

PRODUCT: FEATHER FILL® 4:1 Hybrid Polyester Primer Surfacer

PART NUMBER: 100732 **Gallon** **2 units/case** **24 lbs/case**

DESCRIPTION: Feather Fill 4:1 is a hybrid polyester primer surfacer that utilizes patent-pending technology to provide end users with an easy to mix, easy to spray and easy to sand primer surfacer. It is ideal for holding down troublesome repairs on fiberglass, SMC and properly treated metal substrates. Feather Fill 4:1 is compatible with waterborne paint systems and VOC compliant. **It must be catalyzed with 733 Feather Fill 4:1 Catalyst only!**

FEATURES & BENEFITS:

Feature/Advantage	Benefit
Easy to mix 4:1 mix ratio	Eliminates repair defects related to over/under catalyzed primer
Little to no surface texture	Easy sanding, quickly sands to a flat, even surface
Long pot life	Reduces waste and increases productivity – less mixing, more spraying

SUBSTRATES:



- Fiberglass
- SMC
- Rigid Plastics
- Body Filler or Putty
- Epoxy Primer
- Self-Etch Primer (extends dry-to-sand time)

NOTE: All bare metal areas larger than one inch in diameter must be treated with a high quality self-etch or epoxy primer.

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:



Untreated Steel, Galvanized Steel and Bare Aluminum

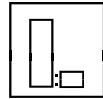
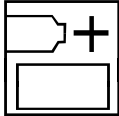
- All bare metals must be treated with a high quality self-etch or epoxy primer prior to the application of Feather Fill 4:1
- Follow paint company's recommendations for surface prep and recoat of self-etch or epoxy primer

PREPARATION:**Pre-Painted Surfaces**

- Sand repair area and featheredge using 180 grit, 220 grit and finish with 320 grit sandpaper on a random orbital sander
- Final clean with a quality wax and grease remover to remove sanding residue prior to applying Feather 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 732 Feather Fill 4:1 Primer
to
1 part 733 Feather Fill 4:1 Catalyst

- Shake and stir thoroughly before mixing
- Pot Life is 70 minutes @ 75°F (24°C); pot life decreases at higher temperatures
- **Do not leave product in the spray gun for longer than 60 minutes**

APPLICATION:

- Use a primer gun with a 1.5 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

FINISH:

- Feather Fill 4:1 will be ready to sand in about *60-90 minutes* depending on film build
- Applying over self-etch primer could add 4-6 hours to the dry time
- Once dry, sand Feather Fill 4:1 with *220-400 grit* sandpaper prior to next step

TECHNICAL SPECIFICATIONS:

Appearance	Gray liquid
VOC	Packaged: 2.97 lbs/gal (356 g/L) Applied: 0.73 lbs/gal (87.5 g/L)
Dry-Film-Thickness (DFT)	2.0 - 3.0 mils per coat
Solids by Volume	57-62%
Solids by Weight	76-78%
Viscosity (Ready to Spray)	30-35 seconds in Zahn #3
Coverage at 1 mil 100% Transfer	1200 sq. ft. per U.S. gallon

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.

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