

# PROCESSING GUIDELINE VR 217

## IGP-REPLACK Kit

Repair kit for repairing damage to paintwork indoors and outdoors.



IGP Pulvertechnik AG  
Ringstrasse 30  
9500 Wil, Schweiz  
Telefon +41 (0)71 929 81 11  
Telefax+41 (0)71 929 81 81  
igp-powder.com  
info@igp-powder.com

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### Product

The IGP-REPLACK Kit is a complete repair kit for multiple use.

By mixing the IGP-REPLACK hardener solution with the coating powder (not included) from the appropriate IGP powder coating range (see miscibility) in the specified mixing ratio, a spot repair paint is mixed.

The shade is determined by the appropriate coating powder. The repair points achieve a gloss level of  $85 \pm 10$  GE (60° angle) according to DIN 2813.

The IGP-REPLACK Kit in combination with IGP coating powder is suitable for indoor and outdoor use due to its good weather resistance (coating powder must be self-explanatory suitable for outdoor use).

### Application

The IGP-REPLACK Kit is suitable for the multiple colour-matching repair of paint damage up to the single size of a thumbnail (approx. 1 cm<sup>2</sup>).

For larger application areas, further solutions are available in the form of IGP-REPLACK spray, IGP-REPLACK hardener solution and DOLD wet paints.

### Features IGP-REPLACK Kit

1. Hardener based on aliphatic isocyanates – Fast drying
2. No yellowing under UV radiation
3. Good absorption and wetting of IGP coating powders
4. Good UV and weather resistance

### Specification IGP-REPLACK hardener solution (included in IGP REPLACK Kit)

Form of delivery	Clear, liquid
Supply viscosity	approx. 24s DIN-Becher 3 mm
Density	approx. 0.96 g/cm <sup>3</sup>
Vapor pressure	1.8 kPa

#### Safety

Please refer to the corresponding safety data sheet IGP-REPLACK KitItem number:  
IGP-950013

SD

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### Delivery unit

1 complete IGP-REPLACK kit in cardboard trays with the following contents:

1. 120 ml IGP-REPLACK hardener solution
2. 10 mixing vials with mixing ball and integrated dabbing brush
3. 10 wiper inserts for mixing vials
4. 10 labels for mixing vials
5. 10 dosing pipettes
6. 1 scoop
7. 1 hopper
8. 10 plastic bags for powder filling

### Processing Guidelines

#### Mix proportion

The following mixing ratios apply to the production of spreadable touch-up varnish for glossy and semi-gloss IGP powder coatings:

IGP-REPLACK Hardener Solution	:	POWDER
10 wt. parts	:	6 wt. parts

The exact dosing is carried out by means of a dosing pipette (IGP-REPLACK hardener solution) and by means of a dosing spoon (powder).

#### Mix/Assortment

For mixing the IGP-REPLACK hardener solution with glossy or semi-gloss IGP powder coatings such as:

1. PGI-DURA®one 5607
2. IGP-HWFclassic 5907
3. IGP-DURA®face 5809, 5807

Conditional miscibility of the IGP-REPLACK hardener solution with:

1. IGP-DURA®guard 3209, 3207
2. IGP-DURA®pol 6809, 6807

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### Application

Dab and stroke

### Pot life and drying

In combination with powder coating

Pot life	Approx. 30 min. at 20°C and depending on the type of powder coating
Drying	Dust-dry <2 h at 20°C

### Liability

The surfaces must be free of dust and grease.

In combination with powder coating

Steel	<GT 1
IGP-Pulverlack	<Gt 1 Depending on the powder coating surface/quality to be repaired, light sanding can improve adhesion strength.

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### Shelf life

The IGP-REPLACK hardener solution in the IGP-REPLACK kit is moisture and oxygen reactive and should be sealed well after opening. Any dirt on the closure and/or closure thread must be removed.

The shelf life of the IGP-REPLACK hardener solution is 6 months in the unopened original container without the addition of powder coating.

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## Directions

### Application in the paint shop

#### Step 1 – Preparation



Stick the enclosed label on a mixing vial.



Open the mixing vial, place it in the working trough and attach the funnel.

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#### Step 2 – Blending



Pour 1 level scoop of coating powder into the mixing vial using a funnel.

Clean the funnel thoroughly after use.

**IMPORTANT:**

Due to the size of the vial, a maximum of 2 level measuring spoons can be used.



Dispense 6 ml of IGP-REPLACK curer solution into the mixing vial using a dosing pipette. The dosing pipettes have a scale of up to 3 ml.

**IMPORTANT:**

Note that when using 2 level dosing spoons of coating powder, the amount of IGP-REPLACK hardener solution must be increased to 12 ml.



Insert a scraper insert into the opening of the mixing vial and press down firmly. Close the mixing vial well and shake the powder intensively (at least 30 s) to mix the powder with the hardener, perceptible by the rattling of the mixing ball inside.

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#### Step 3 – Spot Repair

- Unscrew the lid with an integrated brush and carefully dab the damaged area (possibly sanded beforehand) with varnish. Excess varnish material on the brush can be wiped off on the integrated insert.

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## Application outside the paint shop (e.g. on the construction site)

### Step 1 – Preparation by coater etc.



Stick the enclosed label on a mixing vial.



6 Dose ml of IGP REPLACK HARDENER solution into the mixing vial using a dosing pipette. The dosing pipettes have a scale of up to 3 ml. **IMPORTANT:** Note that when using 2 level dosing spoons of coating powder, the amount of IGP-REPLACK hardener solution must be increased to 12 ml.



Insert a scraper insert into the opening of the mixing vial and press down firmly.



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Fill 1 level scoop of coating powder into one of the enclosed ZIP bags. **IMPORTANT:**Note that when using 2 level dosing spoons of coating powder, the filling quantity of IGP-REPLACK hardener solution must be increased to 12 ml.

#### Step 2 – On-site mixing



Pour the amount of powder coating filled in the ZIP bag into the mixing vial. To do this, lightly cut off a corner of the ZIP bag and let the powder coating slowly trickle into the mixing bottle through the resulting opening.



Close the mixing vial well and shake the powder intensively (at least 30 s) to mix the powder with the hardener, perceptible by the rattling of the mixing ball inside.

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#### Schritt 3 – Spot-Repair

- Unscrew the lid with an integrated brush and carefully dab the damaged area (possibly sanded beforehand) with varnish. Excess varnish material on the brush can be wiped off on the integrated insert.

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### Security

Article-specific safety data sheet and further risk management measures can be found at:  
[www.igp-powder.com](http://www.igp-powder.com)

### Hint

This processing policy is based on the current state of knowledge, but is only a non-binding reference and does not exempt you from your own checks. The application, use and processing of the products are beyond our control and are therefore your sole responsibility.