

MICROFILL PIN-HOLE ELIMINATOR & SEALER



DRIVING SURFACE PERFECTION™



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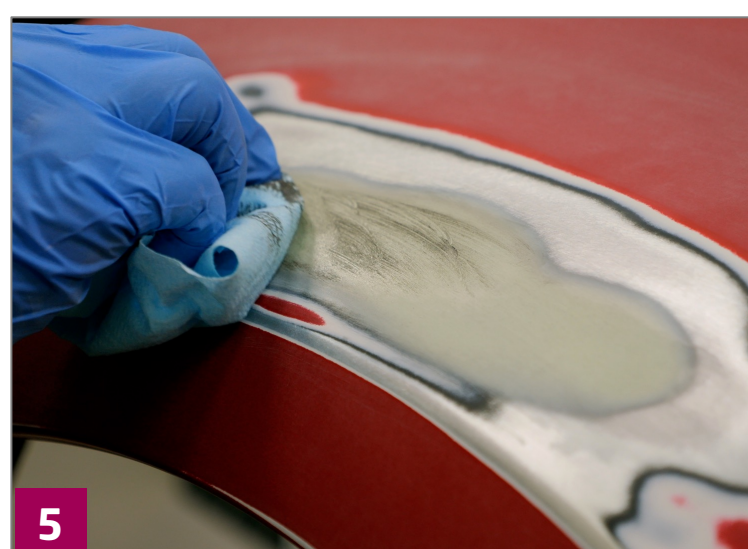
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Step 1: Sand the repair

- Sand filler repair area with block sander and P150-P240 abrasive discs to remove imperfections / sand scratches.

Step 2: Inspect Body filler

- Clean and inspect filler for pin-holes.
- Blow off filler, use appropriate (Axalta) silicone remover and a suitable degreasing cloth to clean the surface. For more details refer to "Preparatory surface degreasing SOP".

Step 3: Mix and apply U-POL UP0654 Dolphin™ Speed Glaze

- Mix 2% activator by weight to a 2-3" puddle of Dolphin™ Speed Glaze. Mix thoroughly together until color is uniform and has no streaks.
- Apply Dolphin™ Speed Glaze with a spreader in very thin coats with firm pressure rather than one heavy coat.
- Air dry – Allow Dolphin™ Speed Glaze to dry for approximately 8-10 minutes at 70F/21C.

Step 4: Sand Dolphin™ Speed Glaze

- Sand to shape using a hand block and P180 abrasive strips followed by P240-P320 as a best practice.
- Use **U-POL UP0873 GUIDE #7** guide coat during all sanding steps.

Step 5: Refine sanding

- Feather edge/scratch reduction sanding of surrounding area with DA/orbital sander and P240-P320 discs.
- Refine surrounding area with DA/orbital sander and P400-P600 abrasive discs. Ensure graduated sanding steps.
- Blow off panel. Removal of dust from micro-pores and voids is of particular importance prior to the application of **U-POL UP0686 MicroFill**. 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 sealer by wiping on MicroFill over filler / glaze surface using a lint free cloth. Remove excess with a clean cloth and reapply if needed and remove excess. Allow to dry for 15 mins (@70F/21C) before applying solvent based primer / surfacer. Refer to MicroFill TDS Guide for additional technical 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 according to the technical data sheet of the product being used. Use "outside-in" technique to reduce overspray.

Step 7: Sand surfacer

- 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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