



## Product Application Instructions from Hawkeye Industries

**Product:** Duratec® Polyester Hi-Gloss Coating (904-040 Clear, 602-021 Black, 608-021 Orange, 614-021 White, 604-041 Unpigmented)

Duratec Polyester Hi-Gloss Coating is used to put a high gloss on composite plugs and patterns and wood product surfaces.

Here's how to apply Duratec Polyester Hi-Gloss Coating:

1. Sand the surface to a 180-grit finish to ensure proper mechanical adhesion. Wipe with a clean cloth. Do not use a tack rag.
2. Thoroughly stir Duratec Polyester Hi-Gloss Coating in the can prior to catalyzing. Due to the rapid gel time of the topcoat, catalyze only what can be applied within 15-17 minutes. (Higher temperatures yield a shorter pot life and gel time, while lower temperatures will yield a longer pot life and gel time.) Catalyze at 2 percent with mekP catalyst (20 cc per quart). Thin 5-15 percent if necessary to a desired spray viscosity with Duratec Thinner or mek solvent after catalyzation.

*Note:* Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

3. Spray the coating with a fine mist coat and wait 2 minutes for the solvents to flash off. Follow with multiple wet coats up to a total thickness of 10-15 mils, 250-375 microns. After curing, dry sand up to a 800- or higher grit finish, then allow to cure overnight prior to further sanding, compounding and polishing.

*Note:* If more than 12 hours pass during sanding, the overnight waiting period is not necessary.

**SAFETY PRECAUTIONS:** Duratec Polyester Hi-Gloss Coating is extremely flammable. Do not apply near sparks, open flame or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Do not take internally.

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