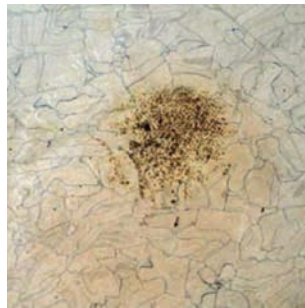


# UK Guidance Note: Colorex SD/EC Damaged Surface Repair and Restoration Process

Colorex SD/EC surface repair and restoration techniques can be applied in all those cases where conventional maintenance would be ineffective, such as:

- Physical damage such as deep scratches, holes, burns etc.
- Extensive soiling within industrial areas or marks by repeated heavy rolling traffic
- Surface discoloration, damage or dulling caused by extended exposure to etching chemicals or solvents
- Stubborn stains, paint, dried out glue, spilled soldering paste etc.



Colorex can be fully repaired and restored back to like-new conditions by “homogeneous welding” and abrasive surface techniques, without leaving any trace and without impairing the original surface characteristics, performance or appearance.

## Repair

Required tools and equipment:

- Hot welding gun
- Flat type repair welding nozzle
- Grinding machine with set of sanding discs (Grades 120/180/240)
- Crescent shape knife
- Hand grooving tool with round blade
- Green and red polishing pads, small size
- Sharp scraper (optional)



## Repair procedure for deep scratches or holes:

1. Where necessary, clean and smooth out the scratch with the hand grooving tool or scraper. Creating a larger groove to expose clean material will ensure a true homogeneous welding process.

Cut a strip of Colorex, approx. 1cm wide, of the same colour reference as the floor.



2. Set the welding gun temperature to approx. 450°C.

Slide the Colorex strip into the flat repair nozzle, bottom side up. Prior to proceeding, test the temperature on the Colorex strip. The material should just become very soft without melting or discolouring.



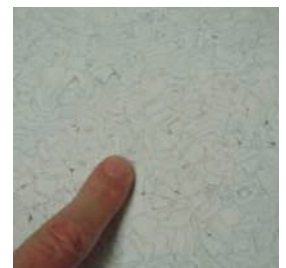
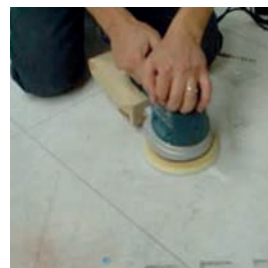
3. Firmly press to weld the strip into the groove. Proceed carefully, in small stages, each time applying adequate pressure on the repair nozzle. When completed, pull on the exposed end of the strip to test the welding result. If the strip comes off easily, start process again with the weld gun set at a higher temperature.



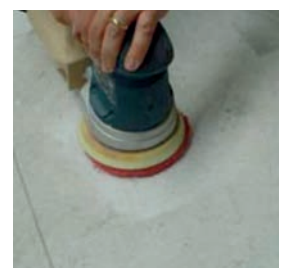
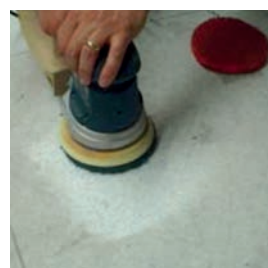
4. While still warm, remove excessive parts of the strip with the crescent shape knife (and/or sharp scraper) and then allow the repair to cool down completely.



5. When fully cooled, the welding can be made flush with the floor by using the grinder. Start sanding with a coarse sandpaper grade (120) and proceed in several steps up to 240. After grinding, no trace of the repair should remain visible.



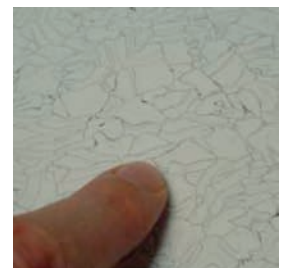
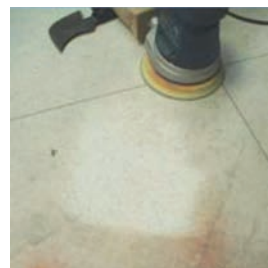
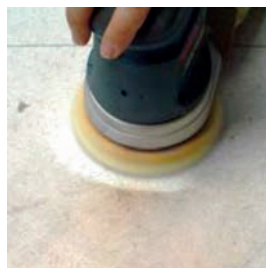
6. Complete by restoring the original surface smoothness of the repaired and grinded area by dry burnishing with a green pad first and then with a red one.



#### Repair procedure for burns or other serious surface harm, caused by spillage of etching chemicals or solvents:

For spot repairs, proceed with steps 5 and 6 as described above.

**Note:** that this technique is not appropriate for large areas. Refer to "restorative maintenance" in the next section.



## Restorative maintenance

Required equipment and products (refer to picture):

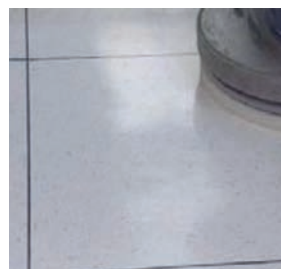
- Low speed single disc machine (150-300 rpm)
- Set of pads (black, brown, green or blue, red and white\*)
- Wet vac
- Bucket trolley and mop
- General purpose cleaner, pH neutral



**\*Note:** Cleaning pads for use with single disc machines are colour coded according to their degree of abrasiveness. Black is the most abrasive grade, red the least abrasive one. White pads are not abrasive and are used to dry buff the floor for a higher sheen appearance.

### Procedure:

1. First sweep or vacuum clean the floor to remove loose dirt and debris. Wet scrub the floor with the single disc machine and a brown or black (most abrasive) pad.
2. Remove the dirty cleaning solution with a wet vac. Rinse with clear water and finish with a wet vac. At this point, the floor will be visually clean, but the surface will be quite rough and needing to be restored.
3. Restore the original surface smoothness and quality by dry burnishing with the low speed single disc machine and pads in decreasing degree of abrasiveness.
4. For example, start with the green and then continue with the red one.
5. If a higher sheen appearance is required, dry buff with the white pad.



A full restoration video which includes the above procedure can be found in the ESD and Cleanroom installation products section (You Tube Guides) of the Forbo website:  
**[www.forbo-flooring.co.uk/ESDInstallation](http://www.forbo-flooring.co.uk/ESDInstallation)**

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