

Aluminum Repair Process - National Rule Markets

Technical Information

TB-017



NOTE: Wear the proper safety protection during this process. To ensure proper corrosion protection and adhesion, specific steps **MUST** be followed when preparing and priming bare aluminum substrates.

Clean entire part:

- Use an approved solvent based wax and grease remover (check local regulations), such as ONECHOICE® SXA330 ACRYLI-CLEAN® Wax & Grease Remover and a clean towel. Dry thoroughly.
- Follow with *OneChoice* SWX350 H2O-SO-CLEAN® Waterborne Pre-Cleaner and a clean towel. Dry thoroughly.

Prepare bare aluminum areas:

IMPORTANT: To avoid galvanic corrosion, never use the same piece of sandpaper on both steel and aluminum. Avoid cross contamination of airborne steel and aluminum particles generated in common shop areas.

- Sand exposed aluminum using a DA sander with 120-180 grit sandpaper and interface pad.
- Re-clean entire part with an approved wax and grease remover.

Prime:

IMPORTANT: Prime or etch prime bare aluminum substrates immediately. Oxidation can form on exposed aluminum surfaces in as little as 15 minutes. If necessary, scuff and re-sand prior to priming.

Prime bare aluminum areas one of two ways:

1. DPLF or DPLV Epoxy Primer or
2. *OneChoice* SX1071 ECOBASE® 5.5 Etch Prime, followed by an appropriate primer surfacer or sealer. Do not apply DPLF, DPLV or body fillers over etch primer.
 - If DF Body Fillers are needed you **MUST** first prime with DPLF or DPLV Epoxy Primer.

Note: Refer to specific product bulletins for detailed information regarding the use of all products listed within this document. Check local regulations for area restriction rules.

