



Hawkeye Industries



909-546-1160



hawkeyesales@hawkeyeind.com



PO BOX 415,
BLOOMINGTON, CA 92316



WWW.DURATEC1.COM

KEY USES

- Surfacing patterns for composite molds
- Tooling board
- MDF
- Brick and concrete
- Plaster and clay
- Polyester or vinyl ester fiberglass

FEATURES

- **RAPID BUILD**
Up to 30 mils.
- **EASY APPLICATION**
Easy to spray from HVLP guns.
Low porosity, fine smooth surface
- **COST SAVING**
Uses less sandpaper and reduces sanding labor by providing a buildable surface that sands quickly.
- **ADHESION**
To most epoxies and substrates other than metal.
- **HDT**
Heat distortion temperature of 180°F (83°C)

COLOR OPTIONS

- Black (702-061)
- White (714-061)
- Grey (707-061)

DURATEC GREY EZ SANDING PRIMER

PRODUCT #707-061

DESCRIPTION

The Duratec EZ Sanding Primer is a favorite across the composites industry, as it is versatile enough to be used in a multitude of applications. This primer is an exceptionally easy-to-sand product that can be sprayed to a high build to eliminate defects. Sand and polish for a smooth, porosity-free surface.

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	1900-2500 cps
Thixotropic Index	6.5
Gel Time Sample based on a 100g mass catalyzed at 2% with MEKP	22 minutes +/- 2 min
Weight per gallon	11.8 lbs
Coverage per Gallon 20 mil thickness	80 ft ²

SAFETY & HANDLING

Duratec EZ Sanding 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 EZ Sanding 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 GREY EZ SANDING PRIMER

APPLICATION GUIDE | PRODUCT #707-061

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.

Prepare

Temperature should be at least 64°F for both the product and the part.

Duratec 707-061 contains functional fillers that will sink to the bottom of the container. Use either a paint shaker or a drill-mounted mixer. A paint stir stick will not be enough to mix up.

We recommend HVLP air-assisted spray guns. A 2.5 mm tip or larger is ideal for Duratec EZ Sanding Primer. Use 34-40 psi air pressure (at the gun). Adjust the needle and fan to provide the proper spray.

Catalyze

Catalyze the Duratec at 2.0 % by weight with a full strength MEKP, like Norox 925. Mix for one minute (when using a cup gun). Only catalyze what can be sprayed in 12 minutes.

Apply

Apply 5-7 mils and immediately apply another 5-7 mils in the opposite direction for a crosshatch effect.

You should spray multiple passes of 5-7 mils, allowing a minimum of two minutes to out-gas between coats. Up to 30 mils can be applied if the part requires aggressive post sanding.

Do not allow the EZ Sanding Primer to become tack-free between build coats. If the EZ Sanding Primer becomes tack-free, allow it to cure completely, sand with 180-220 grit, and recoat.

Duratec products leave the factory mixed for optimal performance. If thinning is required, we suggest the use of Duratec 39UCE Reducer. Duratec Reducer duplicates the solvents that the Primer contains and will quickly reduce viscosity. MEK Thinner is a reasonable alternative. Add as little thinner as possible.

WWW.DURATEC1.COM • 909-546-1160 • HAWKEYESALES@HAWKEYEIND.COM • PO BOX 415, BLOOMINGTON, CA 92316

Limited/ 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.

www.duratec1.com



DURATEC GREY EZ SANDING PRIMER

TROUBLESHOOTING | PRODUCT #707-061

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 60°F, 16°C.
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.
Orange Peel	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