



- 909-546-1160
- hawkeyesales@hawkeyeind.com
- PO BOX 415,
BLOOMINGTON, CA 92316
- WWW.HAWKEYEIND.COM

KEY USES

- Wood and MDF substrates
- Automotive dashboards
- Cabinets and furniture
- Marine and aircraft interiors
- Musical instruments

FEATURES

- EASY TO APPLY**
Sprayable and quick building, to 10-15 mils, 250-375 microns thickness.
- HIGH GLOSS**
Sands easily and polishes to a non-wax, tackfree high gloss finish.
- ELONGATION/FLEX**
Originally designed to work with wood, this clear offers slightly more flex than other topcoats.
- EASILY TOPCOATED**
Can be top coated with lacquers, enamels, polyurethanes, varnishes, etc. to achieve high-gloss or low-lust, hand rubbed finishes.
- COMPATIBILITY**
Compatible with wood, polyester, vinyl ester, and most epoxy substrates.

OTHER CLEAR OPTIONS

- 904-061 CLEAR SUNSHIELD
(A UV RESISTANT OPTION)
- 904-040 HI-GLOSS COATING
(LESS FLEX, HIGHER DURABILITY)

REVISED DECEMBER 2024

DURATEC CLEAR HI-GLOSS TOPCOAT

PRODUCT # 904 -046

DESCRIPTION

A high-build, easy-sand coating designed as a topcoat for cured polyester, polyurethane and lacquer clear or color coats. You will get a superior finish, add quality and save time and labor with Duratec Hi-Gloss Topcoat.

PRODUCT PROPERTIES	
All time calculations are based on temperatures of 77°F, 25°C Lab tested with Norox 925 MEKP	
Viscosity, #2 spindle, RVF, 20 rpm	390-450 cps
Thixotropic Index	min. 3.5
Gel time @ 2% MEKP	17-21 minutes
Weight per gallon	8.68 lbs/gal
Color	Clear (slight hue present while in can)
Shelf Life	Six (6) months from date of manufacture, unopened, with proper storage. See Shelf Life Statement for full details.

SAFETY & HANDLING

Duratec Clear Hi-Gloss Topcoat is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Duratec Clear Hi-Gloss Topcoat 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.



DURATEC CLEAR HI-GLOSS TOPCOAT

APPLICATION GUIDE # 904 -04 6

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.

Prepare & Catalyze

Temperature should be at least 64°F for both the product and the part.

904-046 will mix easily with stirring, a paint shaker (gallons), or a drill mounted mixer (pail or drum). Ensure thorough mix.

Catalyze the Duratec at 2.0 % by weight with a full strength MEKP, like Norox 925. Catalyze only an amount that can be sprayed in 15 minutes, typically about a quart if using a HVLP spray gun. Mix well.

Apply

Duratec Hi-Gloss Topcoat should be applied by spraying. We recommend HVLP air-assisted spray guns.

Epoxy laminates should be washed with clean water and a heavy duty scrub sponge before and after sanding. It is not necessary to water wash polyester, vinyl ester, or wood substrates. Abrade the entire substrate surface with 180-grit to ensure proper mechanical adhesion. Wipe with a clean cloth. Do not use a tack rag.

A 1.8 mm tip is recommended. Use 34-40 psi air pressure (at the gun). Adjust the needle and fan to provide the proper spray. Use the lowest pressures possible to minimize orange peel.

The first coat should be a light dust coat. The dust coating does not completely cover the surface. Wait at least two minutes, and apply another light coat. Continue to make build passes of 4-6 mils, with two minute intervals, until about 20 mils of product is on the surface.

Allow to cure at room temperature for at least one hour. At that time, cure can be accelerated by putting the part in a warm room at 120°F.

Sand

Once the surface is fully cured, sand to remove any texture or orange peel. Use as fine a grit of paper as is reasonable. Continue sanding with progressively finer grits, up to 1000 grit paper. Allow at least eight hours after sanding before re-coating or before polishing begins.

Compound and polish to high gloss. We recommend Aqua Buff 1000W or 1000F, followed by Aqua Buff 2000.

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DURATEC CLEAR HI-GLOSS TOPCOAT

TROUBLESHOOTING | PRODUCT 904-046

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.
Curing on surface but not on substrate	Coating sprayed on cold surface	Expose substrate to higher temperture before spraying.
Dimples (Craters)	Film build up too rapid, solvent trapped in product.	Increase the number of passes to achieve desired thickness. Allow for “ash o” 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 ylttered air.
Orange Peel	Spray equipment set up incorrectly.	Follow the instructions for equipment set up.
	Spray pressure incorrect.	Set pressure at 34-40 psi.
	Pot pressure incorrect.	Set pressure at 10-12 psi.
Pinholes	Substrate porosity.	Fill porous areas with product using squeegee, brush or roller before spraying.
Porosity	Spray pressure too high.	Reduce pressure to 34-40 psi.
	Spray oriýce too small.	Use larger oriýce.
	Acetone used as thinner.	Use slower solvent such as MEK or Duratec Reducer
Surface not hard or glossy	Coating not allowed to “breathe” after sanding	Allow time for solvents to escape before compounding and polishing.
	Low reactivity catalyst used / coating under catalyzed.	Catalyze at 2% with full strength MEKP. Do not use 30 percent MEKP or catalyst with less than 8.8 percent active oygen.