

PRODUCT: Fiber Fill 4:1 Reinforced Polyester Primer Surfacer

PART NUMBER: 100736 **Gallon** **2 units/case**

DESCRIPTION: **Fiber Fill 4:1** is a two-component hybrid polyester epoxy, fiber-reinforced polyester primer surfacer that is ideal for applications that require a durable undercoat. It has excellent filling capability and can be used to hold down troublesome repairs on a variety of substrates. Fiber Fill 4:1 passes 500 hours in salt spray test (ASTM B117) and can be applied over properly sanded and cleaned bare metal. VOC compliant.
Must be catalyzed with 733 4:1 Polyester Primer Catalyst or 734 Fast 4:1 Polyester Primer Catalyst only!

SUBSTRATES:



- Fiberglass
- SMC
- Rigid Plastics
- Sanded OEM Coatings
- Bare Metal
- Aluminum
- 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:

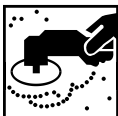
Do not apply over self-etch primers, acidic coatings, or after the use of acidic prep wipes as these materials can inhibit the curing process of polyester primers.

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:

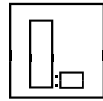
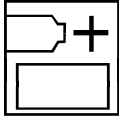


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Final clean with a quality wax and grease remover to remove sanding residue prior to applying Fiber Fill 4:1
- Prime carbon steel and aluminum immediately after cleaning

Body Filler or Putty

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

MIXING:



4 parts 736 Fiber Fill 4:1 Primer
to
1 part 733 or 734 Fast 4:1 Polyester Primer Catalyst

- Shake and stir the primer and catalyst thoroughly before mixing
- **For optimal performance use a strainer when pouring into spray gun**
- When using a gravity fed disposable mixing cup 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 2 hours @ 72°F (22°C), depending on film build
- Once dry, sand Fiber Fill 4:1 with **180-220 grit** sandpaper followed by **320 grit or finer**

NOTE: Fiber Fill 4:1 must be sealed for optimum performance before applying a base coat/clear coat system.

TECHNICAL SPECIFICATIONS:

Appearance	Gray liquid
VOC	Refer to Section 9 of the Safety Data Sheet
Dry-Film-Thickness (DFT)	4.0 – 6.0 mils (100 – 150 microns) / coat (30 mils / 750 microns max. film build)
Maximum Film Build	18 mils (460 microns)
Spray Gun Setup	2.0mm or larger
Pot Life	#733 - 40 minutes @ 75°F (24°C) #734 - 25 minutes @ 75°F (24°C) Pot life decreases 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.