

### Technical Bulletin ETB007

## Sanding and Buffing EC530 En-V® Performance Clearcoat

AFTER AIR DRY	Minimum of 6 hours
AFTER FORCE DRY	Force dry at 140°F (60°C) for 25 minutes plus a minimum 2 hour cool down
	Note: Procedure is the identical same day and after 24 hours
STEP BY STEP	<ol style="list-style-type: none"><li>1. Sand with 1000 grit DA damp and then refine the sand scratch with 1500 grit DA wet</li><li>2. Finish with 3000 grit</li><li>3. Buff as follows:<ol style="list-style-type: none"><li>A.) Buff with rubbing compound with a wool compounding pad. <b>NOTE:</b> Do not heat clearcoat above 120°F (49°C) during buffing process</li><li>B.) Machine polish with a form polishing pad</li><li>C.) Ultrafine machine polish with an ultrafine foam polishing pad</li></ol></li></ol> <p>*Additional process for Black</p> <ol style="list-style-type: none"><li>4. Finish with 5000 grit</li><li>5. Final prep with Finish/Final Glaze (Black)</li></ol>

### TIPS FOR SUCCESS

- Clearcoat has been fully cured either by air drying a minimum of 6 hours at 70°F (21°C) or by force drying for 25 minutes at 140°F (60°C) metal temperature plus 2 hours prior to starting buffing procedure.
- Black vehicles require additional steps - see above.
- Use interface pad with DA sanders for best results.
- Avoid generating too much heat with rubbing compound and wool pads. Be sure to keep the surface temperature below 120°F (49°C) in order to ensure that all sand scratch marks are completely removed.

