



ALUMINUM REPAIR PROCEDURE - NATIONAL RULE



****Note – It is recommended that separate tools and sandpaper are used on aluminum components to avoid cross contamination.**

Clean the repair area prior to any sanding or grinding. Use Axalta™ 200 to remove wax, grease and other contaminants. Soak a cloth with cleaner and wipe the area thoroughly. Use a clean dry cloth to dry the area. Do not allow cleaner to dry on surface prior to wiping with dry cloth.

REPAIR REQUIRING BODY FILLER:

- Remove paint using a DA sander with 80 grit to bare metal. Blow dust off with clean, dry compressed air. Featheredge the area stepping down from 80 to 180 grit DA paper.
- Wipe the area with Axalta™ 200, Axalta™ 210 or Axalta™ 220 pre-paint cleaner. Apply with a soaked cloth and dry with a clean dry cloth. Do not allow cleaner to dry on surface prior to wiping with dry cloth.
- Mix 25X0S DTM Epoxy Primer-Sealer 2:1 with 250XS activator. Apply a medium wet coat over the bare metal area. Bake Primer-Sealer at 140°F metal temperature for 20 minutes using IR or conventional booth or allow to air dry for 16 hours and allow to cool.
- Apply body filler over primed area to fill the imperfection. After body filler has hardened, sand with 80 grit followed by 180 grit until damaged area is filled.
- When body filler process is finished, featheredge the repaired area working down from 80 to 180 to 240 grit sandpaper on a DA sander to ensure a proper featheredge.
- Prime bare metal areas with 25X0S DTM Epoxy Primer-Sealer. Apply one medium wet coat and allow to flash 30-45 minutes prior to applying primer-filler.
- Apply 770XS or 33430S™ urethane primer-filler per label directions. Allow primer to dry and sand as necessary.
- Proceed with balance of refinishing process.

REPAIR WITHOUT BODY FILLER:

- Featheredge repair area stepping down from 80 to 180 to 240 to 320 grit DA sandpaper, dependent on the depth of repair. Use finest grit possible. Blow dust off with clean, dry compressed air. If bare aluminum is present, a pre-treatment type primer is required.
- Wipe the area with Axalta™ 200, Axalta™ 210 or Axalta™ 220 pre-paint cleaner. Apply with a soaked cloth and dry with a clean dry cloth. Do not allow cleaner to dry on surface prior to wiping with dry cloth.
- Etch Primer Options:
 - Option 1**
 - Mix Axalta™ 420 etching primer 1:1 with Axalta™ 421 converter. Apply two medium coats over the bare metal area. Allow etch primer to flash dull between coats.
 - After Axalta™ had flashed 30 minutes, apply urethane fill primer.
 - Option 2**
 - Mix Axalta™ 420 etching primer 1:1 with Axalta™ 421 converter. Apply one medium coat followed by 1 full coat, without intermediate flash-off, over the bare metal area. Allow etch primer to flash dull.
 - After Axalta™ 420 has flashed 30 minutes, apply urethane fill primer.
- Mix 770XS or 33430S™ urethane primer-filler per label directions. Apply primer-filler using an outside-in technique. Allow each coat to flash before applying the next coat. Allow primer to dry thoroughly and sand as necessary.
- Proceed with balance of refinishing process.

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