Application Guide

Priming and Surfacing Application:
Finished Products

Use these Duratec® products to prime and surface finished composite products:

Duratec Vinyl Ester Mold Repair Putty (1804-007 Untinted)

Duratec Polyester Surfacing Primer (702-003 Black, 707-002 Gray, 714-002 White)

Duratec Polyester Fire-Resistant Primer (707-062, Gray)

Duratec Thinner (39LAC-1)

Application Conditions

The surface should be clean, dry and free from oil, grease, wax or other contaminants. Ambient temperatures should be in excess of 60°F, 16°C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77°F, 25°C.

Duratec Vinyl Ester Mold Repair Putty Application

Use Duratec Vinyl Ester Mold Repair Putty when excessive porosity of the sanded surface is exposed prior to priming.

Thoroughly stir Duratec Vinyl Ester Mold Repair Putty in the can using a spatula or putty knife prior to catalyzing. Due to the rapid gel time of the putty, catalyze only what can be applied in 6-8 minutes. Catalyze at 3 percent with BPO catalyst and mix thoroughly.

Note: *Always massage or knead the BPO cream hardener (catalyst) as separation can occur in the tube.*

Application Procedures

To ensure proper adhesion, rub the catalyzed putty into the repair area and fol-

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low by applying with a spatula, putty knife or squeegee. Fill the void completely by working the putty in all directions. For exceptionally deep repairs, repeat the process to ensure a porosity-free surface. Slightly mound the putty to allow for shrinkage.

When cured (20-30 minutes), sand the cured putty to a 320- or 400-grit finish. Continue the resurfacing application with Duratec Polyester Surfacing Primer or Duratec Polyester Fire-Resistant Primer per instructions in this application guide.

Duratec Polyester Surfacing Primer Application

Unless fire-resistant properties are needed, Duratec Polyester Surfacing Primer is used as the surface primer.

Surface and Product Preparation

If the surface is to be topcoated with gelcoat, sand it with 80- or120-grit sandpaper. If the topcoat will be polyurethane, acrylic and/or an automotive paint system, sand with 320-grit sandpaper. Wipe clean. **Do not use a tack rag.**

Note: *If excessive porosity of the sanded surface is exposed, apply Duratec Vinyl Ester Mold Repair Putty, per instructions on page 3 of this application guide.*

Thoroughly stir Duratec Polyester Surfacing Primer in the can prior to catalyzing. 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 or mek solvent after catalyzation.

Application Procedures

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-*

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2.5 millimeter nozzle. Pressure pot systems require 12-15 psi pot pressure and 35-50 psi line pressure.

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. The primer will be dry to the touch in 2-4 hours, depending on thickness and temperature and ready to sand .

Dry sand the entire surface to a 180- or 220-grit finished if polyester topcoats are used, or to a 320- to 400-grit finish if lacquer, urethane or enamel topcoats are used. Wipe the surface with a clean white cloth or paper towel. **Do not use a tack rag**.

Duratec Polyester Fire-Resistant Primer

Use Duratec Polyester Fire-Resistant Primer when fire resistant properties are desired.

Surface and Product Preparation

If the surface is to be topcoated with gelcoat, sand it with 80- or120-grit sandpaper. If the topcoat will be polyurethane, acrylic and/or an automotive paint system, sand with 320-grit sandpaper. Wipe clean. **Do not use a tack rag.**

Note: *If excessive porosity of the sanded surface is exposed, apply Duratec Vinyl Ester Mold Repair Putty, per instructions on page 3 of this application guide*

Thoroughly stir Duratec Polyester Fire-Resistant Primer in the can prior to catalyzing. 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 or mek solvent after catalyzation.

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Product Application

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 10-15 psi pot pressure and 35-50 psi line pressure.*

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. The primer will be dry to the touch in 2-4 hours, depending on thickness and temperature, and ready to sand. Dry sand the entire surface to a 180- or 220-grit finished if polyester topcoats are used, or to a 320- to 400-grit finish if lacquer, urethane or enamel topcoats are used.

Wipe the surface with a clean white cloth or paper towel. **Do not use a tack rag**.

Topcoating

After priming and sanding, topcoat with the appropriate paint system.

SAFETY PRECAUTIONS: Duratec Polyester Surfacing Primer, Polyester Fire-Resistant Surfacing Primer, Vinyl Ester Mold Repair Putty and Thinner are 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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