

Application Guide



Topcoating Application: *Wood and MDF Surfaces*

Use these Duratec® products to topcoat wood and MDF substrates, including architectural woodwork, automotive dashboards, kitchen cabinetry, marine and aircraft interiors and musical instruments.

Duratec Polyester Sealer (823 Clear)

Duratec Polyurethane Wood Sealer (5604-001 Clear)

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

Duratec Polyester Hi-Gloss Topcoat (904-045 Clear)

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 Sealer Application

Surface and Product Preparation

Sand the surface with 120-220 grit sandpaper and wipe clean prior to applying the sealer. Thoroughly stir Duratec Polyester Sealer in the can prior to catalyzing. Due to the rapid gel time, mix only the amount that can be applied within 15-18 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 percent with full strength mekP catalyst (20 cc per quart).



Hawkeye Industries Inc.

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Application Procedures

Roll, brush or spray the sealer on; wipe away any excess using a clean white cloth or paper towel. **Do not use a tack rag.** The sealer will be ready to topcoat within 1-2 hours.

Note: *Do not sand prior to topcoating unless the time between sealing and topcoating is greater than 8 hours.*

Duratec Polyurethane Wood Sealer

Use Duratec Polyurethane Wood Sealer in place of Duratec Polyester Sealer when sealing difficult-to-bond-to woods, such as teak, mahogany, ebony, rosewood, etc.

Surface and Product Preparation

Sand the surface with 120-220 grit sandpaper and wipe clean prior to applying the sealer.

Note: *Duratec Polyurethane Wood Sealer is packaged for correct mixing proportions.*

Thoroughly stir both the A and B components of Duratec Polyurethane Wood Sealer prior to blending. Mix 66 parts of component A, by weight, with 33 parts of component B, by weight, for at least 2 minutes. Wait 5 minutes after mixing before applying to the wood substrate. The sealer has a 45 minute pot life at 77°F, 25°C.

Application Procedures

Spray or brush the sealer onto the substrate. Do not build any film thickness, as the sealer penetrates and seals the substrate surface. **Do not use a tack rag.** The sealer will be ready to topcoat or recoat within 60-120 minutes.

Note: Note: *There is no need to sand after sealing, unless the surface sits for eight hours or longer.*



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Duratec Polyester Hi-Gloss Coating Application

Duratec Polyester Hi-Gloss Coating is interchangeable with Duratec Hi-Gloss Topcoat.

Surface and Product Preparation

If the surface has been primed and/or color coated, it must be sanded to a 180-grit finish to ensure proper mechanical adhesion. Wipe with a clean cloth. **Do not use a tack rag.**

Thoroughly stir Duratec Polyester Hi-Gloss Coating in the can prior to catalyzing. Due to the rapid gel time of the topcoat, catalyze only what can be applied within 15-17 minutes. (Higher temperatures yield a shorter pot life and gel time, while lower temperatures will yield a longer pot life and gel time.) Catalyze at 2 percent with mekP catalyst (20 cc per quart). After catalyzation, thin 5-15 percent with Duratec Thinner or mek solvent if necessary to create a desired spray viscosity .

Application Procedures

Note: *Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.*

Spray the coating with a mist coat and allow to set for 2-5 minutes. Follow with multiple wet coats up to a total thickness of 10-15 mils, 250-375 microns. If additional coating is required to completely fill the wood grain, sand with 180-grit sandpaper and repeat the process. After curing, dry sand with 400-grit sandpaper, then allow to cure overnight prior to further sanding, compounding and polishing.

For best results sand to a 1000- to 1200- grit finish prior to compounding and polishing. Compound with Aqua-Buff 1000-F Fast-Cut Compound and polish with Aqua-Buff 2000 Compound/Polish. The result is a smooth, hard and glossy finish.

Note: *If the Duratec coating is to be topcoated to achieve a low-luster finish and/or to maximize UV resistance, sand the coating to a 320- or 400- grit finish and wait 8 hours or longer to topcoat.*



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Duratec Polyester Hi-Gloss Topcoat Application

Duratec Polyester Hi-Gloss Topcoat is interchangeable with Duratec Clear Hi-Gloss Coating.

Surface and Product Preparation

If the surface has been primed and/or color coated, it must be sanded to a 180-grit finish to ensure proper mechanical adhesion. Wipe with a clean cloth. **Do not use a tack rag.**

Thoroughly stir Duratec Polyester Clear Hi-Gloss Topcoat in the can prior to catalyzing. Due to the rapid gel time of the topcoat, catalyze only what can be applied within 15-17 minutes. (Higher temperatures yield a shorter pot life and gel time, while lower temperatures will yield a longer pot life and gel time.) Catalyze at 2 percent with mekP catalyst (20 cc per quart). Thin 5-15 percent if necessary to a desired spray viscosity with Duratec Thinner or mek solvent after catalyza-tion.

Application Procedures

Note: Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

Spray the topcoat with a mist coat and allow to set 2-5 minutes. Follow with multiple wet coats up to a total thickness of 10-15 mils, 250-375 microns. After curing, dry sand with 400-grit sandpaper, then allow to cure overnight prior to further sanding, compounding and polishing.

For best results sand to a 1000- to 1200-grit finish prior to compounding and polishing. Compound with Aqua-Buff 1000-F Fast-Cut Compound and polish with Aqua-Buff 2000 Compound/Polish. The result is a smooth, hard and glossy finish.



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finish and/or to maximize UV resistance, sand the topcoat to a 320- or 400- grit finish and wait 8 hours or longer to topcoat.

SAFETY PRECAUTIONS: Duratec Polyester Sealer, Polyurethane Wood Sealer, Hi-Gloss Coating, Clear Hi-Gloss Topcoat 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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