

PRODUCT: Optex Super Build 4:1 Polyester Primer Surfacer

PART NUMBER: 100740 **Gallon** **2 units/case**

DESCRIPTION: **Optex Super Build 4:1** is a two-component hybrid polyester epoxy primer surfacer with a patent-pending built-in guide coat that provides exceptional filling, patented 4:1 mix ratio technology, passes 500 hours in salt spray tests (ASTM B117). Compatible with waterborne paint systems and VOC compliant. All substrates must be properly sanded and cleaned prior to primer application for optimum performance.
Must be catalyzed with 733 4:1 Polyester Primer Catalyst or 734 Fast 4:1 Polyester Primer Catalyst only!

SUBSTRATES:



- Aluminum
- Galvanized Steel
- Fiberglass
- Rigid Plastics
- Sanded OEM Coatings
- Steel
- METTON®
- SMC
- 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.

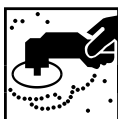
CAUTION: Do not apply over self-etch primers, acidic coatings, or after the use of acidic prep wipes as these materials can inhibit the curing process of polyester primers.

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:

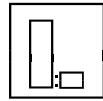
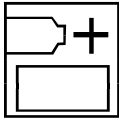


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Final clean with a quality wax and grease remover to remove sanding residue prior to application
- Prime carbon steel and aluminum immediately after sanding and dust removal

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 Optex Super Build 4:1 Primer
to
1 part 733 or 734 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 about **2 hours @ 72°F (22°C)**, depending on film build
- Once dry, sand with **180-400 grit** sandpaper prior to next step

NOTE: All guide coat coloration must be properly sanded off before applying additional coatings or polyester filler/putty.

TECHNICAL SPECIFICATIONS:

Appearance	Pink liquid
Dry-Film-Thickness (DFT)	4.0 – 8.0 mils (100 – 200 microns) / coat
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 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%

VOC Data	Standard Mix 4:1 #733	
	lbs./Gallon	g/Liter
Packaged VOC	1.7	204
Packaged VOC Regulatory	2.2	264
Applied VOC	1.22	146

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.