



Innovative Repair Solutions that Perform™

# ALUMINUM REPAIR GUIDE



## WHAT ARE THE BEST PRODUCTS FOR ME? Comparative Matrix

### Body Filler Specifications

Product	Rage Optex®	Rage® Ultra	Rage® Ultra Xtra	Rage® Gold	Evergold™	Z-Grip®	Chrome-A-Lite	Lite Weight®	Evercoat Filler
Color	Pink > Green	White	White	Gold	Gold	Green	Yellow	Light Gray	Light Gray
Dry-to-Sand Time (72°F)	16 - 20 Min.	15 - 20 Min.	120 Min.	20 Min.	15 - 20 Min.	20 Min.	10 - 15 Min.	10 - 15 Min.	10 - 15 Min.
Putty Requirement	Not Required	Not Required	Not Required	Optional	Optional	Optional	Recommended	Recommended	Recommended
Product Performance	Best*	Best*	Best*	Better	Better	Better	Good	Good	Good
Metalworks® Warranty									
Approved Substrates									
Aluminum	X	X	X	X	X	X	X	X	X
Galvanized Steel	X	X	X	X	X	X	X	X	X
SMC	X	X	X	X	X	X	X		
Fiberglass	X	X	X	X	X	X	X	X	
Stainless Steel	X	X							
Steel	X	X	X	X	X	X	X	X	X
Cured Sanded OEM Finish	X	X	X						
Silicon Bronze Welds	X	X	X						

Rage Family	Why would you choose one premium filler over another?
Rage Optex	Save even more time on the job by eliminating the guesswork involved in dry-to-sand time
Rage Ultra	Easy sanding to help save time and money without sacrificing quality
Rage Ultra Xtra	Extended work time to account for variable shop temperatures and conditions
Rage Gold	Do heavier filling jobs without sacrificing sandability

### Putty Specifications

Product	Metal Glaze Optex®	Metal Glaze® Ultra	Metal Glaze®	Easy Sand™	Polyester Glazing Putty
Color	Pink > Green	Green	Green	White	White
Dry-to-Sand Time (72°F)	14 - 18 Min.	10 - 15 Min.	25 Min.	10 - 15 Min.	12 - 20 Min.
Product Performance	Best*	Best*	Better	Better	Good
Metalworks® Warranty					
Approved Substrates					
Aluminum	X	X	X	X	X
Galvanized Steel	X	X	X	X	X
SMC	X	X			X
Fiberglass	X	X	X	X	X
Stainless Steel	X	X			
Steel	X	X	X	X	X
Cured Sanded OEM Finish	X	X	X	X	
Silicon Bronze Welds	X	X			
Sanded Body Filler	X	X	X	X	X
E-Coat	X	X			X
Rigid to Semi-Rigid Plastics	X	X	X	X	
Cured Sanded 2K Primer	X	X	X	X	

**\*ECORESIN™** Proprietary resin derived from renewable resources. Improves spreadability and sandability to help save shops time and money.

**METALWORKS WARRANTY** Evercoat's METALWORKS® System is the most complete and diversified corrosion resistant body filler system on the market. With good, better, best, and ultra performance levels that are supported by a warranty that guarantees to maintain the original O.E.M. corrosion warranty\*, there are METALWORKS System products that meet most every repair need.

\* See the current METALWORKS System Warranty for specific details and exclusions.



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# ALUMINUM REPAIR

Rage Optex® 440 Express™ Repair Process

Watch the Video!



1

**CLEAN**  
Limpiar

Clean and degrease the body panel to be repaired.  
*Limpiar y desengrasar el panel de carrocería a reparar.*



2

**STRAIGHTEN PANEL**  
Enderezar el panel

Straighten the panel to be repaired as needed.  
*Enderezar el panel a reparar, según sea necesario.*



3

**PAINT REMOVAL**  
Eliminación de la pintura

Remove paint, only where fractured, with 80 grit in the area to be filled.  
*Eliminar la pintura, sólo donde esté fracturada, con abrasivo de grano 80 en la parte a rellenar.*



4

**PREPARATION**  
Preparación

Sand and featheredge the area with 180, then remove sanding dust with clean compressed air.  
*Lijar y biselar la superficie con 180, luego eliminar el polvo de lijado con aire comprimido limpio.*

**SMALL REPAIRS**

Sand and featheredge using 180 grit.  
*Lija con grano 180 para reparaciones pequeños.*

**SMALL REPAIRS**

Skip to step 5.  
*Brinca al paso 5 para reparaciones pequeños.*



5

**APPLY RAGE OPTEX®**  
Aplicar la masilla RAGE OPTEX®



6

**SAND & FEATHEREDGE**  
Lijar y biselar

Sand the filler to shape with 80 grit, then final sand and featheredge with 180 grit.  
*Lijar la masilla para dar forma con abrasivo de grano 80, luego aplicar el lijado y biselado final con abrasivo de grano 180.*

**SMALL REPAIRS**

Sand and featheredge using 180 grit.  
*Lija con grano 180 para reparaciones pequeños.*



7

**REMOVE DUST & INSPECT**  
Eliminar el polvo e inspeccionar

Remove the sanding dust with clean compressed air and inspect area for coarse sand scratches, pinholes, or imperfections.  
*Eliminar el polvo de lijado con aire comprimido limpio e inspeccionar la superficie para rasguños de lijado gruesos, picaduras o imperfecciones.*



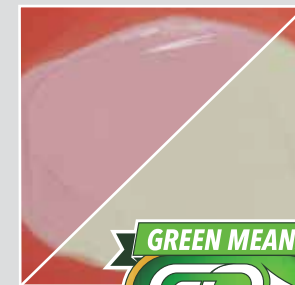
8

**APPLY 440 EXPRESS™**  
Aplicar 440 Express™

Use sponge to apply 440 Express over entire repair surface.  
*Usar una esponja para aplicar 440 Express sobre toda la superficie de reparación.*

**CATALYZED**

16-20 MINUTES



Apply Rage Optex with even, firm pressure in a thin coat, apply additional material as needed. Extend Rage Optex into the clearcoat featheredge area. The repair will gradually turn from pink to a light shade of green between 16 and 20 minutes, indicating the repair is dry and ready to sand.

*Aplicar la masilla Rage Optex con una presión firme y uniforme en una fina capa, aplicar material adicional según sea necesario. Extender la masilla Rage Optex en la superficie biselada con revestimiento transparente. La reparación se volverá gradualmente de rosa a una sombra clara de verde entre 16 y 20 minutos, indicando que la reparación esta seca y lista para lijar.*

- One step primer pretreatment - no sanding required
- Reduces primer usage by up to one third
- Reduces rework by eliminating micro-pinholes
- #100440 440 Express 16oz. Bottle
- #100444 440 Express Kit with 4oz. Bottle and Applicators
- #100439 440 Express Applicators

## GREEN MEANS GO!™

- Changes colors as it dries indicating the repair is ready to sand
- Spreads easy and virtually eliminates micro-pinholes
- Excellent adhesion to steel, stainless steel, galvanized steel, aluminum, SMC, fiberglass, and silicon bronze welds
- Can be applied directly to sanded OEM clearcoat
- Standard 2% mixing ratio using Evercoat cream hardener – Do not under-catalyze
- Meets 500 hour corrosion resistance (ASTM B117)
- Contains patented **ECORESIN™** technology for industry-leading sanding properties

