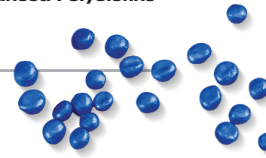


Invision® Enhanced Polyolefin Resin

Repair Guidelines for the Decorative Finish of Non-Painted Invision® Parts



Invision® resins are based on enhanced polyolefin compositions that have been specifically designed to provide high performance for sheet extrusion and thermoforming applications. *Invision* resins can be categorized within the thermoplastic olefin family of polymers. The materials are highly durable, but minor scuffs and scratches on the surface of parts produced with *Invision* resin can occur during normal use. As such, damage to non-painted parts in the form of minor scuffs and scratches can be repaired using the suggested procedure, materials and equipment listed here.

Repair System Suppliers:

- Nu Finish Scratch Doctor (stock #: NFS-05) or similar product, www.nufinish.com
- Kimberly Clark Kim Wipe Tissue – Delicate task type, Available at various retail outlets
- Milwaukee Heat Gun (model #:1220 or similar model), Home Depot (www.HomeDepot.com)

General Repair Procedure

- 1) The surface must be clean prior to starting the repair process. Clean with dish detergent soap and water in order to remove all dirt and grease. After rinsing with water, pad dry with a clean, soft cotton cloth or Kim Wipe brand tissue.
- 2) Use a heat gun (on low setting) to apply heat over the damaged area. Using a constant circular motion, apply heat in short time intervals such as 2-5 seconds and then remove. Evaluate surface between heat applications and repeat as necessary until the desired results are achieved. The goal is to slightly soften or melt the outer most surface of the clear coat. The surface will obtain a “wet” look as soon as the surface is softened. If heat is applied for too long at a location and the surface temperature becomes excessive, permanent damage will occur in the form of part warpage and/or surface discoloration. This repair procedure is most effective when applied over a small area. Large areas of repair should be divided up into smaller sections.
- 3) If haze occurs after removing scratches, apply Nu Finish Scratch Doctor in a circular motion with a clean soft cotton cloth or Kim Wipe brand tissue. Let dry to a haze and then wipe off with a clean, soft cotton cloth or Kim Wipe brand tissue.

Warning: The surface of the repaired area must be allowed to reach ambient temperature before applying Nu Finish Scratch Doctor. If Nu Finish Scratch Doctor is applied while the surface is still hot permanent damage will occur.

- 4) To repair deep scratches and gouges which cannot be satisfactorily repaired with the above procedure, a paint repair procedure may be used. Reference the technical data sheet titled “General Guidelines for Painting *Invision* Resins” for repair suggestions. If the scratch or gouge does not fully penetrate the color coating, a painted clear coat covering the entire part surface may be sufficient to restore the part surface appearance.