

No. 521

## Automotive parts: New part lacquer with complete replacement (electric power tools)

A

### Description

In this application example the sanding process on new body parts is described.

The user is faced with the task of preparing the original spare part, which has been given a preliminary coating by the workshop or is coated with cataphoretic painting, quickly and efficiently so that it can be filled and lacquered.

Previous procedure

1. Complex and time-consuming light sanding by hand with P320, wet.
2. Blowing and drying the damp areas, if necessary cleaning and covering the rebated areas.
3. Applying the filler with subsequent drying.
4. Light sanding by hand with P800 or P1000, wet.
5. Blowing and drying the damp areas, if necessary cleaning and covering the rebated areas.
6. Lacquer application.

Solution

Using the Finish eccentric sander ETS 150 E-C or ETS 125 EQ and the appropriate abrasive, original spare parts can be prepared quickly and efficiently by means of dry sanding for subsequent coatings.

Advantages

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



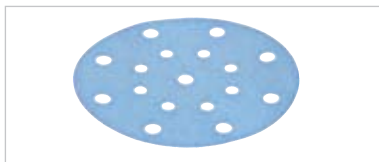
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## B Tools/Accessories

Designation	Order No.
ETS 150/3 E-C (dia. 150 mm, 3 mm stroke)	571732
CTM series mobile dust extractor	
Sanding pad, super soft ST-STF D150/17MJ-M8-SW	496145
STF sanding discs Granat P 320 Ø150 STF D150/16 P320 GR/100	497156
Sanding cloth, VERY FINE 320 115x152/30	497088
Alternative to ETS 150 E-C:	
ETS 125 EQ (dia. 125 mm, 2 mm stroke)	571607
Alternatives to the Granat P320:	
Sanding cloth STF D150/0 A280 VL/5	482779
For harder coating of cataphoretic paint:	
STF sanding discs Diamant STF D150/0 D500 DI/2	496512

## C Preparation/Set-up

1. If necessary position STF sanding pad (extra soft) on eccentric sander ETS.
2. Connect eccentric sander via the extractor hose at CT mobile dust extractor.

## D

### Procedure



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1. Position STF sanding disc Granat P320 (or sanding cloth A280) on sanding pad (see Fig. 521/8)
2. Lightly sand the area of the spare part to be lacquered using ETS 150 (see Fig. 521/9).  
Look out for beading, corners and edges -> Risk of sanding through!  
The use of the sanding cloth is recommended here (see Fig. 521/10).
3. Clean component.
4. Now apply the filler and lacquer coating in accordance with the processing guidelines and/or specifications of the paint/lacquer manufacturer

#### Note:

- Observe the comments and technical processing guidelines of the paint/lacquer manufacturer!
- The efficient, eccentric fine sanding guarantees tidy and fast results.

#### Important:

Depending on the geometry, the speed may have to be adapted (see Fig. 521/11).

Special care should be taken where there are beads, edges and curves. Reduce the speed level to 1-2.