

Application Guide



Repair Application: *Composite Molds*

Use this Duratec® product to repair polyester and vinyl ester molds:

Duratec Vinyl Ester Mold Repair Putty (1804-007 Untinted, 1802-007 Black)

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.

Surface and Product Preparation

Mask off the area to be repaired. This will minimize the surface that will be puttied. For maximum bonding, rout or sand all cracks and chips into the glass substrate.

Aggressively sand the adjoining surface with 80-grit sandpaper to bevel the edge of the routed area. It is important to eliminate the sharp repair line. Follow by wiping the area clean with solvent-soaked white cloth or paper towel. **Do not use a tack rag.**

Thoroughly stir Duratec Vinyl Ester Mold Repair Putty in the can using a spatula or putty knife prior to catalyzing. Due to the rapid gel time of the putty, catalyze only what can be applied in 6-8 minutes. Catalyze at 3 percent with BPO catalyst and mix thoroughly.

Note: Always massage or knead the BPO cream hardener (catalyst) as separation can occur in the tube

Application Procedures

To ensure proper adhesion, rub the catalyzed putty into the repair area and follow by applying with a spatula, putty knife or squeegee. Fill the void completely by working the putty in all directions. For exceptionally deep repairs, repeat the process to ensure a porosity-free surface. Slightly mound the putty to allow for shrinkage.



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When cured (20-30 minutes), sand the cured putty to a 600- or 800-grit finish. Compound, polish and prep as you would a new mold surface. No tooling gelcoat is required. The air-cured putty is the finished surface, and it will develop to a hardness and gloss equal to or greater than the original mold surface.

SAFETY PRECAUTIONS: Duratec Vinyl Ester Mold Putty 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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