



Product Application Instructions from Hawkeye Industries

Product: Duratec® Vinyl Ester Primer (1794-005 or 1794-006 White, 1799-005 or 1799-006 Grey)

Duratec Vinyl Ester Primer is used for composite yacht priming and to provide protection against blistering and osmosis damage.

Important: *If the surface to be coated is epoxy laminate—*

- Always test the compatibility between the epoxy surface and Duratec products.
- Do not apply Duratec Vinyl Ester products over epoxy putties that contain microballoons.
- If the surface is epoxy resin or laminate, scrub with an abrasive pad and water to eliminate any possible amine blush that may be exposed due to sanding and might interfere with the adhesion of Duratec products to the epoxy substrate.

Here's how to apply Duratec Vinyl Ester Primer:

1. When Duratec Vinyl Ester Primer is applied over Duratec Vinyl Ester Fairing Putty or Duratec Vinyl Ester Fairing Primer, follow instructions outlined above. Otherwise, sand or sandblast the surface to a 80- or 120- grit finish and wipe with a fast solvent and clean white cloth. **Do not use a tack rag.**
2. Thoroughly stir Duratec Vinyl Ester Primer in the can. Catalyze at 2 percent with full strength mekP catalyst (20cc/quart) for an 18-20 minute pot life. If ambient temperatures are excessive, cool the primer to 77°F, 25°C to create a longer pot life. Thin, if necessary, 10-20 percent with Duratec Thinner or mek solvent after catalyzation.

Important:

- For proper blister/osmosis resistance, Duratec Vinyl Ester Primer must have a minimum of 0.5 mm, 20 mils, dry thickness remaining after sanding before topcoating. If the primer is used for cosmetic applications above the waterline, no minimum thickness is required.
- After sanding, allow the primer to cure overnight at 77°F, 25°C before topcoating. This allows for the release of solvents that may be trapped at the surface.

Spray Application:

3. Gravity, siphon or pressure-pot spray systems can be used. Line air pressure should be between 35-50psi and pot pressure should be 12-15psi. A 1.5-2.5mm diameter air-cap, needle and nozzle arrangement is recommended. (Plural-component spray equipment —airless, air-assist and/or air-aspirated





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gelcoat type equipment—can also be used.) *Contact Hawkeye Industries for spray equipment recommendations.*

4. To spray, apply a tack coat to the surface and allow it to flash for 2 minutes. Follow with wet passes, building to 1 mm, 40 mils, wet thickness, allowing for flash time between wet passes. If greater thickness is desired, wait 20-40 minutes and continue spraying.

Note: If recoating is necessary and more than 8 hours have passed, the initial coat must be sanded with 80-grit sandpaper before applying the primer.

Roller Application:

3. For rolling use a solvent-resistant roller. Catalyze as for the spray application and build to 1 mm, 40 mils thickness. Repeat the process if greater thickness is required, waiting at least 20 minutes between applications to allow the initial layer to gel. The primer will be ready to sand in 1-5 hours.
4. When properly sanded and cured, Duratec Vinyl Ester Primer will be ready to topcoat with bottom and topside paint systems.

Note: Do not apply abrasive bottom paints directly onto Duratec Vinyl Ester Primer. First, apply an epoxy primer and follow with the abrasive bottom paint. Hard non-abrasive bottom paint can be applied directly onto Duratec Vinyl Ester Primer.

SAFETY PRECAUTIONS: Duratec Vinyl Ester Primer 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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