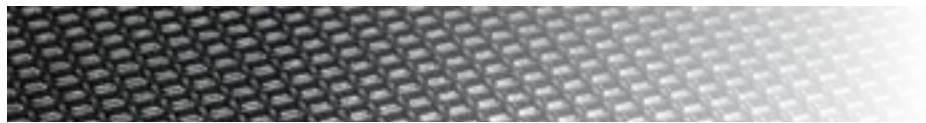


# U-POL<sup>®</sup>



**PROFIT<sup>™</sup>**  
**THROUGH**  
**PROCESS**

## **Refinishing System**



## **Process Guide**

# INDEX - Repair Processes

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# 1

## FILLER REPAIR: Deep Filling

**PROFIT THROUGH PROCESS**

**U-POL®**



Use lint-free cloth to prepare surface with **Water-based S2000** or **Solvent-based S2002 Degreaser**.



Abrade repair area with palm sander with **U-POL P80-150 coarse grit disc**. Repeat step 1.



Mix **U-POL Deep Filling Bodyfiller** with 2% hardener (mixing ratio: a pea of hardener to a golf ball of paste) on **Onion Mixing Board**. Avoid air entrapment by mixing in a figure of eight.



Apply filler by pressing down firmly into repair area, skimming off excess and re-applying. Ensure no air is trapped.



Allow to cure thoroughly then apply thin coat of **U-POL Dry Guide Coat S2004/AL**. Abrade using disc grit P120-240. Prime and paint as required, following application recommendations.



## Products required for performing this process:

### Deep Fillers (steel, fibre glass):

EASY ONE Super Easy Sanding Body Filler	3.5L Tin, 600ml Bag
SMOOTH 7 Smooth Body Filler	3.5L Tin
QUICK SAND Universal Easy Sanding Body Filler	670ml, 2.1L Tin, 1.3L Dispenser

### Deep Fillers - Multifunction \* (steel, fibre glass, aluminium, galvanised steel):

U-POL D Smooth Metallic Body Filler	1.1L Tin, 1.3L Dispenser
GALV X Extra High Adhesion Body Filler	750ml Tin, 1.3L Dispenser
FANTASTIC Ultra Lightweight Body Filler/Stopper	3L Tin, 1L Bag
EXTRA GOLD Extra Smooth Easy Sand Body Filler	600ml, 1.1L , 2.1L Tin, 1.3L Dispenser

### Other Products:

S2000 Water Based Degreaser	5L Tin
S2001 & S2002 Solvent Based Degreasers (Fast & Slow)	1L, 5L Tin, 500ml Aerosol
Maximum Abrasive Paper Discs P80, 120, 150, 180, 240 grit	100 discs
Applicators for Body Filler	Single, Set of 3
ONION BOARD Multi Layered Mixing Palette	100 sheets
S2004 Dry Guide Coat Aerosol (Black)	450ml Aerosol

\* Multifunction fillers provide great adhesion to all substrates including galvanised.

## FILLER REPAIR: Rigid Plastic & Fibre Glass



Use lint-free cloth to prepare surface with **Water-based S2000** or **Solvent-based S2002 Degreaser**.

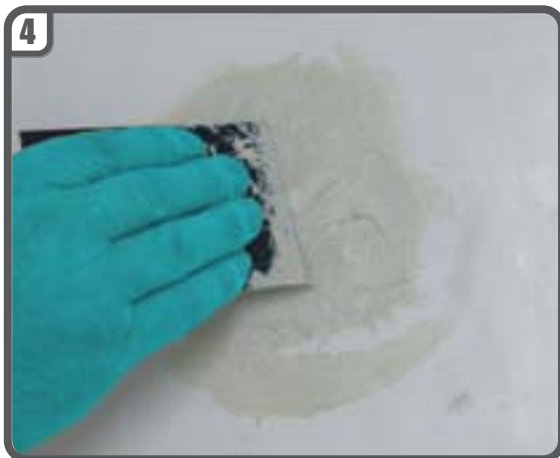


Abrade surrounding area using palm sander with **U-POL P80-150 coarse grit disc**, remove any loose or fractured particles. Repeat step 1.



Bridge large holes or missing sections by supporting bonding material with **U-POL Reinforcing Film** or **Aluminium Mesh**.

Mix **U-POL SMC** or **Fibre Glass Bodyfiller** with correct hardener ratio (refer to mixing guidelines on tin) on **Onion Mixing Board**. Avoid air entrapment by mixing in a figure of eight.



Apply film/mesh with filler into repair, bridging gap and spreading evenly.



Allow to cure thoroughly then apply thin coat of **U-POL Dry Guide Coat S2004/AL**. Abrade using grit P180-240. Repeat step 1. Refill any low areas with **U-POL Fine Finishing Fillers** (see U-POL Filler Repair Process: Top Filling).



## Products required for performing this process:

### Rigid Plastic Fillers:

SMC High Adhesion Glass Fibre Body Filler (White, Black) 1.1L Tin

### Glass Fibre Fillers:

P40 Glass Fibre Repair Paste 1L, 1.85L Tin

FIBRAL Sandable Glass Fibre Repair Paste 900ml Tin, 1.3L Dispenser, 1L Bag

### Other Products:

Reinforcing Film SHRF 3.6metres

Aluminium Mesh PM/1 25x20cm

S2000 Water Based Degreaser 5L Tin

S2001 & S2002 Solvent Based Degreasers (Fast & Slow) 1L, 5L Tin, 500ml Aerosol

Maximum Abrasive Paper Discs P80, 120, 150, 180, 240 grit 100 discs

ONION BOARD Multi Layered Mixing Palette 100 sheets

Applicators for Body Filler Single, Set of 3

S2004 Dry Guide Coat Aerosol (Black) 450ml Aerosol

## FILLER REPAIR: Top Filling / Finishing Filler



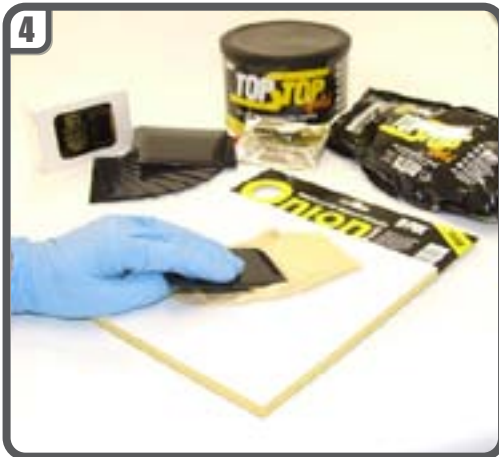
Use lint-free cloth to prepare surface with **Water-based S2000** or **Solvent-based S2002 Degreaser**.



