

SUBJECT: Application of Polyester Fillers, Putties, and Primers over Epoxy Primers.

The application of an epoxy pre-coat is not required when using the Evercoat 4:1 Polyester Primers (Finish Sand, Super Build, Fiber Fill). These DTM products meet the ASTM B117 corrosion standards and provide 500 hours of salt spray corrosion testing, thus eliminating the need for an extra coating requirement.

NOTE: When using fiber reinforced fillers, it is advised to apply those materials directly to the substrate and avoid the use of an epoxy coating.

When applying a polyester body filler, glazing putty, or polyester primer over an automotive aftermarket epoxy primer begin by verifying with the epoxy coating manufacturer that it is compatible to be top coated with the above-mentioned polyester products.

If the epoxy coating manufacturer does NOT recommend the application of a polyester product over their epoxy coating material, follow their recommendations and avoid the application of a polyester product.

The application window and recommendation for a polyester based product over the epoxy system may vary depending on the paint company / epoxy coating manufacturer. Therefore, it is advised to ensure the use of the proper catalyst speed, to check the epoxy catalyst batch date to ensure freshness for proper performance, and ensure compatibility with a polyester top coat before the application of the epoxy system.

The following procedure for the application of Evercoat polyester products is a general guideline, and is therefore not intended to supersede, or be in lieu of the epoxy coating manufacturer's recommendations if not approved to do so.

- Apply 1 – 2 light coat(s) with the recommended spray gun tip size to achieve a Dry Film Thickness minimum of .75 mils (19 microns), but not exceeding 1.5 mils (38 microns)
- Allow at least 24 hours with a minimum temperature of 70°F (21°C)
- Lightly sand with 180 – 220 Grit allowing a minimum remaining film of .5 mils (12 microns), but not exceeding .7 mils (18 microns)
NOTE: If epoxy primer was applied beyond 24 hours, or the Dry Film Thickness exceeds .7 mils, continue sanding until within the range of .5 - .7 mils (12 – 18 microns)
- Remove sanding dust with clean compressed air or a fast evaporating solvent (contact the epoxy coating manufacturer for recommendations if needed)
- Apply the selected Evercoat polyester product as per the Technical Data Sheet.