International Patent Classification:

B32B 37/14 (2006.01) *B44C 5/04* (2006.01)
B32B 5/16 (2006.01) *E04B 5/00* (2006.01)
B32B 21/08 (2006.01)

(21) International Application Number:

PCT/SE2012/050384

(22) International Filing Date:

11 April 2012 (11.04.2012)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

1150321-6 12 April 2011 (12.04.2011) SE
61/474,485 12 April 2011 (12.04.2011) US

(71) Applicant (for all designated States except US): **CER-ALOC INNOVATION BELGIUM BVBA** [BE/BE]; IT Tower, Avenue Louise 480, B-1050 Brussels (BE).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **Ziegler, Göran** [SE/SE]; Hästhovsvägen 11, SE-263 62 Viken (SE). **Rit-tinge, Rickard** [SE/SE]; Oxelvägen 67, SE-263 62 Viken (SE). **Persson, Hans** [SE/SE]; Färgarevägen 7, SE-284 33 Perstorp (SE).

(74) Agent: **Westeman, Maria**; c/o Välinge Innovation AB, Prästavägen 513, SE-263 65 Viken (SE).

(81) Designated States (unless otherwise indicated, for every kind of national protection available):

AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available):

ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Declarations under Rule 4.17:

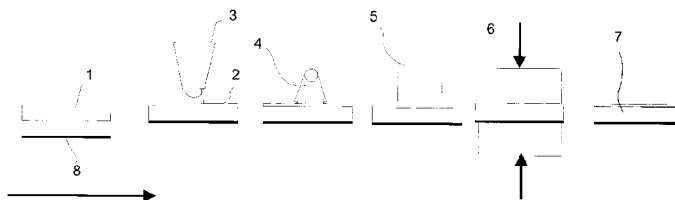
— as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii))

Published:

— with international search report (Art. 21(3))

(54) Title: A POWDER MIX AND A METHOD FOR PRODUCING A BUILDING PANEL

Fig. 1



(57) Abstract: A powder mix layer for a building panel and a method for producing a building panel with a decorative surface produced from a powder mix layer with a controlled loss on cure.

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A POWDER MIX AND A METHOD FOR PRODUCING A BUILDING PANEL

Technical field

5 The disclosure generally relates to the field of fibre-based panels with a wear resistant decorative surface layer, particularly building panels and more particularly floor panels. The disclosure relates to a building panel with such wear resistance decorative surface and to production methods for such panels and a mixed/prefab layer for such methods and panels.

Known Techniques

10 The following discussion of the background to the invention is intended to facilitate an understanding of the invention. However, it should be appreciated that the discussion is not an acknowledgement or admission that any aspect of the discussion was part of the common general knowledge as at the priority date of the application.

15 Recently new "paper free" Wood Fibre Floor (WFF) types have been developed with solid surfaces comprising a substantially homogenous mix of fibres, binders and wear resistant particles. Such a new type of panel called Wood Fibre Floor (WFF) is disclosed in WO2009/065769, which shows both products and methods to produce such a product.

20 The wear resistant particles are preferably aluminium oxide particles, the binders are preferably thermosetting resins such as amino resins and the fibres are preferably wood based. Other suitable wear resistant materials are for example silica or silicon carbide. In most applications decorative particles such as for example colour pigments are included in the homogenous mix. In general all these
25 materials are preferably applied in dry form as a mixed powder on a HDF core and cured under heat and pressure to a 0.1 - 1 .0 mm solid layer.

Powder technology is very suitable to produce solid decorative surface layer, which are much thicker than conventional laminate surface layers. Such solid powder based layers create a much higher tension on the panel when they swell
30 or shrink and balancing is a problem. It is therefore difficult to produce a panel with a thick and a high quality surface, which is also stable and flat in variable moisture

conditions. Furthermore, pores may be formed in the surface layer resulting in weak stain resistance.

Summary of the invention

5 It is desirable to improve the known Wood Fibre Floor (WFF) panels. It is also desirable to provide a product preferably having a width cupping of -0.15% to +0.20% under test conditions according to ISO 24339:2006(E), and/or a water vapour permeability of less than 3 g/m²*24 hours

according to EN 12572 and/or a surface staining of 5(5) according to EN438 based on test using a permanent marker.

