

A Quality Product from Hawkeye Industries, Inc.



Duratec® Pigmented Hi-Gloss Topcoat- 046

Black 902-046 • White 914-046 • Orange 908-046 • Green 906-046

Duratec Pigmented Hi-Gloss TopCoat is a self-leveling air cured polyester coating. The rapid complete cure will provide a hard glossy surface for patterns and molds. This exceptional coating is easy to sand and polish easily achieving a final gloss over 90 percent. The Hi-Gloss Topcoat will not dull during the mold making process thereby producing a shiny tooling gelcoat surface.

Usage

For composite plugs, patterns, wood surfaces and other applications where air-cured chemistry and thin film cure is desired such as mold resurfacing.

Feature and Benefits

Labor Savings- Smooth surface minimizes sanding. Patterns can be finished the day after the Topcoat is applied. Mold prep is also abbreviated due to high gloss transfer.

Superior Finish- Porosity free coating produces glossy patterns that retain 98% of their initial gloss after mold making process.

Resist Fisheyes- Unique additives reduce the risk of fish eyes and pinholes during the spray application.

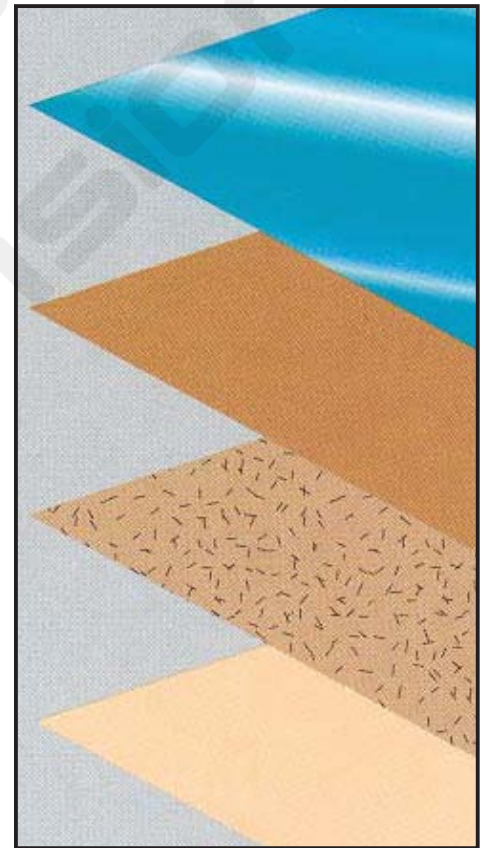
Air Cure Chemistry- Provides a complete cure even at 10 mils, 250 microns. Ester Primer-

Usage & Safety Guidelines

Fully follow comments pertaining to specific Duratec products MSDS. Thoroughly machine agitate, or mix this product for 5 minutes prior to use Refer to application guides for full details for using Duratec Products. Do not apply Duratec products at temperatures below 64 F

High Gloss Topcoat - 046

902-046	Black
914-046	White
908-046	Orange
906-046	Green



Hawkeye Industries

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Limited/ warranty statement: Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, expressed or implied, including any warranty of merchantability or fitness, nor is protection from any law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.



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Typical Product Properties @ 77F, 25c

Gel Time	2% Norox MEKP 925	20 minutes
Viscosity	20 RPM, #2 Spindle	400 CPS
Thixotropic Index	2 RPM/20RPM.....	2.5 Minimum
Weight Per Gallon		8.8 lbs, 3.9 Kg
Coverage Per gallon @ 10 Mils		110 sqft
	@ 250 Microns.....	10.2 sqm

Recommended Application Procedures:

Catalyst: Syrgis 925 is used for product development and quality control. Other 9% oxygen MEKP-type catalysts may be used. Recommended addition is 2% by volume, or 1.8% by weight.

In hot conditions the catalyst may be reduced to 1.5%, in cold, increased to 2.25%. Always mix thoroughly.

Duratec Pot Life Extender may be added to primers to double the pot life. Add 2% (after catalyst) to polyester primers (7## codes) and 0.5% to vinyl ester primers (17## codes).

Thinner: Duratec Pattern Coatings can be applied through most spray guns without thinner. If a thinner is required, Duratec LAC-39 is ideal. Acetone is not recommended. Most commercial lacquer thinners contain incompatible solvents or high levels of water.

Spray Gun Set-up: we recommend a HVLP spray gun. A 1.8 mm tip is ideal for the Duratec Pattern Coating. Primers will require a larger tip. Adjust the needle control and fan control to achieve a wide fan with good breakup. Use the lowest air-pressure setting that allows for good breakup. Lower air pressure reduces turbulence, thus reducing over-spray and orange peel.

Pattern/Part preparation: sand with 220 grit. Wipe down with a rag wetted with Acetone. Do not use a tack rag, as many tack rags will transfer materials to the surface. Seek a dust-free area around the pattern to reduce contamination while the Duratec is liquid.

Spray Technique: start with a fine mist coat. The mist coat should not provide a continuous film on the pattern. Allow two minutes for solvents to flash-off. Apply build coats of 4-5 mils, working in opposing directions. Allow 2-15 minutes between coats for solvent evaporation.

Work at a 90° angle, at about 18" distance.

Apply build coats before the previous coat has tacked-off. The coating should be wet enough to transfer to a fingertip. If the previous coat has cured enough that it will not transfer then allow for full cure and sand before continuing.

Build at least 10 mils. Allow to cure fully. Sand, and wait at least eight hours before polishing.

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