

# Alesta®

## Processing Instructions for the Repair of Powder-Coated Surfaces

### 1. General information

The recoating or repainting of powder-coated surfaces may become necessary for various reasons.

Ideally, the same powder coating should be used, if the parts can be removed and cured again. Parts which are permanently mounted, however, are not suitable for powder-coating. In this case, liquid coatings are used which must then be applied in situ.

### 2. Process 1 - Refinishing with powder coating

In contrast to the standard application of two layers of coating, the first layer in this case is already fully cured. Incorrect procedures can lead to problems with intercoat adhesion. We recommend you follow the following instructions when recoating:

- Wet sand all parts using 320 sandpaper (dull), taking care not to damage the substrate in the process.
- Remove sanding dust with pure water (without additives).
- Once the parts are completely dry, wipe with a tack cloth.
- When hanging up the parts for coating, make sure they are properly earthed.
- Reduce high voltage to the spray gun so that no dielectric breakdown can occur due to the insulating effect of the first layer of powder coating.
- After curing, check intercoat adhesion by means of a cross-cut test in accordance with DIN EN ISO 2409, target value: Gt0.
- Matt powder coatings can cause specific problems with regard to intercoat adhesion (matting additives).
- Higher temperatures are preferable when selecting curing conditions for the topcoat (cf. Technical Data Sheet).
- The above instructions are also applicable to recoating work using all ALESTA® powder coatings, taking into account specific powder coating properties.



### 3. Process 2 - Refinishing with liquid coating systems

For damage which does not penetrate as far as the substrate and for recoating intact powder coating layers:

- Preparation of surface as described for Process 1, steps a) to c).
- Repaint using spray-gun or roller using a 2-component 2K PUR paint. Spraying is the preferred option for metallics. When refinishing, the coating must be applied over the entire visible surface, because only then can a uniform colour finish be achieved.
- Coating may only be carried out in dry weather (at temperatures not lower than 15°C) and on completely clean and dry surfaces.

For damage which penetrates as far as the substrate:

- Wet sand all surfaces using 320 sandpaper (dull). Any coated parts showing insufficient adhesion should have the coating completely removed and the substrate under the damaged areas must be ground down to the bare metal.
- Wash surfaces using isopropyl alcohol or white spirit. Once the surfaces are completely dry, wipe with a tack cloth.
- Apply layer of 2-component epoxy primer using spray-gun or roller. When refinishing, the coating must be applied over the entire visible surface, because only then can a uniform colour finish be achieved. No guarantee can be offered for repair work. In this case, the processing instructions for the relevant liquid coating system are to be observed.
- When the primer coat is ready for recoat (as indicated on the manufacturer's technical data sheet) apply the finishing coat of a 2 component 2K PUR by spraying or roller. Spraying is the preferred option for metallics.

The tests applied correspond in method and accuracy to the current state of the art. The measurement results stated do not constitute a legal assurance of specific product characteristics or the suitability of a product for a defined purpose. Warnings printed on product labels are to be observed. Any existing industrial property rights are to be taken into account. We guarantee the consistency of our products with contractual specifications within the scope of our General Terms and Conditions of Sale - inland trade and/or export.