

No. 522

Automotive Part and complete replacement of lacquer

A

Description

This application example describes the sanding work steps for changing the paint colour or complete lacquering of used cars.

The user has the task in this case of quickly and efficiently sanding the complete body or individual parts of it to prepare for painting.

Previous procedure:

1. Sanding damaged spots by machine with P80
2. Resanding by machine with P180
3. Priming with epoxy filler and drying
4. Sanding by machine with P180
5. Filling and drying damaged spot
6. Resanding the filled spot by hand with P120 and then with P180 and P240
7. Application of filler and drying
8. Wet sanding of the complete vehicle by hand with P800 or P1000
9. Time consuming "blowing out" or drying or damp surfaces

Solution:

Using the Finish eccentric sander ETS 150 E-C or ETS 125 EQ and the abrasives named in the material list, vehicles can be prepared quickly and efficiently by means of dry sanding for succeeding coatings.

Advantages:

- no evaporation time
- neat sanding result
- vehicle is only covered once
- less cleaning work in the rebate area prior to painting



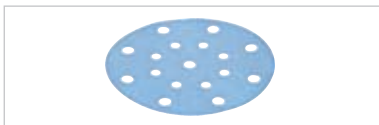
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B

Tools/accessories

Denomination	Order no.
ETS 150/3 E-C 240V (dia. 150 mm, 3 mm stroke)	571770
ETS 150/5 E-C GB 240V (dia. 150 mm, 5 mm stroke)	571771
CTM series mobile dust extractor	
Sanding pad, soft ST-STF D150/17MJ-M8-W-HT	496148
STF sanding discs Granat P80 dia. 150 STF D150/16 P80 GR/50	496977
STF sanding discs Granat P180 dia. 150 STF D150/16 P180 GR/100	496981
STF sanding discs Granat P280 dia. 150 STF D150/16 P400 GR/100	496984
STF sanding discs Granat P400 dia. 150 STF D150/16 P400 GR/100	496987
STF sanding discs Diamant D500 dia. 150 STF D150/0 D500 DI/2	496512
Guide control black powder HB set	495939
Abrasive sheets STF 80 x 130 Granat P 80	497119
Abrasive sheets STF 80 x 130 Granat P 280	497204
Abrasive sheets STF 80 x 400 Granat P 80	497159
Abrasive sheets STF 80 x 400 Granat P 280	497203
Hand sanding block HSK-A 80x130	496962
Hand sanding block HSK-A 80x200	496965
Hand sanding block HSK-A 80x400	496964
Alternative to ETS 150 E-C:	
ETS 125 EQ GB 240V (dia. 125 mm - 2 mm stroke)	571619
Alternative to Diamant D500	
Sanding discs Platin S500 dia. STF D150/0 S500 PL2/15	492369



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C

Preparation/set-up

1. Fit sanding pad (soft w-HT) on eccentric sander
2. Connect eccentric sander to CT mobile dust extractor

D

Procedure



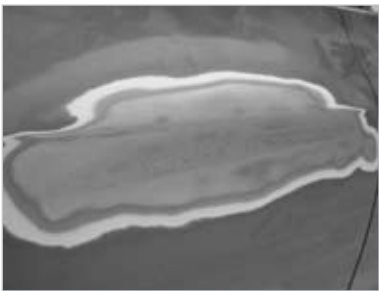
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1. Sand out deep scratches or minor spots of rust with a Granat P80 sanding disc with ETS 150/5 (see Fig. 522/12)



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2. Resand with STF sanding disc Granat P180 with ETS 150/5 (see Fig. 522/13).



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Ensure transitions to old lacquer are tidy (see Fig. 522/14)!



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3. Level surface irregularities such as dents with polyester filler (see Fig. 522/15, processing in accordance with manufacturer's instructions)



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4. After the filler has dried, apply guide control black (see Fig. 522/16)



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5. Use the ETS 150/5 and sanding disc Granat P80 to sand the filled areas and surface grind with the hand sanding block and Granat P80 (see Fig. 522/17 and 522/18)



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Apply guide control black between the sanding steps (see Fig. 522/16)



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After sanding, no guide control black residue must be visible (see Fig. 522/19)



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6. Resand with ETS 150/5 and sanding disc Granat P180 and then P280 (see Fig. 522/20) Apply guide control black between operations (see Fig. 522/16)

7. Then clean and remove dust from the surface

8. Apply filler and let it dry (observe specifications of paint manufacturer!)



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9. Apply guide control black (Festool)(see Fig. 522/16) and use the hand sanding block and sanding discs Granat P280 to surface grind the last irregularities (see Fig. 522/21)



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10. Apply guide control black (see Fig. 522/15) and light sand complete vehicle with abrasive Granat P400 on the ETS 150/3 and resand with abrasive Diamant 500 on the ETS 150/3 (see Fig. 522/22)

11. Clean and remove dust from the surface

12. Now apply the lacquer coating in accordance with the processing guidelines and specifications of the paint manufacturer

Note:

- Observe the comments and technical processing guidelines of the paint manufacturer!
- The rational, eccentric fine sanding guarantees tidy and fast results.
- The hand sanding block is selected according to the size of the damaged spot to be corrected.
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Caution!

Depending on the geometry, the speed may have to be adapted (see Fig. 522/23).

Special care must be taken in this regard in the case of beads, edges and curves. Reduce the speed level to 1–2.