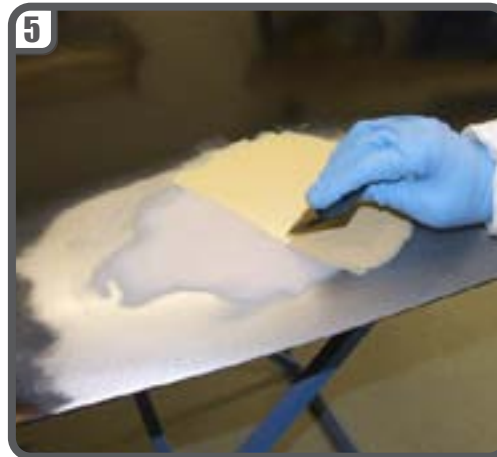
Abrade repair area using palm sander with **U-POL P240-500 grit disc**. Repeat step 1.



Dispense **U-POL Fine Finishing Filler** onto **Onion Mixing Board**.



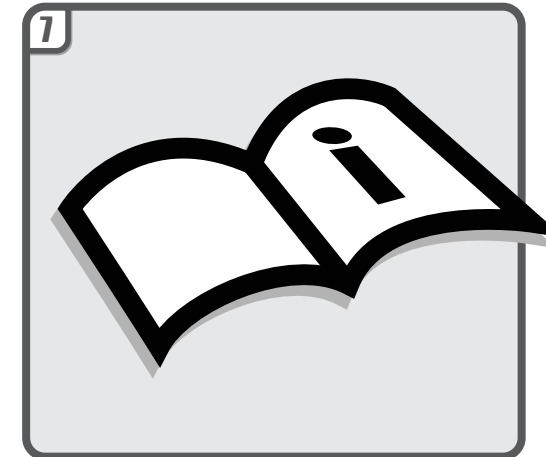
Mix bodyfiller with 2% hardener (mixing ratio: a pea of hardener to a golf ball of paste) on Onion Board. Avoid air entrapment by mixing in a figure of eight.



Apply filler by pressing down firmly into repair area, skimming off excess and re-applying. Ensure no air is trapped.



Allow to cure thoroughly and apply thin coat of **U-POL Dry Guide Coat S2004/AL**. Abrade using **U-POL P320-500 grit disc**.



Prime and paint as required, following application recommendations.

## Products required for performing this process:



### Finishing Fillers (steel, fibre glass):

TOP STOP Smooth Finishing Body Filler

750ml Tin, 1.3L Dispenser



### Finishing Fillers – Multifunction \* (steel, fibre glass, aluminium, galvanised steel):

TOP STOP GOLD Extra Smooth Easy Sand Finishing Stopper

1.1L Tin, 1.3L Dispenser, 1L Bag

DOLPHIN Brushable Very Fine Finishing Stopper

440ml Bag, 880ml Bottle

DOLPHIN HV High Viscosity Brushable Very Fine Finishing Stopper

440ml Bag

### Other Products:

S2000 Water Based Degreaser

5L Tin

S2001 & S2002 Solvent Based Degreasers (Fast & Slow)

1L, 5L Tin, 500ml Aerosol

Maximum Abrasive Paper Discs P240, 320, 400, 500 grit

100 discs

ONION BOARD Multi Layered Mixing Palette

100 sheets

Applicators for Body Filler

Single, Set of 3

S2004 Dry Guide Coat Aerosol (Black)

450ml Aerosol



\* Multifunction fillers provide great adhesion to all substrates including galvanised.





Clean surface with **U-POL Degreaser** and lint-free cloth, for e-coat abrade with **Grey Finishing Pad** for bare metal key surface with **Red Finishing Pad**.



Degrease again and wipe with **U-POL Tack Cloth**.



Mix hardener with **U-POL Primer** according to ratio. Add thinners as necessary (+10% for primer surfacer for large areas, +15-20% for wet-on-wet sealer), for high build no thinners are required.



Pour activated primer through **U-POL Strainer** mesh (sizes 190µm to 280µm depending on thinned product) directly into **U-POL Spraygun** cup.



Wearing protective equipment in booth, apply primer. Allow sufficient flash-off time between coats. Follow curing guidelines for air dry/booth baking or IR.



Once fully cured, apply **U-POL Dry Guide Coat S2004/AL** and abrade using **U-POL P500 grit disc** with an interface pad.

**For wet-on-wet non-sand primer** (with 15-20% thinners added): Skip step 6 (abrading process) and apply basecoat directly to primer surface once matted off (10-20mins).

## Products required for performing this process:

### Multi-Purpose Primers:

S2020 2K High Build Primer 3:1 (Beige, Grey)	1L, 3L Tin
S2021 2K High Build Super Cure Easy Sand Primer 5:1 (Beige, Grey)	1L, 2.5L, 3L, 5L Tin
S2025 2K High Build Primer 4:1 (Grey, Dark Grey)	1L, 4L Tin

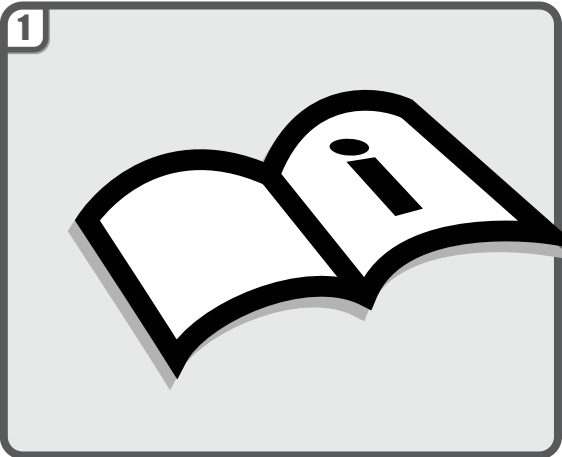
### Associated Coatings:

S2030 Fast Hardener	250ml, 330ml, 500ml, 1L, 2.5L, 5L Tin
S2031 Extra Fast Hardener	330ml, 500ml, 1L, 2.5L Tin
S2032 Standard Hardener	330ml, 500ml, 1L, 2.5L, 5L Tin
S2033 Slow Hardener	330ml, 500ml, 1L, 2.5L Tin
S2040 Slow Acrylic Thinner	1L, 5L Tin
S2041 Standard Acrylic Thinner	1L, 5L Tin
S2042 Fast Acrylic Thinner	1L, 5L Tin
S2044 Fast Universal Thinner	1L, 5L Tin
S2045 Standard Universal Thinner	5L Tin
S2046 Slow Universal Thinner	1L, 5L Tin

### Other Products

Maximum HVLP Gravity Spray Gun	1.3-1.7mm nozzle
Maximum Paint Strainers (Fine 280microns & Extra Fine 190microns)	250 strainers, 1000 strainers
S2000 Water Based Degreaser	5L Tin
S2001 & S2002 Solvent Based Degreasers (Fast & Slow)	1L, 5L Tin, 500ml Aerosol
Maximum Abrasive Paper Discs P500 grit	100 discs
Maximum Finishing Pads (Red Fine, Grey Super Fine)	10 pads, 35 sheet perforated roll
Maximum High Performance Tack Cloth	10 box, 50 dispenser
S2004 Dry Guide Coat Aerosol (Black)	450ml Aerosol





Apply colour basecoat according to your paint manufacturer's recommendations.



