



# TROUBLE SHOOTING GUIDE



## Duratec® Vinyl Ester Primer

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

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
"Alligatoring"	Not enough catalyst used.	Check for proper catalyst levels.
	Substrate/primer incompatibility, chemical reaction.	Check compatibility of surfaces and products.
	Primer sprayed on cold surface.	Expose surface to higher temperature before spraying when ambient temperature is below 60°F, 16°C.
Blisters	Substrate not cured, gassing underneath primer.	Completely cure putties, pastes and compounds before applying primer.
Cracking	Primer sprayed too thickly, too fast.	Increase the number of passes with less product per pass, adding flash time between coats. For exceptionally thick buildup, allow for gel to occur before spraying further.
	Fillers added to product to make putty.	Do not add fillers to the standard vinyl ester primer. Use Duratec Vinyl Ester Fairing Putty (1810-013).
Cure and gel time extremely long.	Primer sensitive to cold temperatures.	Expose primer and surfaces to higher temperatures before spraying when ambient temperature is below 60°F, 16°C.
Curing occurs on surface, but not on substrate interface	Primer sprayed on cold surface; primer cure inhibited.	Expose substrate surface to higher temperature before spraying when ambient temperature is below 60°F, 16°C.
	Primer incompatible with substrate.	Test substrate and primer for compatibility.



### Hawkeye Industries Inc.

P O Box 415 Bloomington, CA 92316

Tel 909-546-1160; Toll Free 800-977-0060; Fax: 909-546-1161

Email [productinfo@duratec1.com](mailto:productinfo@duratec1.com) Web [www.duratec1.com](http://www.duratec1.com)



# TROUBLE SHOOTING GUIDE



## Duratec® Vinyl Ester Primer

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

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
Dry over-spray	Acetone used as a thinner.	Use slower solvent such as mek or Duratec Thinner.
	Spray pressure too high.	Set line pressure at 35-50 psi.
	Spray gun orifice too small.	Use larger orifice.
Fisheyes	Substrate contaminated.	Do not use a "tack rag", slow evaporating solvent or solvent soluble or colored rags or paper to wipe the substrate surface.
	Contamination in the air.	Spray in a clean area to minimize airborne dust, water, waxes and/or silicones.
	Contamination in the air line.	Spray with dry, filtered air.
Gelling in the container	Outdated product.	Replace with new primer. Rotate products to use older primers first.
Lifting or peeling	Substrate not cured or substrate and primer incompatible.	Completely cure putties, pastes and compounds before applying primer. Check compatibility of surfaces and products.
Orange peel	Spray equipment set up incorrectly.	Follow the instructions for equipment setup.
	Spray pressure incorrect.	Set pressure at 35-50 psi.
	Pot pressure incorrect.	Set pot pressure at 10-12 psi.
	Viscosity too high.	Thin with Duratec Thinner or mek solvent.





# TROUBLE SHOOTING GUIDE



## Duratec® Vinyl Ester Primer

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

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
Pinholes	Substrate porosity.	Fill porous areas with product using squeegee, brush or roller before spraying.
Porosity	Spray pressure too high. Spray orifice too small. Acetone used as thinner.	Reduce pressure to 35-50 psi. Use larger orifice. Use slower solvent such as mek or Duratec Thinner.
Pot life too short due to high ambient temperature.	Primer is sensitive to high temperatures.	Cool primer prior to application.
Topcoats or bottom paint systems fail to adhere to primer.	Primer not cured. Primer not compatible.	Allow primer to “breathe” after sanding. Test for compatibility between primer and topcoats and bottom paints.
Tooling application—Surface not hard or glossy	Primer not allowed to “breathe” after sanding. Surface wet sanded when undercured; primer absorbed water. Ambient temperatures less than 60°F, 16°C when primer was sprayed. Low reactivity catalyst used.	Allow time for solvents to escape before compounding and polishing. Dry sand with initial sanding step. Wet sand after “breathing” occurs. Expose surface to higher temperature before spraying. Do not use 30 percent mekP catalyst or a catalyst with less than 8.8 percent active oxygen.

[Home Page](#) [Product Line Card](#) [Contents/Trouble Shooting Guide](#)



### Hawkeye Industries Inc.

P O Box 415 Bloomington, CA 92316

Tel 909-546-1160; Toll Free 800-977-0060; Fax: 909-546-1161

Email [productinfo@duratec1.com](mailto:productinfo@duratec1.com) Web [www.duratec1.com](http://www.duratec1.com)

Revised 3-07-06