

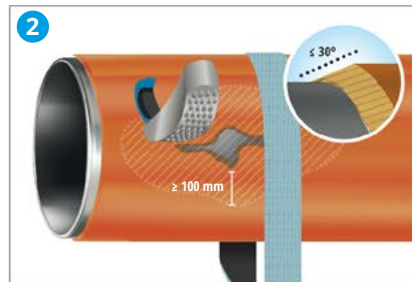


# DEXPAND®-REP MT & -REP HT



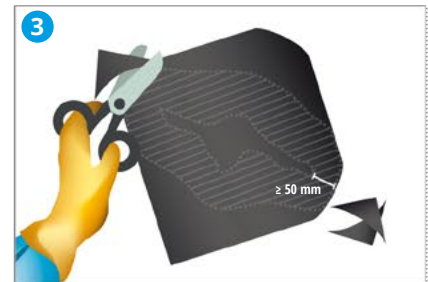
**1 Cleaning**

- The defect to be coated and the neighbouring factory coating must be clean, dry and free of dust and grease. Nonadherent factory coating must be removed.
- All contamination that impairs adhesion (e.g. grease, oil, primers, temporary corrosion protection, coupling agents, etc.) must be removed prior to application. Use an appropriate solvent if necessary.



**2 Surface preparation**

- Non-adherent factory coating is removed using a suitable tool, such as a spherical rasp. Ensure that notches and incisions are smoothed and the edges are bevelled at an angle of  $\leq 30^\circ$ .
- Roughen the factory coating using an abrasive cloth (#40), rubbing in a circumferential direction across a width of at least 50 mm. Remove swarf followed by professional cleaning.



**3 Cutting the DEXPAND®-DRP to size**

- DEXPAND®-DRP is cut to size so that there is a minimum overlap of 50 mm on all sides of the undamaged factory coating. The corner areas must be rounded off.



**4 Preheating**

- DEXPAND®-Filler/DEXPAND®-Mastic:** Use a low-intensity yellow-blue flame to preheat the area to be coated to approx.  $+50^\circ\text{C}$  ( $+122^\circ\text{F}$ ).
- DEXPAND®-Meltstick:** Heat the repair area (factory coating + defect area) from approx.  $+90$  to  $+100^\circ\text{C}$  ( $+122$  to  $212^\circ\text{F}$ ).



**5a Filling the defect with DEXPAND®-Mastic (REP MT)**

- DEXPAND®-Mastic does not need to be preheated for processing!
- Cut DEXPAND®-Mastic to the size of the filling space and work it into the defect. The filled defect is then smoothed with a hot spatula down to the thickness of the coating in the circumferential direction. A cavity-free covering with the DEXPAND®-DRP must be guaranteed.



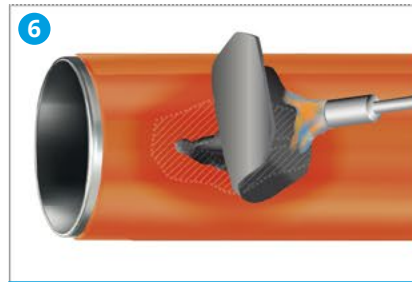
**\*Alternative: DEXPAND®-Meltstick (REP MT)**

- DEXPAND®-Meltstick is heated with a yellow-blue flame until the material becomes shiny and can be applied to the defect as soft as wax.
- The defect must be filled with DEXPAND®-Meltstick in such a way that a cavity-free covering with DEXPAND®-DRP is guaranteed.
- Using a hot spatula and working in a peripheral direction, smooth the filled defect to the same level as the coating thickness.



**5c Filling the defect with DEXPAND® Filler (REP HT)**

- DEXPAND®-Filler is placed on the spatula and heated with a yellow-blue flame until the material becomes shiny and can be applied to the defect as soft as wax.
- The defect must be filled with DEXPAND®-Filler in such a way that a cavity-free covering with DEXPAND®-DRP is guaranteed.
- Using a hot spatula and working in a peripheral direction, smooth the filled defect to the same level as the coating thickness.



**6 Application of DEXPAND®-DRP**

- With DEXPAND®-REP HT, DEXPAND®-Filler in the defect is heated to approx.  $+90^\circ\text{C}$  ( $+194^\circ\text{F}$ ) just before DEXPAND®-DRP is applied. DEXPAND®-Mastic does not need to be preheated for processing.
- Heat DEXPAND®-DRP adhesive side until the adhesive becomes glossy and position it in the centre of the defect.
- Heat the applied DEXPAND®-DRP evenly on the outside until the matt black surface begins to shine.



**7 Fixing the DEXPAND®-DRP**

- Press on DEXPAND®-DRP with a hand roller in longitudinal and circumferential direction smoothly and bubble-free until the adhesive coating emerges visibly on all sides.

Product	Processing temperature		Storage temperature °C (°F)	Compatible factory wrappings
	Surface °C (°F)	Material °C (°F)		
DEXPAND®-DRP	approx. $+50$ ( $+122$ )	$+10$ to $+40$ ( $+14$ to $+105$ )	$\leq +50$ ( $\leq +122$ )	Most common factory coatings
DEXPAND®-Filler				
DEXPAND®-Mastic				
DEXPAND®-Meltstick	approx. $+90$ to $+100$ ( $+122$ to $212$ )			
<b>Surface preparation</b>	Remove loose factory coatings, smooth notches and indentations and chamfer corners to an angle of $\leq 30^\circ$ . Clean adjacent factory coatings on minimum 100 mm with #40 abrasive cloth in a peripheral direction.			
<b>Occupational safety &amp; environmental protection</b>	The installation must comply with all local applicable environmental standards and safety regulations. Safety and environmental notices on labels and safety data sheets must be followed. Personal protective equipment such as safety glasses, safety gloves and fastened work garments must be worn. Protect the ground against contamination.			