Mix **U-POL Clearcoat** with appropriate hardener according to mixing ratio.



Pour activated clearcoat through **U-POL Strainer** mesh (size 125µm) directly into **U-POL Spraygun** cup. Use 1.3-1.4mm nozzle tip for HVLP sprayguns or 1.2mm for Hybrid sprayguns.



Apply "grip coat" by moving quickly over surface area to be sprayed.



Allowing no flash off time, immediately spray full coat ("rip coat") over grip coat, ensuring not to overload product on surface.



Allow product to flow. If within 10 minutes flow out is not satisfactory, lightly apply **U-POL Fade Out Thinner aerosol S2043/AL** to rectify.

## Products required for performing this process:



### Clear Coats:

S2081EV UHS Clear Coat 3:1	1L, 5L Tin
S2083EV UHS Super Clear Coat 2:1	1L, 5L Tin
S2086EV UHS Super Fast Clear Coat 3:1	1L, 5L Tin
S2090 HS Scratch Resistant Clear Coat 3:1 (Conventional Application)	1L, 5L Tin



### Associated Products:

S2034 Standard Hardener (for S2083EV only)	1L, 2.5L Tin
S2035 Fast Hardener (for S2083EV only)	1L, 2.5L Tin
S2036 Slow Hardener (for S2083EV only)	1L, 2.5L Tin
S2037EV Slow Hardener (for S2081EV and S2086EV only)	1L, 2.5L Tin
S2038EV Fast Hardener (for S2081EV and S2086EV only)	330ml, 1L, 2.5L Tin
S2039EV Standard Hardener (for S2081EV and S2086EV only)	330ml, 1L, 2.5L Tin



### Other Products

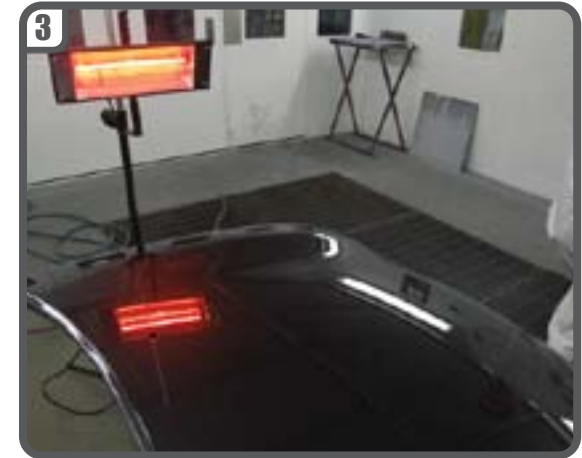
Maximum Hybrid Gravity Spray Gun	1.2mm nozzle
Maximum HVLP Gravity Spray Gun	1.3 or 1.4mm nozzle
Maximum Paint Strainers (Super Fine 125microns)	250 strainers, 1000 strainers
S2043 Fade Out Thinner Aerosol	450ml Aerosol



1 Through dry by air (for all coatings).



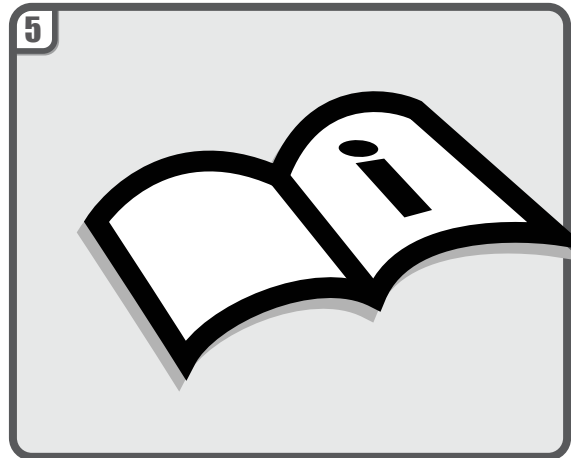
2 Through dry by baking at 60°C in booth (for all coatings except waterborne basecoats).



3 Curing by Infra-Red (IR) dryer (for fillers, primers and clearcoats). When used in a static position, place IR dryer at 0.5m (20inches) minimum distance from curing surface.



4 Through dry by **U-POL DRYFLOW** airflow gun (for all waterborne coatings). Direct airflow across paint surface for optimum drying.



5 Refer to technical datasheets for recommended drying times associated with each method.

## Products required for performing this process:

### Curing Tools:

Maximum DRYFLOW Air Jet Gun

Maximum DRYSTAND Adjustable Stand (for DRYFLOW Gun)

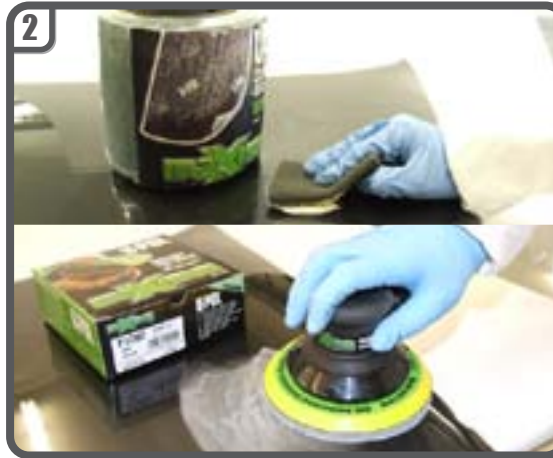


# BLENDING & DE-NIBBING CLEAR COAT

## Blending Repair



1 Clean areas surrounding new repair with **U-POL Degreaser**.



2 Abrade surface gently using sander with **U-POL P1000 grit film disc** and foam interface pad. Remove any excess debris by wiping work surface with **U-POL Tack Cloth**.

**OR**

Abrade surface gently with **U-POL Grey Finishing Pad**. Remove any excess debris by wiping work surface with **U-POL Tack Cloth**.



3 Clean and degrease entire area ready for application of clearcoat. (See U-POL process: Applying Clearcoat)

## De-Nibbing Repair



1 Clean fully cured clearcoat surface with **U-POL Degreaser**.



2 Remove any nibs or contaminants using sander with **U-POL P1500 grit film disc** and soft-foam interface pad. Remove any excess debris by wiping work surface with **U-POL Tack Cloth**.



