



DURATEC STYROSHIELD PRIMER

PRODUCT #707-019

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KEY USES

- Making patterns from expanded polystyrene foam
- Prototype molds, or mold-direct construction
- Anchoring decorative paints onto expanded polystyrene foam
- Sealing forms for cast concrete

FEATURES

- COST SAVNG**
Allows low-cost polystyrene foam to be substituted for urethane foam.
- INSULATION**
This product includes microspheres, which provides excellent insulation for polystyrene foam.
- EASY TO SAND**

COLORS AVAILABLE

- DARK GREY (707-019)
- LIGHT GREY (707-014
THIS OPTION IS ALMOST WHITE IN COLOR. MAY REQUIRE A SPECIAL ORDER)

DESCRIPTION

Duratec StyroShield Primer is an air-cure polyester primer that can be applied directly to expanded polystyrene foam (EPS). When cured, StyroShield forms a barrier that allows the use of conventional polyester laminating resins, tooling putty, Duratec primers, and paint.

PRODUCT PROPERTIES	
All time calculations are based on temperatures of 77°F, 25°C Lab tested with Norox 925	
Viscosity As measured on a Brookfield Viscometer Model RVF, Spindle #4 at 20 rpm	900 - 2200 cps
Thixotropic Index	minimum 2
Coverage per gallon	80 sq feet per gal @ 20 mils 160 sq feet per gal @ 10 mils
Weight per gallon	7.4 lbs
Gel Time Based on 100g mass catalyzed at 2% MEKP	20 to 40 minutes
Cure Time Until tacky, no transfer	Approximately 2.5 hours

SAFETY & HANDLING

Duratec Styroshield 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 Styroshield 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.

Liability/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. All claim requests must be made in writing and are subject to review, including storage temperature verification and retain evaluations. The exclusive remedy for all proven claims is replacement of our materials. In no event shall we be liable for special, incidental or consequential damages, including damages caused in transit (exworks terms). 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 and trademark rights are reserved.



Hawkeye Industries

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APPLICATION GUIDE | PRODUCT #707-019

PLEASE NOTE

The following use instructions are broad to address multiple applications. We recommend testing for product compatibility 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.

It is not uncommon over time for the microspheres to separate from liquid components and float to the top, forming a visible crust. The crust can usually be mixed back into the primer using a drill-mounted mixer or paint shaker. When possible, store the StyroShield primer container upside down, rotating periodically to keep solids and liquids blended.

Do not add solvent, like thinners, to the StyroShield Primer. Solvents will attack polystyrene foam.

Catalyze

Catalyze the Duratec at 2.0 % by weight with a full strength MEKP, Norox 925 or comparable MEKP catalyst.

Apply

For best results, Styroshield should be applied in a spray application. We recommend HVLP air-assisted spray guns. A 2.5 mm tip or larger is ideal. Use 34-40 psi air pressure (at the gun). Adjust the needle and fan to provide the proper spray.

If applying by brush or roller, please note the surface profile will not be as smooth. We advise running a small test with a low nap roller or short-bristle brush to determine best application. Build material slowly to ensure proper out-gassing between coats.

Apply at least 20 mils (450 microns) of StyroShield to the surface, use multiple passes to assure complete coverage and surface protection.

Some rough expanded polystyrene foams will have deep pits on the surface. Sealing the pits is necessary to prevent penetration by resins or topcoats. If pits or voids are observed after spraying the StyroShield primer, drag a paintbrush, or squeegee across the surface to force primer into the voids.

Clean up with acetone or a similar cleaning product.

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TROUBLESHOOTING | PRODUCT #707-019

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.
	Product sprayed on cold surface.	Expose surface to higher temperature before spraying when ambient temp is below 64°F, 18°C.
Cracking	Product spray too thickly, too fast.	Increase the number of passes, adding dwell time between coats.
Dimples (Craters)	EPS foam has imperfections.	Fill in the holes by forcing product into them with squeegee or paintbrush.
Melted Foam	Foam not dense enough	Upgrade to a higher density foam. Product not recommended for XPS.
Pinholes	Substrate porosity.	Fill porous areas with product using squeegee, brush or roller before spraying.
Pooling	Product applied too heavy, too fast.	Lower the number of passes and use a lower milage.