



Repairing OPACI-COAT-300® Using a Preval® Sprayer

Date: Feb 21, 2020

Supersedes Date: N/A

Bulletin Number: #22

ICD's OPACI-COAT-300® silicone elastomer may easily be repaired when minor damage has occurred to the dried film using a Preval® Sprayer (available from ICD).

It is important to note that “minor damage” generally refers to scrapes, scratches, small gouges, etc. that may occur when moving, packaging, unpacking and installing the coated glass. This type of damage may be caused by the edge of one lite scraping the coating on another, a box knife cutting plastic wrap away from a rack of glass scratching the coating, scrapes, scratches or gouges from other tool contact, etc.

Larger areas of damage from a broader scrape, peel or gouge may not be repairable. A successful repair should not be noticeable when inspected according to ASTM C1048 standards for coated glass inspection (test method 10.10 with appearance acceptability in accordance with 8.3.1).

To repair minor damage:

1. Ensure any loose or clinging film has been completely removed from the damaged area.
2. Wipe the damaged area with a clean, cotton cloth and isopropyl alcohol to ensure the coating surface and exposed glass surfaces are thoroughly clean.
3. Allow the alcohol to flash off completely before proceeding.
4. Fill the spray container, through a paint strainer, with the same OPACI-COAT-300® product used to produce the coating that has been damaged—this coating must be supplied by the Approved Factory Fabricator that supplied the coated glass. NOTE: Using any other lot of coating (even if it is the same color number and name) may result in noticeable color difference. See note at step 9.
5. Ensure the dip tube is secured firmly in the bottom of the sprayer and remove the small filter from the end of the dip tube to allow thicker coating to flow. NOTE: If a roll coat formulation was used to produce the coated glass, the repair coating may need to be reduced by no more than 10% water.
6. Despite instructions printed on the sprayer, DO NOT shake the product in the container and do not shake the spray power unit itself.
7. Attach the container to the power unit and tighten the coupler hand tight.
8. Rotate the spray tip so the red insert is opposite the air vent (v-notch) on the coupler.

9. Practice spraying on a piece of cardboard to allow coating to flow through tube and sprayer. NOTE: Test spray a small area near a corner and allow to dry. Ensure dried coating color visually matches the original coating.

10. Repair damaged area on the coated glass by depressing the spray button with the sprayer in motion, at no greater than 45° tilt and 6-10 inches from the surface being coated.

11. After each pass, release the spray button while the sprayer is still in motion to avoid running.

12. Overlap each pass and continue until the repair area is sufficiently coated.

13. After the repair area has dried, inspect the appearance through the glass in accordance with ASTM C1048.

14. If the damage is still noticeable, further coats may be necessary—otherwise, the damaged area may not be repairable.

For a short video demonstration of this process, please visit the portals at www.icdcoatings.com

Please call ICD Technical Services, at (360) 546-2286, regarding any questions about the information provided in this bulletin.