



TROUBLE SHOOTING GUIDE



General Information—Duratec® and Aqua-Buff® Products

Application guides for a variety of industrial applications are available for Duratec and Aqua-Buff products from Hawkeye Industries, your Hawkeye distributor or on line at www.duratec1.com. Using these application guides will decrease the need to trouble shoot. Although every effort has been made to identify problems related to Duratec and Aqua-Buff products, other problems may arise as new product uses are developed. We plan to revise the troubleshooting guide on an as-needed basis. As always, we welcome and encourage your feedback.

Product Information

Store Duratec products out of direct sunlight with containers completely closed with no exposure to air. To increase shelf life stability, store containers in a cool, dry area at a temperature lower than 70°F, 21°C.

Aqua-Buff products have a shelf life of approximately twelve months. The compounds may lose paste properties

after this time.

The Duratec batch identification system uses a seven-digit number. The first digit represents the year, and the second and third digits represent the month in which the product was manufactured. The final four digits are the sequential batch number for that year. Therefore, the batch number 502-0392 is for product manufactured in February 2005, and it is the 392nd batch of the year.

Duratec products have been lead-free since 1990. Duratec polyester products are not intended for below-waterline applications. High-filler loadings contribute to moisture absorption and can possibly cause blistering. Hawkeye Industries Inc. will not warrant the performance of its polyester products when they are used for below-waterline applications. Duratec vinyl ester products are, however, designed for all marine applications, both above and below the waterline. The vinyl ester priming and

(Continued on page 2)



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(Continued from page 1)

fairing products are excellent for use under most linear polyurethane and epoxy paint systems.

Application Information

For proper cure and adhesion, apply Duratec products in ambient temperatures above 60°F, 16°C and below 95°F, 35°C. If the ambient temperature is above 77°F, 25°C, cool the Duratec product to allow for the addition of a full 2 percent mekP catalyst.

Duratec products are highly reactive, and they require full catalyzation to properly cure. The recommended catalysts contain 1.5 percent or less of hydrogen peroxide and a minimum of 8.8-9.0 percent active oxygen. As a general rule, use catalysts that are formulated for polyester gel coats. Most Duratec applications require catalyzation at a full 2 percent of mekP catalyst. Never catalyze at less than 1.5 percent or more than 2.5 percent of mekP. Use only full strength mekP. Do not use 30 percent or low reactivity catalysts.

Duratec products are formulated to air cure; therefore, they must be exposed to air to fully cure. Do not add surfacing agents to or PVA over the products.

Do not add styrene monomer to Duratec products. Doing so will significantly alter the chemical properties of the product and its performance.

In addition, medium or slow flashing solvents should not be used with Duratec products. They remain in the primers and coatings, retarding the cure and adversely affecting gloss levels.

Also, do not use acetone as a thinner. Its rapid flash-off contributes to surface porosity and dry over-spray. If solvents are required, add Duratec Thinner (39LAC-1) or mek solvent after the products have been catalyzed. (This reduces foaming in the mixing containers.)

Always test Duratec products for compatibility with other paint and/or polymer systems.

(Continued on page 3)



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(Continued from page 2)

Spray Equipment Recommendations

A wide range of spray equipment can be used for many Duratec products.

Depending on the size of the area to be sprayed and application frequency, hot potted (catalyst is pre-mixed into the liquid), siphon, pressure pot, as well as air-atomized and air-assisted spray systems are suitable.

Duratec primers can be sprayed with most gel coat spray equipment. Hi-gloss coatings require a smaller air cap, fluid nozzle and needle arrangement.

Conversely, both product categories are too viscous and have a solids content too high to be sprayed through equipment used for lacquers and urethane paints.

Contact Hawkeye Industries to discuss specific equipment systems and spray gun setups.

[Home Page](#) [Product List](#) [Equipment Guide](#)

[Contents/Trouble Shooting Guide](#)



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