



# DOLPHIN ONE FILL BODY FILLER

UP0659, UP0660

Version: 2.0 Date of issue: 18/04/2018 Revision date: 15/10/2019 Supersedes: 16/10/2018




DRIVING SURFACE PERFECTION

## TECHNICAL DATASHEET

Dolphin One Fill is an All-In-One Premium Body Filler. One Fill's intelligent micro-sphere technology formula builds like body filler yet is super smooth and pinhole free like glaze so you can skip the glaze and get on to priming and painting in 20 minutes.

- Industry leading adhesion and to more substrates.
- Sands to a super fine power that won't clog your sandpaper.
- Feathered edges with no lifting or balling.
- Outstanding vertical hold.

<b>Typical Use</b>	Ideal for panel repair and also for correcting minor imperfections.	
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### Application Guide

#### Tools Required



Onion Board Mixing Palette (UP0737), Bodyfiller Applicator (UP0738), U-POL System 20 Degreaser (UP2002, UP2012, UP2022), MAXIMUM Premium Masks, MAXIMUM Painters Overalls, MAXIMUM Abrasives, GUIDE #7 Guide Coat Aerosol.

#### Surface Preparation



	Degreaser	Abrasion
<b>Bare Steel</b>	UP2012 Fast/UP2022 Slow Solvent-Based Degreaser	P80
<b>Aluminum</b>	UP2012 Fast/UP2022 Slow Solvent-Based Degreaser	P180
<b>Galvanised</b>	UP2012 Fast/UP2022 Slow Solvent-Based Degreaser	P180
<b>Original Paint</b>	UP2012 Fast/UP2022 Slow Solvent-Based Degreaser	P180
<b>Polyester Body Filler</b>	UP2012 Fast/UP2022 Slow Solvent-Based Degreaser	P80 - P180
<b>Fiberglass</b>	UP2002 Water-Based Degreaser	P180

DOLPHIN ONE FILL BODY FILLER is multifunctional and has superb adhesion to all the substrates above. For best results, good preparation is essential.

Clean and degrease removing dirt, oil, grease and wax with a cleaning solution, like U-POL SYSTEM 20 Solvent Based Degreaser (UP2012, UP2022) or Water Based Degreaser (UP2002) (please check local VOC regulations). Abrade with grit paper as stated above for each respective substrate.

Re-clean, dry and degrease the abraded substrate ready for application.

#### Application



	50°F	70°F	85°F
<b>Mixing ratio (BPO Hardener):</b>	3%	2%	1%
<b>Gel Time:</b>	6 - 8 minutes	5 - 7 minutes	4 - 6 minutes
<b>Sandable after:</b>	20 minutes	15 - 20 minutes	15 minutes
<b>Maximum Fill Depth</b>	3 - 5 mm		

Mix thoroughly on an Onion Board Mixing Palette. Follow mix ratio carefully. Do not under or over catalyze. Apply with a pressing action to reduce air entrapment. Not recommended for applications below 40°F

#### Sanding



<b>Initial Sanding</b>	P120
<b>Final Sanding</b>	P180 - P240

U-POL recommends using GUIDE #7 Guide Coat Aerosol during the sanding process to identify the high and low spots.

#### Over-Painting



Following curing and sanding, this filler is recommended for use under any primer, basecoat and clearcoat paint system.

### Technical information

<b>Physical properties</b>	<b>Appearance</b> <b>Color</b> <b>Specific gravity / density</b> <b>Viscosity</b>	Paste. Off-white ≈ 1.145 (1.125 - 1.165) g/cm <sup>3</sup> 75000 (70000 - 80000) cP
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U-POL US, Inc.  
108 Commerce Way  
Stockertown, PA 18083  
WWW.U-POL.COM

US Sales  
T: (610) 746 7081  
F: (610) 743 8654  
sales-us@u-pol.com

International  
T: +44 (0)20 8492 5900  
F: +44 (0)20 8150 5605  
sales@u-pol.com

Technical  
T: +44 (0)1933 230 310  
F: +44 (0)1933 425 797  
technicalsupport@u-pol.com



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### VOC Information



<b>As Packaged Regulatory VOC</b>	191 g/l (1.65 lb/gal)
<b>As Packaged Actual VOC</b>	191 g/l (1.65 lb/gal)
<b>As Applied Regulatory VOC</b>	40 g/l (0.35 lb/gal)
<b>As Applied Actual VOC</b>	40 g/l (0.35 lb/gal)
<b>Percent Solids</b>	82.27 wt%
<b>Volatiles</b>	17.7 wt%
<b>Water Content</b>	0 wt%
<b>Exempt Compounds by weight</b>	0 wt%
<b>Exempt Compounds by volume</b>	0 vol %
<b>% HAPS</b>	17.73 wt%

### Shelf Life & Storage



Order Code	Format	Shelf Life	Batch Coding System
UP0659	1 US Gallon Tin	4 years	C
UP0660	1 QT Tin	4 years	C

- A Date of manufacture, unique 5-digit batch code and expiry date printed on base of tin.
- B Date of manufacture and/or 5-digit batch code printed on base of tin/adhesive label/adhesive label on kit box. e.g. 93822 = 2019, week 38, batch 22
- C Date of manufacture and unique 5-digit batch code and printed on base of tin/adhesive label.
- D Date of manufacture and unique 5-digit batch code printed on cartridge.
- E Date of manufacture and unique 7-digit code printed on lid.
- F Date of manufacture and unique 6-digit batch number printed on packaging.
- G Date of manufacture and unique 4-digit batch code and printed on base of tin.
- H Date of manufacture and batch number incorporated into 8-digit code e.g. 18071234 = (18) 2018, (07) July, batch number 1234
- I Date of manufacture printed on tin.
- J Date and time of manufacture printed on neck of aerosol.
- K Date of manufacture and weight of sachet embossed on seal. e.g. 40G 110717
- L Unique 5-digit batch code printed on packaging/adhesive label/embossed on seal. For the date of manufacture, please quote this code to technicalsupport@u-pol.com.
- M Unique 5-digit batch number followed by weight printed on tube. e.g. 17149GR78 = batch number 17149GR, weight 78 g. For the date of manufacture, please quote this code to technicalsupport@u-pol.com.
- N Date of filling and unique 7 digit batch code stamped on adhesive label.
- O LOT number ending in a unique 5-digit code printed on sachet. For the date of manufacture, please quote this code to technicalsupport@u-pol.com.
- P Date of aerosol manufacture and 5-digit aerosol base batch code printed on base of tin. e.g. 93822 = 2019, week 38, batch 22
- Q Date of aerosol manufacture and unique 5-8 digit batch code printed on base of tin.

**Recommended storage temperature** 40 °F - 75 °F  
 Store locked up. Store in a well-ventilated place. Keep container tightly closed. Keep cool.

### IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

*This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the U-POL website at WWW.U-POL.COM. U-POL is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits.*

U-POL US, Inc.  
 108 Commerce Way  
 Stockertown, PA 18083  
 WWW.U-POL.COM

US Sales  
 T: (610) 746 7081  
 F: (610) 743 8654  
 sales-us@u-pol.com

International  
 T: +44 (0)20 8492 5900  
 F: +44 (0)20 8150 5605  
 sales@u-pol.com

Technical  
 T: +44 (0)1933 230 310  
 F: +44 (0)1933 425 797  
 technicalsupport@u-pol.com