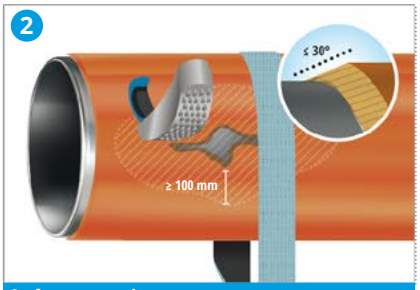
DEXPAND®-REP MT & -REP HT

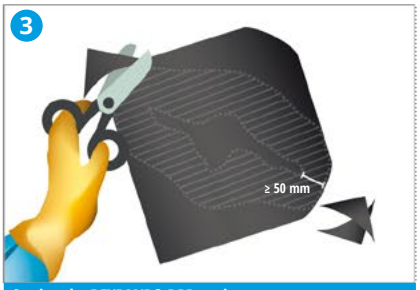
1 Cleaning

- 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 ≤ 30°.
- 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

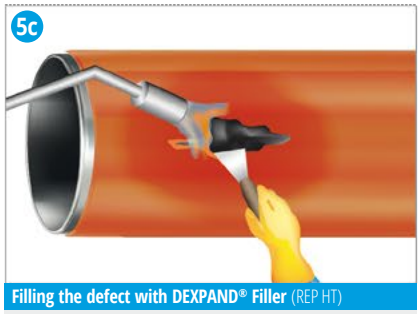
- **DEXPAND®-Filler/DEXPAND®-Mastic:** Use a low-intensity yellow-blue flame to preheat the area to be coated to approx. +50 °C (+122 °F).
- **DEXPAND®-Meltstick:** Heat the repair area (factory coating + defect area) from approx. +90 to +100 °C (+122 to +212 °F).

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.

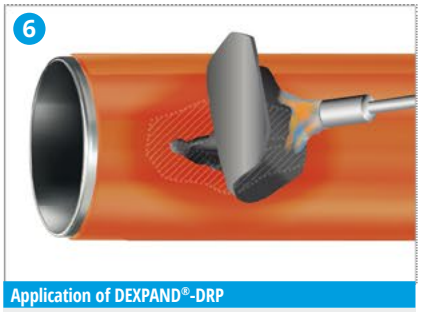
5b *Alternative: DEXPAND®-Meltstick (REP MT)

- **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.



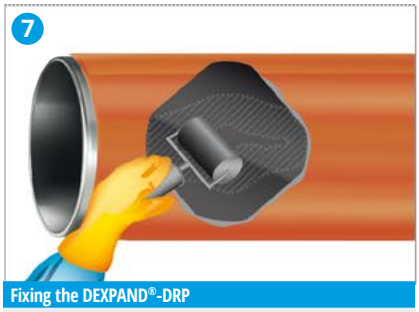
5c Filling the defect with DEXPAND® Filler (REP HT)

- **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 °C (+194 °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: Surface °C (°F)	Processing temperature: Material °C (°F)	Storage temperature °C (°F)	Compatible factory wrappings
DEXPAND®-DRP **DEXPAND®-Filler** **DEXPAND®-Mastic**	approx. +50 (+122)	+10 to +40 (+14 to +105)	≤ +50 (≤ +122)	Most common factory coatings
DEXPAND®-Meltstick	approx. +90 to +100 (+122 to 212)			
Surface preparation	Remove loose factory coatings, smooth notches and indentations and chamfer corners to an angle of ≤ 30°. Clean adjacent factory coatings on minimum 100 mm with #40 abrasive cloth in a peripheral direction.			
Occupational safety & environmental protection	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.			

DEKOTEC GmbH
Felderstrasse 24 | 51371 Leverkusen | Germany
Phone: +49 214 2602-0 | info@dekotec.com
www.dekotec.com

03.2024