This may be achieved by a powder mix layer for the decorative surface layer of a WFF-panel with a controlled loss on cure and a method of producing a building
5 panel.

By loss on cure is in this application meant the weight loss, calculated as weight percentage of the original weight, occurring when heating the powder at 160°C for 5 minutes. The weight loss corresponds to moisture released from the powder. Under these conditions the released moisture consists of two parts. The first part is the
10 free moisture formed from water and/or other substances having a boiling point below 160°C being trapped in the powder and the second part originates from the cross linking of the binder. Melamine formaldehyde resin cures at 160°C and the resin cross-links via a condensation reaction, i.e. water is released by the condensation reaction.

15 By moisture content is meant the weight loss, when the powder is dried under milder conditions at ambient temperatures and only the free water in the powder is released, without curing the resin.

If the loss on cure is too low the powder mix layer will not be completely impregnated by the binder when the binder is in the fluid state during the pressing.

20 An inferior impregnation of the powder mix layer results in discolouration of the decorative surface of the WFF panel, due to pores close to the surface.

If the loss on cure on the other hand is too high, a high amount of pores in the WFF layer are created during the pressing. The pores give a poor resistance of surface staining and increased water/vapour permeability. Increased water/vapour
25 permeability can result in increased cupping of the panels under test conditions according to ISO 24339:2006(E).

The loss on cure depends on the amount of binder in the powder mix layer, the moisture content in the powder mix layer when entering the WFF production line and the amount of powder stabilization fluid applied in the WFF production line. The
30 loss on cure before pressing may be controlled by an in-line or off-line drying process in which the powder layer is dried. The drying may be carried out by heating, e.g., IR heating, preferably in-line, drying in a chamber, preferably in-line, or drying in a controlled climate, preferably off-line.

The drying process stabilizes the powder in the powder mix layer and applying a powder stabilization fluid may not be necessary.

If the drying process involves heating, the binder in the powder mix layer may be melted and the powder is stabilized by the melted binder. Thereby, the drying process may make the stabilization fluid redundant.

According to an aspect of the invention a powder mix layer for producing a building panel with a loss on cure in the range of about 2.5 to about 7 wt-%, preferably about 3 to about 6 wt-% is provided.

A powder mix layer having a loss on cure in the above described range overcomes the above described disadvantages and exhibits improved stain resistance, water/vapour resistance and binder impregnation as described above.

The powder mix layer may have a loss on cure in the range of about 2 to about 7 wt-%, preferably in the range of about 4 to about 6 wt-%, preferably about 5 wt-%.

The powder mix is a substantially homogenous mix, which comprises in one embodiment wood fibres, preferably of HDF, a binder, preferably a melamine resin, and wear resistant particles, preferably a powder of silica, more preferably essentially of aluminium oxide. A more preferred loss on cure is about 3.5 wt-%, to 5.5 wt-%.

According to another aspect of the invention, there is provided a method of producing a building panel comprising the steps of:

- applying a powder mix layer on a substrate, the powder mix layer comprising wood fibres and a binder; and

- applying heat and pressure to the powder mix layer when arranged on the substrate and curing the powder mix layer having a loss on cure in the range of about 2 to about 7 wt-%, preferably in the range of about 4 to about 6 wt-%, more preferably about 5 wt-%, and thereby obtaining a layer formed by the powder mix layer.

A preferred loss on cure is about 2.5 wt-% to about 7 wt-%.

A particularly preferred loss on cure is in the range of about 4% to about 6% and, in particular, 5%

A powder mix layer produced according to the inventive method wherein the powder mix layer has a loss on cure in the above described range overcomes the above described disadvantages and exhibits improved stain resistance, water/vapour resistance and binder impregnation as described above.

- 5 In one embodiment, a powder mix is chosen such that the powder mix already has a loss on cure in the above defined ranged. As an alternative, the loss on cure of

the powder mix layer may be adjusted by for example applying a stabilisation fluid or by drying in order to change the moisture content of the powder mix. The relevant time for determining the loss on cure of the powder mix layer is the moment before applying heat and pressure.

- 5 By adjusting the binder content and the moisture content in the powder mix, and the amount of any added stabilization fluid, a desired loss on cure of the powder mix layer may be obtained. Furthermore, the loss on cure may be controlled by drying the mix, thereby adjusting the moisture content.

