

Technical Data Sheet

Durabuild Surface Primer

Application

- Primer for wood
- MDF
- PU Foam
- Metal
- Fibreglass tooling resurfacing

Properties

- Excellent adhesion to many surfaces
- Easily sanded
- Easily polished
- One coat application

Description

Durabuild Surface Primers a high-quality polyester surface primer that provides outstanding filling and levelling properties for many varied substrates. Excellent adhesion is achieved with fibreglass, metal, wood, MDF, brick, concrete and polyurethane foam. It offers a rapid coat build-up for plugs and master moulding surfacing; the easily sanded primer cures to a surface that buffs and polishes beautifully. Durabuild Surface Primer is excellent for fibreglass tooling resurfacing as it readily accepts Durabuild Pigmented Hi-Gloss Coatings.

Issue date: 12 Dec 2020 Ellsworth Adhesives Ltd

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Physical Data (Approx – values)

Property		
Viscosity	Brookfield Viscometer model RVF, spindle #5 @ 2.5 RPM @ 77°F (25°C)	13,500 cps
Viscosity	Spindle #5 @ 20 RPM @ 77°F (25°C)	2,700 cps
Thixotropic index		5
Gel Time		16 – 18 mins
Weight		4.95kg
Volatile Organic Compounds		199g/Litre
Coverage per 4.95kg		110-115 sq ft 10.2 – 10.7m ²

Processing

Surface should be clean, dry and free from grease or wax. The ambient temperature should be above 60°F (16°C) for a good adhesion and product cure. Starting from a correctly shaped and dimensionally stable plug, sand the entire surface with a coarse grit paper (60-120) 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).

Thoroughly stir the Durabuild Surface Primer in the tin and thin (from 10-40%) if necessary, to a desired spray viscosity with Durabuild Thinners (Methyl Ethyl Ketone (MEK)). Catalyse @ 2% with MEKP 50 (Butanox M50) catalyst (approx. 20cc per quart). Owing to the rapid gel time of the Durabuild Surface Primer, mix only what can be sprayed in 15-20 minutes.

Apply a “tack coat” to the entire surface and allow it to flash for 2 minutes. Follow with wet passes, slowing building to the desired thickness (10-40 mils). Heavier thicknesses can be achieved by repeating the process immediately after gel has occurred. The Durabuild Surface 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 pressure should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

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Dry sand the entire surface with 80-120 grit sandpaper. Wipe the surface with fast solvent and a clean white cloth or paper towel (do **not** use a tack rag).

Again, spray the Durabuild Surface Primer as in Steps 2-3. If an even higher gloss is desired, blend the Durabuild Primer 1:1 with Durabuild Crystal Clear Coating, thin with Durabuild Thinner 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.

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

Remove the scratches with Durabuild 1000 Fast Cut Compound and polish with Durabuild 2000 Compound & Polish for a glossy, swirl mark-free finish. No surface cleaning is necessary prior to the application of release materials.

Storage and Handling

See Material Safety Data Sheet

Flash point is outside Highly Flammable Liquids Regulations

Disposal Consideration

Product: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging: Completely emptied packaging can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

The technical specification and/or our technical advice, whether verbal, in writing or by trials is given in good faith and based on our test results obtained, but without warranty. It does not release the user from the obligation to test products supplied by us or any other third party as to the suitability for the intended application.

*A product Safety Data Sheet should be obtained from Ellsworth Adhesives Ltd prior to use.
ATTENTION: Before handling, read product information, Product Safety Data Sheets and container labels for safe use, and any physical and/or health hazard information.*

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