

PREPARATION PROCESS FOR SEAM SEALER



Step 1: Prepare surface

- If applicable, all pinch welds need grinding and/or abrading to ensure smoothness and adhesion of the entire area to be primed and sealed.
- Remove corrosion from the area to be primed and sealed and clean thoroughly. Use an appropriate (Axalta) silicone remover and a suitable degreasing cloth. For more details refer to "Preparatory surface degreasing SOP".
- Sand panel or area in preparation for primer or primer-surfacer/filler application. Do not use abrasives coarser than P240-P320 when using DA/orbital sander in readiness for primer, primer-surfacer or filler application.
- Reclean the surface to be primed with the recommended solvent or waterborne silicone remover. For more details refer to "Preparatory surface degreasing SOP".



Step 2: Apply primer

- Mix, apply and dry suitable Axalta 2K Epoxy Primer Surfacer.
- Alternatively mix, apply and dry suitable Axalta Etching Primer followed by a 2K Surfacer/Filler.



Step 3: Sand area

- After drying, sand the primer-surfacer, surfacer or filler in readiness for topcoating and to ensure adhesion of the seam sealer.
- Reclean by using an appropriate Axalta silicone remover or waterborne cleaner depending on the basecoat/ topcoat quality to be used.



Step 4: Apply seam sealer

- Apply the appropriate seam sealer to match the OEM application as closely as possible.
- Follow Seam Sealer technical data sheet for topcoat procedure.



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CLEAN AND TIDY UP



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