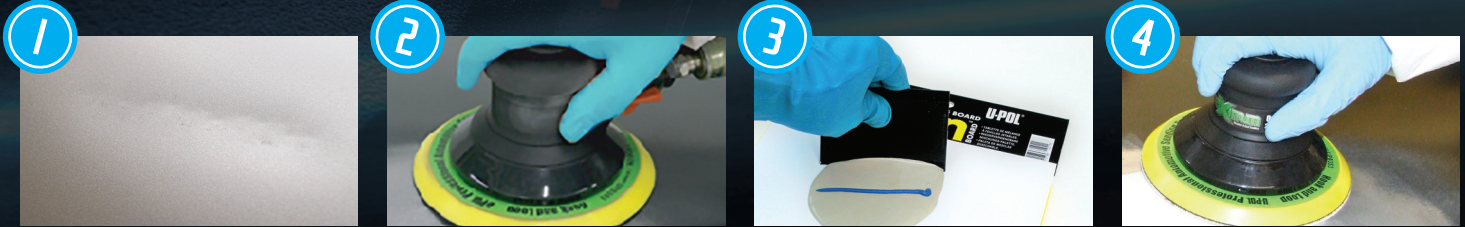


FILL AND PRIME IN RECORD TIME

SAVE MORE
THAN 4 HOURS



CLEAN & DEGREASE REPAIR AREA

Clean all areas around the repair with soap and water. Then clean the repair area using a water-based (UP2002) or solvent-based (UP2012 / 2022) degreaser; wipe dry. **DO NOT wipe surface with lacquer thinner.**

SAND REPAIR SURFACE

Sand repair area removing paint.

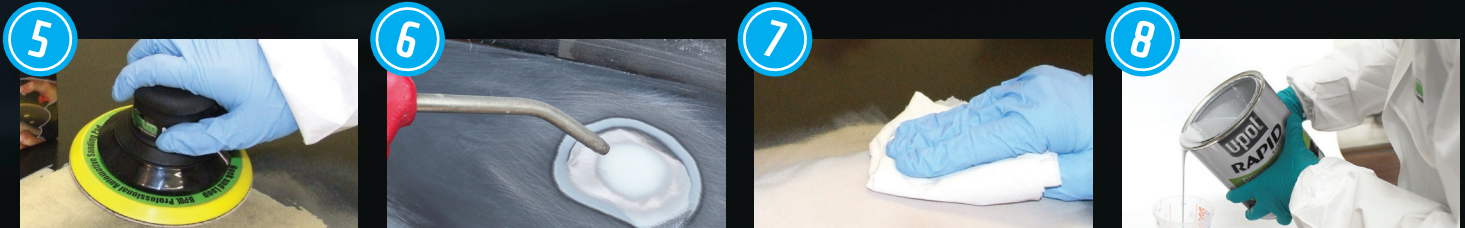
- Bare Metal: 80 grit
 - OEM Paint: 180 grit
 - Aluminum / Galvanized: 180 grit
 - Existing Body filler 80 – 180 grit
- Blow off area with compressed air and degrease.

MIX AND APPLY

On an Onion Board, mix Dolphin One Fill with hardener in a 2% ratio @ 65-85°F air temp (above 85°F, use 1% to extend work time). Apply in thin coats, using firm pressure to force out any air trapped from mixing and to fully wet surface. Allow filler to dry 15 minutes before sanding.

SAND FILLER

Sand filler initially with 120 grit on a DA or by hand block to break surface. Apply GUIDE#7 Dry Guide Coat Aerosol and continue sanding to contour. Blow off and inspect for pinholes or low spots. Re-apply One Fill if needed or use as a skim coat to cover feather edge in place of a traditional glaze / putty coat.



FEATHER EDGE AND FINISH

Feather edge and finish sanding the repair area with 180 grit sandpaper and sand the surrounding paint area with 180 – 320 grit on DA sander removing all straight line scratches.

INSPECTION BEFORE PRIME / PAINT

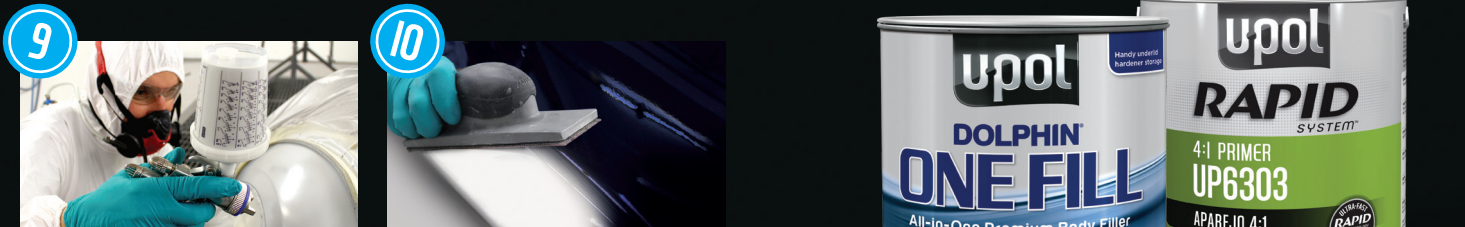
Blow off panel and degrease. Examine repair area for any minor imperfections. If needed, reapply a final skim coat of Dolphin One Fill before primer application.

CLEAN & DEGREASE REPAIR AREA

Clean panels with U-POL Anti-Silicone Degreaser (UP2002 / 2012 / 2022 / 0872). Blow off and tack prior to applying Rapid System Primer UP6303.

MIX PRIMER

Mix Rapid System Primer 4:1:1.



APPLY PRIMER

Apply directly with 1.6 - 1.8 nozzle set. If panel is galvanized or aluminum, first apply one light coat of ACID#8 Acid Etch Primer Aerosol (UP0741V / 0837) and allow to flash for 5-10 minutes.

DRY & SAND

Allow to dry 55 minutes @ 70°F before sanding. Dry sand with 400 – 600 grit or wet sand with 800 - 1000 grit. Follow paint manufacturers' guidelines for top coating primer / sealer.



PROCESS TOOLS REQUIRED

UP2002 Water Based Degreaser or UP2022/2012 Solvent Based Degreaser or UP0872 WIPE#6 Aerosol	Onion Board - UP0737	6" 80 grit DA Paper (bare steel prep)
	Dolphin One Fill - UP0659 / 0660	6" 120 - 320 grit DA Paper
U-POL GUIDE#7 Aerosol - UP0873	ACID#8 Acid Etch Primer (UP0741V / 0837)	120 - 320 grit File Board Paper
Rapid System Primer - UP6303	Rapid System Primer Hardener - UP6425	Rapid System Primer Reducer - UP6701

Dolphin One Fill Polyester Filler and Rapid System Primer is suitable for use over the following substrates:
Bare Metal, Galvanized*, Aluminum*, Fiberglass / SMC, OEM Paint Surfaces, Abraded eCoat.

*Requires ACID#8 for proper adhesion of Rapid System Primer

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