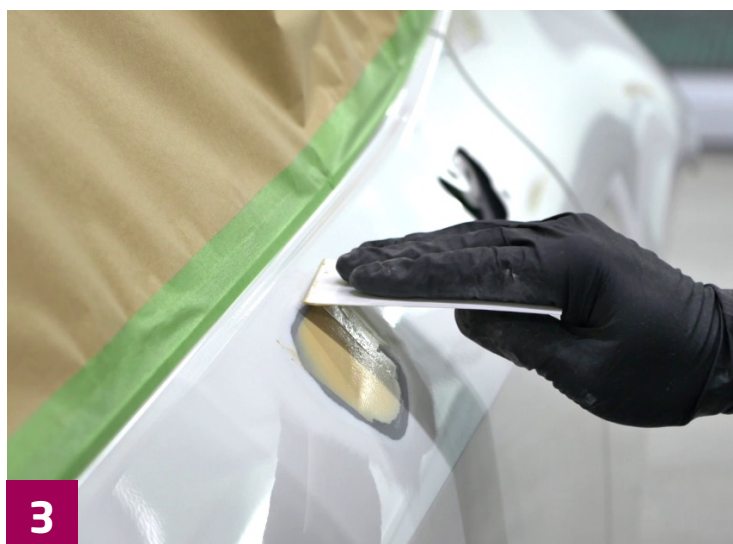


REPAIR PROCESS

DAMAGED METAL PART DOLPHIN™ ONE FILL



DRIVING SURFACE PERFECTION™



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: Sand the repair

- Sand with DA/orbital sander and P150-P240 abrasive discs to remove imperfections.
- If Body Filler needs to be applied, sand to bare metal with P80 grit to remove existing paintwork.

Step 3: Apply U-POL UP0659 / UP0660 Dolphin™ One Fill

- Blow off panel and clean thoroughly by using an appropriate Axalta silicone remover.
- Mix 2% activator by weight to a 3-4" puddle of body filler. Mix thoroughly together until color is uniform and has no streaks.
- Apply body filler with a spreader in thin coats with firm pressure rather than one heavy coat.
- Air dry - Allow filler to dry for approximately 15 minutes at 70F/21C. Shorter if above, longer if below.
- Infrared dry if available - Dry at 170F/76C for 5 minutes at a distance of 24" - 30".

Step 4: Sand Dolphin™ One Fill

- Sand body filler to shape using a hand block and P120 abrasive strips followed by P180-P240.
- Use **UPOL UP0873 U-POL GUIDE #7** guide coat during all sanding steps.

Step 5: Refine sanding

- Refine block sanded area with DA/orbital sander and P240-P320 discs. Use guide coat during all sanding steps.
- Feather edge/scratch reduction sanding of surrounding area with DA/orbital sander and P240-P320 discs.
- Refine surrounding area with DA/orbital sander and P320-P600 abrasive discs. Ensure graduated sanding steps.
- Blow off panel. Removal of dust from pores and voids is of particular importance prior to the application of primer.
- Use appropriate (Axalta) silicone remover and a suitable degreasing cloth to clean the surface.
- Small voids or micro pores can be filled prior to the application of primer, surfacer or filler 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 MicroFill TDS Guide for additional information.

Step 6: Apply primer

- Clean thoroughly using appropriate Axalta silicone remover and mask surrounding areas if required.
- Prime bare metal areas immediately using Axalta pretreatment wipes or etch primer and flash-off.
- Mix and apply a suitable Axalta 2K surfacer/filler according to the technical data sheet of the product being used. Use "outside-in" technique to reduce overspray.

Step 7: Sand surfacer/filler

- Apply guide coat and sand repair with a hand block and P320-P400 abrasive strip.
- Re-apply guide coat, sand edges and corners with a suitable foam backed abrasive followed by DA/orbital machine sanding with P500-P600 abrasive discs.

Step 8: Apply topcoat

- Clean thoroughly using an appropriate Axalta silicone remover or water-based cleaner depending on local VOC legislation and clear over base system to be applied.
- Mask panel as required and apply your chosen Axalta clear over base system.



Watch Tutorial

BE SMART:
CLEAN AND TIDY UP



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