



Tedlar®

polyvinyl fluoride film

Painting and Repair of Tedlar® PVF Film Surfaced FRP

Introduction

Pigmented *Tedlar*® films bonded to glass fiber-reinforced polyester laminates for the transportation industry can be either repaired with *Tedlar*® tape or painted. Paint systems for complete panel finishing, graphics, spot repairs, or scratches have been studied and are described here. Note that the paint procedures for *Tedlar*® films avoid sanding of the *Tedlar*® film itself. Sanding destroys the *Tedlar*® film surface treatment, impairs paint adhesion to the film, and may lead to humidity blistering. Contact your local Dupont Refinish Representative if specific information is needed on any of the DuPont Automotive Refinish products mentioned in this bulletin.

Complete Refinishing or Graphics

Damaged areas should be cleaned, filled, and sanded smooth according to the directions supplied by the laminate manufacturer. No rough edges should remain. **Do not sand the *Tedlar*® film surface.**

Clean the *Tedlar*® film surface with a solvent for removal of waxes, oils, grease, and mold release. Materials such as acetone, isopropyl alcohol, DuPont Prep-Sol® 3919S, 3812S, 3832S, Final Klean™ 3901S, Plas-Stick™ Plastic-Prep 2319S, or equivalent have been used for this purpose. The key is to sufficiently clean the *Tedlar*® film surface with a substance that is also compatible with the primer or topcoat to be used. Be sure to change cloths frequently.

Apply a quality topcoat according to normal procedures. Use of a primer may be necessary to level

the repair area, promote adhesion between layers of different paint and/or filler chemistries, or to provide uniform texture prior to top coating. We recommend priming the *Tedlar*® film surface and painting with a urethane enamel (e.g., DuPont Imron®) or acrylic enamel (e.g., DuPont Centari®). Applying primer (e.g., DuPont Corlar®) will yield optimum system appearance; however, this step may be omitted depending on customer preference. Priming is necessary for good adhesion when applying a topcoat of DuPont Imron®.

Spot or Scratch Repairs

After repair has been made and the repair area cleaned as described above, seal the repair with DuPont Prime-N-Seal™. Priming is optional, but if a particular situation is a problem, apply a primer. Then apply an acrylic enamel (e.g., DuPont Centari®).

Color Matches for *Tedlar*® Films

Color	Tedlar® Film	High-Gloss Match	Low-Gloss Match
White	TWH15BS1	K8781 A or U	G8818A
Yellow	TRY15BS1	K8782 A or U LFK8782 A or U	M1199A LFM1199A

A = Centari® U = Imron®

The white color is lead free. Centari® and Imron® lead-free yellow color matches are identified by the LF prefix. The use of an adhesion promoter (e.g., DuPont Plas-Stick™ Adhesion Promoter for Plastics 2322S) may improve adhesion between the paint or primer and the *Tedlar*® film.

Testing Paint Adhesion

If desired, paint adhesion to the *Tedlar*[®] film can be tested on a *sample* FRP panel. After cleaning and painting a sample panel, allow seven days to achieve full paint cure to the *Tedlar*[®] film. Once the cure is complete, use an X-Acto[®] knife to cut a grid pattern or an "X" into the paint surface of the laminate to be tested. Place tape (3M #600, 3M #610, or equivalent) over the cuts in the paint and firmly press the tape onto the surface. Next, lift the tape off of the panel. The paint should remain on the panel, indicating good system performance.

X-Acto[®] is a product of Hunt Mfg. Co.

Tedlar[®] Repair Tape

Tedlar[®] repair tape can be used in place of painting for spot or scratch repairs to save on time. Simply clean the area to be repaired and apply filler material. The filler does not need sealing properties because the tape itself acts as the sealant. Next, sand the repair area and reclean the surface. Then apply the repair tape by peeling off the backing and adhering the tape to the panel surface with a squeegee, making sure to press out the air bubbles. The tape provides a blended finish without a color difference.

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CAUTION: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Medical Caution Statement," H-50102.

CAUTION: *Tedlar*[®] film is not approved for ultralight aircraft.



Tedlar[®]

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