3 Clean and degrease area ready for polishing. (See U-POL process: Compounding & Polishing)

## Products required for performing this process:

### Products:

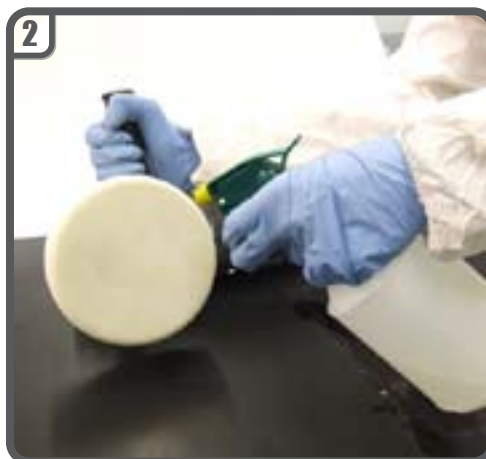
S2000 Water Based Degreaser	5L Tin
S2001 & S2002 Solvent Based Degreasers (Fast & Slow)	1L, 5L Tin, 500ml Aerosol
Maximum Abrasive Premium Film Discs P1000, 1500 grit	50 discs
Maximum Finishing Pads (Grey Super Fine)	10 pads, 35 sheet perforated roll
Maximum High Performance Tack Cloth	10 box, 50 dispenser







To remove P1500 abrasive marks: apply **U-POL 333 Cutting Compound (paste or liquid)** to a clean and conditioned hard foam mop head. Alternatively, for hand use, apply compound to polishing cloth.



For optimum performance add water to mop head as necessary. Re-apply if needed to avoid product dry-out and over-heating.



Start polishing machine (speed 1200 rpm) flat on work surface, maintain pad as horizontal as possible. Work areas of 800mm square at a time before moving on.



Buff surface with polishing cloth, wipe away any residue and bring out gloss.



Repeating steps 1-4, remove any compounding swirl marks with **U-POL 334 Fine Finishing Compound**. Also suitable for restoring weathered paintwork and blending dry edges of blow-ins.



Repeating steps 1-4, use **U-POL 335 High Gloss Final Glaze**, produce a deep, lasting professional gloss. Apply without water, using a soft foam mop head at 1200 rpm. Allow to dry before buffing with soft cloth.



As a final step, give durable long-lasting protection to polished surface by applying **U-POL 336 Ultra Gloss Wax Protector** by hand using soft polishing cloth.

## Products required for performing this process:



### Compounding Products:

333 Cutting Compound Paste	1.25kg, 3.25kg Tub
333 Cutting Compound Liquid	1L Bottle

### Polishing Products:

334 Fine Polishing Compound	1L Bottle
335 High Gloss Final Glaze	1L Bottle
336 Ultra Gloss Wax Protector	1L Bottle



### Other Products:

S2000 Water Based Degreaser	5L Tin
S2001 & S2002 Solvent Based Degreasers (Fast & Slow)	1L, 5L Tin, 500ml Aerosol
Maximum High Performance Tack Cloth	10 box, 50 dispenser

**Tigerseal**


1  
Abrade edges to be sealed using sander with **U-POL P80-120 coarse grit disc**. Alternatively abrade by hand with **U-POL Red Finishing Pad**.



2  
Clean surface area with **U-POL Degreasers** and allow to dry thoroughly.



3  
Load **U-POL Tigerseal** cartridge into dispensing gun, cut nozzle to required bead diameter at 45° angle slice. Gun out and discard first 10cm of sealant.



4  
Apply **Tigerseal** (white, black, grey) to surface in single continuous dispensing stroke. Allow time to through-cure (refer to datasheets for guidelines) before over-coating.

**Greystripe**

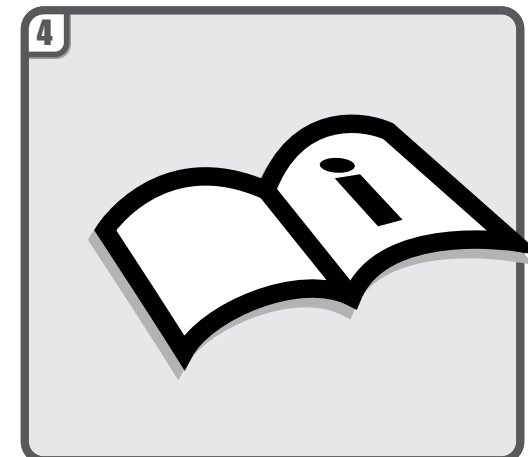

1  
Abrade panel edges to be sealed with **U-POL Red Finishing Pad**.



2  
Clean surface area with **U-POL Degreasers** and allow to dry thoroughly.



3  
Apply **U-POL Greystripe** generously and evenly with stiff brush, always brushing along direction of seam. One coat is adequate for most applications.



4  
Allow time to through-cure (refer to datasheets for guidelines) before over-coating.

## Products required for performing this process:

### Coating Products:

GREY STRIPE Brushable Seam Sealer

1L Tin

TIGER SEAL Polyurethane Adhesive & Sealant (Grey, Black, White)

310ml Cartridge

### Other Products:

S2000 Water Based Degreaser

5L Tin

S2001 & S2002 Solvent Based Degreasers (Fast & Slow)

1L, 5L Tin, 500ml Aerosol

Maximum Abrasive Paper Discs P80, 120 grit

100 discs

Maximum Finishing Pads (Red Fine)

10 pads, 35 sheet perforated roll

ONION BOARD Multi Layered Mixing Palette

100 sheets

Applicators for spreading Sealant

Single, Set of 3



# UNDERBODY STONE CHIP REPAIR

Application of tough, durable coating to reproduce manufacturer's original finish



U-POL®



1 Use **U-POL Clear Masking Film** to protect areas not to be sprayed. Ensure static-cling side of film faces down on vehicle.



2 Mask off areas surrounding repair surface.



3 Use lint-free cloth to prepare surface with **Water-based S2000** or **Solvent-based S2002 Degreaser**.



4 Abrade repair area using sander with **U-POL P180 grit disc**. Repeat step 3.

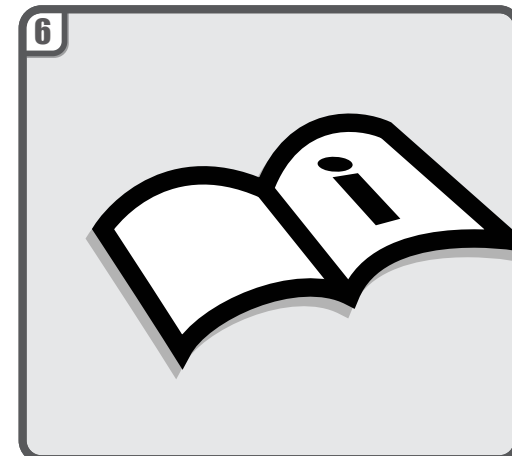


5.1 Thoroughly shake **U-POL Gravi-gard Anti Stone Chip** aerosol for 2mins. Apply 1-2 coats from ca. 30cm away from surface.

