

# Painting Aluminum Panel Directions

## Overview:

Sand aluminum panel, paint primer, paint base color (text color), sand base color to remove high areas, let the paint dry, paint top color, sand if needed, repaint top coat lightly if necessary, let the paint dry, ship.

## Detail Directions:

- \* Sand aluminum with 220 grit sand paper
- \* Paint panels with a primer such as Zinc Chromate
- \* Measure thickness of the panel now to be able to determine how thick the base coat paint will be.
- \* Paint Base Coat (Text Color) to approximately .005"+ thick. Paint and sand as needed to achieve a .005"+ thickness before applying the top coat. More is O.K. for engraving purposes, but if too thick the paint may crack if the panel flexes after installation.
- \* Sand only the high spots until flush to surrounding areas. Common areas of concern are around the holes and edges which tend to have a thicker areas of paint. The reason for sanding these areas is because our engraving machine uses a nose cone to control the cutter depth. This nose cone has a diameter of 3/4" and rides on the painted surface, if the nose cone were to run over a high spot of paint it would lift the cutter away from the adjacent surface areas and the text would not be engraved or have a thinner line width & depth. Let the paint dry! If you paint the top coat too early the bottom layer of paint will not have a chance to dry fully which will affect it's engravability. Hard dry paint engraves much better than soft paint.
- \* Paint Top Coat as needed to cover base coat. Sand and repaint if necessary.
- \* Let dry fully before shipping

