

Application Guide



Manufacturing Application: *Vacuum Forming Molds*

Use this Duratec® product to surface new vacuum forming molds, which are subject to high heat distortion:

Duratec Vinyl Ester Primer (1799-005 Gray, 1794-005 White)

Application Conditions

The pattern should be prepared with the proper release system. Ambient temperatures should be in excess of 60°F, 16°C to ensure a rapid and complete cure. Time

Product Preparation

Thoroughly stir Duratec Vinyl Ester Primer in the can. Catalyze at 2 percent with full strength mekP catalyst (20 cc per quart). At temperatures higher than 77°F, 25°C catalyze at no less than 1.5 percent.

Application Procedures

Spray three wet passes of Duratec Vinyl Ester Primer to a total film thickness of 12-15 mils, 300-375 microns. Allow the film to tack off and repeat the process. Total primer thickness should be 25-30 mils, 625-750 microns. Allow the total film thickness to tack off to the "thumbprint" stage (from 1-3 hours) prior to applying the first laminate.

When the mold is completed, demold from the pattern or master and prepare as a normally gelcoated mold.

Sand the surface to a 100-, 220- or 320-grit finish, as desired. Wait a minimum of 8 hours for the solvent release and complete cure to develop. After this, post-cure the mold for two hours at the temperature that the vacuum forming process will experience.

SAFETY PRECAUTIONS: Duratec Vinyl Ester Primer is 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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