

8. Interpon D Repair Guide

Damage to the Interpon D Range of Powder Coatings may be caused during transportation, installation or as a result of the action of other trades (e.g. scaffold damage) on site.

For on-site rectification of small damaged areas Cromadex 800 Two Pack Non-Isocyanate Acrylic Topcoat, matched for colour and gloss to the appropriate Interpon D Range shade, should be used. Where brush application is to be employed, Interthane 990 should be used to repair gloss systems, and Interthane 870 for off-gloss systems.

Where damage has exposed the metal, the prepared metal only should be primed with Cromadex 903 Two Pack Chromate-Free Etch Primer. Please see the relevant data sheets for thinning ratios and drying times.

Please refer to Appendix 3 for the technical data sheets for Cromadex 800, Cromadex 903, Interthane 990 and Interthane 870.

The following information and repair methods/statements etc. are intended for guidance only. It is the client's responsibility to ensure that the products to be used are fit for purpose.

For additional information contact your local AkzoNobel Helpline.

Repair paints may weather at different rates to the original powder coatings.

Method 1:

Minimum requirements to repair small isolated areas (approx.5-6cm²) and scratch damage:

- (a) Clean all surfaces to be painted with Cromadex 678 Spirit Wipe or equivalent by applying liberally using a clean lint-free cloth and wipe dry using lint-free cloths physically removing all sealants and mastics, etc.
- (b) Abrade all areas to be coated with abrasive paper, up to P320 grade, if necessary, to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac rags.
- (c) Apply by brush to exposed metal surfaces only one thin coat of Cromadex 903 Two Pack Chromate-Free Etch Primer and allow to dry for one hour.
- (d) Apply by brush or spray one coat of the relevant topcoat, matched to shade and gloss.

Method 2:

Minimum requirements to repair larger areas of damage:

- (a) Mask all surrounding surfaces of the damaged areas to the edge of the panel or a suitable breakline.
- (b) Clean all surfaces to be coated with Cromadex 678 Spirit Wipe or equivalent, by applying liberally using a lint free cloth, and wipe dry using lint free cloths, physically removing all sealants and mastics etc.
- (c) Abrade all areas to be coated with abrasive paper, up to P320 grade, if necessary, to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.
- (d) Apply by brush or spray to the exposed metal surface only one thin coat of Cromadex 903 Two Pack Chromate-Free Etch Primer and allow to dry for one hour.
- (e) Apply by spray a minimum Dry Film Thickness of 40 microns of Cromadex 800 Two Pack Non-Isocyanate Acrylic Topcoat matched to shade and gloss, as detailed in the Cromadex 800 Two Pack Non-Isocyanate Acrylic Topcoat Data Sheet.
- (f) Alternatively apply by brush 50 microns of Interthane 990 for gloss systems, or 50 microns of Interthane 870 for off-gloss systems, as detailed in the relevant product data sheets.

Method 3:

Minimum requirements for complete re-sprays on site.:

Substrate Preparation

- (a) Clean all surfaces using Cromadex solvent based degreaser 06-55 or equivalent and physically remove all sealant and mastics products. Degrease all areas to be abraded using lint-free cloth. Inspect and remove all mastic sealant adjoining any surface to below 4mm of metal edges.
- (b) Apply protective masking to unaffected areas as required.
- (c) Mechanically abrade to sound substrate. Drilled holes to be countersunk and butt joints to be filled, the surface should taper on the side for filling.
- (d) Abrade mechanically or by hand using 60/80 abrasive paper areas to receive filling media.
- (e) Clean down with vacuum or air, thoroughly degrease with Cromadex 678 Spirit Wipe or equivalent areas to be filled, physically removing any sealant mastics etc, where necessary.
- (f) Mix the components of the filling media as specified in the manufacturers recommendations and apply directly to the substrate. Work the material to remove any trapped air and finish to profile shape. Allow to fully curing as per manufacturers recommendations.
- (g) Abrade with 80 abrasive paper to correct profile whether by hand or mechanical action. Repeat items (f) and (g) if required. Clean down after each operation to remove dust and debris.
- (h) Abrade all areas coated with abrasive paper up to P320 grade, if necessary, to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.
- (i) De-mask and clean down.

Recoating

- (a) Mask unaffected areas prior to painting. Degrease using Cromadex 678 Spirit Wipe and lint-free cloth and remove all dust.
- (b) Apply one spray coat of Cromadex 903 Two Pack Chromate-Free Etch Primer to any areas of exposed metal to a minimum Dry Film Thickness of 10 to 15 microns. Allow curing as recommended and lightly key surface. Remove all debris and tac-rag surface.
- (c) Apply Cromadex 800 Two Pack Non-Isocyanate Acrylic Topcoat to a minimum Dry Film Thickness of 40 microns, allow to flash off and cure as detailed in the Cromadex 800 Two Pack Non-Isocyanate Acrylic Topcoat Data Sheet.
- (d) De-mask, clean down and remove debris, etc.
- (e) Re-apply sealant/mastic on required areas.
- (f) Present finished painted areas for inspection and approval of client.