

Coating Repair and Touch-Up Procedures

Technical Support Procedure TP-9102-18



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Evaluate and report on any of the above-mentioned damages to the depth and extent of damage to the coating, or to the depth of the damage in terms of microns. Include the dimensions of the damage according to its coordinates on the section of piece being inspected.

Repair and Touch-Up

Mechanical Damage Caused by Transport and Movement of Painted Parts

In the event of mechanical damage to the coating, repair the damaged areas in accordance with the Touch-Up and Repair instructions and the type of damage that is being repaired.

a) *Deep Damage (Damage of Coating Film to the Surface of the Metal surface causing rusting and corrosion)*

If the damage caused to the coating is deep enough to reach the metal surface and cause rusting, use a wire brush and sander/sandpaper to remove the rust. Then use compressed air to blast the surface. Once the surface has been cleaned, use a brush or spray system to reapply the primer layer first, and then the other coating layers in the system. Ensure that you follow each product's technical specifications and operating instructions, especially the Recoating Interval of each product.

b) *Surface Damage*

1. Power wash and clean the painted surface with fresh water at a maximum pressure of 120 PSI.
2. Dry the surface immediately after washing to prevent the formation of sediment or contaminants that may have been present in the water.
3. Inspect the painted surface carefully to ensure that it is fully cleaned and dried.
4. Use sandpaper to remove any remaining contamination left on the surface as well as to smooth any areas where you observe abrasion. Continue this until you have removed all contaminants and you are left with a smooth, even surface. Please note that use of sandpaper will greatly improve evenness of the film, as well as adhesion between layers of paint in the repaired area.
5. Use compressed air to blast the surface and remove any remaining materials and contaminants from step 4.
6. Once the surface has been cleaned, use a brush or spray system to reapply the required coating. Ensure that you follow each product's technical specifications and operating instructions, especially the Recoating Interval of products in the event that more than one layer requires repair and touch-up.
 - ❖ If you are repairing a coating system with two-component coatings, please note the following:
 - i. Look through the "Mixing Instructions" part of the TDS. After you have thoroughly mixed component A to get a uniform, add component B and mix for the stated time in the TDS. Once the two components have been mixed together, the product will require a pre-reaction time prior to application. The pre-reaction time is typically 5-10 minutes.
 - ii. After the components have been combined, a chemical reaction will begin between the paint (component A) and hardener (component B). This is how the coating cures and hardens, and the time period that a chemical reaction is occurring between the components is known as the product's Pot Life. Once the

Pot Life ends, the product will harden, making it impossible to apply the coating. Therefore, it is very important to observe a product's Pot Life (For example, RTB-1275-R's Pot Life is 2 hours at 25°C. Once the Pot Life expires, you should no longer use the product).

7. During coating application, after application and before the coating film dries, do not let any dust, dirt and environmental contamination settle on the painted surface.

c) Damage Caused by Welding, Cutting, Milling...

In these cases, damages to the coating are typically deep and they usually extend to the depth of the primer layer. Use electric and mechanical tools such as a scraper, wire brush or sander to completely remove any rust and remnants of burned paint to a 20 cm radius. Then use compressed air to blast the surface to clean away any dust or contaminants. Once the surface has been cleaned, use a brush or spray system to reapply the primer layer first, and then the other coating layers in the system. Ensure that you follow each product's technical specifications and operating instructions, especially the Recoating Interval of each product.

d) Damages to the Coating Caused by Exposure to Chemicals

In these cases, the damage caused to the coating may be deep damage or surface damage. Use a wire brush or sander/sandpaper to remove the effected areas. Once all damaged areas have been removed, use a cleaning solvent to clean the area exposed to chemicals. Use a wide radius around the impacted areas to ensure that all chemicals, grease and other contaminants are removed and that the surface is clean.

Once the previous steps are complete, check film thicknesses and reapply touch-up paint as needed. For deep damage, once the surface has been completely cleaned and dried, use a wire brush to remove the paint all the way to the substrate. Then use compressed air to blast the surface to clean away any dust or contaminants. Once the surface has been cleaned, use a brush or spray system to reapply the primer layer first, and then the other coating layers in the system. Ensure that you follow each product's technical specifications and operating instructions, especially the Recoating Interval of each product.

e) Other Cases

Repair the coating system based on the type and extent of damage present. Please do not hesitate to contact our Technical Support Team via email at support@ronass.com should you require assistance or have questions.

Note

Please note that there are some limitations to the repair and touch-up of Ethyl Silicate based products such as RTB-766 and RTB-1222-R (Inorganic Zinc Silicate Primer). In the event that the primer layer of the protective coating system being repaired is an Inorganic Zinc Silicate Primer, follow the repair and touch-up procedures explained below:

1. For Protective Coating Systems with a service temperature equal or less than 180°C, repair and touch-up the primer layer using RTB-496 (Highly-Concentrated Zinc-Rich Epoxy Primer).
2. For Protective Coating Systems with a service temperature between 180°C and 420°C, repair and touch-up the primer layer using RTB-585 (Zinc Silicone Heat-Resistant Primer).

