

# Aluminum spot repair guide

Well done! You, or your client, made the right choice by choosing aluminum sidewalls for your vehicle. Aluminum is the right choice for many reasons: it has a high-end automotive look, superb color and gloss retention and the lowest weight per square foot. Amerimax is the leading provider of coated aluminum to the RV market and has decades of experience handling the material. This means we also have more than 50 years of experience when it comes to repairs. Repairing our aluminum sidewalls is nothing new or fancy. In fact, coated aluminum is used extensively in the automotive industry and therefore, our products are spot repairable in accordance with automotive spot-repair procedures.

We are committed to giving our customers the best possible experience, this means that we share our expertise and are there to help you wherever we can.

This manual is intended for use by repair professionals when performing spot repairs on aluminum sidewalls. Before starting a spot repair, please be advised that most light scratches can be removed by polishing. If polishing alone is not sufficient, please use this procedure.

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## What you need to know before you start

1. This manual outlines the spot repair procedure for scratches and is intended for professional use. It is important to have a well-equipped spray booth with all the necessary equipment. All colors are spot repairable in accordance with this procedure.
2. For non-metallic sidewalls, this procedure is suitable for scratches in an area of up to 2 sqft. For metallic sidewalls, this procedure is suitable for scratches in an area of up to 1 sqft.
3. If scratches occur in a larger area than mentioned above, it is advised that the repair professional and the owner of the vehicle decide on the amount of square feet that needs to be repainted together. This will vary on a case-by-case basis, depending on the exact position of the scratch. When in doubt, please do not hesitate to reach out to Amerimax at [info@amerimaxfm.com](mailto:info@amerimaxfm.com).
4. For all steps of the procedure, we recommend using products of professional, well-known paint suppliers (AkzoNobel Sikkens, Sherwin Williams, or PPG).

## Spot repair: step-by-step procedure

- ✓ **Step 1: Clean the surface that will be repainted**
  - Remove dirt, dust, and grease from the surface, using alkaline cleaner
- ✓ **Step 2: Polish the cleaned surface**
  - Using a mechanical polisher until an even, smooth surface appears
- ✓ **Step 3: Sand the cleaned surface**
  - Using an electrical sanding machine, we recommend a first round of rough sanding (grit 200 - 250) and a second round of more delicate sanding (grit 300 - 400)
- ✓ **Step 4: Apply primer with UV protection (UV primer)**

Steps 4 and 5 only apply in case of a deep scratch that exposes the metal, otherwise proceed to step 6.

  - Apply 20-30mu thickness
  - Allow the primer to dry for 4-6 minutes
- ✓ **Step 5: Sand the UV primer**
  - Using an electrical sanding machine, sand in three rounds from least to most delicate (grit 300 / 400 / 500)
- ✓ **Step 6: Apply Basecoat**
  - If available, you can find the color code using the QR code on the sticker in the vehicle
  - Otherwise, match the required color by measuring the original surface color (spectrometer)
  - Ensure paint spray direction is horizontal
  - Apply 30-40mu thickness
- ✓ **Step 7: Apply clearcoat with a thickness of 20-30mu**

Step 7 only applies in case of a metallic color, for unicolor surfaces proceed to step 8.
- ✓ **Step 8: Polish the surface**
  - Using pads and a polishing agent, polish in three steps (rough / delicate / extra delicate)
- ✓ **Step 9: The vehicle looks as new and is ready to go!**