

A Quality Product from Hawkeye Industries, Inc.

# Duratec® Polyester **Hi-Gloss Coating**



**Special blends of polyester polymers that produce a tack-free, non-wax high gloss finish-with chemical resistance, high impact strength and excellent color and light stability.**

## **Usage**

For composite plugs and patterns and wood product surfaces. Used by boat manufacturers as well as manufacturers of aircraft interiors, architectural woodwork, automotive wood dashboards, furniture and musical instruments. Also used for gelcoat repair applications and for upgrading tooling gelcoats.

## **Features:**

*You'll get a superior finish and save time and labor with Duratec Polyester Hi-Gloss Coating.*

**Here's why you should choose Duratec Polyester Hi-Gloss Coating:**

**Easy to apply:** *The coatings build quickly and spray easily. You'll save time and labor.*

**High gloss:** *sand and polish to a non-wax, tack free high gloss finish.*

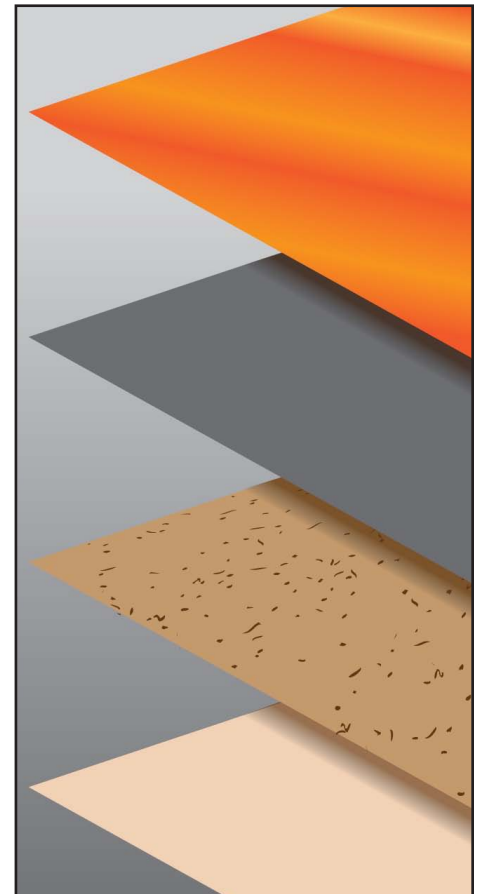
**Stability:** *The coatings offer clarity (clear), color (pigmented) and light stability.*

**Superior Finish:** *The coatings produce a hard, chemical-resistant finish.*

**Scratch Resistant:** *For a durable finish in high use areas.*

## **Duratec Polyester Hi-Gloss Coating**

<b>904-040</b>	.....	<b>Clear</b>
<b>602-021</b>	.....	<b>Black</b>
<b>608-021</b>	.....	<b>Orange</b>
<b>614-021</b>	.....	<b>White</b>
<b>604-041</b>	.....	<b>Unpigmented</b>



## **Hawkeye Industries**

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904-040 Clear, 602-021 Black, 608-021 Orange  
614-021 White, 604-041 Un-Pigmented

Data Sheet  
Continued

# Duratec® Polyester Hi-Gloss Coating

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Product Properties: Measured at 77°F, 25°C, at the time of manufacture.

Viscosity as measured on a Brookfield Visometer

Model RVF, Spindle- #2 at 20rpm

Clear .....420-480 cps  
Pigmented .....450-700 cps  
Un-pigmented .....450 cps

Thixotropic

Clear ..... 2.5  
Pigmented ..... 3  
Un-pigmented ..... 3

Gel Time: Sample based upon a 100 g mass,  
catalyzed at 2% with mekP

Clear .....8-11 min  
Pigmented ..... 15-17 min  
Un-pigmented .....15-17 min

Time to peak exotherm ..... 20-25 min

Peak exotherm ..... 260°F, 128°C

Weight per gallon

Clear .....8.4 lb., 3.41 kg  
Pigmented .....8.5 lb. - 10.5 lb., 3.9 kg - 4.8 kg  
Un-pigmented ..... 9.01 lb.

Coverage per Gallon:

110 ft<sup>2</sup> - 115 ft<sup>2</sup> @ 10 mil thickness. | 10.2 - 10.7 m<sup>2</sup> @ 250 micron thickness.  
220 ft<sup>2</sup> - 230 ft<sup>2</sup> @ 5 mil thickness. | 20.4 - 21.4 m<sup>2</sup> @ 125 micron thickness.

### Use instructions:

The use of Duratec 823A Polyester Sealer or Duratec 5604-001 Polyurethane Sealer (for oily woods or over an alcohol stain) is recommended.

1. Thoroughly mix the Duratec Clear Polyester Topcoat.
2. Measure out an amount that can be sprayed in 15 minutes...usually about a quart with a HVLP spray gun.
3. Assure an appropriate spray gun is available and clean. Dry compressed air is recommended for air-assisted spray guns. A 1.4 to 1.8 mm tip is ideal. About 34-40 pounds of break-up air is usually required. Use the lowest pressures possible to minimize orange peel.
4. Catalyze with 2% MEKP Catalyst like Norox 925. About 20 CC/quart is required. Stir thoroughly.
5. Start with a light pass over the wood or MDF. Wait two minutes, then make a build coat of 4-6 mils. Wait two minutes. Continue to make build passes, with two minute waits, until about 20 mils of Duratec is on the surface.
6. Allow to cure at room temperature for at least one hour. At that time, cure can be accelerated by putting the part in a warm room at up to 120° F.
7. Once the surface is fully cured, sand to removed any texture or orange peel. Use as fine a grit of paper as is reasonable.
  - a. It may be necessary to make additional build coats to eliminate all surface profile and grain texture. Allow at least eight hours after sanding before re-coating.
8. Continue sanding with progressively finer grits up to 1000 grit paper. Assure that at least 8 hours passes between the beginning of sanding to the beginning of polishing.
9. Compound and polish to a high gloss. We recommend Aqua Buff 1000W or 1000F, followed by Aqua Buff 2000

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