OR



5.2 Alternatively, apply **U-POL Gravitex Stone Chip Protector** using **U-POL Suction Shutz Gun**.



6 Prime and paint as required, following application recommendations.

# UNDERBODY STONE CHIP REPAIR

Application of tough, durable coating to reproduce manufacturer's original finish



# U-POL®

## Products required for performing this process:

### Stone Chip Repair Products:

GRAVI-GARD Anti Stone Chip Aerosol (Grey, Black)	500ml Aerosol
GRAVITEX HS Stone Chip Protector Coating (Black, Grey, White)	1L Bottle

### Other Products:

Shutz Thick Coating Spray Gun	
S2000 Water Based Degreaser	5L Tin
S2001 & S2002 Solvent Based Degreasers (Fast & Slow)	1L, 5L Tin, 500ml Aerosol
Maximum Abrasive Paper Discs P180 grit	100 discs
Maximum Premium Clear Masking Film (on Dispensing roll)	4x150m, 5x120m
Maximum Safety Cutter for Masking Film	5 pcs.



# RAPTOR TRUCK BED LINER



1 Lightly abrade original manufacturer's finish using sander with **U-POL P240 grit disc**, or by hand with **U-POL Red Finishing Pad**. Treat any bare metal surface with **U-POL ACID#8 Etch Primer**.



2 Clean entire surface with **U-POL Degreaser**. Use **U-POL Clear Masking Film** to protect areas not to be sprayed.



3 Add **U-POL System20 Hardener** directly into **Raptor** bottle up to level A (see product instructions). For tintable version, add basecoat tinter to level B. For option to apply using a **HVLP spraygun**, add up to 10% **U-POL System20 Fast Thinners**.



4 Replace cap and shake vigorously for 2minutes to activate mix. Remove cap and attach **U-POL Raptor** bottle directly to suction shutz gun.



5 Apply to truck bed with an even sweeping motion to obtain required texture. Allow 60minute flash off period between coats. Allow to cure according to recommended guidelines.

## Products required for performing this process:

### Coating Products:

RAPTOR Spray-On Liner (Black, Tintable)

4L Kit (incl. hardener)

### Associated Coatings:

S2030 Fast Hardener

250ml, 330ml, 500ml, 1L, 2.5L, 5L Tin

S2031 Extra Fast Hardener

330ml, 500ml, 1L, 2.5L Tin

S2032 Standard Hardener

330ml, 500ml, 1L, 2.5L, 5L Tin

S2033 Slow Hardener

330ml, 500ml, 1L, 2.5L Tin

S2040 Thinners Range (for spraygun application)

1L, 5L Tin

### Other Products:

S2000 Water Based Degreaser

5L Tin

S2001 & S2002 Solvent Based Degreasers (Fast & Slow)

1L, 5L Tin, 500ml Aerosol

Maximum Abrasive Paper Discs P240 grit

100 discs

Shutz Thick Coating Spray Gun

ACID#8 Acid Etch Primer Aerosol

450ml Aerosol





# WELD THROUGH CORROSION PROTECTION

To achieve rust protection  
in welding applications



# U-POL®



Use lint-free cloth to prepare surface with **Water-based S2000** or **Solvent-based S2002 Degreaser**.



Spray one coat of **U-POL WELD#2 Weld Tough Zinc rich** or **Copper rich Primer** onto all surfaces to be welded and allow to dry.



SPOT, MIG or TIG-weld directly through primed surfaces. Refinish as required.

## Products required for performing this process:



### Products:

WELD#2 Weld Through Zinc-rich Primer Aerosol	450ml Aerosol
WELD#2 Weld Through Copper-rich Primer Aerosol	450ml Aerosol
S2000 Water Based Degreaser	5L Tin
S2001 & S2002 Solvent Based Degreasers (Fast & Slow)	1L, 5L Tin, 500ml Aerosol





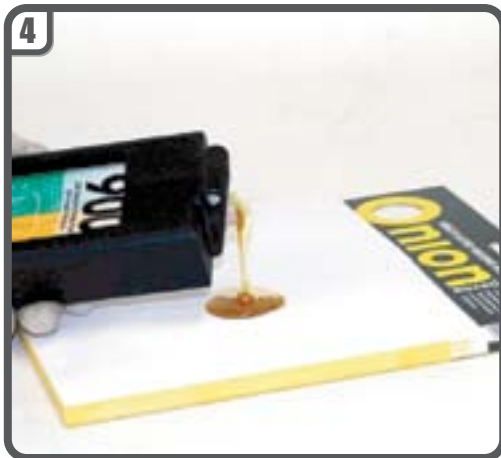
1 Use lint-free cloth to prepare surface with **Water-based S2000**.



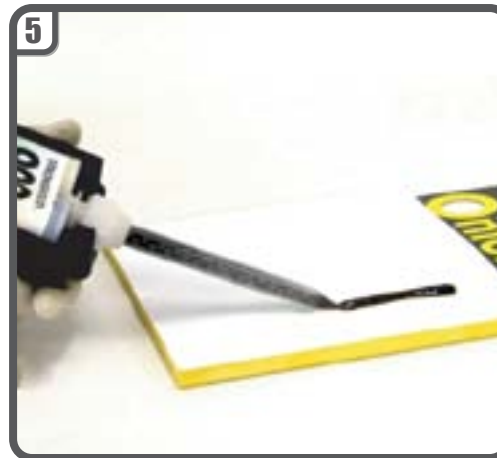
2 Abrade repair area using sander with **U-POL P80-120 coarse grit disc**. Repeat step 1.



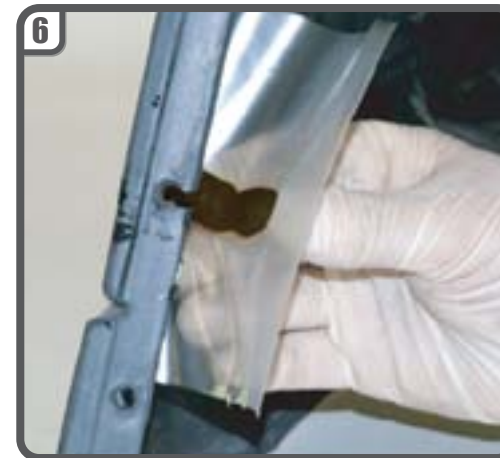
3 Apply one coat of **U-POL Plast-X Adhesion Promoter PLAS/2** aerosol and allow to dry for 30 minutes.



