

Bumper Paint Process From Raw Steel

NOTE: Always follow the paint and product manufacturer instructions used for the paint and process to ensure safe use and proper results. Plan ahead to allow proper dry/flash time between products and painting steps. Always wear protective clothing during the paint process with proper respiratory protection and eye protection when handling chemicals and throughout this process.

These steps listed below are recommendations/suggestions only.

- Raw bumpers may show surface rust, a quick media blast is the fastest way to get rid of surface rust.

- Completely clean the parts inside and out with wax and grease remover supplies. Remove all possible contaminants from the surface of the parts before further prepping or painting.

- Sand (DA) the outside of the parts with 120 or 180 grit to smooth out the surface for paint prep.

- Completely clean the parts inside and out once sanding is complete. Use wax and grease remover to remove all possible contaminants.

- Use Bare Metal Etch Prime for the inside and outside of all bumper parts. The etch prime must be done prior to any primer being applied for proper adhesion. .

- Apply a MINIMUM of two coats of High Build Primer to the parts.

- Paint the back side/inner side of the bumpers with a satin black paint. The inside of the parts can also be painted body color, if desired.

- Sand the recesses in the pockets/hook mount areas of the bumper, if present.

- Thoroughly clean the sanded areas and areas with sanding residue before applying seam sealer over the seams in the hook mounting areas.

- Mask off the back side of the bumper to prevent paint overspray, if desired.

- After allowing the seam sealer the necessary amount of time to dry, block sand and/or DA sand the bumper assembly with the desired sanding grit for the painting process.

- Completely clean the parts inside and out once sanding is complete. Use wax and grease remover to remove all possible contaminants.

- Apply sealer.

-Apply color/paint.

-Apply clear coat.

-Denib & Polish bumpers, if desired, after the paint has fully cured.

-If the backside of the bumpers have been masked off at this point, remove the masking materials and rust proof the seams/joints on the backside of the bumper with an appropriate rust proofing material. This will help to prevent rust in these seams and other areas. Recommended: LIKE 90 10012 Dry Film Clear or equivalent.

Kelderman Manufacturing is not responsible for any rust or damage that may occur before, during, or after the painting process.