

## Interpon D1000 Repair Procedure of Powder Coated Components

### Introduction

This technical bulletin outlines the appropriate in on-site rectification procedures for Interpon D Architectural grade powder coat finishes when damage has occurred.

Interpon Powder Coatings and International Protective Coatings Australia recommends the appropriate occupational health and safety measures are employed prior to commencement of rectification works. All on site health and safety measures must be observed. Full details of appropriate handling of materials can be found on the relevant Material Safety and Technical Datasheets.

Repair materials may weather at different rates to that of the original powder coatings. It is therefore important that the repair procedures are kept to a minimum. Where practical, sections needing extensive rectification should be replaced with factory coated sections.

### **Interpon D1000Series**

For on-site rectification of small damaged areas Interthane 990 (gloss) or Interthane 990SG (Semi Gloss) Acrylic Polyurethane, matched for colour and gloss to the appropriate Interpon D1000 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 lower gloss systems.

Where damage has exposed the metal, the prepared metal only should be primed with Interprime 160 Etch Primer. Please see the relevant data sheet for thinning ratios and drying times.

### **Method 1: Minimum requirements to repair scratch damage** ***(Small isolated areas approx.5-6cm<sup>2</sup>)***

1. Clean all surfaces to be painted with Interplus 546 Cleaner/Degreaser 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.
2. 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.
3. Apply by brush to exposed metal surfaces only one thin coat of Interprime 160 Etch Primer and allow to dry for one hour.
4. Apply by brush or spray one coat of the relevant Topcoat, matched to shade and gloss.
5. Present finished painted areas for inspection and approval of client.

## **Method 2: Minimum requirements to repair larger areas of damage**

1. Mask all surrounding surfaces of the damaged areas to the edge of the panel or a suitable breakline.
2. Clean all surfaces to be coated with Interplus 546 Cleaner/Degreaser or equivalent, by applying liberally using a lint free cloth, and wipe dry using lint free cloths, physically removing all sealants and mastics etc.
3. Abrade all areas to be coated with abrasive paper, up to 320 grade, if necessary, to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.
4. Apply by brush or spray to the exposed metal surface only one thin coat of Interprime 160 Etch Primer and allow to dry for one hour.
5. Apply by spray a minimum of 40 microns Interthane 990 (Gloss) or Interthane 990SG (Semi Gloss) Acrylic Polyurethane matched to shade and gloss, as detailed in the Interthane 990 (Gloss) or Interthane 990SG (Semi Gloss) Acrylic Polyurethane Data Sheet.
6. 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
7. De-mask, clean down and remove debris, etc.
8. Re-apply sealant/mastic on required areas.
9. Present finished painted areas for inspection and approval of client.

## **Method 3: Minimum requirements for complete re-sprays on site.**

### **• Substrate Preparation**

1. Clean all surfaces using Interplus 546 Cleaner/Degreaser 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.
2. Apply protective masking to unaffected areas as required.
3. 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.
4. Abrade mechanically or by hand using P60/P80 abrasive paper areas to receive filling media.
5. Clean down with vacuum or air, thoroughly degrease with Interplus 546 Cleaner/Degreaser or equivalent areas to be filled, physically removing any sealant mastics etc, where necessary.

6. 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.
7. Abrade with P80 abrasive paper to correct profile whether by hand or mechanical action. Repeat items (6) and (7) if required. Clean down after each operation to remove dust and debris.
8. Abrade all areas coated with abrasive paper up to P320/P400 grade, if necessary, to ensure a suitable keyed surface, ready to be coated, then wipe clean using lint free tac-rags.

- **Recoating**

1. Mask unaffected areas prior to painting. Degrease using Interplus 546 Cleaner/Degreaser and lint-free cloth and remove all dust.
2. Apply one spray coat of Interprime 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.
3. Apply Interthane 990 (Gloss) or Interthane 990SG (Semi Gloss) Acrylic Polyurethane to a minimum dry film thickness of 50 microns allow to flash off and cure as detailed in the Interthane 990 (Gloss) or Interthane 990SG (Semi Gloss) Acrylic Polyurethane Data Sheet.
4. De-mask, clean down and remove debris, etc.
5. Re-apply sealant/mastic on required areas.
6. Present finished painted areas for inspection and approval of client.

Interthane 990 and Interthane 870 colour matched to Interpon D1000 Range shades and glosses and data sheets are available from International Protective Coatings. Other rectification material systems and method statements are available. For further information refer to International Protective Coatings. However, these method statements are for information only and an "Approved Repair Applicator" must carry out any Rectification or Repairs that are carried out to the Interpon D Powder Coating Range.

The above 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 Customer Support Team.

Interpon Powder Coatings Australia - 1800 630 561  
Interpon Powder Coatings New Zealand - 0800 150 527

International Protective Coatings Australia - 131 474  
International Protective Coatings New Zealand - 0800 808 807