



**POLYCRYL
CORPORATION**
**EarthGuard Resins
and Gel Coats**

Product
Data Sheet

**POLYCRYL
CORPORATION**
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PPS-A-765
EarthGuard Easy Sand
Polyester Primer Surfacer

EarthGuard Low Shrink Easy Sand Primer Surfacer is ideally suited as a surface coating for plugs and patterns for composite tooling. This Innovative Air Dry Tooling Primer Surfacer gives manufacturers the option to rapidly build superior plug surfaces due to its low shrink and ability to fill surface imperfections, along with easy sanding and simple buff back properties.

Product Data:

- Air Dry Chemistry Rapidly Forms a Tack Free Surface
- High Build Primer for Filling Rough Uneven Surfaces
- Excellent Sprayability with Minimal Shrinkage
- Rapid Cure Rate Allowing for Quick Sanding
- Buffs Out to a High Gloss

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Product Properties:

Weight/Gallon, Pounds	10.95
MEKP: Norox 925, Luperox DDM-9 or equivalent	2%
Gel Time: 100 g mass	16-20 minutes
Viscosity: LVT #4 spindle @ 6 rpm.	4000 - 6000 cps
Thixotropic Index	4-6

Product Use Instructions:

- Thoroughly mix the Polycryl Primer in the five gallon container with a proper agitator.
- The Polycryl Primer Surfacer is designed to be applied at a minimum temperature of 65°F, with the ambient temperature and the part temperature of 65°F or greater.
- The Primer Surfacer can be sprayed with airless, pressure pot, or suction gun/cup equipment.
- The spraying surface should be dry and clean and free from dirt, oil or other contaminants.
- Catalyze the Primer Surfacer with 2% MEKP Catalyst. Polycryl recommends either Norox 925 or Luperox DDM-9.
- Spray the Primer Surfacer with a fine and even mist to a thickness of 8-12 mils. Let the film breathe for several minutes before applying each additional 8-12 mil layer. Keep a wet line between layers.
- The Primer Surfacer should be tack free in approximately one hour under normal conditions. The surface should be ready for sanding approximately two hours after the last layer is sprayed. Sanding with 220-320 grit paper is a good starting point.
- Wait approximately 8-10 hours after cure before compounding and polishing.