

Protection upgraded

SurTec® 650 V Retouche TCP Repair Pen

Properties

- the repair pen is a special felt-tip marker, similar to highlighter pens, designed for the repair of mechanically damaged aluminium surface by scratches, abrasions, etc.
- contains a non-hazardous trivalent chrome solution
- especially suited for the repair of small or hard to reach areas on assembled and finished equipment
- restores the conversion coating layer through simple application of the pen
- produces an excellent corrosion resistance, comparable to hexavalent chrome processes
- QPL qualified: QPL-81706B, TYPE II, Class 1A and Class 3, FORM VI, METHOD D
- the restored conversion coating layer is an effective pre-treatment for optimum adhesion of subsequent paint, powder coating and adhesive applications
- IMDS-number: 511025914

Application

SurTec 650 V Retouche is applied manually by the pen.

Application time: 5 min (2-10 min)
pH-value: 3.8 (solution in the pen)

Application: Prior to the application of SurTec 650 V Retouche, the aluminium surface must be clean and free of oxides, e.g. by sanding and solvent wiping.

Steps for applying SurTec 650 V Retouche within a total time of 5 minutes:

1. Open the pen and push the felt tip into a piece of dry and clean cotton until the felt tip is totally soaked with liquid.
2. Wet the damaged aluminium surface area completely and quickly with firm pressure by the felt tip.
3. If there is too little liquid to wet the relevant surface area completely then press the felt tip once again until the liquid is evenly distributed. Let the solution take its effect on the surface, and make sure that the surface is constantly wet.
4. Every 1 minute spread the solution with gentle pressure and apply fresh solution if necessary, to avoid a drying-out of the surface.
5. Repeat this procedure until a total treatment time of 5 minutes is accomplished.

During the entire treatment period, the surface needs to be permanently wet; in no case it is allowed to dry out. Hence, the spreading interval of the solution might be shorter than 1 minute, depending on the climatic conditions.



Hints: After the conversion coating, the parts can be rinsed or just wiped dry. For best corrosion resistance and best paint adhesion, a rinsing with deionised water is recommended (conductivity: < 30 µS/cm). The drying temperature should not exceed 65 °C at the part's surface, ambient air drying for 30 min is recommended.

Treated surfaces can be coated immediately after drying or stored as long as they are protected from contamination and temperature extremes. For optimum results, the parts should be coated within 7 days.

Product Safety and Ecology

Classification and designation are noted in the **Material Safety Data Sheets** (according to the European legislation). The safety instructions and the instructions for environmental protection have to be followed in order to avoid hazards for people and environment. Please pay attention to the explicit details in our Material Safety Data Sheets.

Warranty

We are responsible for our products in the context of the valid legal regulations. The warranty exclusively accesses for the delivered state of a product. Warranties and claims for damages after further processing of our products do not exist. For details, please find our country-specific **General Terms and Conditions** for downloading on our homepage or ask your regional SurTec representative.

Further Information and Contact

If you have any questions concerning the process, please contact your local technical department.

For further information and contact details, please visit our homepage:

<http://www.SurTec.com>

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