

PRODUCT: Super Build 4:1 Polyester Primer Surfacer

PART NUMBER: 100730 **Gallon** **2 units/case**

DESCRIPTION: **Super Build 4:1** is a two-component hybrid polyester epoxy primer surfacer that has exceptional filling capabilities and patented 4:1 mix ratio technology. It is ideal for holding down troublesome repairs on fiberglass and SMC. Super Build 4:1 passes 500 hours in salt spray tests (ASTM B117) and can be applied over properly sanded and cleaned bare metal. It is compatible with waterborne paint systems and VOC compliant.

Must be catalyzed with 733 4:1 Polyester Primer Catalyst or 734 Fast 4:1 Polyester Primer Catalyst only!

SUBSTRATES:



- Aluminum
- SMC
- Rigid Plastics
- Sanded OEM Coatings
- Bare Metal
- Fiberglass
- Sanded Body Filler or Putty

NOTE: An epoxy pre-coat is NOT required for Evercoat 4:1 polyester primers if a minimum of 2 coats with a dry film thickness of 4.5 – 6 mils (115 – 150 microns) are applied to achieve proper protection.

CAUTION: Do not apply over self-etch primers, acidic coatings, or after the use of acidic prep wipes as these materials can inhibit the curing process of polyester primers.

CLEANING:



- Surface must be clean and free of dirt, oil, grease and wax
- To solvent clean **raw, exposed fiberglass**, it is recommended to clean exposed area with **acetone**.

PREPARATION:

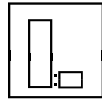
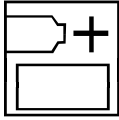


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Remove sanding dust residue with clean compressed air
- Prime carbon steel and aluminum immediately after sanding and dust removal

Body Filler or Putty

- Finish sanding body filler or putty with 180-220 grit sandpaper
- Featheredge surrounding area with 220 grit sandpaper
- Remove sanding dust residue with clean compressed air

MIXING:



**4 parts 730 Super Build 4:1 Primer
to
1 part 733 4:1 Catalyst or 734 Fast 4:1 Catalyst**

- Shake and stir the primer and catalyst thoroughly before mixing
- **For optimal performance use a strainer when pouring into spray gun**
- When using gravity fed disposable mixing cups remove the internal filter for improved flow and spray.

APPLICATION:



- Apply **2-3** medium wet coats at a distance of 8-10 inches (20-25cm) allowing **5-10** minutes flash time between coats

(Spray at paint gun manufacturer's recommended air pressure)

FINISH:



- Ready to sand in about 2 hours @ 72°F (22°C), depending on film build
- Once dry, sand with *180-220 grit* sandpaper followed by 320 prior to next step
- **For optimal performance apply a quality sealer and prepare per coating manufacturer recommendations.**

TECHNICAL SPECIFICATIONS:

Appearance	Gray liquid
VOC	Refer to Section 9 of the Safety Data Sheet
Dry-Film-Thickness (DFT)	4.0 – 8.0 mils (100 – 200 microns) / coat (30 mils / 750 microns max. film build)
Maximum Film Build	24 mils (600 microns)
Spray Gun Setup	2.0mm or Larger Fluid Nozzle
Pot Life	#733 - 40 minutes @ 72°F (22°C) #734 - 25 minutes @ 72°F (22°C) Pot life decrease at higher temperature
Air Dry	2 hours @ 72°F (22°C)
Force Dry	30 min @ 140°F (60°C)
Recoat Window	After sanding: Within 7 days or light sand before coating Un-sanded: Within 30 days, then sand per finish procedures above
Total Solids by weight @ 4:1 RTS	62-65%

SAFETY & HANDLING:

Read full instructions before use. This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Safety Data Sheets (SDS) and warnings displayed on product labels must be read carefully. SDS and product labels convey the possible health hazards, appropriate engineering controls, personal protection equipment and precautions to be observed in using the material. Copies of the SDS and product labels are available upon request. Consult your local environmental compliance agency for disposal of un-used products. Never dispose of products down the drain. If exposed, contact a POISON CONTROL CENTER IMMEDIATELY. KEEP OUT OF REACH OF CHILDREN. The information provided in this Technical Data Sheet is correct to the best of our knowledge, information and belief at the date of its publication.