



- 909-546-1160
- hawkeyesales@hawkeyeind.com
- PO BOX 415, BLOOMINGTON, CA 92316
- WWW.HAWKEYEIND.COM

DURATEC CRYSTAL CLEAR SEALER

PRODUCT #823

DESCRIPTION

Our Duratec Crystal Clear Sealer is a low viscosity, rapid curing sealer that penetrates deeply allowing a solid anchor for lacquers, urethanes, polyesters, vinyl esters, and most epoxies to a variety of substrates.

SAVE TIME AND ADD QUALITY TO YOUR SURFACE PROFILE!

- EASY TO APPLY**
Spray, roll, or brush on as your application sees fit.
- RAPID CURING**
Surfaces are ready for topcoats in one to two hours - some even faster with no need to wait!
- DEEP PENETRATION**
Low viscosity allows sealer to penetrate surfaces for a more complete seal.
- HIGH COMPATIBILITY**
Versatile to work with your substrate and your choice in topcoat – lacquers, urethanes, polyesters, vinyl esters, and most epoxies.
- HDT of 180°F**

VINYL ESTER OPTION

- If your process requires a higher HDT consider our 1800 Vinyl Ester Sealer which offer an HDT of 280°F.

REVISED JANUARY 2023

PRODUCT PROPERTIES

All time calculations are based on temperatures of 77°F, 25°C
Lab tested with Norox 925 MEKP

Gel Time Sample based on a 100g mass catalyzed at 2% with MEKP	10-14 minutes
Weight per gallon	8.28 lbs/gal
Viscosity As measured on a Brookfield Viscometer Model RVF, Spindle #2 at 20 rpm	80 cps

SAFETY & HANDLING

Duratec Crystal Clear Sealer is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Duratec Crystal Clear Sealer contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating or drinking. All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures. For more detailed instructions on storage, please see the MSDS sheet.

ia iit warrant tate ent r rod ct are intended for a e to ind tria and co ercia c to er We re t that c to er in ect and te to r rod ct efore e and ati f the e e a to content and ita iit A cai re et t e ade in writin and are ect to re iew inc din tora e te erat re erification and retain e a ation The e c i e re ed for a ro en cai i re ace ent of o r ateria n no e ent ha we e ia e for ecia incidenta or con e entia da a e inc din da a e ca ed in tran it (e wor ter Nothin herein ha con tit te a warrant e re ed or i ied inc din an warrant of erchanta iit or fitne nor i rotection fro an aw or atent to e inferred A atent and trade ar ri ht



DURATEC CRYSTAL CLEAR SEALER

APPLICATION GUIDE | PRODUCT #823

PLEASE NOTE

The following use instructions are broad to address multiple applications. We recommend testing for product compatibility with your process. Please contact our Tech Team at (909) 546-1160 with any questions.

Prepare

Temperature should be at least 64°F. Low temperatures extend cure time.

Ensure the surface is clean and free of both chemical and environmental contaminants. If needed, slightly sand the surface with 120-220 grit and then wipe off surface with a clean (not tack) rag.

Thoroughly stir the Duratec Crystal Clear Sealer in the can prior to catalyzing.

Catalyze Crystal Clear Sealer with a full strength MEKP, like Norox 925. Catalyst ratio is 2% by weight. Due to the rapid gel time, mix only the amount that can be applied within 15-18 minutes.

NOTE: Higher temperatures yield a shorter pot life and gel time, while lower temperatures yield a longer pot life and gel time.

Apply Sealer

Roll, brush, or spray the sealer on. If spraying, apply using air-assisted or airless spray at lowest practical pressure. Wipe away any excess using a clean white cloth or paper towel. Do not use tack rag.

Topcoating (Urethane, Polyester, Vinyl Esters)

In general, sealer will be ready to topcoat within an hour or two, but may be ready faster depending on amount of sealer used and ambient temperature.

Sanding the sealer prior to topcoating is not necessary if the time between sealing and topcoating is less than eight hours. If more than 8 hours have passed, we suggest sanding with 180-200 to provide mechanical tooth for the bond.

Topcoating (Epoxy)

Adhesion between the Duratec Crystal Clear Sealer and epoxy is dependent on a mechanical bond with the epoxy rather than a chemical bond. We advocate for a cure time of at least eight hours. Abrade the surface with sandpaper (180-220) prior to topcoating with epoxy.



DURATEC CRYSTAL CLEAR SEALER

TROUBLESHOOTING | PRODUCT #823

Problem	Cause	Solution
Extended dry or cure rate	Substrate too dense or hard.	Add up to one quart of acetone per gallon of sealer.
Failure to totally cure	Incompatibility with substrate.	Replace 823 Sealer with Duratec Polyurethane Sealer (5604-002).
Spotty cure	Oily substrate.	Replace 823 Sealer with Duratec Polyurethane Sealer (5604-002).