



Working Process: Aluminum Repair Process

Substrates: Aluminum

It is recommended that separate tools and sandpaper be used on aluminum components to avoid cross contamination. Follow all OEM requirements for aluminum structural and repair processes. Exposed, abraded aluminum must be primed within one hour to prevent oxidation which may lead to adhesion or corrosion failure.

Surface Preparation:

For substrate cleaning, see **Standex** Painting System S1.

Clean with compliant **Standex** Silicone Remover or **Standex** Solvent Cleaner or **Standohyd** VOC Cleaner 25. Do not allow cleaner to dry on the surface prior to wiping. Sand area to be repaired with 80 grit, featheredge with 180 grit. Sand all areas where primer will be applied with 320 grit.

Final clean with **Standohyd** VOC Cleaner 25 or compliant **Standex** Silicone Remover or **Standex** Solvent Cleaner. Do not allow cleaner to dry on the surface prior to wiping dry with a clean cloth.



Primer Application: See TDS 931, 931.1

- For aluminum repairs that require body filler, apply 2 coats of **Standex** 2K EP Primer (Aerosol) to the aluminum substrate. Force dry 30 minutes @140°F (60°C) panel temperature or air dry overnight. Lightly de-nib or sand, then apply body-filler to the **Standex** 2K EP Primer (Aerosol). Properly sand, featheredge body filler, finishing with 180 grit or finer. Re-apply **Standex** 2K EP Primer (Aerosol) to any cut-throughs if more body filler needs to be applied.
- Using the outside-in technique, apply **Standex** PF Filler to repair area. Select the proper undercoat shade dependent on topcoat color required. Finish sand with 600 grit, scuffing all edges first with appropriate scuff pad. Blend areas should be scuffed first with a gold scuff pad and finished with P1000 grit or P1000 grit Trizact™. Final clean with compliant **Standex** Silicone Remover or **Standex** Solvent Cleaner or **Standohyd** VOC Cleaner 25.
- For repairs not requiring body filler, apply 2 coats of **Standex** Low VOC Etching Adhesion Primer to the aluminum substrate. Apply **Standex** PF Filler using the outside-in technique. Use all appropriate sanding processes as described just above.

Important Technical Remarks:

- Oxidation forms immediately on exposed aluminum. If exposed for more than one hour the aluminum must be re-abraded and re-cleaned before applying any primer system.
- Utilize separate repair work areas, tools, sandpaper, and vacuum systems to avoid cross contamination. Follow all OEM recommendations for bonding, riveting, or welding of aluminum.
- Do not grind or sand aluminum substrates with grits coarser than 80 grit sandpaper.
- Refer to TDS 931.1 and TDS 931 for specific and complete **Standex** 2K EP Primer product details.
- Do not apply 2K EP Primers over **Standex** Low VOC Etching Adhesion Primer or **Standex** 1K Primer Light Gray (Aerosol).
- For small areas of exposed aluminum such as cut-throughs, **Standex** Low VOC Etching Adhesion may be used; refer to TDS 312 and TDS 313. Etching Adhesion primers must be followed by **Standex** PF Filler or **Standex** PF Sealer.

Important Legislative Remarks:

- For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.