THE NEW & IMPROVED FORMULA

- Spreads smoothly and self-levels
- Virtually eliminates micro-pinholes
- Excellent vertical hang properties
- Can be applied directly to sanded OEM clearcoat
- Superior adhesion to aluminum, stainless steel, galvanized steel, SMC, fiberglass and silicon bronze welds
- Passes 500 hour salt spray testing for corrosion protection (ASTM B117)
- Eliminates the need for finishing putty
- Contains patented ECO-RESIN® technology

Available in:
1 Gallon (#100125)
3 Gallon pail (#100127)

evercoat.com
RAGE® ULTRA EXPRESS REPAIR PROCESS

The following process is true for large and small repairs unless otherwise specified.

1: CLEAN  LIMPIAR
Clean and degrease the body panel to be repaired.
Limpiar y desgrasar el panel de carrocería a reparar.

2: STRAIGHTEN PANEL  ENDEREZAR EL PANEL
Straighten the panel to be repaired as needed.
Enderezar el panel a reparar, según sea necesario.

3: PAINT REMOVAL  ELIMINACIÓN DE LA PINTURA
Remove paint, only where fractured, with 60 grit in the area to be filled.
Eliminar la pintura, únicamente donde esté fracturada, con abrasivo de grano 60 en el área a rellenar.
- Sand and featheredge using 180 grit for small repairs.  - Lijar con grano 180 para reparaciones pequeñas.

4: PREPARATION  PREPARACIÓN
Sand and featheredge the area with 180, then remove sanding dust with clean compressed air.
Lijar y biselar la superficie con 180, luego eliminar el polvo de liado con aire comprimido limpio.
- Skip to step 5 for small repairs. - Bríscala el paso 5 para reparaciones pequeñas.

5: APPLY RAGE® ULTRA  APLICAR LA MASILLA RAGE® ULTRA
Apply Rage® Ultra with even, firm pressure in a thin coat; apply additional material as needed. Extend Rage® Ultra into the clearcoat featheredge area.
Aplicar la masilla Rage® Ultra con una presión firme y uniforme en una fina capa; aplicar material adicional según sea necesario. Extender la masilla Rage® Ultra en la superficie biselada con revestimiento transparente.

6: SAND & FEATHEREDGE  LIJAR Y BISELAR
Sand the filler to shape with 80 grit, then final sand and featheredge with 180 grit.
Lijar la masilla para dar forma con abrasivo de grano 80, luego aplicar el lijado y biselado final con abrasivo de grano 180.
- Sand and featheredge using 180 grit for small repairs. - Lijar con grano 180 para reparaciones pequeñas.

7: REMOVE DUST & INSPECT  ELIMINAR EL POLVO E INSPECCIONAR
Remove the sanding dust with clean compressed air and inspect area for coarse sand scratches, pinholes, or imperfections.
Eliminar el polvo de liado con aire comprimido limpio e inspeccionar la superficie para rasguños de liado gruesos, pinzones o imperfecciones.

8: APPLY 440 EXPRESS™  APLICAR 440 EXPRESS™
Use sponge to apply 440 Express™ over entire repair surface.
Usar una esponja para aplicar 440 Express™ sobre toda la superficie de reparación.

COMPLETE THE RAGE® ULTRA EXPRESS REPAIR PROCESS WITH 440 EXPRESS™:
- One step primer pretreatment - no sanding required
- Reduces primer usage by up to one third
- Reduces rework by eliminating micro-pinholes
- #100440 440 Express™ 16oz. Bottle
- #100444 440 Express™ Kit with 4oz. Bottle and Applicators
- #100439 440 Express™ Applicators
## Approved Substrates
Approved substrates include: steel, stainless steel, aluminum, fiberglass, galvanized steel, SMC, sanded OEM paint and silicon bronze welds.

**NOTE:** For structural repairs prone to high degrees of stress and flexibility, use a fiber reinforced filler such as Fiber Tech®, Everglass®, or Kitty Hair®.

## Preparation
- Clean and degrease the entire panel to be repaired with soap and water, followed by a mild cleaning solvent. Thoroughly dry the surface before repairing.
- Keep the repair area small. Use 80-180 grit to remove the paint and featheredge with 180. **NOTE:** Smaller repairs on OEM Paint can be prepared with 180 grit.

## Mixing
- Stir the filler before using. Knead the cream hardener.
- Measure hardener 2% by weight by adding a ribbon of cream hardener from edge to edge across the center of a 4" (10 cm) diameter puddle.
- Puddles larger than 4" (10 cm) in diameter will require additional hardener. Mix thoroughly until uniform color is achieved.

**NOTE:** ONLY USE EVERCOAT® CREAM HARDENER!*

## Application
- Apply in layers with even firm pressure.
- Do not apply all at once.

## Finishing
- Sand body filler with 80-180 grit sandpaper.
- If necessary, reapply Rage® Ultra to fill any pinholes or low spots, allow filler to dry and then sand with 180 grit sandpaper.
- Finish sand body filler with 180 grit.

**NOTE:** Allow minimum of 20 minutes sanding time over silicon bronze welds.

**NOTE:** To optimize primer performance apply 440 Express™ before applying primer surfacer.

## Technical
<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Off-White Paste</td>
</tr>
<tr>
<td>VOC</td>
<td>Refer to Section 9 of Safety Data Sheet</td>
</tr>
<tr>
<td>Relative Density</td>
<td>Refer to Section 9 of Safety Data Sheet</td>
</tr>
<tr>
<td>Sand Time</td>
<td>15-20 mins.</td>
</tr>
<tr>
<td>Max Recommended Thickness (sanded)</td>
<td>1/4 inch (6mm)</td>
</tr>
</tbody>
</table>

**NOTE:** Properties are typical values and should not be considered as sales specifications. Physical testing performed @ -72°F (22°C) / 75% RH unless otherwise noted.

## Safety
Read all directions and warnings prior to using Evercoat® products. Safety Data Sheets can be found online at evercoat.com. Never return mixed filler to container.

**NOTE:** Keep can closed and store in a cool dry place. ONLY USE EVERCOAT® CREAM HARDENER!*