



Product Application Instructions from Hawkeye Industries

Product: Duratec® Polyester Base Primer (707-051 Tan)

Use Duratec Polyester Base Primer to rapidly fair and shape plugs, patterns or models. Duratec Base Primer air cures to an easily sandable surface, which provides a stable base for other coatings.

Here's how to apply Duratec Polyester Base Primer:

1. If Duratec Sealer (823) was first applied to the substrate no sanding is required. If Duratec Sealer was not first applied to the substrate, sand the substrate with 80- or 120-grit sandpaper and wipe clean prior to applying the base primer.
2. Thoroughly mix Duratec Polyester Base Primer in the can.

Note: A machine mixer must be used to completely mix the primer. The low-density fillers will rise to the top of the container and form a crust. Do not discard the crust; it must be completely mixed back into the primer solution.

3. Pour out the quantity of material required. Due to the primer's rapid gel time, mix only what can be sprayed in 15 minutes. Catalyze at 2 percent with full strength mekP catalyst (20 cc per quart). Thin 10-20 percent if necessary to a desired spray viscosity with Duratec Thinner (39 LAC-1) or mek solvent; if (and only if) application temperatures are below 77°F, 25°C, the base primer should be thinned with acetone.

Equipment Notes: For spraying, gravity, siphon or pressure pot spray systems can be used. Gravity and siphon guns require 35-50 psi line pressure and 2.5-3.5 millimeter nozzle. Pressure pot systems require 12-15 psi pot pressure and 35-50 psi line pressure.

4. Apply a "tack coat" to the entire surface and allow it to flash for 2 minutes (minimum). Follow the tack coat with wet passes, slowly building to the desired thickness. Time between wet-on-wet passes should be 1 minute (minimum) to 30 minutes (maximum).

Note: It is possible to apply up to 3 mm wet-on-wet; if further buildup is required, a 10-20 minute solvent "flash-off" period is recommended. Although the primer will build continuously wet-on-wet, there is a relationship between thickness and cure time. Curing will take longer, and with extremely thick coats, there is a possible risk of solvent entrapment.

5. After shaping and sanding with 120- or 220-grit sandpaper, follow with Duratec Polyester Surfacing Primer (702-003 Black, 707-002 Grey, 714-002 White), or Duratec Polyester EZ Sanding Primer (707-060 Grey, 702-060 Black, 714-060 White).

SAFETY PRECAUTIONS: Duratec Polyester Base 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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