



# Metal Surface Prep Bare Aluminum

**Caution: Wear the proper safety protection when sanding, cleaning, mixing and spraying all materials included within this process.**

To ensure proper corrosion protection and adhesion, specific steps MUST be followed when preparing and priming bare aluminum substrates. These procedures apply to a damaged painted OEM panel or an e-coated OEM replacement panel.

Step #	Action	Products
1	<b>Clean entire part</b> a) Use an approved solvent-based wax and grease remover (check local regulations) and a clean towel. Dry thoroughly. b) Follow with waterborne pre-cleaner and a clean towel. Dry thoroughly.	DX330* or similar followed by SWX350
2	<b>Inspect part</b> for imperfections and damage. Determine what repairs should be made if any (follow all process documents for repairs made to the part).	---
3	<b>Prepare bare aluminum areas</b> – After making any necessary repairs, sand exposed aluminum using a DA sander with 120-180 grit sandpaper and interface pad. Featheredge existing finish using a DA sander with 320 grit sandpaper and interface pad. Re-clean entire part. Spot treat or prime bare aluminum areas as outlined below in step <b>4A, 4B or 4C</b> .  <u>IMPORTANT:</u> 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 the same shop areas. <u>CAUTION:</u> under proper conditions, aluminum dust can be combustible.	120 – 180 grit and 320 grit sandpaper
4	<b>Prime or chemically treat bare aluminum</b> substrates immediately. <u>IMPORTANT:</u> oxidation can form on exposed aluminum surfaces in as little as 15 minutes! If necessary, scuff or re-sand prior to priming.	---
Option 4A**	<b>Etch Primer</b> followed by surfacer or sealer and PPG topcoat system (refer to PD-0700 or PD-0700WB). <u>IMPORTANT:</u> do NOT apply epoxy primer, body filler, or topcoat directly over etch primer.	SX1071
Option 4B**	<b>Epoxy Primer</b> followed by body filler or surfacer or PPG topcoat system (refer to PD-0700 or PD-0700WB).	DPLF* or DPLV
Option 4C**	<b>DX Metal Treatments*</b> followed by epoxy primer and body filler or surfacer or PPG topcoat system (refer to PD-0700 or PD-0700WB). <u>IMPORTANT:</u> do NOT apply etch primer, DPLV, body filler, or topcoat directly over DX Metal Treatments.	DX533, DX503*, and DPLF*
NOTE:	<b>To prevent dissimilar metal corrosion</b> where bare metals make contact with one another (bolts, rivets, hinges, etc.), ECK® (Electrolysis, Corrosion, Kontrol) should be applied. Refer to ECKPB01 for complete details.	ECK®

\*Cannot be used in some areas due to VOC or heavy metal restrictions. Refer to local regulations.

\*\*Refer to individual product sheets for complete mixing and application procedures and approved product systems.