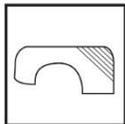


PRODUCT: Rage Ultra Xtra

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. Blue cream hardener included. Gallon package comes with 4 oz. tube of blue cream hardener.

APPROVED SUBSTRATES:



- Steel
- Aluminum
- Fiberglass
- Silicon Bronze Welds
- Galvanized Steel
- SMC
- Sanded OEM Paint

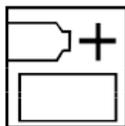
NOTE: For structural repairs prone to high degrees of stress and flexibility, use a fiber reinforced filler such as Everglass®, Kitty Hair® or Fiber Tech®.

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 80-180 grit to remove the paint and featheredge with 180.
- * Smaller repairs on OEM Paint can be prepared with 180 grit

MIXING:



- Stir the filler before using. Knead the cream hardener.
- Measure hardener 2-3% by weight (add a ribbon of cream hardener from edge to edge across the center of a 4" diameter puddle).
DO NOT UNDER-CATALYZE.
- Puddles larger than 4" (10 cm) in diameter will require additional hardener. Mix thoroughly until uniform color is achieved.

NOTE: For large applications use the entire 4 oz. tube of Evercoat BPO Cream hardener to a full gallon to ensure even cure for thinner applications and for Truck / Fleet / Commercial applications.

APPLICATION:



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

FINISH:



- Sand body filler with 80-180 grit sandpaper.
- If necessary, reapply Rage Ultra Xtra 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.

* Allow minimum of defined sanding time as per below chart over silicon bronze welds.

NOTE:

For optimum performance apply 440 Express before applying primer surfacer.

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)
See chart below for adjusted sanding times
- 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 EVERCOAT CREAM HARDENER ONLY!