10 The curing performed by applying heat and pressure may be performed at high line speed and the powder layer withstands high acceleration and retardation forces created, at short press cycles of about 20 seconds.

The powder mix in the second aspect may be the same as the embodiments of the first aspect. Accordingly, the powder mix layer may comprise a substantially homogenous mix of wood fibres and a binder, preferably a thermosetting resin,
15 more preferably melamine. The powder mix layer may further comprise wear resistant particles, preferably of aluminium oxide or of a silica powder.

The loss on cure is measured using a gravimetric method comprising heating the powder mix layer at 160°C for five minutes.

20 The powder mix layer may be heated before pressing, preferably by IR heating, and preferably with an effect of about 15-25 kW/m. A preferred feeding speed in the range of about 1-4 m/min, most preferably about 3m/min at an effect of about 20kw. Preferably, the substantially homogenous mix is conditioned before being applied in order to obtain the desired loss on cure of the powder mix layer.

25 In the curing step, the pressure applied may be in the range of about 20 kg/cm² to about 60 kg/cm², preferably about 40 kg/cm², and the temperature of the press plate may be in the range of about 160 to about 200°C, preferably about 180°C, The heat and pressure may be applied in the range of about 10 to about 200 seconds, preferably in the range of about 10-60 seconds, and as an example in about 40 seconds.

30 The powder mix layer may comprise wood fibres and a binder, preferably a thermosetting resin.

The method may comprise the further step of applying a stabilisation fluid, preferably water, on the powder mix.

5 The method may comprise the further step of drying the powder mix layer, preferably by applying heat with an effect of about 15-25 kW/m and a feeding speed in the range of about 1-4 m/min, preferably about 3 m/min.

The method may comprise the further steps of fixing the powder mix layer to the substrate, preferably by applying stabilisation fluid and drying with an effect of about 15-25 kW/m and a feeding speed in the range of about 1-4 m/min, preferably about 3 m/min.

10 The method may comprise the further step of adjusting the loss on cure of the powder mix layer by the step of applying the stabilisation fluid, or the step of drying, or a combination thereof such that the powder mix layer obtains the loss on cure in said range. Thereby, the loss on cure of the powder mix layer can be adjusted such that a loss on cure in the desired range can be obtained, even if the powder mix
15 originally has a loss on cure outside the desired range.

The powder mix layer may be applied by scattering. The powder mix may be applied by an applying unit, preferably a scattering unit, which forms the powder mix layer.

The powder mix layer may be applied as a continuous powder mix sheet.

20 Consequently, it is possible to produce a separate layer such as a continuous powder mix sheet. In this embodiment, the substrate may be a press belt, a release foil etc. The components of the powder mix is connected together but essentially uncured, in a separate process and in a separate production line. The separate layer may be based on carrier, e.g. a paper or a metal or plastic foil, but the powder
25 mix may also only be bonded together by it self achieved by e.g. wetting with a fluid, preferably water and drying. The powder mix sheet may be stored and later applied on the core as a powder mix layer.

The substrate may be a core, preferably a wood-based core, more preferably a HDF or MDF board.

30 The layer may form a decorative surface layer arranged on the core.

A third aspect of the invention is a production line comprising an applying unit for applying a powder mix layer on a substrate, a pressing unit for applying heat and

pressure on the powder mix layer and a conveyor that comprises conveyor units preferably with separately controllable feeding speed of the substrate. The production line may also comprise stabilisation units and/or drying units. The conveyor preferably comprises separate conveyor units at each of the production units. The separate conveyor units provide an enhanced control of the loss on cure, since the feeding speed at each production unit (the applying unit, stabilisation unit and/or drying unit) can be controlled and thereby it will be easier to control the amount of applied powder or stabilisation unit or degree of drying. Furthermore the separate conveyor units prevent moisture/water from being transported between the production units by the conveyor itself.

In all aspects the wood fibres may be both virgin, refined and/or processed, comprising lignin and without lignin, e.g. α -cellulose fibres or holocellulose. A mixture of refined and unrefined fibres may also be used. It is also contemplated that vegetable fibres as jute, linen, flax, cotton, hemp, bamboo, bagasse and sisal may be used. Also mineral fibres and carbon fibres may be used.

The applying unit is preferably a scattering device. The substrate is preferably an HDF or MDF board, which is preferably provided with a balancing layer .

