



Specification for Maintenance & Repair

Project: OL 3

Recommendation for maintenance and repair of assembly and transport damages of the following original coating system:

Prime Coat:

Material: Interthane® 611 – grey-green – 1K Polyurethane

Intermediate Coat:

Material: Interthane® 870 – 2K Polyurethane

Top Coat:

Material: Interfine® 629HS – 2K Acrylic

With the following Maintenance and Repair System:

Prime Coat

Material: Interseal® 670HS – Aluminium – 2K EP surface tolerant
DFT: 140µm

Top Coat:

Material: Interfine® 629HS – 2K Acryl – colour shade acc. to specification
DFT: 60µm

Surface Preparation

- Remove all contaminations at the surface with suitable methods
- Surface preparation by power tool clean to a minimum P ST 3 acc. to DIN EN ISO 12-944 Part 4. Preferred usage of the MBX BRISTLE BLASTERS for surface preparation acc. to SA 2,5 acc. to DIN EN ISO 12-944 Part 4.
- Remove all contaminations (dust, etc.)
- Roughing of the intact coating system at the area which needs to be repaired (overlapping area)

Application of the M&R coating system

1. Mixing the two components of Interseal® 670HS (always use complete units) followed by agitating with a power agitator.
2. Application of the prime coat Interseal® 670HS by brush on the correct prepared surface – Thickness: 140µm NDFT – overlapped to a closed surfaces. Please note that it is maybe necessary to apply two coats to achieve the specified dry film thickness.
3. Control of the wet film thickness with wet film thickness gauge
4. Drying of the prime coat Interseal® 670HS (drying time depend on temperature so please consult the technical datasheet)

Over coating of the prime coat Interseal® 670HS, please notice the over coating intervals described in the technical datasheet.

5. Application of the top coat Interfine® 629HS by brush on top of the correct applied prime coat Interseal® 670HS– Thickness 60µm NDFT – overlapped to high level optical surfaces.
6. Control of the wet film thickness with wet film thickness gauge
7. Drying of the top coat Interfine® 629HS (drying time depend on temperature so please consult the technical datasheet)
8. Control of the total dry film thickness (DFT) with calibre measuring instrument
For example Elcometer 456
Total dry film thickness of the M&R coating system: 200µm NDFT.

Please note the following points:

- Working pot life
- Always apply a closed film
- Drying time and over coating intervals
- Climate conditions (ambient temperature & rh humidity)

This M&R coating system and the description belongs to assembly and transport damages which defects the complete original coating system as well as defects through the film to the intermediate and to the prime coat.

If defects shown only at the surface of the top coat Interfine® 629HS the surface should be cleaned with thinner acc. to SSPC-SP1 followed by roughing the top coated surfaces with suitable methods. After this preparation go forward with point 5 to 8 at the above described application process.

For further information please consult the technical datasheets.