4 Open **U-POL Stronghold Super-Fast Adhesive SH901** and allow to stand upright for 1 min. Place into **Cartridge Gun** and equalise content of tube. Refer to **U-POL Stronghold Range** for adhesive product options.



5 As adhesive cures in 50seconds, fit mixing nozzle, quickly gun out and discard first 5cm of adhesive on **Onion Mixing Board**.



6 Apply adhesive on **U-POL Contouring Film** and immediately position on repair. Leave to harden for minimum 30mins. **U-POL Reinforcing Film** can be used for greater strength.



7 Adhesive can be used for re-attaching lugs on bumpers and headlamps, fixing new bolts which have been torn out or applying block of bonding material for drilling and tapping.

## Products required for performing this process:

### Plastic Adhesion Products:

PLAST-X 2 Adhesion Promoter Aerosol

400ml Aerosol

### Adhesive Bonding Products:

STRONGHOLD SH900 Adhesive Range

### Other Products:

S2000 Water Based Degreaser

5L Tin

Maximum Abrasive Paper Discs P80, 120 grit

100 discs

ONION BOARD Multi Layered Mixing Palette

100 sheets

High Performance Dual Cartridge Dispensing Gun

50ml, 200ml

Reinforcing Film (for PLAST-X)

1metre

Contouring Film (for PLAST-X)

1metre

Mixing Tips (for PLAST-X and STRONGHOLD)





Use lint-free cloth to prepare surface with **Water-based S2000 Degreaser**. Use heat gun to warm plastic and re-shape any damaged areas.



Drill 5mm holes at end of each split. Open entire split to 3mm wide, chamfer edges to 30mm width. Drill 5mm-holes 10mm apart, along both sides of split.



Abrade inside and outside of repair area using **U-POL P80-180 grit disc**. Repeat step 1. Apply one coat of **U-POL Adhesion Promoter PLAS/2** and allow to dry for 30 minutes.



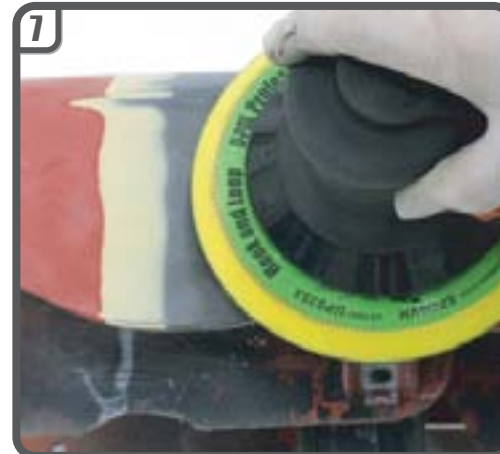
Open **Stronghold SH915 Adhesive** (for all thermo plastics), allow to stand upright for 1 min to settle and equalise contents of tube.



Work on sections that can be covered with one hand at a time. Cut a piece **U-POL Reinforcing Film** and **Contouring Film** larger than area required. Attach mixing nozzle, gun out and discard first 5cm of adhesive on **Onion Mixing Board**. Apply to reinforcing film.



Apply coated reinforcing film to underside of repair, quickly push adhesive through splits and holes, place contouring film on the top. Smooth adhesive through film.



Remove contouring film after 10-15minutes. Abrade adhesive with **U-POL P120-240 grit disc**.



For minor imperfections in repair or a scuff: Apply **Adhesion Promoter PLAS/2** and allow to dry. Mix **Plastic Filler PLAS/6** with 2% hardener. Apply and once cured, abrade

## Products required for performing this process:



### Specialist Plastic Products:

PLAST-X 2 Adhesion Promoter Aerosol	400ml Aerosol
STRONGHOLD SH915 Flexible TPO Adhesive (50sec)	50,200ml Cartridge
PLAST-X 6 Smooth High Adhesion Body Filler for Plastics	600ml Tin

### Other Products:

S2000 Water Based Degreaser	5L Tin
Maximum Abrasive Paper Discs P80, 120, 150, 180, 240, 320 grit	100 discs
ONION BOARD Multi Layered Mixing Palette	100 sheets
Applicators for Body Filler	Single, Set of 3
Reinforcing Film (for PLAST-X)	1 metre
Contouring Film (for PLAST-X)	1 metre
High Performance Dual Cartridge Dispensing Gun	50ml
Mixing Tips (for PLAST-X)	

# PLASTIC REPAIRS: Texturing & Painting

Reproducing manufacturers original finish on plastic parts



U-POL®



Use lint-free cloth to prepare surface with **Plastic Cleaner PLAS/1** or **Water-based S2000 Degreaser** (do not spray directly onto paint).



Apply **U-POL Adhesion Promoter PLAS/2** and allow to dry.



Spray surface with **Grey Primer PLAS/3** or **High Build Primer PLAS/3HB**. Once cured, flat with **U-POL P240-320 grit disc**. Repeat step 1.



For fine texture coating:  
Apply **Fine Texture PLAS/4F** in one or two very light coats.

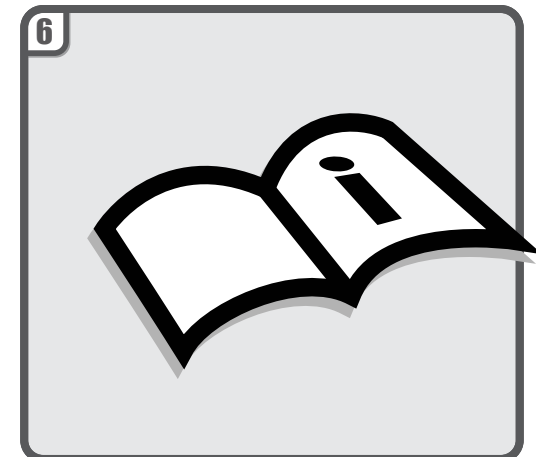
**OR**



For coarse texture:  
Apply **Coarse Texture PLAS/4C** from distance of about 1 meter, single very light even coat.



For the black or grey colours: check against available shades of **U-POL Plastic Bumper Colours PLAS/5**. Spray two or three light coats directly over prepared surface until match is achieved.



