

## **Best Practices for Preparing aluminum for Repair and/or Welding Part 2**

- **Remove paint from repair area using a 4 inch medium scotch brit flap disc or 80 grit DA sanding (**Do not use 36grit or 50grit grinding disc—thins out the metal**).**
- **Clean area using Best Practice for Aluminum cleaning.**
- **Use aluminum flap disc to remove excess welding material on part (Fastest and best way). (A 50 grit grinder can be used but do not take the sanding down to surrounding metal. Finish removing excess weld with 80 grit DA).**
- **Finish aluminum panel with a fine or ultra-fine scotch-brite flap disc.**
- **Check for any cracks with the dye check process (See Best Practice for Checking for Cracks with Dye Check Kit).**
- **Apply epoxy primer to bare aluminum. (See Best practice of applying epoxy primer).**
- **Apply body filler designed for Aluminum.**

*This document is courtesy of Kent Automotive's Partners in Profitability Program*