

REPAIR PROCESS

DAMAGED PLASTIC PART - REINFORCED REPAIR 7061 FLEXIBLE HIGH DENSITY FILLER



DRIVING SURFACE PERFECTION™



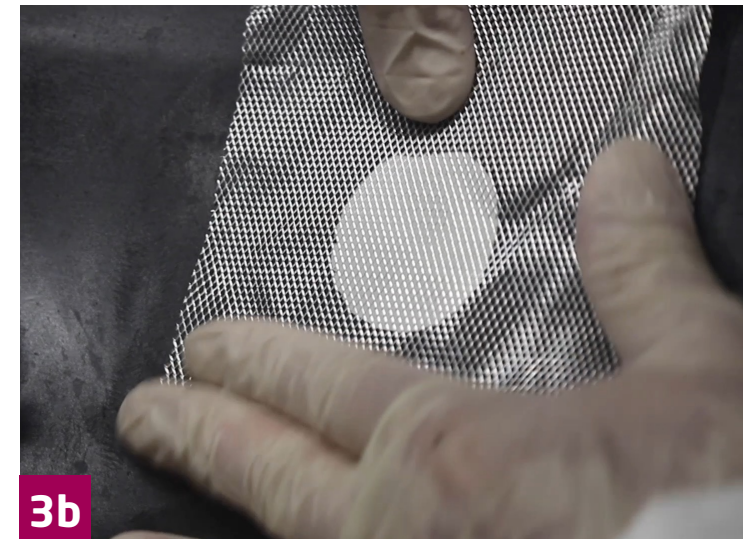
1



2



3a



3b



4



5



6



7

Step 1: Inspect panel*

- Clean and inspect panel.
- Use an appropriate (Axalta) silicone remover or plastic cleaner and a suitable degreasing cloth.
- Repair any cracks or heavier damage prior to step 2.

Step 2: Initial sanding

- For hole or tear damage sand repair area with DA/orbital sander with P120 grit at low RPM to remove paint and prepare plastic. Dish out damaged area leaving rounded edges. U-POL UP7061 Flexible High Density Filler will not adhere to melted plastics, so use a low RPM. Blow off area with compressed air.
- Clean with a waterborne (Axalta) silicone remover and a suitable degreasing cloth.
- Do not re-clean with solvent cleaner. Apply 1 light coat of adhesion promoter to substrate if necessary. For reinforced back, see #3b.

Step 3a: Front side - mix & apply U-POL UP7061 Flexible High Density Filler

- For deeper damage (e.g. scratches / gouges) mix and apply UP7061 Flexible High Density Filler @ 2% hardener ratio on mixing board. Apply 1 - 2 thin coats with firm pressure. Allow to dry approx. 20-30 minutes before shape sanding - see #4.
- Block sand to shape starting with P180-P240. Refine scratches with incremental abrasive grades. Use **U-POL UP0873 GUIDE #7** guide coat during all sanding steps of the repair.

Step 3b: Back side - reinforcement

- Sand area with 60 - 80 grit. Cut reinforcement mesh approx. 1" larger than repair area and apply mesh to back of panel. Mix as in step 3a and apply 1-2 thin coats of UP7061 Flexible High Density Filler to mesh. Repair front side as in step 3a. View repair video for additional information.

Step 4: Refine sand front side

- Hand sand corners and edges with sanding sponge or suitable foam backed abrasive.
- Feather edge the repair area with P240-P320 abrasive disc followed by P400-P500 disc using a DA/orbital machine sander.
- Blow off panel and clean thoroughly by using an appropriate Axalta silicone remover or plastic cleaner. Ensure that no dust remains in the pores of the UP7061 Flexible High Density Filler. Fill any micro pores by wiping on **U-POL UP0686 MicroFill** using a lint free cloth. Remove excess. Allow to dry for 15 mins (@70F/21C) before applying solvent based primer. Refer to UP0686 TDS Guide for additional information.

Step 5: Apply primer

- Apply a suitable Axalta plastic primer if required. Flash off or dry.
- Mix and apply a suitable elastified Axalta surfacer/filler. Ensure the surfacer/filler is mixed with an appropriate elastic additive or adhesion promoter to ensure suitable adhesion and flexible properties.

Step 6: Sand primer

- After drying of the surfacer/filler, hand sand corners and edges with an ultrafine sanding sponge or suitable foam backed abrasive.
- DA/orbital machine sand with P500-P600 abrasive disc, use a suitable soft backing pad.
- Use guide coat during all sanding steps of the repair.
- Clean again with an appropriate (Axalta) silicone remover or plastic cleaner.

Step 7: Apply topcoat

- Mix and apply your chosen (elastified) Axalta clear over base system and dry according to technical data sheets of the products being used.
- The use of an anti-stat gun should be considered.

*Check for ADAS implications for plastic parts. Repairs must be carried out according to OEM specifications which may include masking of the inside of the bumper. Check for radar and use radar approved paint formulas if applicable.



Watch Tutorial

BE SMART:
CLEAN AND TIDY UP



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