



## Applying DuraTex® (Tips and Tricks)

Applying **DuraTex**® is quite easy, but a few tips need to be mentioned:

- Work in a well lighted area so you can easily see variations in surface textures.
- Make sure your work area will maintain a temperature of at least 65°F so the **DuraTex**® will cure properly once it's dry. The curing process takes a few days, so it's best to keep the coated cabinet in a warm area.
- Keep a container of clean water handy with a clean rag to wipe up any spills. Once the **DuraTex**® dries it is very difficult to remove.
- Keep the lid on the **DuraTex**® as much as possible so it doesn't start to skin over in the container. Dip your roller and set the lid on the pail between dips.
- Use drop cloths, old newspaper or other means to catch minor drips.
- Place the speaker cabinet face side down over some sort of object that will suspend the speaker cabinet above the bench or table on which you're working. This allows you to first coat the front, and then set it so you can complete coating the other 5 sides of the cabinet.

**DuraTex**® will adhere to all wood surfaces and will also adhere to painted surfaces provided the surfaces are sanded smooth and all gloss is removed from the substrate. **Fill holes in end grain or staple or nail holes with DRYWALL SPACKLE, or BONDO for best results.** Plastic wood fillers and many other types of filler may not dry or cure hard and will stay rubbery which will not allow adhesion for the **DuraTex**®. Surfaces that are sanded should be wiped to remove all sanding residue and should be clean and dry prior to application.

Mask off any hardware that may be already installed on the cabinet. It's best to remove hardware and reinstall it after the application of **DuraTex**®. **No primer is needed** on bare wood or on well sanded latex paint as **DuraTex**® is self-priming and has great adhesion.

If spraying the **DuraTex**® with a hopper gun, be sure to spray in an area with a drop cloth or plastic film on the surrounding walls and floor. Overspray will stick real well to whatever it hits so be sure the area is protected. A spray booth is not required as there are no dangerous fumes of solvents released, **but overspray will make a mess!**

**The Protective Coat:** The first coat of **DuraTex**® is the protective coat. This coat completely seals the surface against moisture so it is critical that this coat is uniform with no voids, light areas, pinholes or other imperfections. You can apply this first coat in a number of different ways including: **textured foam roller** (we have some that work great and cost \$5.50 to \$6.50 each), **a paint brush** (dabbing creates a texture finish), **a typical paint roller** with ¼" or 3/8" nap, **HVLP pressure pot sprayer**, a **hopper gun** or any other means by which a relatively smooth or "orange peel" surface can be accomplished. This first coat will be applied quite a bit heavier than typical latex paint. The first coat should be approximately 10 wet mils which would result with an application rate of 130 square feet per gallon (26 square feet per quart, or about 1 ounce per 1 square foot). If applying by roller, remember that a lot of material will be needed to fully wet out the roller so more will appear to be consumed when you consider the roller holds a lot.

Once the first coat of **DuraTex**® has been applied and has dried to the touch, carefully inspect to insure that the coating is uniform and that it completely covers the substrate. You can sand any grain raise to smooth the surface if desired. If any imperfections are found, reapply the **DuraTex**® to the affected area and allow it to thoroughly dry before proceeding.

**IF THE SPEAKER CABINETS ARE TO BE USED IN AN OUTDOOR SETTING**, apply a second full protective coat of **DuraTex®** to increase the protection level required for exterior service. Once this protective coat is applied satisfactorily and dry, you can apply the texture coat. No sanding is required between coats as **DuraTex®** has incredible adhesion.

**The Texture Coat:** Creating a texture with **DuraTex®** is simple. You can accomplish this with our **textured roller**, a **sea sponge faux finishing roller**, **HVLP pressure pot sprayer** or a **hopper gun**. This texture coat will be applied differently than the protective coat and it will be important for you to test the application method to be sure it will create the desired texture. Test this out on a piece of flat cardboard before you apply the **DuraTex®** to your cabinet. **OR... look at the DuraTex® Leather Look instructions online.**

The **texture roller** creates a nice even texture unless you apply the product too heavily in which case it will create a very aggressive texture. A medium coat rather than a heavy coat will give a better result, and you might find that rolling the texture out in a thinner layer will produce the texture design you like. Experiment to find an application technique that creates the texture you desire. Adding a small amount of water to the finish coat or base coat will result in a smoother surface texture.

The **HVLP pressure pot** should only be used by large volume cabinet producers. It is a very intricate system with a lot of very critical components that require a lot of maintenance and care in order to produce the best finish. Generally speaking, the pressure pot to spray the **DuraTex®** requires a 3/8" fluid line of not more than 10', a fluid pressure of around 30 psi and an air breakup pressure of 20 – 35 psi. Also, if you are using the HVLP pressure pot system, you **MUST** have a large needle, air cap and seat. We suggest the 1.7mm orifice or larger for your gun assembly.



When applying the protective coat with the **hopper gun**, use a high airflow and small amount of trigger pull to lightly spray on the **DuraTex®** and create an "Orange Peel" finish. By adjusting the air flow to a lower level and pulling the trigger more to release the **DuraTex®**, it spatters on the surface in small to large drops and you can add or reduce the air flow to create the size texture drops that you desire for your texture coat. Practice with a piece of flat cardboard and note the trigger pull, the air flow and the orifice size you used in accomplishing the texture so that you can reproduce the texture look you desire.

If you find that after the application of the texture coat, the texture is not quite what you wanted, you can apply the **DuraTex®** right over it to create the texture you want. Practice, practice and practice again so you are familiar with the technique required to product the texture look you desire.

**CURING:** **DuraTex®** will air dry and the drying time will depend on the amount of relative humidity in the area. On real dry days with low relative humidity, the product will dry within an hour. On hot muggy, rainy days with high relative humidity, it may take 2 or 3 hours to dry fully. Once the **DuraTex®** is dry, it begins to cure and it may feel a little soft the next day. Don't worry. **DuraTex®** will cure to a hard finish within a few days and it gets its maximum toughness after about 5 days. You can speed up this curing process by the addition of heat such as in a drying oven by raising the temperature to 140 degrees and drying the cabinet for about 30 minutes. That makes handling, stacking and packaging easier for rapid shipping. **Some customers load their cabs into the back of a van parked in the sun. Cheap oven!**

**CLEAN UP:** **DuraTex®** is waterbased and cleans up easily with water while the **DuraTex®** is still wet. If you want to remove dried material, use Xylene, Toluene or other strong solvent or paint stripper. Flush out your roller nap and tools immediately after using. Flush out the hopper gun or HVLP assembly, disassemble the air cap and make sure the inside of the hopper or gun is clean. If some of the product has dried, soak in solvents to loosen the product and flush thoroughly.

**IMPORTANT TIP FOR STORAGE:** If you finish the job and have a partial can of **DuraTex®** left over, just sprinkle a little water on the top of the remaining **DuraTex®** in the pail (a spritz bottle works good for this) then seal the can again. Make sure there is no wet or dried coating along the top edge of the pail or on the inside of the lid so it will seal well. That way, the dead air space in the bucket will have a little moisture to raise the humidity level and prevent skinning of the **DuraTex®**. Whenever you're ready to use the product again, stir the little bit of remaining water into the coating and you're ready to go. If you mistakenly put too much water on top of the **DuraTex®**, you can pour the water off and then stir the contents of the pail and reincorporate the slight amount of remaining water. Too much water stirred into the coating will reduce viscosity and you may not get the texture finish you desire. A bit of water will not hurt the product; it will just lower the viscosity slightly.

**Good luck with your project, and if you have any questions, please call us. We love discussing this great product.**