CLAIMS

1. A method of manufacturing a wear resistant surface layer comprising the steps of:

- applying a dry powder layer comprising a mix of refined fibres, binder, pigments and wear resistant particles on a carrier; and
- curing the mix to a pale colored wear resistant layer by applying heat and pressure on the mix.

2. The method as claimed in claim 1 or 2, wherein the decorative layer is attached to a wood fibre based core to obtain a panel.

3. The method as claimed in any one of the preceding claims, wherein the panel is a floor panel.

4. The method as claimed in any one of the preceding claims, wherein the wear resistant particles are aluminium oxide.

5. The method as claimed in any one of the preceding claims, wherein the thickness of the cured layer is less than about 1 mm.

6. The method as claimed in any one of the preceding claims, wherein the pale colour wear resistant surface layer is bright white or red.

7. The method as claimed in any one of the preceding claims, wherein the decorative layer is attached to an HDF panel.

8. The method as claimed in any one of the preceding claims, wherein the thickness of the cured layer is less than about 0.3 mm.

9. The method as claimed in any one of the preceding claims, wherein the ratio of resin compared to refined fibres is higher than about 100%,

10. The method as claimed in any one of the preceding claims, wherein the ratio of resin compared to refined fibres is higher than about 120%

11. The method as claimed in any one of the preceding claims, wherein the ratio of resin compared to refined fibres is in the range of about 120% to about 180%.

12. The method as claimed in any one of the preceding claims, comprising the step of scattering a sublayer on the core.

13. The method as claimed in any one of the preceding claims, comprising the step of scattering a top layer above the dry powder layer.

14. The method as claimed in claim 1, wherein the surface layer is pale and/or plain coloured.

15. A floor panel produced according to the method in any one of the preceding claims.

16. The floor panel as claimed in claim 15, wherein the surface layer of the floor panel is of pale and/or plain colour.

CLAIMS

1. A method of manufacturing a surface layer comprising the steps of:
• applying a sublayer comprising a mix of wood fibres and a resin on a carrier;
• applying a powder layer comprising a mix of refined fibres and a binder on the sublayer, wherein the sublayer is arranged between the carrier and the powder layer; and
• curing the powder layer by applying heat and pressure on the powder layer, wherein the powder layer is cured to a surface layer.

2. The method as claimed in claim 1, wherein the mix forming the powder layer further comprises wear resistant particles.

3. The method as claimed in claim 2, wherein the wear resistant particles are aluminium oxide.

4. The method as claimed in claim 1, wherein the mix forming the powder layer further comprises pigments.

5. The method as claimed in claim 1, wherein the powder layer is a dry powder layer.

6. The method as claimed in claim 1, wherein the carrier is a wood fibre based core, and the surface layer is attached to the wood fibre based core to obtain a panel, wherein the core comprises a major part of the panel.

7. The method as claimed in claim 6, wherein the panel is a floor panel.

8. The method as claimed in claim 6, wherein the carrier is an HDF panel.

9. The method as claimed in claim 1, wherein the thickness of the surface layer is less than about 1 mm.

10. The method as claimed in claim 1, wherein the binder is a resin and the weight ratio of resin compared to refined fibres is higher than about 120%.

11. The method as claimed in claim 1, wherein the binder is a resin and the weight ratio of resin compared to refined fibres is in the range of about 120% to about 180%.

12. The method as claimed in claim 1, wherein the step of applying the sublayer on the carrier comprises scattering the mix of wood fibres and resin on the carrier.

13. The method as claimed in claim 1, further comprising a step of scattering a top layer above the powder layer.

14. The method as claimed in claim 6, wherein a balancing layer is applied to a surface of the wood fibre based core that is opposite the sublayer and the surface layer.

15. A method of manufacturing a surface layer comprising the steps of:
• applying a powder layer comprising a mix of refined fibres and a resin on a carrier, wherein the weight ratio of resin to refined fibres is higher than about 120%; and
• curing the powder layer to a wear resistant layer by applying heat and pressure on the powder layer.

16. The method as claimed in claim 15, wherein the mix forming the powder layer further comprises wear resistant particles.

17. The method as claimed in claim 16, wherein the wear resistant particles are aluminium oxide.

18. The method as claimed in claim 15, wherein the mix forming the powder layer further comprises pigments.

19. The method as claimed in claim 15, wherein the powder layer is a dry powder layer.

20. The method as claimed in claim 15, wherein the carrier is a wood fibre based core, and the surface layer is attached to the wood fibre based core to obtain a panel.

21. The method as claimed in claim 20, wherein the panel is a floor panel.

22. The method as claimed in claim 15, wherein the thickness of the surface layer is less than about 1 mm.

23. The method as claimed in claim 20, wherein the carrier is an HDF panel.

24. The method as claimed in claim 15, wherein the weight ratio of resin compared to refined fibres is in the range of about 120% to about 180%.

25. The method as claimed in claim 15, further comprising a step of scattering a sublayer on the carrier.

26. The method as claimed in claim 15, further comprising a step of scattering a top layer above the powder layer.

27. A method of manufacturing a surface layer comprising the steps of:
• applying a powder layer comprising a mix of refined fibres and a binder on a carrier,
• applying a top layer comprising refined fibres on the powder layer, and
• curing the powder layer to a surface layer by applying heat and pressure on the powder layer.

28. The method as claimed in claim 27, wherein the mix further comprises wear resistant particles.