



# USE INSTRUCTIONS

## Duratec 904-061 Use Instructions

For detailed application information please see: Finishing Composites Parts with Clear Duratec at [www.duratec1.com/applicationguides](http://www.duratec1.com/applicationguides)

### IN MOLD: PRIOR TO LAMINATING

- 1 Ensure mold is clean and free of silicone. A silicon-free paste wax like TR 108 provides nice results. With an HVLP gun use a 1.8 -2.2 tip with 35 pounds of pressure. A plural component tip selection should have a .015 to .018 orifice.
- 2 Catalyze the Duratec at 1.5- 2.0 % by weight with a full strength MEKP, like Norac 925. Mix for one minute. Only catalyze what can be sprayed in 12 minutes.
- 3 If thinning is required, add 5-10% Duratec 39LAC3 after catalyzing
- 4 Adjust fluid pressure and atomizing air to achieve an even pattern with fine droplets prior to spraying the mold.
- 5 The first pass should be a dust coat that sets up for two minutes before further application. The dust coat should be a light fog, not a continuous film.
- 6 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 with UV protection. Up to 22 mils can be applied if the part requires aggressive post sanding.
- 7 The coating needs to be tacky for each build coat to bond. With polyesters and vinyl esters laminate when the Duratec has set up and does not transfer, but retains some tack/. Cure time varies with temperature and air flow.
- 8 For 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.

### FINISHING PARTS AFTER DE-MOLDING

- 1 Epoxy Laminate: water washing with clean water and a scotch brite pad is necessary before and after sanding. It is not necessary to water wash polyester or vinyl ester laminates.
- 2 Abrade the entire surface with 180 grit, providing mechanical tooth. Remove dust, and acetone-wipe the surface.
- 3 Catalyze, mix, and set up gun as previously mentioned.
- 4 The Duratec may need to be mechanically forced into severe porosity. The first 2-3 mil pass can be worked with a squeegee to fill the holes.
- 5 Addition coats can be applied after two minutes and while the surface is tacky.
- 6 If recoating the fully cured Duratec is necessary, first sand with 180 grit.
- 7 The final spray should be sanded with 400 grit and allowed to cure, for 8 hours prior to the final polishing

### SANDING AND BUFFING

- 1 Because of the tough, scratch resistant nature of the Duratec Clear regular automotive compounds are not aggressive enough to remove sanding scratches.
- 2 Work through sandpaper grits from 400- 1500, removing only the Duratec necessary to achieve a smooth flat profile. Wet sanding yields best results.
- 3 Beginning with Aqua Buff 1000f, remove the scratches, using a wool pad and water as your lubricant.
- 4 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.

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