US COMPOSITES
PERFORMANCE PRODUCTS DELIVERED

Hawkeye Industries

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DURATEC GREY SURFACE PRIMER

PRODUCT #707-002

KEY USES

- Composite plugs and patterns
- Priming wood products
- Furniture
- Architecture
- High density foams

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 EPOXIES

With heat distortion level of 200°F (93°C) the primer also adheres to most epoxies, including fiberglass, wood, MDF, brick, concrete and polyurethane foam.

- RAPID BUILD UP

Up to 40 mil 1000 microns, wet on wet, on composite plugs and master mold surfaces. Save time and labor.

- EASY SANDING

Saves time and labor. The primer cures to a surface that polishes to a gloss.

COLOR OPTIONS

- Black (702-003)
- Light Grey (707-082)
- Grey (707-002)

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DESCRIPTION

The ultimate high-gloss surface primer for wood, MDF, tooling board for 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.

PRODUCT PROPERTIES
All time calculations are based on temperatures of 77°F, 25°C
Lab tested with Norox 925 MEKP

Viscosity As measured on a Brookfield Viscometer Model RVF, Spindle #5 at 2.5 rpm	2300-2600 cps
Thixotropic Index	6
Gel Time Sample based on a 100g mass catalyzed at 2% with MEKP	18-22 minutes
Weight per gallon	10.9 lbs
Coverage per Gallon 20 mil thickness	80 sq. feet

SAFETY & HANDLING

Duratec Surface Primer is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Duratec Grey Surface Primer contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating or drinking. All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures.

For more detailed instructions on storage, please see the MSDS sheet.

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APPLICATION GUIDE | PRODUCT #707-002

PLEASE NOTE

The following use instructions are broad to address multiple applications. We recommend testing for product compatability with your process. Please contact our Tech Team at (909) 546-1160 with any questions.

Mix

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 64°F.

Catalyze

Catalyze with full strength MEKP catalyst at 2% by weight (approx. 20 cc per quart). Norox 925 is a good choice. Catalyze only what will be used in 10-15 minutes. Mix well.

Apply

Surface Primer is best applied by spray using 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 2.0-2.4 mm tip is recommended. If applying by brush or roller, please speak with our Technical Support Team.

Apply at least 10 mils, building 4-5 mils at a time, in a crosshatch pattern for even and complete cure. Allow time (2-3 min) between passes for out-gassing. Recoat before the primer has set up and lost its tack. If the primer cures completely wait at least eight hours, sand, and recoat.

In-Mold Tip: If spraying in-mold, the first pass should be a light dust coat to allow proper surface tension to form.

Additional solvent is not needed for most spray guns. If solvent is required, do not add acetone. Duratec Reducer 39UCE is the best choice. Methyl Ethyl Ketone Solvent (MEK) will work for most users. High quality urethane reducers are good choices. Lacquer Thinners are not recommended.

If extended gel time is needed, check out Duratec Gel Time Extender.

Sand

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.

Polish

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 Duratec Surface Primer.

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TROUBLESHOOTING | PRODUCT #707-002

Problem	Cause	Solution
Alligatoring	Not enough catalyst used.	Check for proper catalyst levels.
	Substrate/primer incompatibility or chemical reaction.	Check compatibility of surface of product.
	Primer sprayed on cold surface.	Expose surface to higher temperature before spraying when ambient temp is below 64°F, 18°C.
Blisters	Substrate not cured, gassing underneath primer.	Completely cure putties, pastes and compounds before applying primer.
Cracking	Primer spray too thickly, too fast.	Increase the number of passes, adding dwell time between coats.
Dimples (Craters)	Film build up too rapid, solvent trapped in primer.	Increase the number of passes to achieve desired thickness. Allow for "flash off" between passes.
Fisheyes	Substrate contaminated.	Do not use a "tack rag". Ensure rag does not leave contaminant on surface.
	Contamination in the air.	Spray in a clean area to minimize airborne dust, water, waxes, and/or silicones.
	Contamination in the line.	Spray with dry filtered air.
Orange Peel	Spray equipment set up incorrectly.	Follow the instructions for equipment set up.
	Spray pressure incorrect.	Set pressure at 35-50 psi.
	Pot pressure incorrect.	Set pressure at 10-12 psi.
Pattern surface sticks to mold upon release	Improper release preparation.	Follow manufacturer's instructions when applying release materials.
	Primer not fully cured before compounding and polishing.	Follow instructions in the application guide for pattern surfacing.
	Excess gel time for tooling gel coat.	Follow manufacturer's recs for gel time
Pinholes	Substrate porosity.	Fill porous areas with product using squeegee, brush or roller before spraying.
Porosity	Spray pressure too high.	Reduce pressure to 35-50 psi.
	Spray orifice too small.	Use larger orifice.
	Acetone used as thinner.	Use slower solvent such as MEK or Duratec Reducer

See the Liability and Warranty Statement on Page 1