



Hawkeye Industries



909-546-1160



hawkeyesales@hawkeyeind.com



PO BOX 415,  
BLOOMINGTON, CA 92316



WWW.HAWKEYEIND.COM

# FAST, EASY SOLUTION TO MOLD MARKS & PART REPAIR!

## FEATURES

- **QUICK CURE**

Catalyzes quickly with the included BPO crème hardener. Surfaces are ready to sand in 20-30 minutes.

- **HIGH BUILD**

The putty can be troweled to ¼ inch with each application. Build thicker by repeating application.

- **LOW POROSITY**

Strengthen repairs by reducing air porosity, allowing a solid, firm repair surface.

- **HIGH HEAT DISTORTION**

An HDT of 300°F (150°C) resists thermal breakdown due to exposure to high exothermic or mold temperatures.

- **QUALITY CONTROL**

Formulated to meet consistent standards, ensuring material for quality repairs each time.

## COLOR OPTIONS

- Black (1802-007)
- Untinted (1804-007)
- White (1814-007)

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# DURATEC ORANGE MOLD REPAIR PUTTY

PRODUCT #1808-007

## DESCRIPTION

The Duratec Vinyl Ester Putty is high quality, BPO catalyzed putty, for repairing polyester, vinyl ester, and most epoxy composites molds.

### PRODUCT PROPERTIES

All time calculations are based on temperatures of 77°F, 25°C.  
Lab tested with BPO creme hardener.

<b>Viscosity</b> As measured on a Brookfield Viscometer Model RVF, Spindle #5 at 2.5 rpm	350,000-400,000 cps
<b>Thixotropic Index</b>	n/a
<b>Gel Time</b> Sample catalyzed at 3% with BPO	3-8 minutes
<b>Weight per gallon</b>	10.7 lbs.

## SAFETY & HANDLING

Duratec Vinyl Ester Repair Putty is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Duratec Vinyl Ester Repair Putty 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.

**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. All claim requests must be made in writing and are subject to review, including storage temperature verification and retain evaluations. The exclusive remedy for all proven claims is replacement of our materials. In no event shall we be liable for special, incidental or consequential damages, including damages caused in transit (exworks terms). 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 and trademark rights are reserved.

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



# DURATEC ORANGE VINYL ESTER PUTTY

APPLICATION GUIDE | PRODUCT #1808-007

## 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

The repair surface should be clean, dry, and free from oil, grease, wax or other contaminants. The laminate must be structurally sound. If the laminate has a crack, a repair will eventually crack in the same place.

Ambient temperature should be excess of 68°F (20°C) to ensure a rapid and complete cure.

- (1) Sand repair area with 80 grit. Use an angle grinder to bevel the edge of the gelcoat, avoiding an abrupt edge. Grind down to the laminate to assure a great bond. \*For repairs larger than a dime, drill holes using a 1/8" drill bit into the laminate at an angle.
- (2) Wipe the area until it is free of dust using a clean rag. If working with epoxy, wipe away dust and then water wash surface. Allow to fully dry before proceeding.
- (3) Apply two layers of masking tape around the area that will be repaired.
- (4) Estimate the amount of Mold Repair Putty that will be required. Use a putty knife to move twice that amount (golf ball size) out of the container and onto cardboard or another smooth, sealed surface.

## Catalyze

Catalyze the Mold Repair Putty with the BPO catalyst provided. The recommended catalyst amount is 3% by weight - correct measurements ensure correct results. A one-inch line of catalyst for a golf ball size mound of putty is about right. (One-ounce of BPO is provided per quart of Duratec VE putty.)

Carefully stir the catalyst into the putty, avoid trapping air by folding the putty, moving the putty around the board until fully mixed.

## Fill & Finish

Fill the repair area, and use the masking tape as a guide to assure the repair is over-filled. Tool in multiple directions to make sure adhesion to all sides occurs.

Rough sand the repaired area as soon as possible, usually after about an hour. Leave the repair area slight mounded. (You can use a heat gun to warm the repair and assure a full cure around 120°F.

Sand the mold into the proper shape and surface.

Buff and polish using Aqua Buff compound and polish to bring shine to match mold gloss.

Apply release and return the mold to use.



# DURATEC ORANGE MOLD REPAIR PUTTY

TROUBLESHOOTING | PRODUCT #1808-007

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
<b>Cured putty not glossy</b>	Ambient temperature too cold.	Apply in 68°F (20°C) or warmer temperatures.
<b>Putty gels too quick</b>	Ambient temperature too warm.	Cool putty prior to catalyzing.
<b>Putty jelly-like</b>	Too much catalyst used.	Start with new putty and weigh out catalyst for accuracy. (3% by weight).
<b>Putty under cured</b>	BPO catalyst separated in the tube.	Massage BPO in tube prior to catalyzing.
	Too little catalyst used.	Start with new putty and weigh out catalyst for accuracy. (3% by weight).
	Ambient temperature too cold.	Apply in 68°F (20°C) or warmer temperatures.

Please see Liability/Warranty Statement on Page 1