EVERCOAT®

SUPER BUILD 4:1
ULTRA HIGH BUILD POLYESTER PRIMER SURFACER

TWICE THE FILM BUILD OF OTHER POLYESTER PRIMERS!

Direct to metal application eliminates the need for epoxy or self-etch primers
Easy, accurate mixing without a scale
Sprays with less overspray than traditional polyester primers

Part No. 100730

evercoat.com
**SUPER BUILD 4:1**

**ULTRA HIGH BUILD POLYESTER PRIMER SURFACER**

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**MIXING:**

- Shake and stir thoroughly before mixing.
- Mix thoroughly before pouring primer into gun cup.
- Pot life is 45 minutes @ 75°F (24°C); pot life decreases at higher temperatures or when using #734 Fast 4:1 Catalyst.
- Do not leave product in the spray gun for longer than 45 minutes.

```
#730 SuperBuild 4:1
#733 4:1 Catalyst
or
#734 FAST 4:1 Catalyst
```

**APPLICATION:**

- Use a primer gun with a 1.6 to 2.2 fluid nozzle/air cap.
- Adjust air pressure to 40-45psi for conventional guns or 10 psi at the cap for HVLP.
- Apply 2 – 3 medium wet coats allowing 5 – 10 minutes flash time between coats.

**FINISH:**

- Super Build 4:1 is ready to sand in about 80-120 minutes, depending on film build.
  - Force Dry – Bake 30 minutes @ 140°F (60°C).
- Once dry, sand Super Build 4:1 with 180-400 grit sandpaper prior to next step.

**TECHNICAL DATA:**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Gray liquid</td>
</tr>
<tr>
<td>VOC</td>
<td>Packaged: 2.02 lbs/gal (243g/L)</td>
</tr>
<tr>
<td></td>
<td>Applied: 1.51 lbs/gal (180.9g/L)</td>
</tr>
<tr>
<td>Wet-Film-Thickness (WFT)</td>
<td>8.0 - 10.0 mils per coat</td>
</tr>
<tr>
<td>Dry-Film-Thickness (DFT)</td>
<td>6.0 - 8.0 mils per coat</td>
</tr>
<tr>
<td>Solids by Volume</td>
<td>65 – 70%</td>
</tr>
<tr>
<td>Solids by weight</td>
<td>70 – 75%</td>
</tr>
<tr>
<td>Viscosity (ready to spray)</td>
<td>30 – 35 seconds in Zahn #3</td>
</tr>
<tr>
<td>Coverage at 1 mil 100% Transfer</td>
<td>1200 sq. ft. per US gallon</td>
</tr>
</tbody>
</table>

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**EVERCOAT**

ITW Evercoat | a division of Illinois Tool Works Inc. | 6600 Cornell Road
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