

**Instruction for reparation of damaged paint surfaces**

Coating systems: A20/240; A20/320; A20/320+

Surface preparation: Localized hand- and power-tool cleaning in surface preparation grade PSt 3

**Pos. Products and processing**

**Remarks:**

- The reparation work has to be executed in a way that guarantees that the original coatings and dry film thicknesses are restored in the reparation areas (e.g. damaged spots).
- Superficial damages (e.g. scratches) are repaired using only the top coating; if the original coating is damaged down to the steel substrate (and in cases of doubt), the complete coating system has to be applied.
- The below-mentioned coating materials are applied by brush application, in the case of larger areas possibly also by roller coating.

**1 Surface preparation**

- All areas which are to be restored must be dry and free of dirt, dust, greases, oils and the like, corrosion products and coatings with insufficient adhesion.
- Hand- and power-tool cleaning PSt 3 in order to remove lightly adhering coating parts and possible corrosion products (rust). Always create a smooth transition between the damaged area and the intact coating.

**2 Reparation of the primer coat**

**GEHOPON-E97R-Primer**

Binder 2-component epoxy  
NDFT: 160 µm in two or three working operations

**3 Reparation of the protective coat / top-coat**

**WIEREGEN-M165R or WIEREGEN-M162R**

Binder 2-component polyurethane  
NDFT: 80 – 160 µm in one up to three working operations

Please notice:

The needed dry film thickness of both, primer and protective coat, depends on the dry film thickness of the original coat.