



# LOTUS SERVICE BULLETIN

Class	III
Number	1970/29
Type	All Models
Date	1.7.1970

LOTUS CARS (SERVICE) Ltd NORWICH NORFOLK NOR92W Tel: WYMONDHAM 3411 CABLES LOTUS NORWICH TELEX 97401

Circulation List	Service Manager		Foreman				
------------------	-----------------	--	---------	--	--	--	--

**Title:** Paint Rectification .

**Reason:** To give advice in the recognition and rectification of certain paint defects which have been experienced on older cars .

**Parts Required:** -

**Price:** -

**Charges:**

U.K.	-	Warranty.....	NO
EXPORT	-	Factory .....	NO
	-	Distributor.....	NO

**Action:** BEFORE commencing rectification, decide into which category the defect falls. The possibilities are:-

1. Paint Blistering - Recognizable by the blisters being quite sharply defined, as only the paint is affected.
2. Primer Blistering - Recognizable by the blisters being less defined, as both the paint and the polyurethane are affected.
3. Mat Blistering - Recognizable by the blisters being 'sausage' shaped and following a random pattern.

Rectification for the above defects is as follows:-

1. Paint Blistering

Flat out defects with '320' or '360' grade paper. Prime, then colour. The use of heat is preferable but not essential.

2. Primer Blistering

Break the blisters and remove the polyurethane in the affected areas ONLY. Flat out defects with '320' or '360' grade paper removing only the MINIMUM amount of polyurethane as is necessary. Build up with primer, then colour. The use of heat is preferable but not essential.

3. Mat Blistering

In cases of this nature the use of heat is ESSENTIAL.

For rectification of all listed faults, proceed as follows:-

1. Wet flat out defects with '320' or '360' grade paper.
2. Wash down thoroughly.
- \* 3. Force dry for 60 minutes MINIMUM at 140°F. (60°C.).
4. Apply two cross coats of surfacer (Part No. 036 B 6139) thinned 1 : 1 with thinner (Part No. 036 B 6140) to give 26 - 28 seconds No. 4 cup, with 5 minutes MINIMUM flash between coats.
- \* 5. Flash off 10 - 15 minutes and force dry 40 minutes MINIMUM at 120°F. (48.9°C.) - 130°F. (54.4°C.).
6. Wet flat with '400' grade paper and wash thoroughly.
7. Dry off thoroughly, solvent wipe and tack rag.
8. Apply two cross coats of colour thinned with thinner (Part No. 036 B 6142) to give 23 - 24 seconds No. 4 cup with 5 minutes MINIMUM flash between coats.
- \* 9. Flash off 10 - 15 minutes and force dry for 60 minutes at 120°F. (48.9°C.) - 130°F. (54.4°C.).
10. Inspect and rectify, if required with '600' grade paper, cut back with coarse compound, then fine compound.
11. Final polish with Pinchin & Johnson liquid wax polish (Part No. A036 B 6308).
- \* Force drying optional in cases (1) and (2).