



EQUIPMENT SELECTION

General Instructions for Spraying Duratec Products

Following are general instructions for spraying Duratec products with either pre-mixed (hot-potted) catalyst spray systems or with air-aspirated, air-assisted airless or airless plural component spray systems.

Pre-Mixed (Hot-Potted) Spray Systems

This chart provides information about Binks spray guns when used with Duratec polyester and vinyl ester primers and coatings when catalyst is premixed. Although Binks spray equipment is listed, the orifice sizes recommended are applicable for all manufacturers' spray equipment.

Binks Spray Equipment

GUN	TYPE	ORIFICE SIZE	FLUID NOZZLE	AIR CAP	NEEDLE	APPLICATION
18	Siphon	.070	66	66SD	65	Duratec Primers and Topcoats
	Pressure	.046	63B	63PB	63A	Duratec Topcoats
	Pressure	.070	66	63PB	65	Duratec Primers
	Pressure	.086	67	67PB	67	Duratec Primers
	Pressure	.110	68	68PB	68	Duratec Primers, Polyester Base Primer and Vinyl Ester Fairing Primer



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EQUIPMENT SELECTION

Binks Spray Equipment Cont'd

GUN	TYPE	ORIFICE SIZE	FLUID NOZ- ZLE	NOZ-	AIR CAP	NEEDLE	APPLICATION
95	Siphon	.070	66		66SD	665	Duratec Primers and Topcoats
	Pressure	.046	63B		63PB	663A	Duratec Topcoats
	Pressure	.070	66		63PB	665	Duratec Primers
	Pressure	.086	67		67PB	667	Duratec Primers
	Pressure	.110	68		68PB	668	Duratec Primers, Polyester Base Primer and Vinyl Ester Fairing Primer
95 G	Gravity	.070	2070		66SD	765	Duratec Primers and Topcoats
630	Siphon	.070	2070		66SD	59	Duratec Primers and Topcoats



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Binks Spray Equipment Cont'd

GUN	TYPE	ORIFICE SIZE	FLUID NOZ- ZLE	AIR CAP	NEEDLE	APPLICATION
MACH 1-PC	Pressure	.046	92	92PC	54-3941	Primer/Topcoat
	Pressure	.055	94	95PC	54-3941	Duratec Primers
	Pressure	.070	97	95PC	54-3941	Duratec Primers
MACH 1	Pressure	.046	92	95P	54-3941	Duratec Primers and Topcoats
	Pressure	.055	94	95P	54-3941	Duratec Primers
	Pressure	.070	97	95P	54-3941	Duratec Primers
MACH 1-G	Siphon	.055	94	95P	54-3941	Duratec Primers and Topcoats
	Siphon	.070	97	95P	54-3941	Duratec Primers



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EQUIPMENT SELECTION

Plural Component Systems

(Air Aspirated, Air-Assisted Airless, Airless)

General information

- For optimum performance modify the pump by changing to a 11:1 pump ratio (vs. 20:1) or lower and lowering line pressure.
- High-Volume/Low Pressure (HVLP) spray guns normally spray Duratec products with more "orange peel" than non-HVLP spray guns.
- When spraying Duratec Polyester Base Primer and Duratec Vinyl Ester Fairing Primer with plural component equipment, use only air-aspirated spray systems. (CAUTION: When sprayed with air-assisted or airless spray systems, the base primer's or fairing primer's glass microsphere fillers will fracture, collapse and dramatically alter the performance and sanding properties.
- Due to low viscosities, use air-assisted rather than airless equipment for Duratec Hi-Gloss Coatings.

Orifice recommendations for plural component systems

- Duratec Polyester Base Primer and Vinyl Ester Fairing Primers use .023 to .032 orifices.
- Duratec Polyester Surfacing Primer and EZ Sanding Primer and Duratec Vinyl Ester Primer use .018 to .023 orifices.
- Duratec Polyester and Vinyl Ester Hi-Gloss Coating use .015 to .018 orifices.

The tables on the next two pages provide a sampling of tip sizes for various plural component systems.



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EQUIPMENT SELECTION

Binks LEL Gelcoat Spray Gun

Tip Size

118-81820 = 20 Degree Fan .018 Orifice

118-82424 = 24 Degree Fan .024 Orifice

Glas-Craft Equipment

Tip Size

LPA-111540 = 40 Degree Fan .015 Orifice

LPA-11-1840 = 40 Degree Fan .018 Orifice

Other Tip Sizes

2140, 2340, 1850, 2150,
2350, 2360

GS Equipment

Tip Size

4J = 40 Degree Fan .018 Orifice

4K = 40 Degree Fan .021 Orifice

4A = 40 Degree Fan .023 Orifice

4L = 40 Degree Fan .026 Orifice



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EQUIPMENT SELECTION

Magnum/Venus Equipment Gelcoat Air-Assist Nozzle

Tip Size

515 = 10" Fan @ 12" from surface being sprayed .015 Orifice

418 = 8" Fan @ 12" from surface being sprayed .018 Orifice

419 = 40 Degree Fan .019 Orifice

521 = 50 Degree Fan .021 Orifice

Other Tip Sizes

518, 521, 523, 615, 618,
621, 623

415, 421, 423, 515, 523,
615

Polycraft Equipment

Tip Size

1540 = 40 Degree Fan .015 Orifice

1840 = 40 Degree Fan .018 Orifice

Other Tip Sizes

2140, 2340, 1850, 2350,
2360

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