

**PRODUCT:** Finish Sand 4:1 Hybrid Polyester Primer Surfacer

**PART NUMBER:** 100738      **Gallon**      **2 units/case**

**DESCRIPTION:** **Finish Sand 4:1** is a hybrid polyester primer surfacer that utilizes patented technology to provide a smooth, low-texture finish. It is ideal for holding down troublesome repairs on a variety of substrates. Finish Sand 4:1 passes 500 hours in salt spray test (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:**



- 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 when a minimum of 2 coats are applied to achieve proper protection.

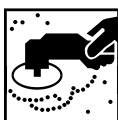
**CAUTION:** Do not apply over self-etch primers, acidic coatings, or after the use of acidic prep wipes as these materials can inhibit the curing process of polyester primers.

**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:**

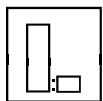
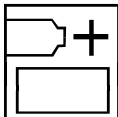


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Final clean with a quality wax and grease remover to remove sanding residue prior to applying Finish Sand 4:1

**Body Filler or Putty**

- Finish sanding body filler or putty with 180-220 grit sandpaper
- Featheredge with 320 grit sandpaper
- Blow off the surface with an air blow gun

### MIXING:



**4 parts 738 Finish Sand 4:1 Primer  
to  
1 part 733 4:1 Catalyst or 734 Fast 4:1 Catalyst**

- Shake and stir thoroughly before mixing
- **For optimal performance use a strainer when pouring into spray gun**

### APPLICATION:



- Use a primer gun with a 1.6 to 2.0 fluid nozzle/air cap (Spray at paint gun manufacturer's recommended air pressure)
- Apply **2-3** medium wet coats allowing **5-10** minutes flash time between coats

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

### FINISH:



- Finish Sand 4:1 will be ready to sand in *2 hours*, depending on film build
- Once dry, sand Finish Sand 4:1 with *180-220 grit* sandpaper followed by *320 grit or finer*

### TECHNICAL SPECIFICATIONS:

|                                  |   |
|----------------------------------|---|
| Appearance                       | Gray liquid   |
| VOC                              | Refer to Section 9 of the Safety Data Sheet   |
| Dry-Film-Thickness (DFT)         | 2.0 - 3.0 mils (50 – 75 microns) /coat  |
| Maximum Film Build               | 9.0 mils (225 microns)  |
| Spray Gun Setup                  | 1.6mm – 2.0mm Fluid Nozzle  |
| Pot Life                         | <b>#733</b> - 60 minutes @ 72°F (22°C)<br><b>#734</b> - 45 minutes @ 72°F (22°C)<br><b>Pot life decreases at higher temperature</b>         |
| Air Dry                          | 2 hours @ 72°F (22°C)   |
| Force Dry                        | 30 min @ 140°F (60°C)   |
| Recoat Window                    | <b>After sanding:</b> Within 7 days or light sand before coating<br><b>Un-sanded:</b> Within 30 days, then sand per finish procedures above |
| Total Solids by Weight @ 4:1 RTS | 65-70%  |

### SAFETY & HANDLING:

**IMPORTANT:** The contents of these packages must be mixed with other components before the products can be used. Before opening the packages, be sure to understand the warnings on all labels of all components since the resulting product will have the warnings and cautions of all its parts. Improper spray technique may result in hazardous conditions. Follow the spray equipment manufacturer's instructions to prevent injury or fire. Follow respirator manufacturer's directions for respirator use. Always wear eye and skin protection. Observe all precautions. Consult MSDS for further safety information and/or handling instructions. In case of emergency, contact your local emergency room or poison control center immediately. For professional use only. Material Safety Data Sheets can be found online @ evercoat.com.