Hawkeye Industries

TOPCOATING WOOD & VENEER

APPLICATION GUIDE

PRODUCTS

Duratec Crystal Clear Sealer - 823
Duratec Clear Sealer Kit - 5604-002
Duratec Hi-Gloss Topcoat - 904-046
Sunshield Polyester Topcoat - 904-061
Duratec Hi-Gloss Coatings - Clear - 904-040, White - 614-021, Black - 602-021, Orange - 608-021

This guide is to serve as application instructions for topcoating wood and veneers. Use the Duratec® products listed to topcoat wood and MDF substrates, including architectural woodwork, automotive dashboards, kitchen cabinetry, marine interiors and musical instruments.

Application Conditions

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

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

Ambient temperatures should be in excess of 64°F, 18°C to ensure a rapid & complete cure. Time calculations are based on temps of 77°F

Duratec Crystal Clear Sealer Application # 823

Surface and Product Preparation

Sand the surface with 120-220 grit sandpaper and wipe clean prior to applying the sealer.
Thoroughly stir Duratec Polyester Sealer in the can prior to catalyzing.
Due to the rapid gel time, mix only the amount that can be applied within 15-18 minutes. Note that higher temperatures will yield a shorter pot life and gel time, while lower temperatures yield a longer pot life and gel time.
Catalyze with full strength MEKP catalyst at 2%, like Norox 925.

Application process

Roll, brush or spray the sealer on; wipe away any excess using a clean white cloth or paper towel. Do not use a tack rag. The sealer will be ready to topcoat within 1-2 hours.
Note: Do not sand prior to topcoating unless the time between sealing and topcoating is greater than 8 hours.

Clear Sealer Kit Application # 5604-002

Use Duratec Polyurethane Wood Sealer in place of Duratec Polyester Sealer when sealing difficult-to-bond-to woods, such as teak, mahogany, ebony, rosewood, etc.

Surface and Product Preparation

Sand the surface with 120-220 grit sandpaper and wipe clean prior to applying the sealer.
Note: Duratec Clear Sealer Kit is packaged for correct mixing proportions.

Clear Sealer Kit Application CONTINUED

Thoroughly stir both the A and B components of Duratec PolyurethaneWood Sealer prior to blending. Mix 66 parts of component A, by weight, with 33 parts of component B, by weight, for at least 2 minutes.Wait 5 minutes after mixing before applying to the wood substrate. The sealer has a 45 minute pot life at 77°F, 25°C.

Application process

Spray or brush the sealer onto the substrate. Do not build any film thickness, as the sealer penetrates and seals the substrate surface. Do not use a tack rag. The sealer will be ready to topcoat or recoat within 60-120 minutes.
Note: There is no need to sand after sealing, unless the surface sits for eight hours or longer.

Hi-Gloss Coating & Topcoat Application

 # 904-040 · # 614-021 · # 602-021 · # 608-021 · # 904-046

Which clear topcoat is right for you?

904-040 - Best used when you need a durable clear coating on non-UV exposed parts

904-046 - Pick this one when you need slightly more flex and sandability than 904-040, and don't mind a slight amber hue with your topcoat.

904-061 - A perfect choice for any clear parts or products where UV resistance is desirable.

Surface and Product Preparation

If the surface has been primed and/or color coated, it must be sanded to a 180-grit finish to ensure proper mechanical adhesion. Wipe with a clean cloth, do not use a tack rag.

Thoroughly stir Duratec Polyester Hi-Gloss Coating in the can prior to catalyzing. Due to the rapid gel time of the topcoat, catalyze only what can be applied within 15-17 minutes. (Higher temperatures yield a shorter pot life and gel time, while lower temperatures will yield a longer pot life and gel time.)

Catalyze at 2% with MEKP.

Thinning with Duratec Reducer (# 39UCE)
Most Duratec products can be sprayed without thinner. If thinner is necessary the best is Duratec Thinner 39UCE. The 39UCE has dry, urethane grade solvents that rapidly cut the viscosity of the primer or topcoat. Add one ounce per quart, up to three ounces, to reduce the viscosity and improve the spray fan. Most primers can be thinned with Methyl Ethyl Ketone Solvent (not MEKP Catalyst). MEK may cause cloudiness or porosity in a topcoat. Acetone or Lacquer thinners are not recommended.

Hi-Gloss Coating & Topcoat Application CONTINUED

2 Application process

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

Spray the coating with a mist coat and allow to set for 2-5 minutes. Follow with multiple wet coats up to a total thickness of 10-15 mils. If additional coating is required to completely fill the wood grain, sand with 180-grit sandpaper and repeat the process. After curing, dry sand with 400-grit sandpaper, then allow to cure overnight prior to further sanding, compounding and polishing.

For best results sand to a 1000- to 1200- grit finish prior to compounding and polishing. Compound with Aqua-Buff 1000-W and polish with Aqua-Buff 2000. The result is a smooth, hard and glossy finish.

Note: If the Duratec coating is to be topcoated to achieve a low-luster finish and/or to maximize UV resistance, sand the coating to a 320- or 400- grit finish and wait 8 hours or longer to topcoat.

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.

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.

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