

# 750



## *750 Superbuild* HI-BUILD POLYESTER PRIMER

**750 Superbuild** is a true high-build polyester primer which is more than 80% solids, providing applicators exceptional build and economy.

Primarily designed for gloss topcoating, 750 Superbuild displays excellent top coat hold out and shrink back resistance with very easy sanding.

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## Key Product Features

- Extra-high build polyester primer
- High solids (80%+) content
- Economical – requires less application time
- Fast, easy sanding

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## Ideal Use

750 Superbuild is widely used by quality manufacturers and applicators throughout Australia as a sanding primer for compatible Evic polyurethane finishes, such as 2000 Spraythane Gloss and the new 1600 Global range. Applications may include kitchens, vanities, commercial fitouts and other work that requires a solid, even finish.

Suitable for most wood substrates including MDF, melamine and wood veneers.

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## Available Sizes

PART A (750A) is available in **4L** and **20L** cans

PART B (750B) is available in **0.08L** and **0.5L** sizes

**Kits (A+B) are also available**

**MIXING RATIO (A:B) IS 100:1 – 100:2 (Note: kit supplies sufficient catalyst for 100:2 mixing)**

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## Coverage Rate

Practical Coverage to achieve 200µm Dry Film Thickness (DFT), is **four square metres per litre**.

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## Mixing

For ease of incorporation, it is recommended that the solvent is mixed into Part A first, followed by Part B catalyst. Please use supplied measuring cup for Part B to ensure accuracy (too much Part B catalyst may cause the potlife to shorten dramatically, causing equipment blockage).

**NOTE:** There is **no danger of explosion** when mixing any combination of Part A, Part B and solvent thinner, as accelerator has been pre-added to Part A in manufacture.

### **Warm to Hot Conditions (25–30°C+)**

1 Litre Part A + 300ml 765S + 10ml 750 Part B

The 765S Solvent slows the reaction and increases pot life. By using only 10ml (1%) 750B the reaction is slowed further.

### **Moderate Conditions (15–25°C)**

1 Litre Part A + 300ml 760S + 10–20ml 750 Part B

The 760S Solvent slows the reaction and increases pot life. By using only 10ml (1%) 750B the reaction is slowed further.

### **Cool Conditions (<15°C)**

1 Litre Part A + 300ml 750S + 20ml 750 Part B

By using 750S Solvent not 760S the reaction will be more positive. By increasing the 750B to 20ml (2%) a faster through cure will be provided for cooler conditions.

**IMPORTANT!** Using 2% catalyst (100:2) will halve (i.e. shorten) stated potlife estimates.

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## Thin Quantity

Thin up to 30% with 750S (cool), 760S (moderate) or 765S (hot) solvent.

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## Suggested Equipment

**Conventional Suction Spray Guns** – Anest Iwata W200 at 275kpa (40psi) or Star Pro-Series SP770 at 310kpa (45psi)

**Pressure Pot** – 55kpa (8psi) pot pressure with the gun pressure set to 240–275kpa (35–40psi)

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**Pot Life Estimates** The table (overleaf) provides estimates based on 1% catalyst (100:1)

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**Dry Times\***

**Touch Dry:** 1–2 hours

**Time to Sand:** 12–16 hours

\*Based on 750S and 1% catalyst. Times apply to standard film thickness only. Overnight drying gives better results.

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**Recommended Film Build**

750 is a high solids, high build primer and over-application must be avoided. It is recommended that dry film build not exceed 200 µm (350 µm wet film build); inadvertent excessive build in routing and corners may reduce the coating flexibility and can cause cracking. This should be remedied by sanding back to a maximum thickness of 200 µm.

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**Preparation**

**ALUMINIUM, ZINCALUME, GALVANISED & MILD STEEL (for interior use ONLY):** Use Evic 145E Etch and Protect Primer in light grey followed by 730 or 731 polyurethane primer. We do not recommend using any polyester primer over etch.

**MDF BOARD:** Sand edges and routes with 180 grit free-cut sandpaper or 3M Medium Sanding Sponge to remove excess raised fibre. Apply primer in 2 to 3 double wet coats allowing solvent flash off between coats.

**Alternatively** seal routes and edges with thinned 860 or 866 polyurethane sealer and allow to dry. Sand sealed edges and routes with 150 to 180 free-cut sandpaper or 3M Medium Sanding Sponge. Sealer will prevent fibres from resurfacing during the priming coat. Apply 2 to 3 double header wet coats, allow solvent flash off between coats. Allow overnight dry.