Brief Description of the Drawings

The invention will in the following be described in connection to preferred embodiments and in greater detail with reference to the appended exemplary drawings, wherein

- Fig 1 illustrates a production line according to an embodiment of the invention;
- Fig 2 illustrates a panel with a decorative layer according to an embodiment of the invention;
- Fig 3 illustrate the relationship between moisture content and loss on cure for the formulation in example 1-4

Detailed Description of Embodiments

A panel 7, which is described with reference to fig 1 and 2, comprises according to one embodiment of the invention a wood fibre based core 1, an essentially homogenous decorative surface layer (transparent or non-transparent) 2 and preferably a balancing layer 8. The panel 7 is in one embodiment integrally formed

in a production line (see fig 1) where the surface layer 2, the core 7 and the balancing layer 8 are formed in the same pressing operation 6.

Figure 2 shows the decorative surface layer and the core in more detail. The surface layer comprises a substantially homogenous mixture of fibres 14, small
5 hard wear resistant particles 12, 12' and a binder 19. The fibres 14 are preferably wood fibres. The binder 19 is preferably a binder that cross-links by a condensation reaction. The binder is preferably a thermosetting resin such as amino-resins or phenolic resin. In one embodiment, the binder is melamine formaldehyde. The wear resistant particles 12, 12' are preferably aluminium oxide particles. The surface layer
10 preferably may also comprise pigment 15.

The surface layer may comprise colour pigments 15 and/or, optionally, other decorative materials or chemicals. Decorative materials include, for example, materials that may affect design aspect(s) the surface layer. Exemplary design materials include materials effecting texture, reflectivity, shine, luminescence,
15 transparency, etc.

In methods according to embodiments of the invention preferably the same scattering 3 and pressing units 6 as disclosed in WO 2009/065769 or WO 2009/124704 are used, preferably together with a structured press plate in the method. Each of WO 2009/065769 and WO 2009/124704 are hereby incorporated
20 by reference in its entirety.

Fig 1 discloses a production line according to an embodiment of the invention. The production line comprises an applying unit 3, preferably a scattering unit for applying/scattering a powder mix 2 on the core 1, e.g. an HDF/MDF board, which is preferably already provided with a balancing layer 8. A stabilisation unit 4 for
25 applying a stabilization fluid and a drying unit 5 for drying the powder mix layer are provided. A pressing unit 6 finally applies heat and pressure on the powder mix layer, the core and the balancing layer in order to cure the binder and thereby obtaining the finished building panel 7 with a decorative surface layer. The production line further comprises a conveyor (not shown) preferably comprising
30 separate conveyor units such that the speed of the core 1 through the production line can be varied at the different units e.g. at the applying unit 3, the stabilisation unit 4 or at the drying unit 5. A suitable conveyor is a belt or roller conveyor.

A powder formulation can for example comprise an essentially homogenous

powder mixture comprising 187.5 g/m² recycled HDF fibre with a moisture content of 5.2 %, 62.5 g/m² Aluminium Oxide (ZWSK-180 ST, Treibacher Schleifmittel AG), 265,625 g/m² Melamine Formaldehyde resin (Prefere 4865, Dynea), 62.5 g/m² Titanium dioxide (Kronos 2190, Kronos) and 46,875 g/m² pigment (Heucosin G10512, Heubach).

The core of an HDF board preferably has a moisture content of 0-6 %.

The scattering unit has the capacity of scattering of 100-1000 g/m² with a tolerance of +/- 5% as measured using a calibration cup with an area of 100x100 mm cross- and length wise the board. The amount of stabilization fluid may vary between 0 up to 200 g/m².

The scattering unit comprises a needle belt and a scattering roller. The scattering roller is provided with needles in the range of about 30-120, preferably about 50-100, and most preferably about 70-90 needles per cm². The needle length is about 0.5-2.5 mm, preferably about 1-2 mm and most preferably about 1.5 mm. Several scattering units machines to even out differences in the applied powder mixture.

Furthermore, the scattering device may be provided with a needle belt with needles with a preferred length of about 15-20 mm, a preferred frequency in the range of about 500-1000 rpm preferably about 1000 rpm, and a stroke length of about +/- 3 mm.

