

Application Guide



Surfacing Application: *Clay Models and Pattern*

Use these Duratec® products to rapidly create a "Class A" finish on clay models and patterns:

Duratec Polyester Surfacing Primer (702-003 Black, 707-002 Gray, 714-002 White)

Duratec Polyester Hi-Gloss Coating (904-040 Clear, 602-021 Black, 608-021 Orange, 614-021 White)

Duratec Thinner (39LAC-1)

Application Conditions

The surface should be clean, dry and free from oil, grease, wax or other contaminants. Ambient temperatures should be in excess of 60°F, 16°C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77°F, 25°C.

Duratec Polyester Surfacing Primer Application

Surface and Product Preparation

After the clay has been properly steeled and slicked, spray a water-based adhesive onto the surface and allow it to dry for one hour. Follow by spraying a water-based primer (acrylic or latex)—available from a paint supply store—to a thickness of 20 mils, 500 microns, and, when cured, sand with 120 or 180 grit sandpaper.

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 15-20 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 percent with full strength mekP catalyst (20 cc per quart). Thin if necessary with Duratec Thinner or mek solvent after catalyzing.



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Application Procedures

Spray or brush Duratec Polyester Surfacing Primer onto the primed and sanded surface to the desired thickness, up to 40 mils, 1000 microns, wet on wet. Sand to a smooth finish. Wait overnight for a complete cure to develop prior to compounding and polishing.

Use Aqua-Buff® 1000-F Fast-Cut Compound and Aqua-Buff 2000 Compound/Polish to achieve a glossy, swirl mark-free finish.

Note: *Do not overheat the surface with the buffing pad, as excessive heat will soften and possibly distort the clay.*

Apply the desired mold release system.

Duratec Polyester Hi-Gloss Coating Application

For a glossier surface apply Duratec Polyester Hi-Gloss Coating over Duratec Polyester Surfacing Primer.

Surface and Product Preparation

Sand the primer with 180 grit sandpaper and wipe with a dry cloth. **Do not use a tack rag.** Catalyze Duratec Polyester Hi-Gloss Coating at 2 percent with full strength mekP catalyst (20 cc per quart) for a 15-20 minute pot life at 77°F, 25°C. Thin if necessary with Duratec Thinner or mexk solvent after catalyzing.

Application Procedures

Spray Duratec Polyester Hi-Gloss Coating up to 10 mils, 250 microns, thickness with multiple wet passes. Sand to a smooth finish. Wait overnight for a complete cure to develop prior to compounding and polishing.

Use Aqua-Buff 1000-F Fast-Cut Compound and Aqua-Buff 2000 Compound/Polish to achieve a glossy, swirl mark-free finish.

Note: *Do not over-heat the surface with the buffing pad, as excessive heat will*



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SAFETY PRECAUTIONS: Duratec Polyester Surfacing Primer, Hi-Gloss Coating and Thinner are extremely flammable. Do not apply near sparks, open flame or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Do not take internally.



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