

A Quality Product from Hawkeye Industries, Inc.



Duratec® Polyester **EZ Sanding Primer**

An exceptionally easy-to-sand primer, that can be polished to a smooth, porosity-free surface.

Uses: for surfacing patterns for composite molds, and where an easy sanding, high build primer is required.. Apply over tooling board, MDF, brick, concrete, plaster and clay.

Features:

Builds rapidly and provides a surface that sands quickly.

- Use less sandpaper
- Reduce sanding labor

Easy to spray from HVLP guns. Low porosity, fine smooth surface.

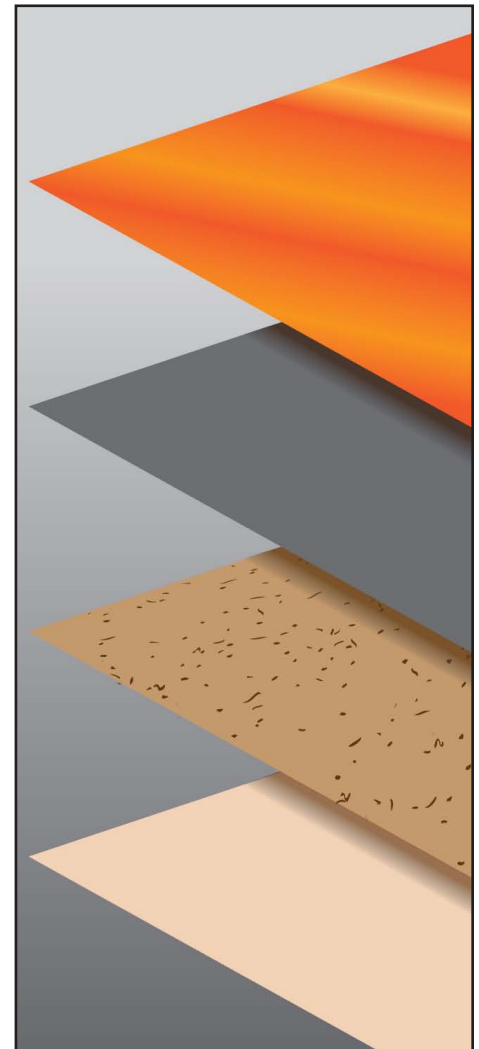
- Start sanding with a fine grit, reduce dust and film loss.
- Build up to 30 mils.

Adhesion to most epoxies.

- Heat distortion temperature of 83° C, 180° F
- Not recommended for use on CNC patterns over a low (less than 120° F) HDT tooling putty.

707-061 Lt. Grey

Use Instructions - Page 2



Hawkeye Industries

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Limited/ warranty statement: Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, expressed or implied, including any warranty of merchantability or fitness, nor is protection from any law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.



Product Properties: All time calculations are based on temperatures of 77°F, 25°C

As measured on a Brookfield Viscometer Model RVF, Spindle #2 at 20 rpm.....	1900-2500 cps
Thixotropic.....	6.5
Gel Time: Sample based on a 100 g mass catalyzed at 2 percent with mekP.....	22 min +/- 2 min
Weight per Gallon.....	11.8 lb., 5.36 kg
Coverage per Gallon:	
10 mil thickness (wet-dry)	110-115 ft ²
250 micron thickness (wet-dry)	10.2-10.7 m ²

USE INSTRUCTIONS:

Below you will find general use instructions for this product. If you have specific questions regarding your application please contact our office and speak with a Technical Sales Rep (909) 546-1160 or look for an application guide online: www.duratec1.com

Assure that the work area is at least 60°F, and that the Duratec and the part that will be sprayed are at least 60° F. Compressed air must be free of water.

1. Duratec 707-061 contains functional fillers that will sink to the bottom of the container. Use either a paint shaker or a drill-mounted mixer. A paint stir stick will not be enough to mix up.
2. We recommend HVLP air-assisted spray guns. A 2.5 mm tip or larger is ideal for Duratec EZ Sanding Primer. Use 34-40 psi air pressure (at the gun). Adjust the needle and fan to provide the proper spray.
3. Catalyze the Duratec at 2.0 % by weight with a full strength MEKP, like Norox 925. Mix for one minute (when using a cup gun). Only catalyze what can be sprayed in 12 minutes.
4. Apply 5-7 mils and immediately apply another 5-7 mils in the opposite direction for a crosshatch effect. You should spray three coats of 5-7 mils, allowing a minimum of two minutes to out-gas between coats. Up to 22 mils can be applied if the part requires aggressive post sanding.
5. Do not allow the EZ Sanding Primer to become tack-free between build coats. If the EZ Sanding Primer becomes tack-free, allow it to cure completely, sand with 180 grit, and recoat.

Duratec products leave the factory mixed for optimal performance. Always use the correct application tools before changing the formula. If thinning is required we suggest the use of Duratec 39LAC Thinner. Duratec Thinner duplicates the solvents that the VE Primer contains & will quick reduce viscosity. MEK Thinner is a reasonable alternative. Acetone or styrene is not recommended. Add as little thinner as possible

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