Hawkeye Industries

SunShield Clear Polyester Topcoat

APPLICATION GUIDE | 904-061

PRODUCTS

SunShield Clear Polyester Topcoat - 904-061

This guide is to serve as application instructions for the use of SunShield. For performance and product details, please see the 904-061 Technical Data Sheet available on our website.

Application Conditions

The surface should be clean, dry and free from oil, grease, wax or other contaminants.

Thoroughly stir products before use. A paint shaker or drill-mounted mixer is necessary - a stir stick is not enough.

Ambient temperatures should be in excess of 60°F, 16°C to ensure a rapid & complete cure. Time calculations are based on temps of 77°F

If thinning is required, add 5-10% Duratec 39UCE after catalyzing.

In-Mold: Prior to Laminating

1 Surface and Product Preparation

Ensure mold is clean and free of silicone. A silicone-free paste like TR 108 provides nice results. With an HVLP gun use a 1.8-2.2 tip with 35 pounds of pressure. A plural component tip selection should have a .015 to .018 orifice.

Catalyze the Duratec at 2.0% by weight with a full strength MEKP, like Norox 925. Mix for one minute. Only catalyze what can be sprayed In 12 minutes

Adjust fluid pressure and atomizing air to achieve an even pattern with fine droplets prior to spraying the mold.

PRO TIP

If using a semi-permanent mold release agent, also add a layer of paste wax to allow for surface tension across mold or consider our High Viscosity Sunshield 904-070.

2 Application process

The first pass should be a dust coat that sets up for two minutes before further application. The dust coat should be a light fog, not a continuous film.

Additional coats of 4-5 mils can be applied, again allowing a minimum of two minutes to out-gas. Twelve mils will provide a nice finish with UV protection. Up to 22 mils can be applied if the part requires aggressive post-sanding.

The coating needs to be tacky for each build coat to bond. Laminate Polyesters and Vinyl Esters when the Duratec has set up and does not transfer, but retains some tack. Cure time varies with temperature and
air flow.

For epoxy laminating systems a tack free surface is required. Increased heat up to 120° F will speed this process. Remember the adhesion comes from the epoxy. Test the bond between the Duratec and your epoxy blend to ensure good adhesion.

Topcoating Finished Parts

1 Surface and Product Preparation

Epoxy Laminate: water washing with clean water and a heavy duty scrub sponge.pad is necessary before and after sanding. It is not necessary to water wash polyester or vinyl ester laminates.

Abrade the entire surface with 180 grit, providing mechanical tooth. Remove dust and acetone-wipe the surface.

Catalyze, mix, and set-up gun as previously mentioned

2 Application process

The Duratec may need to be mechanically forced into severe porosity. The first 2-3 mil passes can be worked with a squeegee to fill in the holes.

Additional coats can be applied after two minutes and while the surface is still tacky.

The final spray should be sanded to allow for out-gassing and complete cure. Evaluate your surface to determine the finest grit possible to achieve the desired profile.

If re-coating the full cured Duratec is necessary, first sand with 180 grit.

Compounding and Buffing with Aqua Buff

1 Surface and Product Preparation

The tough, scratch resistant nature of the SunShield Topcoat means regular automotive compounds are not aggressive enough to remove sanding scratches.

2 Application process

Beginning with Aqua Buff 1000W remove the scratches, using a wool pad and water as your lubricant.

Exceptional final gloss will be achieved with Aqua Buff 2000 with a cotton/wool blend pad. Again, use a mist bottle to lubricate and cool the part as you polish. Finish with a foam pad for outstanding results.

Check the material safety data sheet of your product for recommendations on protective equipment. The Duratec products are extremely flammable. Each product has a corrosponding Technical Data Sheet available on our website, which includes a troubleshooting guide, general use instructions and other helpful information.

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