

PRODUCT: RAGE® XTREME™ High Performance Premium Lightweight Body Filler

PART NUMBER:

100120	Gallon	4 units/case	33 lbs/case
100121	3-Gallon Pail	1 each	26 lbs/each
100122	5-Gallon Air Pail	1 each	40 lbs/each

DESCRIPTION: RAGE® XTREME™ is the first truly pinhole-free, high performance premium lightweight filler developed to work with new HAPS compliant and waterborne coatings.

USES: RAGE® XTREME™ is a High Performance Premium Lightweight Filler designed for professional use to repair damaged body panels where increased productivity, decreased material costs and premium results are desired.

APPROVED SUBSTRATES:

Steel, galvanized and other zinc coated steel, SMC, fiberglass and aluminum. Can be used for cosmetic fiberglass and composite repairs. For structural repairs prone to high degrees of stress and flexibility, use a fiber reinforced filler. See FIBER TECH™, GLASS-LITE™, EVERGLASS® and VETTE PANEL ADHESIVE FILLER™ Product Information Sheets for more information

PREPARATION:

Clean and degrease the entire panel to be repaired with soap and water, followed by a mild cleaning solvent. Thoroughly dry surface before repairing. Keep the repair area small. Grind repair area with 40 – 50 grit for large areas, or 80 grit for small areas, removing only the paint. Use 80 grit to remove the 40-50 grit marks and to featheredge the paint. Featheredge inward toward the repair.

MIXING:

Stir the body 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" in diameter will require additional hardener. Mix thoroughly until uniform color is achieved.

APPLICATION:

Apply in thin layers and spread smoothly. Do not blob on or apply all at once.

FINISH:

Sand down body filler with 40 grit to 80 grit sandpaper (use 40 grit as an initial cut only when necessary to knock down high spots). Avoid coarse sand scratches outside the filler area during the initial cut. Finish sand body filler with 80 grit. Sand bare metal and featheredge with 180 grit to remove 80 grit scratches. For best results, apply #416 Metal Glaze® or 417 Glaze Coat™ pourable glazing putty. This will provide a smoother finish and reduce the number of coats of primer required for a quality finish.

TECHNICAL SPECIFICATIONS:

▪ Appearance	Light gray colored paste
▪ VOC	Packaged: 1.56 lbs/gal (187 g/L) Applied: 0.40 lbs/gal (48 g/L)
▪ Weight per Gallon	10.78 lbs/gal (373 g/l) Average
▪ Gel Time	5-6 minutes
▪ Sand Time	10-15 minutes
▪ Viscosity	78,000 to 96,000 cps
▪ Shore D Hardness	65 to 70 (24 hour cure)
▪ Lap Shear Adhesion @ 20/40/60 min	689 / 787 / 663 500 hours Harsaw salt spray cabinet and 200 hours @ 100% RH
▪ Corrosion Resistance	No blistering, wrinkling or softening after
▪ Water Resistance	24 hours immersion in water.
▪ Max Recommended Thickness (sanded)	1/4 inch
▪ Max Allowable Heat	260°F (126.6°C) Surface Temp
▪ Contents and Caution	MSDS Available upon request
▪ Crystalline Silica Content	Contains no Crystalline Silica

NOTE: Properties are typical values and should not be considered as sales specifications. Physical testing performed @ ~77 F (25 C) / 75% RH unless otherwise noted.

SAFETY & HANDLING:

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

NOTES:

Never return mixed filler to can

Keep can closed and store in a cool dry place

USE WITH CREAM HARDENER ONLY!