The stabilization unit may stabilize using steam, nozzle spray coating, ultra sonic spray coating, a stabilization sheet comprising a sheet based material with inherent stabilizing properties or a surface coverage providing the stabilizing properties.

Stabilization fluid may comprise solvents such as non-polar solvents, polar aprotic solvents and polar protic solvents or mixtures thereof. Preferred solvents are polar protic solvents such as isopropanol, ethanol and water. Most preferred is water.

The stabilization fluid can further comprise additives such as wetting agents, defoamers, release agents, anti-slip agents, anti-abrasives and catalysts.

Decorative effects can also be added in the form of inks, dyes and effect pigments.

In examples 1-4 below the powder formulation was used comprising 34 weight-% recycled HDF fibre (Välinge Innovation Sweden), 10 weight-% Aluminium oxide (ZWSK 180-ST, Treibacher Schleifmittel AG), 50 weight-% Melamine Formaldehyde resin (Prefere 4865, Dynea), 2 weight-% Titanium dioxide (Kronos

2190, Kronos) and 4 weight-% pigment (G 6555 N, Heubach GmbH).

The relation between Weight Loss on Cure and the free moisture content, that is excluding the water released in the curing of the melamine resin, in the powders used in the examples, is shown in fig 3.

- 5 Depending on the loss cure of the powder mix applied to the substrate, a stabilization fluid may be applied and/or drying may be performed. If the loss on cure of the powder mix applied to the substrate is within the above described range, no stabilization fluid is to be added and no drying is to be performed. If the loss on cure of the powder mix applied to the substrate is outside the above described
- 10 range, a stabilization fluid is to be added, or drying is to be performed, depending if the loss on cure is too low or too high, in order to obtain a powder mix having the desired loss on cure before applying heat and pressure.

Even if the loss on cure of the powder mix applied is within the above described range, it may be desired to apply a stabilization fluid in order to stabilize the powder

15 layer. In order to adjust the loss on cure of the powder mix layer, subsequent drying may be required.

Alternatively, the binder content of the powder may also be adjusted in order to obtain the desired loss on cure of the powder mix layer.

Example 1: Powder based product obtained through heat compression of an

20 incorrectly treated powder, comparative example; no drying and a stabilization fluid of water (20g/m²)

A powder based product comprising an HDF core with a thickness of 9.7 mm, a balancing paper 550 g/m² of a scattered powder layer and 20 g/m² stabilisation fluid, giving an a loss on cure of 8 wt-%, was pressed in a short cycle press using a

25 force of 40 kg/cm² for 37 seconds at a surface temperature on the upper press plate of 184 °C and a surface temperature on the lower press plate of 180 °C. The press plate was a granite structure plate.

The resulting product was:

- a building panel with a solid surface having a width cupping outside -0.15 % to +0.2% installed board according to ISO 24339:2006(E). Typical values obtained are -0.26 % to +0.29%.
- staining of 3(5) according to EN438 based on test using a permanent marker

- water vapour permeability in excess of $5.3 \text{ g/m}^2 \cdot 24 \text{ hours}$ according to EN 12572

Example 2: Powder based product obtained through heat compression of a treated powder, preferred example, drying and a stabilization fluid of water (20 g/m^2)

- 5 A powder based product comprising a HDF core with a thickness of 9.7 mm, a balancing paper and 550 g/m^2 of a scattered powder layer and 20 g/m^2 of stabilisation fluid was pressed in a short cycle press using a force of 40 kg/cm^2 for 37 seconds at a surface temperature on the upper press plate of $184 \text{ }^\circ\text{C}$ and a surface temperature on the lower press plate of $180 \text{ }^\circ\text{C}$. The press plate had a
- 10 granite structure. Prior to pressing the powder was treated by an IR drying with an effect of 19 kW/m and a feeding speed of $2,7 \text{ m/min}$ in order to obtain a loss on cure of 4.6 wt-\% as measured using a gravimetric method comprising heating the treated powder at $160 \text{ }^\circ\text{C}$ for five minutes.

The resulting product was:

- 15
- a solid surface having a width cupping within -0.15 \% to $+0,2 \text{ \%}$ installed board according to ISO 24339:2006(E), typical values obtained are -0.07 \% to $+0.17 \text{ \%}$.
 - staining of 5(5) according to EN438 based on test using a permanent marker
 - water vapour permeability lower than $1.1 \text{ g/m}^2 \cdot 24 \text{ hours}$ according to EN
- 20 12572.