**MELAMINE:** Correctly sand with 240 to 320 grit free-cut paper and apply “top coat” directly. Alternatively, sand with 150 to 240 free-cut paper, remove all surface gloss, dust off, then apply 2 double header wet coats of primer allowing flash off between coats.

**Warning:** 750 does not stick to unsanded melamine. This surface must be prepared correctly especially in corners or hard to get at areas. Melamine can easily wear out paper which then effectively polishes the surface making adhesion by further coats impossible.

**MELAMINE WITH RAW EDGES & ROUTES:** Thin down 860 (or 866) Polyurethane Sealer 30% with 850S Solvent or thin 750 Polyester 45% with 750S–765S Solvent. Spray apply thinned sealer directly onto the raw routes and edges only, allow to dry. Sand back sealer with 150 to 180 free-cut paper or 3M Medium Sanding Sponges. Dust off then prime the sealed routes and edges only with 750 primer, allow to dry.

**Method A:** Scrape excess primer and sealer off melamine surface using razor blade scrapers. Sand routes and edges with 320 to 400 free-cut paper or 3M Fine Sanding Sponges. Machine sand the melamine face with 240 to 320 free-cut paper. Ensure all oversprayed primer and sealer is removed from the melamine face.

**Method B:** Sand edges and routes with 320 to 400 free-cut paper or 3M Fine Sanding Sponge. Machine sand the primer off the melamine face with 240 to 320 free-cut paper making sure that all primer is removed and that there are no gloss areas left on the melamine. Dust off and wipe clean for top coating.

**TIMBER:** It is important to pre-seal all raw timber and veneer surfaces with either 860 (or 866) Polyurethane sealer or 850 Polyurethane clear finish before applying 750 Polyester.

**SANDING:** 750 polyester should be sanded within 24 hours otherwise the primer further hardens and sanding time will increase.

**Routing and Edges:** (by hand) 3M Fine Sanding Sponges or 320 free-cut paper; (by machine) Festool ES125 Lightweight sander with 400 open coat paper

**Face or Broad Areas:** (by machine) Festool RS1C orbital sander, Festool ET2 disk orbital or Festool Rotex eccentric disk sander with 400 or 500 free-cut paper.

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**Application**

**FINISH COAT:** It is recommended that Evic’s 2000 Spraythane or 1600 Global finish coats be applied within 24 hours of sanding the 750 Superbuild Primer to ensure good intercoat adhesion.

## Pot Life Estimates (continued)

Temperature	Solvent	Approx. Pot Life	Cure Rate
10°C	750S	2.5 hours	moderate-slow
15°C	750S	1.5 hours	moderate
	760S	4.0 hours	slow
20°C	750S	1.0 hours	fast
	760S	3.0 hours	moderate
	765S	7.0 hours	moderate-slow
25°C	750S	0.5 hours	very fast
	760S	2.0 hours	fast-moderate
	765S	5.0 hours	moderate
30°C	760S	0.5 hours	very fast
	765S	2.0 hours	fast

**Note:** These pot life estimates are approximate for one litre of mixed material. Catalysing larger amounts (e.g., 4L) can reduce pot life times by up to 50% (i.e. 5 hours down to 2.5 hours). As a guide, moderate cure rates give early next day sanding (16-20 hours). Using cool weather combinations in hot conditions would reduce pot life to minutes. Using hot weather combinations in cool conditions would increase pot life and cure times would become excessively slow.

## Baking

750 Sanding Primer responds positively to baking and dry times to sand can be reduced to as little as 1 hour. Allow 15 minutes flash off time then bake at up to 50°C for 30 minutes, allowing to cool before sanding.

## Shelf Life

**Part A** – For safety reasons, 750 Polyester has had accelerators added during manufacture – which means the product must be used before the use-by date on the label (i.e. 4 months from manufacture). Out-of-date product will thicken and should not be used.

**Part B** – Store up to 6 months in cool area.

## Note to Users

This is a specialised industrial coating and should only be applied by experienced and competent tradesmen and in accordance with the manufactures specification.

**Please read Material Safety Data Sheets M750.**

## More Information

Go to [www.evic.com.au](http://www.evic.com.au) for product and material safety data on all Evic products. Information is also available in booklet and CD-ROM form, or by e-mail and fax transmission.

For further enquiries, call the Evic Group on (freecall) 1800 761 761.



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