

PRODUCT: Fiber Fill 4:1 Reinforced Polyester Primer Surfacer

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

DESCRIPTION: **Fiber Fill 4:1** is a 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. 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
- Bare Metal
- Aluminum
- Body Filler or Putty

NOTE: All substrates must be properly sanded and cleaned prior to primer application for optimum performance.

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:

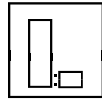
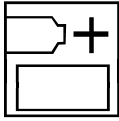


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Final clean with a quality wax and grease remover to remove sanding residue prior to applying Fiber Fill 4:1

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 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
- 733 – Pot Life is 40 minutes @ 75°F (24°C); pot life decreases at higher temperatures
- 734 – Pot Life is 25 minutes @ 75°F (24°C); pot life decreases at higher temperatures
- **Do not leave product in the spray gun for longer than 20 minutes**

APPLICATION:



- Use a primer gun with a 2.0 or larger 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

FINISH:



- Fiber Fill 4:1 is ready to sand in *2 hours*, 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 per coat (30 mils max. film build)
Solids by Volume	45 – 50%
Solids by Weight	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.