

A Quality Product from Hawkeye Industries, Inc.

## Duratec® Polyester **Duratec Surface Primer**



***The ultimate High-Gloss surface primer for wood, MDF, tooling board and composite plugs, patterns and models. Unique air-cure technology for fast cure even with thin coats. Easy to sand, polish to a gloss. Take a mold directly off the Surface Primer or topcoat for the highest gloss.***

### **Recommended Uses:**

- Surface coat for plugs/patterns for composite tooling.
- Easy Sanding High-Build Primer for composite parts.
- High Build, Fast Sanding Primer perfectly smooth surfaces

### **Recommended Uses:** (cont)

- A substitute for sanding gelcoat - epoxy laminates or pinhole-free surfaces.
- Highly crosslinked coating providing excellent chemical resistance

### **Features:**

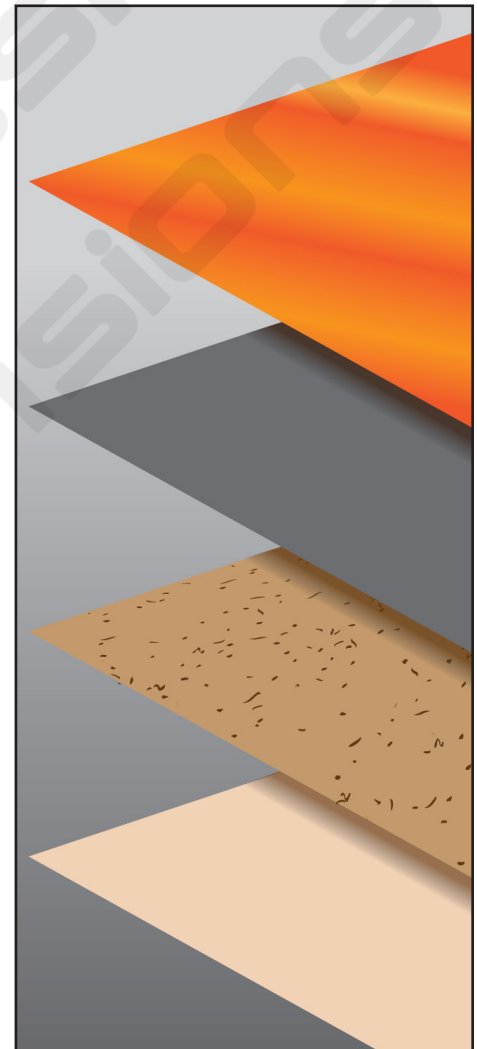
*Low Porosity- provides a super fine leveling and filling system. Applied properly, Surface Primer provides a porosity-free surface without pinholes or defects.*

*Adhesion to most epoxies- with heat distortion level of 200° F/93 C the primer also adheres to fiberglass, wood, MDF, brick, concrete and polyurethane foam.*

*Rapid Buildup- up to 40 mils 1000 microns, wet on wet, on composite plugs and master mold surfaces. Save time and labor.*

*Easy Sanding-also saves time and labor. The primer cures to a surface that polishes to a gloss.*

**702-003 Black**  
**707-002 Dark Grey**  
**707-082 Light Grey**  
**714-002 White**



### **Hawkeye Industries**

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Data Sheet  
Continued

## Duratec® Polyester Surface Primer

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### Product Properties:

Viscosity as measured on a Brookfield Visometer Model RFG, Spindle #5 at 2.5 rpm .....	2700 cps
Thixotropic.....	5
Gel Time: Sample based upon a 100 g mass, catalyzed with 2% Norox 925 .....	16-18 min
Weight per Gallon .....	10.9 lb, 4.995 kg.

### Coverage per Gallon:

10 mil thickness (wet-dry) .....	160 ft <sup>2</sup> -125 ft <sup>2</sup>
250 micron thickness (wet-dry) .....	15 m <sup>2</sup> -12 m <sup>2</sup>

### Use Instructions:

- Mix thoroughly with a drill-mounted mixer or paint shaker. Hand stirring is not enough.
- Duratec Surface Primer is designed to be applied when the ambient temperature and part temperature are both above 60°F.
- Catalyze with 1.75-2.25% MEKP Catalyst. Norox 925 works well. Mix well.
- Surface Primer can be applied by roller, brush or by spray. Spray with an HVLP gun, or with a gelcoat application system. Seek a fine spray, and use the lowest pressure that allows an even spray fan. (approximately 40 psi). A 2.0 mm tip is recommended.
- Apply at least 10 mils for even and complete cure. . Recoat before the Primer has set up and lost its tack. If the Primer cures completely wait at least eight hours, sand, and recoat.
- Additional solvent is not needed for most spray guns. If solvent is required, do not add Acetone or Styrene.
- Duratec Thinner is the best choice. Methyl Ethyl Ketone Solvent will work for most users. High quality urethane reducers are good choices. Lacquer Thinners are not recommended.
- Sand when the primer has cured. Start with the finest paper that will remove the surface profile. If sprayed well, 220 or 320 grit paper is a good starting point.
- Wait at least eight hours from the start of sanding before polishing or topcoating.
- Aqua Buff 1000 and 2000 are good choices for compounding and polishing Surface Primer.
- Duratec Pot Life Extender will extend the pot life by 2-3 times, and does not extend the cure time (spray only).

Shelf Life: this product is shelf-stable for six months from the date of productions when stored away from sunlight at no more than 77° F. Extended storage will result in settling, drift in the gel time and viscosity. Elevated temperatures will reduce the shelf life.

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