



**IMRON®**

# Bare Aluminum or Steel Process

## Step 1 | Clean

- Clean bare steel or aluminum with Axalta 200 solvent wipe completely using Sontara towels E-4143
- Dry then re-clean 1 more time before sanding

## Step 2 | Sand

- DA sand with 220 grit final sand on bare steel or aluminum, 180 grit for stainless steel, nothing finer
- Note: Do not use finer sand paper on aluminum as loss of adhesion could occur

## Step 3 | Clean

- Blow off and re-clean with Axalta 200 Silicone Remover using the 2-rag method
- Wipe completely dry

## Step 4 | Mix and Apply

- Mix pretreatment as per TDS. Apply pretreatment epoxy Metalok® 235S non-chromate or 250S with chromate. Allow proper dry time
- Mix and apply 2-component primer as per TDS
- Review the available undercoat options

## Step 5 | Apply

- Apply urethane topcoat or urethane basecoat color followed by urethane clearcoat as per the TDS and SOP

## Step 6 | 5S (Sort, Straighten, Shine, Standardize, and Sustain)

- Clean spray gun
- Dispose of waste according to local environmental regulations
- Return all items to their proper place