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## DATA SHEET      ENV 805 – Processing instructions for repairing powder coated surfaces with powder coated high performance foil “powderfix patches”

Necessary repairs to the coating can be carried out in various ways. The type of repair basically depends on the application and the strain.

It is recommended that all repairs are carried out by a specialist company, otherwise the warranty will not apply. In any case, tests with the repair system should be carried out in advance on a suitable area of the object. If the parts can be removed and cured again, it is preferable to repair them in the same powder coating quality.

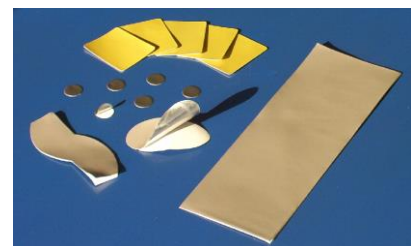
Permanently installed parts, on the other hand, are not suitable for powder coating. In this case, liquid paint systems are used, which must be applied on site (see data sheet ENV 802).

The self-adhesive foil technology is a **completely new method of repair**. The area to be repaired is covered with a special self-adhesive foil, which is already coated with the original powder coating. Uncoated cutting surfaces at the edges of these **powderfix patches** are usually only visible to the critical observer.

The size of the patches can be selected in such a way that the application of these powderfix patches covers entire fields of view.

### This repair technique is suitable for:

- Areas up to 550 x 550 mm
- Strips up to 100 x 1000 mm
- Custom sizes
- Punched parts in many shapes



## Repairs with powder coated high performance foil "powderfix patches"

For damages that do not reach the substrate:

1. Before repairing the defect on the original part, a color match must be carried out with the coated high-performance foil.
2. A processing temperature of 10 to 25 °C should be maintained.
3. Defective areas, damaged areas or areas to be covered and their surroundings must be carefully cleaned and sanded (min. 120 grit sandpaper). They must be dry, free of grease and dust.
4. Depending on the size of the area to be repaired, cut or punch the required pressure-sensitive **powderfix patches** into the desired shape (a punching service is available). Attention: Foil kinks easily!
5. Carefully remove the foil from the carrier paper and apply it to the damaged area without creasing; press on firmly.

The adhesion of the **powderfix patches** is maintained even after prolonged exposure to temperature and humidity stress. The optical correction of the powder coating surface achieved in this way, as well as the corrosion protection that can be achieved, can in individual cases be a good alternative to other repair methods, depending on the type of damage to be repaired, the viewing distance and the corrosion load.

Upon request, **powderfix patches** can also be produced from provided coating powder, in order to eliminate production-related batch variations in the powder coating and to avoid small-volume production of special color tones.

**A quick delivery service of such original powder coated powderfix patches is provided by:**

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There is no warranty given for repair work and "**powderfix patches**".