

Application Guide



Priming and Leveling Application: *Wood and MDF Surfaces*

Use these Duratec® products to prime and level wood and MDF surfaces.

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 Polyester Hi-Gloss Tint Base (604-041 Unpigmented)

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

Duratec Polyester Sealer allows primers and topcoats to bond to the substrate.

Surface and Product Preparation

Sand the surface with 120- or 180-grit sandpaper and wipe clean prior to applying the sealer.

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 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 2 percent with mekP catalyst (20 cc per quart).



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Revised 1-11-07

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Application Procedures

Roll, brush or spray the sealer on; wipe away any excess using a clean white cloth or paper towel. Do not use a tack rag. The sealer will be ready to topcoat within 1-2 hours.

Note: Do not sand prior to topcoating.

Duratec Polyester Surfacing Primer Application

Duratec Polyester Surfacing Primer is used over the sealer as the surfacing primer.

Product Preparation

Thoroughly stir Duratec Polyester Surfacing Primer in the can prior to catalyzing. Due to the rapid gel time of the primer, catalyze only what 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 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 Note: Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

Apply a "tack coat" to the entire surface and follow with wet passes until the desired thickness (10-40 mils, 250-1000 microns) is achieved. When cured (2-4 hours), sand to a 180- or 220-grit finish if polyester topcoats are applied or to a 320- or 400-grit finish if lacquer, urethane or enamel topcoats are applied.

Duratec Polyester Hi-Gloss Coating or Duratec Polyester Hi-Gloss Tint Base Application

To achieve the ultimate gloss, apply Duratec Polyester Hi-Gloss Coating or Tint Base.



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Surface and Production Preparation

Sand the primed surface to a 180-grit finish. Thoroughly stir Duratec Polyester Hi-Gloss Coating or Tint Base in the can prior to catalyzing. Due to the rapid gel time of the coating, mix only the amount that can be applied within 15-18 minutes. (Higher temperatures yield a short pot life and gel time while lower temperatures yield a longer pot life and gel time.) Catalyze at 2 percent with mekP catalyst (20 cc per quart). Thin with Duratec Thinner or mek solvent, if desired.

Application Procedures

Spray Duratec Polyester Hi-Gloss Coating or Tint Base 10-15 mils, 250-375 microns, thick over the sanded surface. When cured, sand to a 600- or higher grit finish.

Note: For best results, after sanding, wait at least overnight at 77°F, 25°C before compounding and polishing the surface.

Compounding and Polishing the Surface

Remove scratches with Aqua-Buff 1000-F or 1000-W Fast-Cut Compound and polish with Aqua-Buff 2000 Compound/Polish for a glossy, swirl mark-free finish.

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