

SUBJECT: Body Filler High Heat and Large Panel Application Recommendation

It is common to cut back on the cream hardener/catalyst when working in hot temperatures to extend working time, however excessive under-catalyzation can lead to post-paint repair mapping/movement, or even cracking under extreme conditions. This can occur when the filler is radically under-catalyzed and painted to a dark color. When the repair is exposed to the sun the panel heats up thus reactivating the uncured materials and causing the filler to post-cure and move. If the filler is excessively under-catalyzed the solvents in the filler that should have hardened in the curing process may even begin to gas off and dry out leading to the filler cracking. To avoid these issues Evercoat recommends catalyzing fillers at a ratio of 50:1 (2%) and use below 90°F/32°C to provide ample working time.

It is not recommended to catalyze Evercoat fillers below the minimum ratio of 1%. Ambient heat will not offset the incorrect catalyst ratio to create a proper cure. To help achieve more working time it is recommended to store the filler and cream hardener/catalyst in a cool dry area before use to help slow down the reaction and provide the needed working time. Cooling the panel before the application of the repair material can also help to extend the working time. Mixing smaller amounts while spreading the mixed product out over a larger working surface can also help to dissipate the heat and slightly extend the working time.

NOTE: Where available incorporate Evercoat Rage® Ultra XTRA™ #100144 or #100147 to extend the working time for high heat and large panel applications when needed. Refer to the Technical Data Sheet for mixing guidance when mixing with the following Evercoat Products.

Rage® OPTEX®
Rage® Gold
Z-GRIP® OPTEX®
LITE-WEIGHT® OPTEX®
Commercial Optex®
EverGold Filler

Rage® Ultra
Rage®
Z-GRIP®
LITE-WEIGHT®
Commercial Ultra™
CHROME-A-LITE™

May also be added to Evercoat Premium Polyester Glazing and Blending Putties to extend working time and adjust viscosity for high-heat applications.

WARNING: Rage® Ultra Xtra is NOT to be used with Quantum1™ 10:1 Single Step Repair Technology products.