

Title (en)

Method for producing decorated wood material boards and floor panel produced from the wood material board

Title (de)

Verfahren zum Herstellen dekorierter Holzwerkstoffplatten und aus der Holzwerkstoffplatte hergestelltes Fußbodenpaneel

Title (fr)

Procédé de fabrication de plaques en bois décorées et panneau de sol fabriqué à partir de celles-ci

Publication

**EP 2942207 B1 20180704 (DE)**

Application

**EP 14001642 A 20140509**

Priority

EP 14001642 A 20140509

Abstract (en)

[origin: CA2948202A1] A method for producing decorated wooden composite boards having the following steps: a) sprinkling of glued wood fibres or wood chips to form a wooden composite cake, b) pressing of the wooden composite cake under the influence of elevated temperature to form a support plate which is provided in a press-finished state and has a press skin which arises during the production thereof at least on one of the upper sides thereof, c) applying of a base coat made from a melamine-based liquid resin to the preferably untreated press skin of the upper side of the support plate, wherein the resin penetrates at least partially into the upper edge layer of the support plate and in the process at least partially penetrates and improves the press skin, d) drying of the base coat, e) applying of a base colour to the base coat layer, f) drying of the base colour, g) applying of at least one water-based printing ink enriched with pigments onto the dried base colour in order to produce a decorative pattern, h) drying of the decorative pattern, i) applying of a seal made from at least one melamine-based resin to the decorative layer, j) drying of the seal, k) pressing of the support plate with the base coat applied on the upper side, base colour, decorative pattern and seal and with a counteracting layer applied on the lower side with the application of pressure and temperature in order to form a laminate which is distinguished by the fact that a water-based ink is used as base colour, which water-based ink is applied to the dried base coat by means of a digital printer, and that the resin for sealing is applied in liquid form.

IPC 8 full level

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