



DRIVING SURFACE PERFECTION™

UP0659 / UP0660 DOLPHIN ONE FILL



DESCRIPTION

Dolphin One Fill is an All-In-One Premium Body Filler. One Fill's intelligent micro-sphere technology formula builds like body filler yet is super smooth and pinhole free like glaze so you can skip the glaze and get on to priming and painting in 20 minutes.

FEATURES

- Industry leading adhesion to more substrates
- Sands to a super fine powder that won't clog your sandpaper
- Feathered edges with no lifting or balling
- Outstanding vertical hold
- Tack free
- Color: Off-White
- Available in 0.8 US Gallon and 1 US Quart Tins

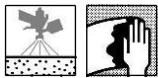
TECHNICAL DATA SHEET

DOLPHIN ONE FILL

Product preparation - application



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare Steel - cleaned with solvent based degreaser and sanded with P80 grit. Re-clean the abraded substrate before application.
Galvanized Steel - cleaned with solvent based degreaser and sanded with P180 grit. Re-clean the abraded substrate before application.
Aluminum / Old or Original paintwork - cleaned with solvent based degreaser and sanded with P180 grit. Re-clean the abraded substrate before application.
Fibre Glass / GRP / SMC - cleaned with solvent based degreaser and sanded with P180 grit. Re-clean the abraded substrate before application.
Existing bodyfiller - cleaned with solvent based degreaser and sanded with P80-P180 grit. Re-clean the abraded substrate before application.



	50°F	68°F	86°F
	Weight	Weight	Weight
Dolphin One Fill	100	100	100
BPO Hardener	3	2	1

Mix thoroughly on an Onion Board mixing palette.
Maximum Fill Depth 3 - 5 mm
Infra-Red Bake: Apply the lamp between 50 and 80 cm, 176°F 5 minutes



Pot life at 50°F: 6 min - 8 min
Pot life at 68°F: 4 min - 6 min
Pot life at 86°F: 4 min - 5 min



Apply smooth film immediately after mixing, avoiding air entrapment.



Sanding	
50 °F	20 min
68 °F	15 min - 20 min
86 °F	15 min



Initial Sanding P120
Final Sanding P180 - P240

VOC compliant

Regulatory VOC 202g/l (1.75lb/gal), Actual VOC 43g/l (0.36lb/gal)

TECHNICAL DATA SHEET

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Products

UP0659 DOLPHIN ONE FILL 0.8 US GALLON
UP0660 DOLPHIN ONE FILL 1 US QUART

Waste treatment Dispose of contents / container to approved disposal companies or municipal collection points. Do not empty into drains.

Remarks

- Do not add more hardener than recommended to avoid bleeding and spot marking.
- Reaction temperature should be at least +40°F.
- Recommended storage temperature at 40°F to 77°F.
- Surplus ready for use material should not be returned to original can.
- Store in a well-ventilated place.
- Application of a solvent based primer is recommended to achieve the perfect surface for the color of your choice.
- For additional technical assistance, please contact the U-POL Technical Department at upol.technicalsupport@axalta.com

Shelf Life	5 years

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our brand product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our brand product range, unless explicitly indicated otherwise.

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