



## TOUCH-UP RECOMMENDATIONS

Damage to the coating may occur during transport and assembly or in service. The type of repair carried out will depend upon the quality of the original coating and the prevailing ambient conditions.

In order to ensure that the functionality and overall appearance of the coating are restored to as close to the original condition as possible, all touch-up work must be carried out by a specialist contractor. In all cases, tests must first be performed with the intended touch-up system on a non-visually exposed surface – this is the only way of obtaining optimum colour-matching and functionality, and of checking whether the touch-up adheres properly to the original coating.

### 1.1. TIGER Drylac® Medium 90/00120

<b>Description:</b>	Touch-up paint for <b>minor defects</b> in the powder-coating film
<b>Area of application:</b>	Suitable for interior and (with limitations) exterior applications. Do not use for architectural and corrosion-protection applications! Please note: because of their different finish-effect mechanisms, metallic and other TIGER Drylac® effects are not suitable for use with TIGER Drylac® Medium.
<b>Processing:</b>	Mix TIGER Drylac® Medium with TIGER Drylac® powder-coating in a 1:1 mixing ratio. Stir the mixture until it is homogeneous and free of lumps, sieving it if necessary. Any other mixing ratios must be tested first, on the user's own responsibility. The mixture is applied by brushing or spray coating. At room temperature, the touch-up paint is tack-free after approx. 15 - 30 minutes. Before processing, apply a trial coat to non-visually exposed surfaces to assess the colour shade and the surface quality. The required surface hardness and mechanical properties will only be achieved once the TIGER Drylac® Medium mixture has been cured in accordance with the curing conditions for the TIGER Drylac® powder-coating concerned. The visual, mechanical, chemical and corrosion-inhibiting properties and the UV and weathering resistance of the touch-up paint are not equal to those of the original TIGER Drylac® powder-coating.
<b>Pot-life:</b>	The pot-life of the TIGER Drylac® Medium mixture will depend upon which TIGER Drylac® system it is used with, and must be tested on the user's own responsibility. Exterior grades, in particular, have a narrower processing window of less than 30 minutes.
<b>Packing:</b>	In 1-litre can
<b>Shelf life:</b>	6 months at below 25°C



## 1.2. TIGER Replac 90/00003 (gloss) and 90/00004 (matte)

<b>Description:</b>	<p>For touching up minor defects in the powder-coating film on interior and (with limitations) exterior applications.</p> <p>NOT suitable for architectural or corrosion-protection applications!</p> <p>Please note: because of their different finish-effect mechanisms, Metallic and other TIGER Drylac® effects are not suitable for touching-up with TIGER Drylac® Replac.</p>
<b>Area of application:</b>	<p>Mix TIGER Replac gloss or matte with TIGER Drylac® in a 1:1 mixing ratio. The desired viscosity can be obtained by adding TIGER Drylac® Medium 90/00120. The behaviour of the mixture will vary greatly depending on the colour shade, the surface and the TIGER Drylac® series concerned. The optimum mixing ratio must be established by user-performed trials.</p> <p>TIGER Replac gloss 90/00003 and TIGER Replac matte 90/00004 can be mixed with one another to achieve a customised gloss level. Here too, users should carry out their own trials to establish the optimum mixing ratio.</p> <p>Apply this mixture evenly with a small brush, taking care not to apply too thick a coat. The coating rapidly becomes tack-free, but takes up to 48 hours to cure completely. The pot-life of the TIGER Drylac® / TIGER Replac mixture will depend upon the powder-coating systems being used, and must be tested on the user's own responsibility. TIGER Drylac® for weatherproof exterior applications has a particularly narrow processing window of less than 30 min.</p>
<b>Note:</b>	<p>Before starting to use this product, please read and follow the latest issue of the relevant safety data sheet.</p> <p>The visual, mechanical and chemical properties and the UV and weathering resistance are not equal to those of TIGER Drylac®. A suitability test for the desired application must be performed on the customer's own responsibility. Large-area coating repairs are not possible.</p>
<b>Practical tips:</b>	<p>Use a sheet of paper that has been folded into a funnel to pour the TIGER Drylac® into the mixing bottle. Then add the TIGER Replac. Screw down the lid of the mixing bottle tightly and shake it vigorously for several minutes.</p> <p>Using the brush attached to the underside of the lid, apply a trial coat to a non-visually exposed surface of the workpiece. This coating should be appraised after a short drying time. If the finish of this trial coat is not satisfactory, thin the mixture by adding TIGER Drylac® Medium. Do not attempt to touch up (small) defects on the workpiece until several trial coats have been successful. When touching-up, it is advisable to brush in one direction only. Residues left on the equipment can be removed with TIGER Drylac® Medium. When doing this, make absolutely sure that no TIGER Drylac® Medium comes into contact with the powder-coating film.</p>
<b>Product numbers:</b>	<p>90/00003 TIGER Replac gloss (500 ml)</p> <p>90/00004 TIGER Replac matte (500 ml)</p> <p>998/99935 mixing bottles incl. mixing ball and integrated brush (20 flasks)</p>
<b>Packing:</b>	500 ml



## 1.3. TIGER Epo Strong 93/70080

<b>Description:</b>	Two-component conductive knifing putty for repair jobs prior to powder or liquid coating on all metallic substrates. Its "elastic" formulation and excellent adhesion together provide very good mechanical properties. No change occurs in the volume of the putty during the drying process.
<b>Note:</b>	Do not use for architectural applications. The properties of the system as a whole (Epo Strong + coating) must be checked on the user's own responsibility, as the resilience of the coating system is impaired.
<b>Pre-treatment:</b>	The substrate must be free of oil, grease, dust, rust and other contaminants. Any wet-chemical pretreatment must be carried out before TIGER Epo Strong is applied.
<b>Processing:</b>	<ul style="list-style-type: none"> <li>- clean all rust, dust, oil and grease off the substrate</li> <li>- prepare the putty by mixing it with hardener 60/70010 in a 2:1 ratio (2 parts putty to 1 part hardener, by weight)</li> <li>- apply the putty until a layer thickness of max. 2 mm has been reached</li> <li>- stays workable for approx. 4 hours</li> <li>- hardening: forced drying is possible at 200°C (10 min), 160°C (20 min) or 60°C (2h), otherwise for 2 to 3 days at room temperature of 20°C</li> <li>- sand the dried putty</li> <li>- remove all sanding dirt</li> <li>- overcoat with powder or liquid coating</li> </ul>
<b>Packing:</b>	in 1.5 kg container (1 kg knifing putty + 0.5 kg hardener)



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