Product: Duratec® Vinyl Ester Hi-Gloss Topcoat (1904-045 Clear, 1902-045 Black, 1908-045 Orange

Use Duratec Vinyl Ester Hi-Gloss Topcoat when a hi-gloss is desired after priming molds.

Here's how to apply Duratec Vinyl Ester Hi-Gloss Topcoat:

1. Ambient temperatures should be in excess of 68 F, 20 C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77 F, 25 C.

2. Sand the primed mold with 180-grit sandpaper. No waiting is required before applying the topcoat.

3. Thoroughly stir Duratec Vinyl Ester Hi-Gloss Topcoat in the can prior to catalyzing. Due to the rapid gel time of the topcoat, mix only the amount that can be applied within 10 minutes at 77°F, 25°C. Higher temperatures yield a shorter pot life and gel time while lower temperatures yield a longer pot life and gel time. Catalyze at 2 percent with mekP catalyst (20 cc per quart). For improved flow and leveling properties, thin 5-10 percent with Duratec Thinner or mek solvent.

Equipment Note: Use air aspirated or pressure pot spray equipment. The recommended line air pressure is 35-50 psi and pot pressure is 10-15 psi. Airless, air-assisted airless and air-aspirated gelcoat plural-component spray systems can also be used.

4. Spray the entire surface with a fine mist coat and wait 2 minutes for the solvents to flash off. Follow with wet coats building to 15-20 mils, 375-500 microns, thickness.

Note: Do not inhibit cure by adding wax surfacing agents. The topcoat will cure to a hard, glossy finish in approximately 4-6 hours.

5. When cured, dry sand the surface to remove entrapped dirt and dust beginning with 320-400-grit sandpaper. Finish with 800-or higher-grit wet/dry sandpaper. Wait a minimum of 8 hours (@77°F, 25°C) for the solvent to release prior to compounding and polishing.

SAFETY PRECAUTIONS: Duratec Vinyl Ester Hi-Gloss Topcoat 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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