



**Hawkeye Industries Inc.**

Duratec® & Aqua-Buff®  
Products Marketed Worldwide

## Duratec Vinyl Ester Primer

Unmatched versatility and value for pattern surfacing, marine repair, and coating.

The Duratec Vinyl Ester Primer is based upon a highly functional resin that brings unmatched strength and performance. Originally developed as the ultimate barrier coat for boat hulls the Duratec Vinyl Ester Primer has proven its dynamic capability and solid value across many composite project uses.

### Uses:

- Primer for general purpose patterns and high temp patterns
- Marine construction and repair
- In-mold coating
- Tie coating with tooling gelcoat & epoxy laminate
- Repair coat or post-coat for composite parts
- Resurfacing molds with extraordinary results
- Epoxy or prepreg mold pattern surface
- Many other creative, innovative uses!

### Product Options:

1799-006 Grey : 1702-006 Black : 1794-006 White

### Features:

- Catalyze and use: pre-promoted for simplicity and consistent performance.
- Air Cure: no wax or barrier coat is required. Cures at room temperature.
- Can be polished to a medium gloss.
- High Build: smooth out a rough surface, hide texture or laminate.
- In-Mold Coating with print-blocking capabilities.
- Easy to apply: spray, brush or roller application.
- Low VOC, low HAPS
- Low Porosity: provides a smooth, defect-free surface.
- Temperature Stability: HDT of 285°F
- Tough, water resistant, chemical resistant.
- Available in one-gallon cans, five-gallon pails, & 55-gallon drums.



# USE INSTRUCTIONS

## Duratec 1799-006 Use Instructions

For detailed application information please see visit [www.duratec1.com](http://www.duratec1.com) or contact our technical team at (909) 546-1160.

### PREPARATION

**Safety:** comply with all local regulations regarding personal protective equipment and safety practices.

Duratec 1799-006 contains fractional fillers that will sink to the bottom of the container. Use either a paint shaker or a drill-mounted mixer. A paint stir stick will not be enough to mix up the Duratec. Mix until all the pigment is dispersed and the Duratec Vinyl Ester Primer is free of lumps. Filter through a cone filter or filter sock.

We recommend HVLP air-assisted spray guns. A 2.2 mm tip or larger is ideal for Duratec VE primer. Use 34-40 psi air pressure (at the gun). Adjust the needle and fan to provide a fine spray.

Catalyze the Duratec at 2.0 % by weight with a full strength MEKP, like Norac 925. Mix for one minute (when using a cap/cap gun). Only catalyze what can be sprayed in 12 minutes.

Duratec products leave the factory mixed for optimal performance. Always use the correct application tools before changing the formula. If thinning is required we suggest the use of Duratec 39LAC Thinner. Duratec Thinner duplicates the solvents that the VE Primer contains & will quick reduce viscosity. MEK Thinner is a reasonable alternative. Acetone or styrene is not recommended. Add as little thinner as possible.

Adjust fluid pressure and atomizing air to achieve an even pattern with fine droplets prior to spraying the mold.

### APPLICATION

Catalyze, mix, and set up gun as previously mentioned.

The Duratec may need to be mechanically forced into severe porosity. The first 2-3 mil pass can be worked with a soft squeegee to fill the holes.

The first pass should be a dust coat that sets up for a minimum of two minutes before further application. The dust coat should be a light fog, not a continuous film.

Apply 5-7 mils and immediately apply another 5-7 mils in the opposite direction for a crosshatch effect. Addition coats can be applied after a minimum of two minutes and while the surface is tacky.

For polyester/vinyl ester application: do not allow the VE primer to become tack-free between build coats. If the VE primer becomes tack-free, allow it to cure completely, sand with 180 grit, and recoat.

Additional coats of 4-5 mils can be applied, again allowing a minimum of two minutes to out-gas. Twelve mils will provide a nice finish. Up to 22 mils can be applied if the part requires aggressive post sanding.

The coating needs to be tacky for each build coat to bond. Cure time varies with temperature and air flow.

For epoxy, follow the steps above - however, with epoxy laminating systems a tack free surface is required. Increased heat up to 120° F will speed this process. Remember the adhesion comes from the epoxy. Test the bond between the Duratec and your epoxy blend to assure good adhesion.

### SANDING AND BUFFING

Work through sandpaper grits from 400- 1500, removing only the Duratec necessary to achieve a smooth flat profile. Wet sanding yields best results. We advocate a sanding guide coat or sanding dye.

Because of the tough, scratch resistant nature of the Duratec regular automotive compounds may not be aggressive enough to remove sanding scratches. We advocate the use of Aqua Buff as described below.

Allow at least eight hours between the start of sanding and the start of compounding. Pre-sand out any gas.

Beginning with Aqua Buff 1000F, remove the scratches, using a wool pad and mist bottle as your lubricant.

Exceptional final gloss will be achieved with Aqua Buff 2000 with a cotton/ wool blend pad. Again use a mist bottle to lubricate and cool the part as you polish the part. Finish with a foam pad for outstanding results.

