Application Guide

Surfacing Application: *Plaster Plugs and Molds*

Use these Duratec® products to rapidly create a "Class A" finish on plaster plugs and molds:

Duratec Polyester Sealer (823)

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

Duratec Polyester Hi-Gloss Coating (904-040 Clear, 602-021 Black, 608-021 Orange, 614-021 White)

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 Polyester Sealer Application

Surface and Product Preparation

Cure the plaster until the surface is dried at least to a depth of 0.25 inches or 6 mm. Sand the surface with 120 or 180 grit sandpaper and wipe with a dry cloth to remove the dust. **Do not use a tack rag.**

Thoroughly stir Duratec Polyester Sealer in the can prior to catalyzing. Due to the rapid gel time, mix only the amount that can be applied within 15-18 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).

Hawkeye Industries Inc.
P O Box 415 Bloomington, CA 92316
Tel 909-546-1160; Toll Free 800-977-0060; Fax: 909-546-1161
Email productinfo@duratec1.com Web www. duratec1.com

Revised 1-11-07

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Application Procedures

Brush, roll or spray the sealer onto the surface. The sealer quickly penetrates the plaster surface and acts as an "anchor" for Duratec Polyester Surfacing Primer. Wipe away any excess. The sealer is ready to top coat in 2-4 hours.

Note: *Do not sand Duratec Polyester Sealer prior to topcoating*.

Duratec Polyester Surfacing Primer Application

Product Preparation

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 17-20 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 if necessary with Duratec Thinner (39LAC-1) or mek solvent after catalyzing.

Application Procedures

Spray or brush the primer onto the sealed surface to the desired thickness, up to 40 mils, 1000 microns, wet on wet. Sand Duratec Polyester Surfacing Primer to a smooth finish. Wait overnight for a complete cure to develop prior to compounding and polishing.

Use Aqua-Buff® 1000-F Fast-Cut Compound and Aqua-Buff 2000 Compound/ Polish to achieve a glossy, swirl mark-free finish.

Apply the desired mold release system.

Duratec Polyester Hi-Gloss Coating Application

Surface and Product Preparation

For an even glossier surface, sand the primer with 180 grit sandpaper and wipe

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with a dry cloth. **Do not use a tack rag.** Catalyze Duratec Polyester Hi-Gloss Coating at 2 percent with full strength mekP catalyst (20 cc per quart) for a 15-17 minute pot life. Thin if necessary with Duratec Thinner or mek solvent after catalyzing.

Application Procedures

Spray Duratec Polyester Hi-Gloss Coating up to 10 mils, 250 microns, thickness with multiple wet passes. Sand to a smooth finish. Wait overnight for a complete cure to develop prior to compounding and polishing.

Use Aqua-Buff 1000-F Fast-Cut Compound and Aqua-Buff 2000 Compound/ Polish to achieve a glossy, swirl mark-free finish.

Apply the desired mold release system.

SAFETY PRECAUTIONS: Duratec Polyester Sealer, Surfacing Primer, Hi-Gloss Coating 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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