Example 3: Powder based product obtained through heat compression of an incorrectly treated powder, comparative example, stabilization fluid and over drying.

- A powder based product comprising a HDF core with a thickness of 9.7 mm, a balancing paper and 550 g/m^2 of a scattered powder layer with 20 g/m^2 of
- 25 stabilisation fluid, was pressed in a short cycle press using a force of 40 kg/cm^2 for 37 seconds at a surface temperature on the upper press plate of 184°C and a surface temperature on the lower press plate of 180°C . The press plate had a granite structure. Prior to pressing the powder was treated by an IR drying process with an effect of 19 kW/m and a feeding speed of 1.5 m/min in order to obtain a loss
- 30 on cure of 2.5 wt-\% as measured using a gravimetric method comprising heating the treated powder at 160°C for five minutes.

The resulting product was:

- a building panel with a solid surface having a width cupping inside -0.15 % to +0.2 % on installed board according to ISO 24339:2006(E)
 - staining of 3(5) according to EN438 based on test using a permanent marker
 - water vapour permeability of 2.5 g/m²*24 hours according to EN 12572
- 5
- Discoloured decorative surface, due pores close to surface.

Example 4: Powder based product obtained through heat compression of a treated powder, preferred example, drying and without stabilization fluid of water.

A powder based product comprising a HDF core with a thickness of 9.7 mm, a balancing paper and 550 g/m² of a scattered powder layer, with a loss on cure of 5.3 % before drying, was pressed in a short cycle press using a force of 40 kg/cm² for 37 seconds at a surface temperature on the upper press plate of 184 °C and a surface temperature on the lower press plate of 180 °C. The press plate had a granite structure. Prior to pressing the powder was treated by an IR drying with an effect of 19 kW/m and a feeding speed of 2.7 m/min in order to obtain a loss on cure of 3.7 wt-% as measured using a gravimetric method comprising heating the treated at 160 °C for five minutes.

10

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The resulting product was:

- A solid surface having a width cupping within -0.15 % to +0.2 % on the installed board according to ISO 24339:2006(E), typical values obtained are -0.05 % to +0.20 %.
 - staining of 5(5) according to EN438 based on test using a permanent marker
 - water vapour permeability lower than 1.9 g/m²*24 hours according to EN 12572.
- 20

CLAIMS

1. A method of producing a building panel comprising the steps of:
 - applying a powder mix layer on a substrate, the powder mix layer comprising wood fibres and a binder; and
 - applying heat and pressure to the powder mix layer when arranged on the substrate and curing the powder mix layer having a loss on cure in the range of about 2 to about 7 wt-%, preferably in the range of about 4 to about 6 wt-%, more preferably about 5 wt-%, and thereby obtaining a layer formed by the powder mix layer.
2. The method according to claim 1, wherein the loss on cure is in the range about 4 to 6 wt-%.
3. The method according to claim 1, wherein the loss on cure is about 5wt-%.
4. The method according to any one of claims 1 to 3, wherein the binder is a thermosetting resin.
5. The method according to any one of claims 1 to 4, comprising the further step of applying a stabilisation fluid on the powder mix layer.
6. The method according to claim 5, wherein the stabilisation fluid is water.
7. The method according to any one of claims 1 to 6, comprising the further step of drying the powder mix layer.
8. The method according to claim 7, wherein drying the powder mix layer performed by applying heat with an effect of about 15-25 kW/m and a feeding speed in the range of about 1 -4 m/min.
9. The method of claim 8, wherein the feeding speed is about 3 m/min.

10. The method according to any one of claims 1 to 9, comprising the further steps of fixing the powder mix layer to the substrate.

11. The method according to claim 10, wherein fixing the powder layer to the substrate is performed by applying stabilisation fluid and drying with an effect of about 15-25 kW/m and a feeding speed in the range of about 1 -4 m/min.

12. The method of claim 11, wherein the feeding speed is about 3 m/min.

13. The method according to any one of claims 1 to 12, further comprising adjusting the loss on cure of the powder mix layer by the step of applying the stabilisation fluid, or the step of drying, or a combination thereof such that the powder mix layer obtains the loss on cure in said range.

