



**Fiberglass Services,
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- ◆ Epoxy
- ◆ Resin
- ◆ Gel Coat
- ◆ Mat
- ◆ Woven Roving
- ◆ Cloth & Tape
- ◆ Biaxial
- ◆ Coring Material
- ◆ Polyurethane Foam
- ◆ Aerosil
- ◆ Talc
- ◆ Pigments
- ◆ Webbing Solution
- ◆ Styrene
- ◆ Acetone
- ◆ Brushes/Rollers
- ◆ Tools

DURATEC SANDING PRIMER

A high quality polyester sanding primer that provides outstanding filling and leveling properties for many varied substrates. Builds rapidly and provides an easily sanded, low porosity, smooth surface.

Why you should choose Duratec Polyester Sanding Primer:

- ◆ Low Porosity-provides a super fine leveling and filling system on a variety of surfaces with superior release properties.
- ◆ Adhesion to most epoxies-with heat distortion level of 201°F, the primer also adheres to fiberglass, properly prepared metal, wood, MDF, brick, concrete and polyurethane foam.
- ◆ Rapid coat buildup-to 40 mils, (1000 microns) wet on wet, on composite plug and master mold surfaces; saves time and labor cost.
- ◆ Easy Sanding-saves time and effort. An exceptional primer for top coating with Duratec Surfacing Primers and Hi-Gloss Coatings, lacquers and polyurethane paints.

Application Guide for Duratec Sanding Primer

PLUG SURFACING

- 1) Surface should be clean, dry and free from grease or wax. The ambient temperature should be above 60°F for a good adhesion and product cure. Starting from a correctly-shaped and dimensionally stable plug, sand the entire surface with a coarse sandpaper (60-120 grit) making sure to feather in puttied and filled areas. Wipe the sanded surface with a fast solvent and a clean white cloth or paper towel. DO NOT USE A TACK RAG.
- 2) Thoroughly stir the DURATEC SANDING PRIMER in the can and thin (10-40%) if necessary to a desired spray viscosity with mek solvent or a fast acrylic lacquer thinner. Catalyze at two percent (2%) with mek-p catalyst, approximately 20 cc per quart. Due to the rapid gel time of the product, mix only what can be sprayed with in 15-20 minutes.
- 3) Apply a "tack coat" to the entire surface and allow it to flash for 2 minutes. Follow with wet passes, slowly building to the desired thickness (10-40 mils) Heavier thicknesses can be achieved by repeating the process immediately after gel has occurred. The DURATEC SANDING PRIMER will be dry to the touch in 1-4 hours, depending upon the thickness and temperature, and ready to sand within 2-4 hours.

NOTE: Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

- 4) Dry sand the entire surface with 80-120 grit sandpaper. Wipe the surface with a fast solvent and a clean white cloth or paper towel. DO NOT USE A TACK RAG.
- 5) Spray the primer as in Steps 2-3. If an even higher gloss is desired, blend the Primer 1:1 with the DURATEC HI-GLOSS ADDITIVE, thin with a fast acrylic-thinner or mek solvent and spray to the desired thickness following the equipment directions as described in the NOTE of Step 3. Sand to a 600 or higher grit finish.

To achieve the ultimate gloss, spray a topcoat of the DURATEC BLACK HI-GLOSS COATING over the sanded DURATEC SURFACING OR SANDING PRIMER (thin with a fast acrylic lacquer thinner or mek solvent if desired) and when cured, sand to a 600 or higher grit finish.

NOTE: To achieve the highest possible gloss: after sanding, wait overnight prior to compounding, polishing and prepping the surface.

- 6) Remove the scratches with AQUA-BUFF 1000 FAST CUT COMPOUND and polish with AQUA-BUFF 2000 COMPOUND/POLISH for a glossy, swirl mark-free finish. No surface cleaning is necessary prior to the application of release materials.

PRODUCT PROPERTIES –All time calculations are based on temperatures of 77°F, 25°C
Viscosity-as measured on a Brookfield Viscometer Model RVF, spindle #5 at 2.5 rpm- 2500 cps
Thixotropic Index- 5
Gel Time-Sample based on a 100 g mass, catalyzed at 2% with mekP- 16-18 minutes
Weight per gallon- 10.90 lbs, 4.95 kg.
Volatile Organic Compounds - 199 g/L
Coverage per gallon- 110-115 sq. ft.