

SBC

REPAIR PROCEDURE

(CATEPOX® Heat- and Wear-Resistant Coating)

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1. PURPOSE

This Repair Procedure defines the requirements for repairing damaged or non-conforming **CATEPOX® Heat- and Wear-Resistant Coating** systems.

The objective of this procedure is to restore the corrosion protection, mechanical performance and aesthetic appearance of the coating system as closely as possible to its original condition.

2. SCOPE

This procedure applies to:

- Repair of mechanical damage;
- Repair of local coating defects;
- Restoration of worn coating areas;
- Repair of corrosion-damaged surfaces;
- Correction of application defects identified during inspection.

It is applicable to all substrates coated with the CATEPOX® coating system where local repair is technically feasible.

3. DEFECT IDENTIFICATION

Before any repair work begins, the following shall be determined:

- Type of defect;
- Extent of the damaged area;
- Condition of the substrate;
- Degree of corrosion, if present;
- Appropriate repair method.

Where appropriate, the damaged area should be documented by photographs before repairs commence.

4. SURFACE PREPARATION

The damaged area shall be prepared by:

- Removing loose or damaged coating;
- Removing corrosion products;
- Cleaning and degreasing the surface;
- Removing dust and other contaminants;
- Mechanically roughening the surface where required.

The prepared substrate shall be clean, dry, sound and free from contamination before coating application.

5. MATERIAL PREPARATION

The CATEPOX® components shall be prepared in accordance with the Technical Data Sheet by:

- Measuring the correct mixing ratio;
- Mixing the components thoroughly;
- Achieving a homogeneous mixture;
- Applying the material within the specified pot life.

No additional solvents or additives shall be used unless specifically permitted in the Technical Data Sheet.

6. APPLICATION OF THE REPAIR COATING

The repair coating may be applied using:

- Brush;
- Roller;
- Airless spray equipment;
- Other approved application methods.

The repaired area shall achieve the specified dry film thickness and shall overlap sound existing coating to ensure continuous protection.

7. INSPECTION OF THE REPAIR

Following completion of the repair, the repaired area shall be inspected for:

- Complete coverage;
- Dry Film Thickness (DFT);

- Adhesion;
- Surface defects;
- Colour consistency;
- Complete curing.

Where specified, additional testing may be performed in accordance with the project specification or Quality Control Plan.

8. DOCUMENTATION

The following information shall be recorded:

- Project location;
- Date of repair;
- Identification of repaired area;
- Batch (LOT) number;
- Quantity of material used;
- Name of the person performing the repair;
- Inspection results;
- Any observations or corrective actions taken.

Repair records shall be retained as part of the project quality documentation.

9. HEALTH AND SAFETY

During repair work:

- The Safety Data Sheet (SDS) shall be followed at all times;
 - Appropriate Personal Protective Equipment (PPE) shall be worn;
 - Adequate ventilation shall be provided;
 - Open flames and ignition sources shall be prohibited where applicable;
 - Waste materials shall be disposed of in accordance with applicable environmental regulations.
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10. RELATED DOCUMENTS

- Technical Data Sheet (TDS)
- Safety Data Sheet (SDS)
- Application Guide

- Maintenance Guide
 - Inspection and Acceptance Checklist
 - Quality Control Plan
 - System Specification
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11. DOCUMENT CONTROL

This Repair Procedure forms part of the SBC document management system.

The document shall be reviewed whenever:

- A new repair technology is introduced;
- Product technical characteristics are modified;
- Applicable legislation or standards are revised;
- Or at least once every three years as part of the regular document review process.