

3-STEP REPAIR PROCESS DEEP PANEL DAMAGE



DRIVING SURFACE PERFECTION™



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Step 1: Inspect panel

- Clean and inspect panel.
- Use appropriate (Axalta) silicone remover and a suitable degreasing cloth to clean the surface. For more details refer to "Preparatory surface degreasing SOP".

Step 2: Prepare substrate

- Sand with DA/orbital sander and P80-abrasive discs to remove existing paintwork in readiness for U-POL UP0659 / UP0660 Dolphin™ ONE FILL putty application.

Step 3: Apply U-POL UP0659 / UP0660 Dolphin™ ONE FILL

- Blow off panel and clean thoroughly by using an appropriate Axalta silicone remover.
- Mix Dolphin™ ONE FILL @ 2% activation ratio, apply and allow Dol to dry 15 – 20 minutes @ 70F/21C according to the ONE FILL technical data sheet.
- Sand ONE FILL to shape using a hand block and P120-P150 abrasive strips.
- Use **UPOL UP0873 U-POL GUIDE #7** guide coat during all sanding steps of the repair.
- Blow off panel and repeat step 3 if required. Removing dust from pores and voids is of particular importance prior to the application of another layer of ONE FILL or UP0654 Dolphin™ Speed Glaze.

Step 4: Mix and Apply U-POL UP0654 Dolphin™ Speed Glaze

Activate at 2% ratio (70F/21C). Avoid air entrapment by applying a smooth skim / scrape coat immediately after mixing. Work / gel time of Dolphin™ Speed Glaze is 4-6 mins @ 70F/21C.

Step 5: Sand Dolphin™ Speed Glaze

- Allow Dolphin™ Speed Glaze to dry approx. 8-10 minutes @ 70F/21C and sand with P180 – P240 abrasive.

Step 6: Apply U-POL UP0686 MicroFill

- Blow off panel. Removal of dust from micro-pores and voids is of particular importance prior to the application of MicroFill.
- Use appropriate (Axalta) silicone remover and a suitable degreasing cloth to clean the surface.
- Fill small voids or micro pores / pin-holes prior to the application of primer, surfacer or sealer by wiping MicroFill over the filler / glaze surface using a lint free cloth. Remove excess with a clean cloth.

Step 7: Apply surfacer/filler

- Allow MicroFill to dry for 15 mins (@ 70F/21C) before applying Axalta solvent-based primer / surfacer or sealer. Refer to MicroFill TDS Guide for additional technical information.

Step 8: Prepare for top coating

- Apply U-POL GUIDE #7 guide coat and sand primed repair area with a hand block and P320-P400 abrasive strip if necessary.
- Re-apply GUIDE #7 guide coat, sand edges and corners with a suitable foam backed abrasive followed by DA/orbital machine sanding with P500-P600 abrasive discs.
- Clean thoroughly using an appropriate Axalta silicone remover or water-based cleaner depending on local VOC legislation in readiness for your chosen clear over base system to be applied.



BE SMART:
CLEAN AND TIDY UP



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