





OEM ED Coated Panel

Surface Preparation



Process Steps		Products	
1	<p>Degrease the entire panel</p> <ul style="list-style-type: none"> Wash panel prior to repair. Sand out scratches and dust particles with P400 grit dry <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>	
→ Proceed to Primer Surfacer Application			

Aftermarket ED Coated Panel

Surface Preparation

Process Steps		Products	
1	<p>Degrease the entire panel</p> <ul style="list-style-type: none"> Wash panel prior to repair. After degreasing allow surface to flash-off for 5 minutes <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>	
2	<p>Sand primer with P400 grit dry.</p> <p>Abrade closed areas with grey scuff pad</p> <ul style="list-style-type: none"> Remove minor scratches and imperfections Blow dust off after sanding <p><i>Proper sanding will prevent later visible sanding scratches and contour mapping</i></p>	<p>P400</p>	
3	<p>Degrease the entire panel</p> <ul style="list-style-type: none"> After degreasing allow surface to flash-off for 5 minutes <p><i>Degreasing supports good adhesion and prevents blistering and cratering</i></p>	<p>nax Pro LV Universal Degreaser</p>	

Primer Surfacer Application

Process Steps		Products	
4	<p>Apply 1 coat of surfacer</p> <p>Recoating time: Minimum 15 min. flash of and within 6 hours</p> <ul style="list-style-type: none"> In case of exceeding recoating time, surface must be scuffed with P400 dry. <p><i>Proper application provides even finish and adequate film build.</i></p>	<p>nax Pro LV36xx VHS Primer Surfacer</p>	
4.a	<p>In case more than 20% ED coat is removed</p> <ul style="list-style-type: none"> Apply 1 coat of epoxy primer prior to Primer Surfacer in the bare areas <p>Recoating time: Minimum 15 min. flash of and within 3 hours</p> <ul style="list-style-type: none"> After flash off proceed to Primer Surfacer <p><i>Provides corrosion protection and adhesion to substrate and to subsequent layers</i></p>	<p>nax Pro LV1101 DTM Epoxy Spot Sealer or nax Pro LV3200 Epoxy Primer Surfacer</p>	

For detailed product information always refer to TDS