FIBREGLAST®

1041

Fibre Glast Developments Corporation
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Duratec® Gray Surfacing Primer

Product Properties @ 77°F (25°C)	
Viscosity [1]	2,300-2,600 cps
Thixotropic Index	5
Gel Time [2]	16-24 Minutes
Coverage per Gallon @ 10 mils	125-160 ft^2
Coverage per Gallon @ 250 microns	12-15 m^2

1. As measured on a Brookfield Viscometer Model RVF, Spindle #1 at 25 rpm
2. Sample based on a 100 gram mass catalyzed at 2% with MEKP

Description

Perfect for Plug Finishing and Hiding Repairs. Duratec Surfacing Primer is the best choice for coating your plug or reconditioning your mold. Thin 5%-15% if necessary to a desired spray viscosity with #2306 Duratec Reducer after catalyzing. This surface primer can be applied as heavily as 45 mils to fill fabric pores on plugs or over repairs. With a higher heat distortion temperature, shrinkage is reduced. This further hides the repair. The gray primer sands easily and is then buffed to a Class 'A' mirror finish before building the mold. Requires 2% MEKP.

Why Use Duratec® Polyester Surfacing Primer:
Low Porosity: Provides a superfine leveling and filling system on a variety of substrates with superior release properties.

Adhesion to Most Epoxies: With heat distortion level of 201°F, 94°C, the primer also adheres to fiberglass, properly prepared metal, wood, MDF, brick, concrete and polyurethane foam.

Rapid Coat Buildup: To 40 mils, 1000 microns, wet on wet, on composite plugs and master mold surfaces; saves time and labor cost.

Easy Sanding: Also saves time and labor. The primer cures to a surface that polishes to a high gloss, when required.

Useage

For composite plugs and patterns and to prime a growing number of wood products-- including furniture, musical instruments and architectural applications.

Features

All in one coat! Duratec Polyester Surfacing Primer provides rapid coat buildup and a smooth surface with high gloss, when required.

Mixing Directions

Thoroughly mix this coating in can prior to use. Catalyze the coating with two percent (2%) by weight (approximately 20cc per quart) of MEKP. Warning: once catalyzed, Duratec coatings have limited pot lives. Do not catalyze more material than can be applied within 15 minutes at 77°F.

Surface Preparation:

• The surface should be clean, dry and free from oil, grease, was or other contaminants. Ambient temperature should be in excess of 60°F, or 16°C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77°F.

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• Starting from a correctly shaped and dimensionally stable plug, sand the entire surface with coarse sandpaper (80-120 grit), making sure to feather in puttied and filled areas. Wipe the sanded surface with a fast solvent and a clean white cloth or paper towel. Do not use a tack rag.
• Thoroughly stir Duratec Polyester Surfacing Primer in the can prior to catalyzing. Due to the rapid gel time of the primer, mix only the amount that can be applied within 16-18 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% with MEKP catalyst. Thin 5-15% if necessary to a desired spray viscosity with Duratec Thinner after catalyzation.

Application:
• 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 allow it to flash for 2 minutes. Follow with wet passes, slowly building to the desired thickness (10- 40 mils). Heavier thickness can be achieved by repeating the process immediately after gel has occurred. The primer will be dry to the touch in 1-4 hours, depending on the thickness and temperature, and ready to sand within 24 hours.
• Dry sand the entire surface with 80-120 grit sandpaper. Wipe the surface with fast solvent and a clean white cloth or paper towel. Do not use a tack rag. Wait overnight for the solvent to release and complete cure to develop. Again spray the primer as directed.
• If an even higher gloss is desired, blend the primer one-to-one with Duratec Polyester Clear Hi-Gloss Additive (#01040-B), thin with Duratec Thinner and spray to the desired thickness following equipment directions. Sand to a 600 or higher grit finish. (Note: For best results, after sanding, wait overnight before compounding and polishing the surface.)
• Remove scratches with #01102 Polishing Compound and polish with #01103 Polishing Compound for a glossy, swirl mark-free finish. No surface cleaning is necessary prior to the application of release materials.

Safety & Handling:
Duratec Gray Surfacing 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 Gray Surfacing 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. For more detailed instructions on handling, please see the MSDS sheet. 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.

Troubleshooting:

Problem	Causes	Solutions
Alligatoring	Not enough catalyst used	Check for proper catalyst levels
	Substrate/primer incompatibility/Chemical reaction	Check compatibility of surface of product
	Primer sprayed on cold surface	Expose surface to higher temp before spraying
Blisters	Substrate not cured, Gassing underneath primer	Complete cure putties, pastes, & compounds before applying
Cracking	Primer sprayed too thickly, too fast	Increase passes, add dwell time between coats
Cures Only On Surface, Not On Substrate	Primer sprayed on cold surface; primer cure inhibited	Increase # of passes, allow for "flash off" between passes
Dimples (Craters)	Film buildup too rapid, solven trapped in primer	Increase # of passes, allow for "flash off" between passes

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Troubleshooting Continued:

Problem	Causes	Solutions
Dry Over-spray	Acetone used as thinner	Use slower solvent such as a fast acrylic lacquer thinner
	Spray gun orifice too small	Use larger orifice
	Spray pressure too high	Set line pressure at 35-50 psi
Fisheyes	Substrate contaminated	Do not use a “tack rag”, slow evaporating solvent
	Contamination in the air	Spray in a clean area to minimize airbourne contaminants
	Contamination in the line	Spray with dry filtered air
Gelling in the Container	Outdated product	Replace with new product
Lifting or Peeling	Substrate not cured/primer incompatibility	Cure everything completely/check compatibility
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
	Viscosity too high	Thin with fast acrylic lacquer thinner
Pattern Surface Sticks to Mold	Improper release preparation	Follow manufacturer’s instructions with applying
	Primer not fully cured before compounding/polishing	Follow instructions aboce for pattern surfacing
	Excessive gel time for tooling gel coat	Follow manufacturer’s recommendations for gel time.