



Technical Service Bulletin

Repair of Magnesium Substrates

Number: GLABUL0105-E

Magnesium substrates are growing in popularity in a variety of both OEM and aftermarket applications. In order to keep Glasurit shops ahead of the curve, Glasurit Technical Service is pleased to announce the following procedure for refinishing magnesium substrates.

Magnesium Repair Process

1. Clean the magnesium substrate with Glasurit 360-4 Metal Cleaner and dry.
2. Sand with P80; the use of a DA is recommended. If sand or media blasted, ensure all residue is completely removed before refinishing.
3. Re-clean with Glasurit 360-4 and dry.
4. Apply 2 coats of Glasurit 801-1871 Epoxy Primer (chromated) using Glasurit 965-32/2 Activator and Glasurit 352-Series reducers. Bake for 30 minutes @ 140°F.
5. When cool, sand with P400. Wipe sanding residue with Glasurit 541-5 Silicone and Tar Remover.
6. Apply Glasurit 55-Line Basecoat per recommendations, allowing sufficient flash time before clearcoat application. For optimum durability, catalyze the basecoat with 10% Glasurit 355-55 Basecoat Activator.
7. Apply two coats of Glasurit 923-450 Multi-Temp Baking Clear using Glasurit 929-93 hardener and 352-91 reducer. Flash off for five minutes before baking for 30 minutes @140°F.
8. To ensure proper flash off of tail solvents and achieve a full cure, avoid exposing the painted substrate to excessive UV or moisture for seven days.

Note: To ensure adhesion, proper cleaning of the magnesium substrate is essential. Refer to the Glasurit Technical Manual for more detailed technical information. Always check local VOC regulations to ensure product compliance.

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