



Hawkeye Industries



909-546-1160



hawkeyesales@hawkeyeind.com



PO BOX 415,
BLOOMINGTON, CA 92316



WWW.DURATEC1.COM

KEY USES

- Composites
- Wood & Foam
- MDF & GRP
- Plaster & clay

FEATURES

- **EASY TO APPLY**
The ability to be sprayed, brushed, or rolled on makes for easy application.
- **QUICK SHAPING**
Quickly shaped by knife, file or sandpaper.
- **RAPID BUILD UP**
Builds quickly – between 1 to 3mm, 40-120 mils, maximum wet-on-wet application with minimum sag on vertical surfaces.
- **FAIR AIR CURING**
Saves time and labor. The primer quickly air cures to an easily sandable surface, which provides a stable base for other coatings.
- **PROTECTIVE LAYER**
Hi-build primer offers a 200°F HDT, which reduces the risk of post-cure distortion due to exotherm and consequential print-through of substrates.

DURATEC TAN BASE PRIMER

PRODUCT #707-051

DESCRIPTION

A low-porosity, high-building, fairing and shaping primer. Great for forming composite plugs, patterns and models and a variety of other substrates. Used by manufacturers in the automotive, housing, leisure products, marine and transportation industries.

PRODUCT PROPERTIES

All time calculations are based on temperatures of 77°F, 25°C
Lab tested with Norox 925 MEKP

Viscosity As measured on a Brookfield Viscometer Model RVF, Spindle #2 at 20 rpm	1700-2100 cps
Thixotropic Index	minimum 5
Gel Time Sample based on a 100g mass catalyzed at 2% with MEKP	18-23 minutes
Weight per gallon	7.66 lbs
Coverage per Gallon 20 mil thickness	80 sq ft

SAFETY & HANDLING

Duratec Base Primer is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Duratec Base Primer contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating or drinking. All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures.

For more detailed instructions on storage, please see the MSDS sheet.



DURATEC TAN BASE PRIMER

APPLICATION GUIDE | PRODUCT #707-051

PLEASE NOTE

The following use instructions are broad to address multiple applications. We recommend testing for product compatibility with your process. Please contact our Tech Team at (909) 546-1160 with any questions.

Mix

Mix thoroughly with a drill-mounted mixer or paint shaker. Hand stirring is not enough.

Duratec Base Primer is designed to be applied when the ambient temperature and part temperature are both above 64°F.

Catalyze

Catalyze with full strength MEKP Catalyst at 2% by weight (approx. 20 cc per quart). Norox 925 is a good choice. Catalyze only what will be used in 10-15 minutes. Mix well.

Apply

Duratec Base Primer is best applied by spray using an HVLP gun, or with a gelcoat application system. Seek a fine spray, and use the lowest pressure that allows an even spray fan. (approximately 40 psi). A 2.0 mm tip is recommended. If applying by brush or roller, please speak with our Technical Support Team

Apply at least 10 mils, building 4-5 mils at a time, for even and complete cure. Recoat before the primer has set up and lost its tack. If the primer cures completely wait at least eight hours, sand, and recoat.

Additional solvent is not needed for most spray guns. If solvent is required, do not add acetone. Duratec Reducer 39UCE-3 is the best choice. Methyl Ethyl Ketone Solvent (MEK) will work for most users. High quality urethane reducers are good choices. Lacquer Thinners are not recommended.

If extended gel time is needed, check out Duratec Gel Time Extender.

Sand

Sand when the primer has cured. The grit of sandpaper that should be used will be determined by the surface quality of cured primer and your desired outcome.

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DURATEC TAN BASE PRIMER

TROUBLESHOOTING | PRODUCT #707-051

Problem	Cause	Solution
Alligatoring	Not enough catalyst used.	Check for proper catalyst levels.
	Substrate/primer incompatibility or chemical reaction.	Check compatibility of surface of product.
	Primer sprayed on cold surface.	Expose surface to higher temperature before spraying when ambient temp of below 64°F, 18°C.
Blisters	Substrate not cured, gassing underneath primer.	Completely cure putties, pastes and compounds before applying primer.
Cracking	Primer spray too thickly, too fast.	Increase the number of passes, adding dwell time between coats.
Dimples (Craters)	Film build up too rapid, solvent trapped in primer.	Increase the number of passes to achieve desired thickness. Allow for "flash off" between passes.
Fisheyes	Substrate contaminated.	Do not use a "tack rag", slow evaporating solvent.
	Contamination in the air.	Spray in a clean area to minimize airborne dust, water, waxes, and/or silicones.
	Contamination in the line.	Spray with dry filtered air.
Orange Peel	Spray equipment set up incorrectly.	Follow the instructions for equipment set up.
	Spray pressure incorrect.	Set pressure at 35-50 psi.
	Pot pressure incorrect.	Set pressure at 10-12 psi.
Pattern surface sticks to mold upon release	Improper release preparation.	Follow manufacturer's instructions when applying release materials.
	Primer not fully cured before compounding and polishing.	Follow instructions in the application guide for pattern surfacing.
	Excess gel time for tooling gel coat.	Follow manufacturer's recs for gel time
Pinholes	Substrate porosity.	Fill porous areas with product using squeegee, brush or roller before spraying.
Porosity	Spray pressure too high.	Reduce pressure to 35-50 psi.
	Spray orifice too small.	Use larger orifice.
	Acetone used as thinner.	Use slower solvent such as MEK or Duratec Reducer