

**PRODUCT:** EDGE DTM High Build 4:1 Polyester Primer Surfacer

**PART NUMBER:** 200530      **Gallon**      **2 units/case**      **25 lbs/case**

**DESCRIPTION:** **EDGE DTM High Build 4:1** is a two component primer surfacer that has exceptional filling capabilities and patented 4:1 mix ratio technology. It is ideal for holding down troublesome repairs on fiberglass and SMC. EDGE DTM High Build 4:1 passes 500 hours in salt spray tests (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 535 4:1 DTM Fast Catalyst or 536 4:1 DTM Medium 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:**

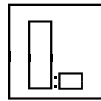
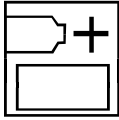


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Final clean with a quality wax and grease remover to remove sanding residue prior to applying EDGE DTM High Build 4:1

**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 530 EDGE DTM High Build 4:1 Primer  
to  
1 part 535 Fast DTM 4:1 Catalyst or 536 Medium DTM 4:1 Catalyst

- Shake and stir thoroughly before mixing
- 535 – Pot Life is 60 minutes @ 75°F (24°C); pot life decreases at higher temperatures**
- 536 – Pot Life is 45 minutes @ 75°F (24°C); pot life decreases at higher temperatures**
- Do not leave product in the spray gun for longer than 45 minutes**

### APPLICATION:



- Use a primer gun with a 1.6 to 2.2 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:



- EDGE DTM High Build 4:1 is ready to sand in about *2 hours*, depending on film build
- Once dry, sand with *180-400 grit* sandpaper

### TECHNICAL SPECIFICATIONS:

Appearance	Gray liquid
VOC	Packaged: 2.02 lbs/gal (243g/L) Applied: 1.51 lbs/gal (180.9g/L)
Dry-Film-Thickness (DFT)	6.0 – 8.0 mils per coat
Solids by Volume	65 – 70%
Solids by Weight	70 – 75%

### 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.