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## DATA SHEET      ENV 802 – Repairs

### Instructions for repairing powder-coated surfaces with liquid paint systems

For various reasons, overcoating or painting of powder-coated surfaces may become necessary. Preferably, this should be done in the same powder coating quality, if the parts can be removed and cured again. Permanently installed parts, on the other hand, are not suitable for powder coating. In this case, liquid paint systems are used, which must be applied on site.

#### Repair coating with liquid paint systems:

For damages which do not reach the substrate and recoating of intact powder coatings:

1. Always sand parts wet with 320 grit sandpaper (blind); the substrate is not to be damaged in the process.
2. Remove sanding dust with clear water (without additives).
3. After proper drying, wipe with dust-binding cloth.
4. Overcoating by spraying or rolling with 2-component PUR lacquer paint. For metallics, spray painting is preferable. The repair coating must be applied over the entire visible surface, as this is the only way to achieve a decoratively uniform color appearance.
5. The coating can only be applied in dry weather (temperatures not below 15°C) and on an absolutely clean and dry substrate.

**For damage that extends to the substrate:**

1. Sand surfaces wet with 320 grit sandpaper (blind). All loose particles of paint must be completely removed and the substrate under the damaged areas must be sanded to a bright metallic finish.
2. Wash off with isopropyl alcohol or white spirit. After proper drying, wipe off with a dust-binding cloth.
3. Coating with 2-component epoxy primer by spraying or rolling. After drying (above 15°C), the 2C PUR lacquer paint can be applied by spraying or rolling. For metallic systems, the spray process is to be preferred. The repair coating must be applied over the entire visible surface, as this is the only way to achieve a decoratively uniform color appearance.

Observe the processing instructions of the respective liquid coating system.  
There is no warranty on repair work.

**Sealant adhesion:** According to sealant adhesion on powder-coated surfaces of facades (compare data sheet ENV 803)