

Processing guideline

VR217 – IGP-REPLACK Kit

Product description

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

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

The shade is determined by the appropriate coating powder. The repair areas achieve a gloss in accordance with DIN 2813 of 85 ± 10 GE (60° angle).

In combination with IGP coating powder, the IGP-REPLACK kit is suitable for indoor and outdoor applications due to its good weather resistance (coating powder must be suitable for exterior use).

Application

The IGP-REPLACK kit is suitable for the multiple colour-matched repair of paint damage up to the size of a thumbnail (approx. 1 cm²).

For larger application areas, further solutions are available with IGP-REPLACK Spray, IGP-REPLACK Hardener Solution and DOLD wet paints.

Properties IGP-REPLACK Kit

- Hardness based on aliphatic isocyanates - Fast drying
- No yellowing under UV radiation
- Good absorption and wetting of IGP coating powders
- Good UV and weather resistance

Specification IGP-REPLACK hardener solution (contained in IGP REPLACK Kit)

Delivery form	Clear, liquid
Delivery viscosity	approx. 24s DIN cup 3 mm
Density	approx. 0.96 g/cm ³
Vapour pressure	1.8 kPa

Safety: Please refer to the associated [safety data sheet](#) IGP-REPLACK Kit
Article number: SD IGP-950013

Delivery unit

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

- 120 ml IGP-REPLACK hardener solution
- 10 mixing vials with mixing ball and integrated dabbing brush
- 10 labels for mixing vials
- 10 dosing pipettes
- 1 dosing spoon
- 1 filling funnel
- 10 plastic bags for powder filling

Processing guidelines

Mixing ratio

The following mixing ratios apply for the production of brushable touch-up paint for glossy and silk gloss IGP powder coatings:

IGP-REPLACK hardener solution	:	POWDER
10 parts by weight	:	10 parts by weight

Exact dosing is carried out using a dosing pipette (IGP-REPLACK hardener solution) and a dosing spoon (powder).

Mixture/Assortment

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

- **IGP-DURA[®]one 5607**
- **IGP-HWFclassic 5907**
- IGP-DURA[®]face 5809, 5807

Conditional miscibility of the IGP-REPLACK hardener solution with:

- **IGP-DURA[®]guard 3209, 3207**
- **IGP-DURA[®]pol 6809, 6807**

Application

Dabbing and painting

Pot life and drying

In combination with powder coating

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

Adhesion

The surfaces must be free of dust and grease.

In combination with powder coating

Steel	< Gt 1
IGP powder coating	< Gt 1 Depending on the powder-coated surfaces/quality to be repaired, light sanding can improve adhesion strength

Suitability for storage

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.

Instructions for use

Step 1 - Preparation

- Stick the enclosed label onto a mixing vial
- Open the mixing vial, place it in the work bowl and attach the funnel

Step 2 - Mixing

- Add 1 level dosing spoon of coating powder to the mixing bottle using the funnel. Clean the funnel thoroughly after use
IMPORTANT: Due to the size of the vial, a maximum of 2 level dosing spoons can be used.
- Dose 6 ml IGP-REPLACK HARDENER SOLUTION into the mixing bottle using a dosing pipette. The dosing pipettes are scaled up to 3 ml
IMPORTANT: Please note that when using 2 levelled dosing spoons of coating powder, the amount of IGP-REPLACK hardener solution added must be increased to 12 ml
- Insert a wiper insert into the opening of the mixing bottle and press down firmly. Close the mixing bottle tightly and shake vigorously (min. 30 s) to mix the powder on powder with the hardener, noticeable by the rattling of the mixing ball inside.

Step 3 - Spot repair

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

Safety data

Article-specific safety data sheet and further risk management measures at: www.igp-powder.com

Hint

This processing guideline is based on the current state of knowledge, but is only non-binding and does not exempt you from carrying out your own tests. The application, use and processing of the products are beyond our control and are therefore exclusively your responsibility.
