

AkzoNobel

Architectural Powder Coatings

Interpon D Repair Procedure - Guidance Note ZA

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Introduction

Coatings can get damaged during fabrication, shipping and installation, and then require repairs onsite. The powder coatings can be repaired with a suitable spray on or brush on liquid, depending on the area to be repaired.

NB! Any repair will age / weather at a different rate compared to the powder coated surface. This will become more noticeable as the coating ages.

For AAMA2603 and 2604 / Qualicoat Class 1 or 2 systems:

For onsite rectification of small damaged areas, **Sikkens Autocryl**, matched for colour and gloss, to the appropriate Interpon D shade, should be used. Where damage has exposed the aluminium substrate only the exposed aluminium should be primed with **Sikkens Washprimer 1K**. Please read the relevant data sheet for thinning ratios and drying times.

1. Minimum requirements to repair small isolated areas (approx. 5 6cm) and scratch damage.

a. Using a clean lint free cloth, liberally apply **Sikkens Degreaser** or equivalent to clean all surfaces to be painted, then wipe dry using a lint free cloth to physically remove all sealants and mastics etc.
b. Abrade all areas to be coated with 220 – 320 grit wet & dry type sandpaper to ensure a suitably keyed surface. Wipe clean using lint free tac rags.
c. Apply a single coat of **Sikkens Washprimer 1K**, to exposed metal surfaces only and allow to dry. The wash primer will provide good adhesion onto the substrate
d. Apply a coat of **Sikkens Autocryl**, matched to shade and gloss. Please read the relevant data sheet for mixing/ thinning ratios and drying times.

Very small scratches can be touched up using a brush, for any larger repairs only spray application is recommended.

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 break line.
b. Using a clean lint free cloth, liberally apply **Sikkens Degreaser** or equivalent to clean all surfaces to be painted, then wipe dry using a lint free cloth to physically remove all sealants and mastics etc.
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 areas to receive filling media mechanically or by hand, using 60/80 abrasive paper.
e. Clean areas to be filled with vacuum or compressed air.
f. Mix the components of the **Sikkens Polykit** filling media or equivalent 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 cure fully as per manufacturer's instructions.
g. Abrade with 80 abrasive paper to correct profile, either by hand or mechanical action.
h. Repeat filling procedure if required.
i. Clean after each operation to remove dust and debris.
j. Finish sand the filler with 220 grit wet and dry sand paper to remove deep sanding marks.
k. Abrade all areas coated with 320/400 grit wet and dry sand paper to ensure a suitably to ensure a suitably keyed surface, then wipe clean using lint free tac rags.
l. Abrade all areas to be coated with 220 – 320 grit wet & dry type sandpaper to ensure a suitably keyed surface. Wipe clean using lint free tac rags.
m. Observing the technical data sheet recommendation for mixing, application and drying times. Apply one coat of **Sikkens Washprimer 1K**, only to exposed aluminium surfaces.
n. Apply two coats of **Sikkens Autocryl** matched to shade and gloss, prepared as detailed in the Technical Data Sheet.

3. Minimum requirements for complete re sprays on site.

Substrate Preparation

a. To clean all surfaces to be painted , use clean lint free cloths. Apply **Sikkens Degreaser** or equivalent liberally and wipe dry physically removing all sealants and mastics etc.
b. Inspect and remove all mastic sealant adjoining any surface, to below 4mm of metal edges.
c. Apply protective masking to unaffected areas as required.
d. 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.
e. Abrade areas to receive filling media mechanically or by hand, using 60/80 abrasive paper.
f. Clean areas to be filled with vacuum or compressed air.
g. Thoroughly degrease with **Sikkens Degreaser** or equivalent.
h. Mix the components of the **Sikkens Polykit** filling media or equivalent 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 cure fully as per manufacturer's instructions.
i. Abrade with 80 abrasive paper to correct profile, either by hand or mechanical action.
j. Repeat filling procedure if required.
k. Clean after each operation to remove dust and debris.
l. Finish sand the filler with 220 grit wet and dry sand paper to remove deep sanding marks.
m. Abrade all areas coated with 320/400 grit wet and dry sand paper to ensure a suitably keyed surface, ready to be coated, then wipe clean using lint free tac rags.
n. De mask and clean thoroughly.

Recoating

a. Mask unaffected areas prior to painting.
b. To clean surfaces to be painted, use clean lint free cloths, apply **Sikkens Degreaser** or equivalent liberally and wipe dry
c. Observing the technical data sheet recommendation for mixing, application and drying times; Evenly apply one coat of **Sikkens Washprimer 1K**, to the exposed aluminium surfaces.
d. Apply one spray coat of **Sikkens Autosurfacer Rapid**, prepared and applied as per the data sheet. Allow to dry and de-nib with 400 grit abrasive paper. Remove all debris and wipe clean using lint free tac-rags.
e. Apply two coats of **Sikkens Autocryl** matched to shade and gloss, prepared as detailed in the Technical Data Sheet
f. De-mask, clean and remove all debris etc.
g. Re-apply sealant / mastic on required areas.
h. Present finished painted areas for inspection and approval of client.

Some Interpon D finishes may require a base and top clear coat to achieve a match, please be guided by the wet coat supplier's expertise mentioned below.

Sikkens Autocryl colour matched in Interpon D Range shades and gloss levels and relevant Data Sheets, are available from Top Coat Automotive + 27 (0 11 453 9600).

For further information refer to AkzoNobel technical services: +27 (0 11 861 0500).

This Guideline is not intended to replace, but is intended to supplement, the various industry specifications and standards (BS, ISO, AS, Qualicoat, GSB, AAMA etc). Wherever the specifier nominates such an industry specification, then the requirement of that specification (pretreatment, film thickness etc) shall be over riding.

Disclaimer: The information included in this document is given in good faith, but since metal manufacture, metal pre treatment and coatings application may be subject to a wide variety of external and unknown factor s, we cannot take responsibility for any failure or shortcoming arising from following any of the advice given, except as may be covered by the relevant Product Data Sheet or Product Guarantee. It is the responsibility of the user to establish what is the correct procedure for his particular set of circumstances, for the substrate he has selected and for the processes he will use to apply the powder coating for decoration and/or anti corrosion protection.

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