**For coloured parts skip steps 4 and 5:** refinish as paint manufacturer's recommendations.

## Products required for performing this process:



### Specialist Plastic Products:

PLAST-X 1 Plastic Cleaner	400ml Aerosol
PLAST-X 2 Adhesion Promoter Aerosol	400ml Aerosol
PLAST-X 3 Primer Filler for Plastic Components	400ml Aerosol
PLAST-X 3HB High Build Primer Filler for Plastic Components	400ml Aerosol
PLAST-X 4F Fine Texture Coating	400ml Aerosol
PLAST-X 4C Coarse Texture Coating	400ml Aerosol
PLAST-X 5 Plastic Bumper and Trim Colour Coatings	400ml Aerosol

(See attached range leaflet for detail)

### Products:

S2000 Water Based Degreaser	5L Tin
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**Product Description**

Make of Car	Model	Product Description									
		PLAS/5B (UP0209) BLACK	PLAS/5BG (UP0219) BASALT GREY	PLAS/5DG (UP0208) DARK GREY	PLAS/5GG (UP0220) GRAPHITE GREY	PLAS/5LG (UP0206) LIGHT GREY	PLAS/5MG (UP0207) MID GREY	PLAS/5SB (UP0222) SIGNAL BLACK	PLAS/5SG (UP0221) SMOKE GREY	PLAS/5TB (UP0223) TRAFFIC BLACK	
<b>ALFA ROMEO</b>	All models										
<b>AUDI</b>	A2										
	A3										
	A4										
	A6										
	A8										
<b>BMW</b>	2 Series										
	3 Series *										
	5 Series *										
	7 Series										
	Mini *										
<b>CITROËN</b>	Berlingo										
	C5										
	C3										
	C2										
	Xsara										
<b>FIAT</b>	Saxo										
	Punto										
	Stilo										
	Panda										
	Scudo										
	Doblo										
	Mutipla										
	Ducata										
	Bravo *										
	Cinquecento										
<b>FORD</b>	Fiesta *										
	Mondeo *										
	Ka										
	Focus										
	Fusion										
	Escort										
	Maverick										

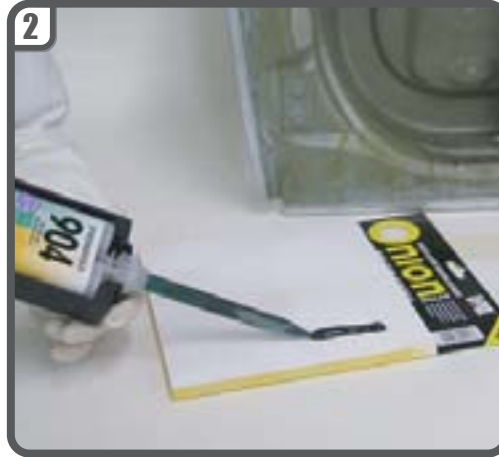
**Product Description**

Make of Car	Model	Product Description									
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<b>HONDA</b>	CR-V										
	Civic										
	Jazz										
	HR-V										
<b>LAND ROVER</b>	All models *										
<b>MERCEDES</b>	A190										
<b>NISSAN</b>	Almera										
	Interstar										
	Micra										
	Primera										
<b>PEUGEOT</b>	106										
	205										
	206										
	306										
	405										
	406										
	605										
<b>RENAULT</b>	807										
	Laguna										
	Clio										
	Mégane										
	Espace										
	Trafic										
<b>ROVER</b>	Scenic										
	25										
<b>TOYOTA</b>	Corolla										
	Starlet *										
	Avensis										
	Rav 4 *										
<b>VAUXHALL OPEL</b>	Corsa										
	Vectra *										
	Astra *										
	Zafira										
	Meriva										
<b>VOLVO</b>	Agila										
	V40 *										
	XC90 *										
	S60										
	S80										
<b>VW</b>	740										
	V70										
	Golf *										
	Polo *										
	Sharan										
	Passat *										
	Touran										

\* The choice of bumper colour may vary depending on the year of manufacture of the vehicle.



Use lint-free cloth to prepare surface with **S2000 Water-based Degreaser**. Abrade panel edges using sander with **U-POL P80-120 coarse grit disc**. For plastics, apply single coat of **Adhesion Promoter PLAS/2** and allow to dry for 30 minutes.



Use **U-POL Stronghold** bonding compounds **SH902 (5 mins)** or **SH904 (45 mins)**; depending on working time required. Remove tip, allow to stand upright for 1 min then equalise the two sections. Attach mixing tube, dispense and discard one trigger full onto a **U-POL Onion Board**.



Apply bead of bonding material to both surfaces to be bonded.



Spread evenly over edges of contact and apply second bead ca. 5mm thick over prepared surface.



Position new panel carefully and clamp gently and evenly into place.

#### A. For Metal door skins:

Fold door skin edges over door frame flange, remove excess adhesive with lint-free cloth and leave to dry. Metal finish panel, prepare and paint to match car.

#### B. For Stylizing kits:

Remove excess bonding material, sand down edges and fill as required (See U-POL Filler Repair Process: Top Filling).

#### C. For Plastic door skins and Roof panels:

Remove excess bonding material, seal edges where necessary with a Seam Sealer.



## Products required for performing this process:

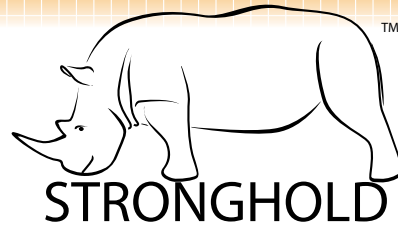
### Bonding Products:

STRONGHOLD SH901 Semi-Rigid Adhesive (90sec)	50ml, 200ml Cartridge
STRONGHOLD SH902 Semi-Rigid Adhesive (5minutes)	50ml, 200ml Cartridge
STRONGHOLD SH904 Semi-Rigid Adhesive (45minutes)	200ml Cartridge
(See attached instructions leaflet for further detail)	

### Other Products:

PLAST-X 2 Adhesion Promoter Aerosol	400ml Aerosol
S2000 Water Based Degreaser	5L Tin
Maximum Abrasive Paper Discs P80, 120 grit	100 discs
ONION BOARD Multi Layered Mixing Palette	100 sheets
High Performance Dual Cartridge Dispensing Gun	50ml, 200ml
Applicators for spreading Adhesive	Single, Set of 3

# U-POL®



All **STRONGHOLD™** Adhesives are easy to apply, have excellent gap-filling properties, are non-shrinking, can be sanded easily and are over-paintable.

Curing is rapid and once achieved, **STRONGHOLD™** Adhesives provide a bond that has both excellent strength and durability.