14. The method according to any one of claims 1 to 13, wherein the powder mix layer is applied by scattering.

15. The method according to any one of claims 1 to 13, wherein the powder mix layer is applied as a continuous powder mix sheet.

16. The method according to any one of claims 1 to 15, wherein the substrate is a core.

17. The method according to claim 16, wherein the core is a wood-based core.

18. The method according to claim 17, wherein the wood-based core is a HDF or MDF board.

19. The method according to any one of claims 1 to 18, wherein the layer forms a decorative surface layer arranged on the core.

Fig. 1

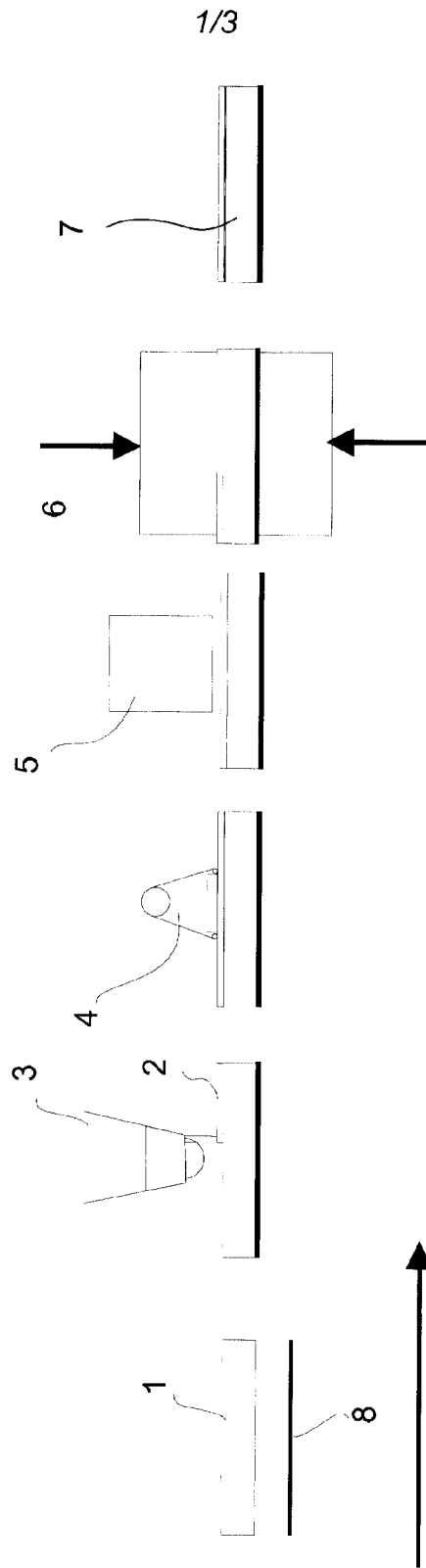


Fig. 2

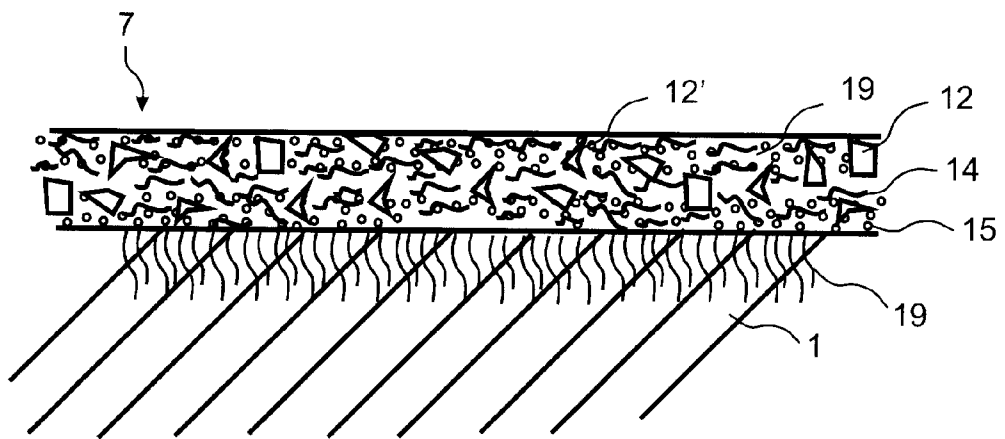


Fig. 3

