

Application Guide



Surfacing Application: *Tooling Gelcoat Upgrade for Mold Surfaces*

Use this Duratec® product to upgrade your tooling gelcoat. It will reduce subsurface porosity and orange peel, increase impact resistance and improve gloss retention and elevate heat distortion temperatures:

Duratec Polyester Clear Hi-Gloss Additive (904-001)

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.

Surface and Product Preparation

Blend 15 percent Duratec Polyester Clear Hi-Gloss Additive to the tooling gelcoat, thoroughly stirring in the can prior to catalyzing. Due to rapid gel time, mix only the amount that can be applied within 18 to 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 the recommended gelcoat catalyst level.

Application Procedures

Spray as recommended by the tooling gelcoat manufacturer. Due to the lower viscosity, an extra wet pass may be required to achieve wet coat total film thickness. Gel and tack times are comparable to the straight tooling gelcoat. Laminate as usual when the additive/tooling gelcoat blend "tacks off" to the thumbprint stage.

SAFETY PRECAUTIONS: Duratec Polyester Clear Hi-Gloss Additive 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.



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

Liability/warranty statement: Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, expressed or implied, including any warranty of merchantability or fitness, nor is protection from any law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.

Duratec is a registered trademark of Dura Technologies Inc.