



Product Application Instructions from Hawkeye Industries

Product: Duratec® Polyester Surfacing Primer (702-003 Black, 707-002 Grey, 707-082 Light Grey, 714-002 White)

Use Duratec Polyester Surfacing Primer to prime composite plugs and patterns and a number of wood products—including those used for furniture, musical instruments and architectural applications.

Here's how to apply Duratec Polyester Surfacing Primer:

Note 1: Duratec Polyester EZ Sanding Primer is an alternative to Duratec Polyester Surfacing Primer. The EZ Sanding Primer air cures quicker and sands easier than the Surfacing Primer, while the Surfacing Primer provides a tougher, glossier coating.

Note 2: If a higher gloss is desired and you choose not to use a topcoat, you can blend the Surfacing Primer one-to-one with Duratec Polyester Clear Hi-Gloss Additive (904-001).

1. If no other Duratec product was first applied to the substrate sand the entire surface with 80- or 120-grit sandpaper and wipe clean. **Do not use a tack rag.**
2. If applying Duratec Polyester Surfacing Primer over Duratec Polyester Sealer no sanding is required. If applying the primer over Duratec Polyester Base Primer, shape and sand the surface with 120- or 220-grit sandpaper and wipe clean. **Do not use a tack rag.**
3. Thoroughly stir Duratec Polyester Surfacing Primer in the can prior to catalyzing—any fillers must be mixed completely into the liquid. Due to the rapid gel time of the primer, mix only the amount that can be applied within 15-20 minutes. (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 full strength mekP catalyst (20 cc per quart). Thin 5-15 percent if necessary to a desired spray viscosity with Duratec Thinner (39LAC-1) or mek solvent after catalyzation.

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 1.5-2.5 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. Follow with wet passes, slowly building to the desired thickness (10-40 mils, 250-1000 microns). Heavier thickness can be achieved by repeating the process immediately after gel has occurred, approximately every 2 minutes. The primer will be dry to the touch in 2-4 hours, depending on thickness and temperature, and ready to sand within 2-4 hours.
5. Dry sand the entire surface with 180- or 220-grit sandpaper. Wipe the surface with a clean white cloth or paper towel. Do not use a tack rag. Repeat the process if more Surfacing Primer is necessary. If the surfacing primer is to be the





Product Application Instructions from Hawkeye Industries

final gloss surface sand with up to 800-grit sandpaper and allow the sanded surface to sit overnight at 25° C, 77° F or warmer prior to compounding, polishing and prepping the surface.

Note: If more than 8 hours pass during sanding, the overnight waiting period is not necessary.

SAFETY PRECAUTIONS: Duratec Polyester Surfacing 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.

8-25-2011