

No. 523

Removing rust bubbles

A

Description

Stone-chippings or other damage to the lacquered layer, which are not repaired straight away, often lead to corrosion creep on metal body parts and thus to subsurface corrosion of the paintwork or the formation of rust bubbles.

This application example describes the repair of the damaged area by sanding out the rust bubbles.

Previous procedure

1. Sanding out the damage using an angle grinder
2. Blending by machine with P80
3. Blending by machine with P180
4. Priming with epoxy filler and drying
5. Sanding by machine with P180
6. Applying filler and drying
7. Sanding by hand with P120
8. Sanding by machine with P180
9. Sanding by machine with P240
10. Filler application and drying
11. Sanding by hand with P320
12. Sanding by machine with P400
13. Wet sanding by hand using P800 or P1000
14. Time-consuming blowing or drying of the damp surfaces
15. Paintwork varnish or basic and clear coat

Solution

Using the ROTEX RO 150 FEQ-C, the eccentric sanders ETS 150/3 and ETS 150/5 and the abrasive specified in the list of materials rust bubbles can be quickly and efficiently sanded out and/or the area prepared for the repair paintwork.

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



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B Tools/Accessories

Designation	Order No.
Geared eccentric sander ROTEX RO 150 FE (Ø150 mm, 5 mm sanding stroke)	571768
FastFix sanding pad, soft ST-STF D150/17MJ-FX-W-HT	496147
ETS 150/3 E-C (dia. 150 mm, 3 mm stroke)	571732
ETS 150/5 E-C (dia. 150 mm, 5 mm stroke)	571744
Sanding pad, soft ST-STF D150/17MJ-M8-W-HT	496148
CTM series mobile dust extractor	
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 the ROTEX RO 150 FEQ-C:	
ROTEX RO 125 FEQ Plus (Ø 125 mm, 3.6 mm sanding stroke)	571533
Alternative to ETS 150 E-C:	
ETS 125 EQ (Ø 125 mm, 2 mm sanding stroke)	571607
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 FastFix sanding pad (soft HT) on geared eccentric sander ROTEX RO 150
2. Position sanding pad (soft HT) on the eccentric sanders ETS 150/3 and 150/5
3. Connect ROTEX and eccentric sander to CT mobile dust extractor

D

Procedure

First using the ROTEX RO 150

1. Sanding out the rust bubbles (see Fig. 523/14) as far as the bare panel with P80 (coarse sanding setting, see Fig. 523/15)



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2. Sanding down in the fine sanding setting (see Fig. 523/16) with P180 Granat
3. Priming with epoxy filler and then drying according to the processing guidelines of the paint/lacquer manufacturer



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1. Resanding with STF sanding disc Granat P280 with ETS 150/5 (see Fig. 523/17)

Clean and remove dust from the surface



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2. Level surface irregularities such as corrosion pits, rust, etc. with polyester filler (see Fig. 523/18, processing in accordance with manufacturer's instructions)



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3. After the filler has dried, apply guide control black (see Fig. 523/19)



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4. Use the ETS 150/5 and sanding disc Granat P80 to sand the filled areas (see Fig. 523/20) and surface grind with the hand sanding block and Granat P80 (see Fig. 523/21).

Apply guide control black between the sanding steps (see Fig. 523/19)



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After sanding, no guide control black residue must be visible (see Fig. 523/22)



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5. Resand using ETS 150/5 and sanding discs Granat P180, then with P280. Apply guide control black between the sanding steps (see Fig. 523/19)

6. Then clean and remove dust from the surface



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7. Apply filler and let it dry (observe specifications of paint/lacquer manufacturer!)



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8. After complete drying of the filler apply guide control black (see Fig. 523/19 and 523/22) and use the hand sanding block and sanding discs Granat P280 to surface grind the last irregularities (see Fig. 523/24)



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9. Apply guide control black (see Fig. 523/19 and 523/22) and lightly sand entire area with abrasive Granat P400 on the ETS 150/3 and resand with abrasive Diamant 500 on the ETS 150/3 (see Fig. 523/25)

10. Clean and remove dust from the surface

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

- Observe the comments and technical processing guidelines of the paint/lacquer manufacturer!
- The efficient, eccentric fine sanding guarantees tidy and fast results.
- The size of the damaged spot to be corrected determines the hand sanding block selected.



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Caution!

Depending on the geometry the speed must be adjusted accordingly (RO 150: see Fig. 523/26; ETS 150: see Fig. 523/27).

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



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