## ADHESIVES for metal, plastics & wood

	Order Code	Product Description	Applications								Technical Data		
			Ferrous Metals and Aluminium	Zinc and Galvanised Metal	GRP/SMC/Thermoset Composites	Rigid Thermoplastics	Flexible Thermoplastics	Polyamides/Polystyrene Foams/PU Foams	Rubbers	Wood	Work Time Open Time	De-Clamping sanding and over painting Time	Optimum Cure Time
Semi-Rigid	901	SH9011 (50ml) SH9012 (200ml) <b>90 sec black adhesive for rapid repair &amp; assembly operations.</b> Brackets, lugs, clips, fixings, trim and emblems. Rapid repair of rigid plastic and composite sections.	✓	✓	✓	✓	✗	✗	✗	✓	90 Sec	10 Min	1 hr
	902	SH9021 (50ML) SH9022 (200ml) <b>5 min black adhesive for structural repair &amp; assembly/full bodied seamsealer.</b> Splits, cracks and general repair of rigid substrates. Used to reproduce OE seam sealer.	✓	✓	✓	✓	✗	✗	✗	✓	5 Min	20 Min	4 hr
	904	SH9042 (200ml) <b>45 min black adhesive for doorskin, metal, aluminium, SMC &amp; fibre glass.</b> Door skins, body kits, small panel and sectional replacements.	✓	✓	✓	✓	✗	✗	✗	✓	45 Min	3 hr	24 hr
TPO	915	SH9151 (50ml) SH9152 (200ml) <b>50 sec black TPO plastic repair adhesive for rapid repair &amp; bonding of thermoplastic olefins.</b> Suitable for difficult to repair TPO plastics such as PP, PPEPDM, EPDM.	✗	✗	✗	✓	✓	✓	✓	✓	50 Sec	10 Min	1 hr

## HOW TO USE THIS CHART

### Step 1 - Substrate.

Once you have identified the substrate(s) you wish to bond or repair, use the chart to choose a suitable group of adhesives e.g. for metals, composites and rigid thermoplastics use the semi-rigid group of adhesives.

### Step 2 - Work time / Open time.

Using the chart, choose an adhesive with a suitable work time/open time to carry out the repair or bonding operation.

Work time/open time refers to the maximum amount of time in which the mixed adhesive remains in a workable state prior to setting.

Case Quantities: 200ml (6 cartridges/carton)  
50ml (5 cartridges/carton)

## ANCILLARIES

	Order Code	Product Description
Filler	706 SH706/1 (600ml)	High density plastic filler for the repair of scratches and dents to most plastic substrates.
Tips	PLAS/TIP PLASTIP	Small tip. Precise static mixer for use with all Stronghold 50ml cartridges.
	TIP M SHTIPM	Medium tip. Precise static mixer for use with all Stronghold 200ml adhesives.
Guns	PLAS/GUN PLAS/GUN	Dispensing gun for all Stronghold 50ml cartridges.
	GUN SHGUN	Dispensing gun for all Stronghold 200ml cartridges.
Films	CF PLASCFLM (1m)	Contouring film. To aid the shaping and contouring of plastic repair adhesives.
	RF PLASRFLM (1m)	Reinforcing film. To reinforce and support repairs to plastic and composite substrates.



Use lint-free cloth to prepare surface with **Water-based S2000** or **Solvent-based S2002 Degreaser**. Abrade repair area with sander with **U-POL P240 grit disc**.



If required, apply **U-POL Topstop Gold Bodyfiller** or similar fine finishing filler (see U-POL Filler Repair Process: Top Filling). Repeat step 1.



Apply **U-POL HIGH#5 High Build Primer** (beige, grey, dark grey or white). For difficult areas to abrade, apply 2 light coats of **U-POL GRIP#4 Adhesion Promoter** prior to priming.



Flat down primer with fine grit P500 paper. If any bare metal is exposed, apply very light coat **U-POL ACID#8 Etch Primer**.



Mix and fill basecoat colour into **U-POL Custom Can** aerosol (see U-POL process: Paint Aerosol Filling), apply basecoat as per manufacturer's recommendations.



Apply two or three light coats of **U-POL CLEAR#1UV Clear Coat**.



Blend any dry edges by lightly applying **U-POL Fade Out Spray S2043/AL**. Polish repaired panel to gloss finish (see U-POL Compounding & Polishing repair process).



## Products required for performing this process:

### Fillers:

TOP STOP GOLD Extra Smooth Easy Sand Finishing Stopper 1.1L Tin, 1.3L Dispenser, 1L Bag  
(see "FILLER REPAIR: Top Filling /Finishing Filler" for other fillers that can be used for this step)

### Aerosols:

HIGH#5 High Build Primer Aerosol (Grey, Beige, White, Dark Grey) 450ml Aerosol  
GRIP#4 Universal Adhesion Promoter Aerosol 450ml Aerosol  
ACID#8 Acid Etch Primer Aerosol 450ml Aerosol  
CCUP Custom Can Aerosol 400ml Aerosol  
CCWP Custom Can Waterbased Areosol 400ml Aerosol  
CLEAR#1 High Gloss Clear Coat Aerosol 450ml Aerosol  
S2043 Fade Out Thinner Aerosol 450ml Aerosol

### Other Products:

Maximum Abrasive Paper Discs P240, 500 grit 100 discs  
S2000 Water Based Degreaser 5L Tin  
S2001 & S2002 Solvent Based Degreasers (Fast & Slow) 1L, 5L Tin, 500ml Aerosol  
Applicators for Body Filler Single, Set of 3



1 Remove lid and nozzle from U-POL Custom Can aerosol. Attach U-POL Custom Can Filling Cup.



2 Mix paint to manufacturer's recommendations, pour basecoat through U-POL Strainer mesh (size 125µm) directly into Custom Can cup.



3 Place mounted cup and aerosol into U-POL Custom Can Filling Machine, securing with spring clamp.



4 Close and lock door. Push green button to activate fill cycle.



5 Open door, remove mounted cup with aerosol and detach cup from aerosol.



6 Replace aerosol nozzle and lid. Label contents of aerosol with a permanent marker pen. To flush out nozzle, turn aerosol upside down and apply short spray.



7 To apply, shake vigorously for 2 minutes and spray as per manufacturer's recommendations.



8 Clean piston tip and cup with U-POL Degreaser.

## Products required for performing this process:

### Products:

Custom Can Professional Pneumatic Machine

CCUP Custom Can Aerosol

400ml Aerosol

CCWP Custom Can Waterbased Aerosol

400ml Aerosol

Maximum Paint Strainers (Super Fine 125microns)

250 strainers, 1000 strainers

S2000 Water Based Degreaser

5L Tin

S2001 & S2002 Solvent Based Degreasers (Fast & Slow)

1L, 5L Tin, 500ml Aerosol







1 Full body protection with **U-POL Painters Overalls**.



2 Hand and finger protection with gloves.



3 Eye protection with safety goggles.



4 Lung protection with **U-POL Particulate Respirators** (when sanding and spraying aerosols).



5 Lung and respiratory tract protection with full-face and eye air-fed respirator (when spraying isocyanates).



6 Ear protection with ear defenders/earplugs (when using noisy vibrating machinery and spraying).

**Products required for performing this process:****Products:**

Maximum Painters Overalls

M, L, XL, XXL, XXXL sizes

Maximum Paint Respirators with Valve (FFP2 Protection)

10 pcs.

