**Caution:** Wear the proper safety protection when sanding, cleaning, mixing and spraying all materials included within this process.

PD-1590

SANDING PRIMER SURFACER

IMPORTANT—If you are not ready to paint, do NOT sand. Sanded primer that sits for days can become contaminated. When you’re ready: sand, clean and paint.

If you intend to wet sand the primer surfacer, you should paint within 24 hours. After 24 hours, re-sanding or re-scuffing is required since two-component primers may have case hardened.

1 **Apply**

dry guide coat primed area for final sanding.

2 **Block sand**

the entire area with P320 grit using a flat sanding block to remove the dry guide coat. Clean with an appropriate PPG cleaner. Ready for wet-on-wet sealer application. Refer to **PD-1701**.

3 OPTIONS

**Sealer as Final Prime:** Sealer has more resin than surfacer to create a harder surface to paint. This inhibits the solvent from penetrating into the undercoats and leads to better gloss of the final finish. Refer to **PD-1530** for more information.

**Prep for Single-Stage Color without Sealer:** Reapply dry guide coat. Using a flat sanding block and P400 grit sandpaper, remove the dry guide coat. Ready for **PD-1720**.

**Prep for Waterborne Basecoat Color without Sealer:** Reapply dry guide coat. Using a flat sanding block and P600-800 grit sandpaper, remove the dry guide coat. Hand sand edges using gray scuff pads. Ready for **PD-1710**.

**Prep for Solvent Basecoat Color without Sealer:** Reapply dry guide coat. Using a flat sanding block and P500-600 grit sandpaper, remove the dry guide coat. Hand sand edges using gray scuff pads. Ready for **PD-1715**.

**NOTE:** If dry guide coat remains in low areas or if body filler is exposed, then additional primer surfacer must be applied. If bare metal is exposed, epoxy primer must be applied to bare metal area for corrosion protection, then primer surfacer may be reapplied.

4 **Blow away**

sanding dust while wiping with a clean cloth. Clean all panels with the appropriate PPG cleaner, using clean cloths to dry thoroughly. Tack off all panels.