

PRODUCT: Rage Ultra Xtra

PART NUMBER: 100144 **Gallon** **4 units/case**
100145 **16 oz. Pouch** **6 units/case**

DESCRIPTION: **Rage Ultra Xtra** is specially formulated to allow for extended work times- up to 40 minutes at 75°F (24°C). Manufacturers and technicians can mix and spread large quantities knowing they have enough time to work larger surfaces, saving time and increasing productivity. **Rage Ultra XTRA** can also be mixed with Rage Ultra for the ultimate flexibility in work time in most any temperature while maintaining the proper mix ratio.

APPROVED SUBSTRATES:



- Steel
- Aluminum
- Fiberglass
- Galvanized Steel
- SMC
- Sanded OEM Paint

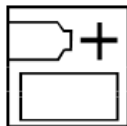
NOTE: For structural repairs prone to high degrees of stress and flexibility, use a fiber reinforced filler such as Everglass®, Kitty Hair® or Fiber Tech®.

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 grit to remove the paint and featheredge.

MIXING:



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

APPLICATION:



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

FINISH:



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

TECHNICAL SPECIFICATIONS:

- | | |
|--------------------------------------|--|
| ▪ Appearance | Yellow paste |
| ▪ VOC | Refer to Section 9 of the Safety Data Sheet |
| ▪ Relative Density | Refer to Section 9 of the Safety Data Sheet |
| ▪ Sand Time | 120 minutes @ 72°F (22°C)
<i>See chart below for adjusted sanding times</i> |
| ▪ Max Recommended Thickness (sanded) | 1/4 inch (6mm) |

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.

MIX RATIO						
RAGE ULTRA	RAGE ULTRA XTRA					
		60°	75°	90°	105°	
100%	0%	Work Time	6:00	4:30	2:10	1:15
		Dry time	22:00	20:00	16:00	14:00
75%	25%	Work Time	17:00	9:00	6:40	3:00
		Dry time	45:00	33:00	20:00	15:00
50%	50%	Work Time	30:00	20:00	8:45	5:10
		Dry time	69:00	40:00	22:00	17:00
25%	75%	Work Time	50:00	28:00	14:20	7:45
		Dry time	110:00	64:00	31:00	20:00
0%	100%	Work Time	80:00	40:00	21:45	13:00
		Dry time	140:00	110:00	90:00	62:00

SAFETY & HANDLING:

Read all directions and warnings prior to using Evercoat® products. Safety Data Sheets can be found online at evercoat.com.

NOTES:

- Never return mixed filler to can
- Keep can closed and store in a cool dry place

USE WITH CREAM HARDENER ONLY!