DuraFil Instructions

DuraFil is a surface filler designed to eliminate imperfections such as pits, dings and scratches in metal, wood and plastic. Start by degreasing with LCW TruStrip. Allow the parts to soak in TruStrip for a minute or two. Swish the parts in the TruStrip before removing. Allow the parts to air dry. The air dry will take only a few seconds and the TruStrip will not leave a residue. This is very important as the residual contaminates evaporate with the TruStrip and do not stay on the surface as with other degreasers. In a commercial application I recommend blasting with 60-120 grit aluminum oxide or sand. When blasting is complete blow the dust off the parts with shop air. Do not degrease after blasting. Shake the DuraFil container for three minutes after hearing the mixing ball. Mix DuraFil at a ratio of 12 parts DuraFil to 1 part Hardener. Mix no more than what can be used in 6-8 hours. Discard any mix that is left over at the end of 8 hours. Never put mixed DuraFil back in the original container. Apply with conventional air spray gun or a HVLP spray gun. Spray with smooth even passes. If needed for proper atomization, reduce slightly. Build the DuraFil on the areas to be repaired, i.e.: pits, scratches, etc. Stop intermittently to "flash off" the solvents by spraying air only with your spray gun onto the parts. Clean your spray gun thoroughly with DuraCoat Reducer. When dry, sand off the excess leaving a smooth, even surface ready for a final application of DuraCoat. DuraFil will be ready to sand in 4 hours. DuraFil dries to the touch in about 15 to 20 minutes. If needed, DuraFil can be oven cured at 110°F for 45 minutes to 1 hour. When sanding, 220-grit can be used to quickly knock down the DuraFil, finishing with 400-grit for a smooth surface ready for topcoat. Repeat this entire process if the surface was in very poor condition and some filling is still necessary. Finish by topcoating with DuraCoat. DuraFil has a shelf life of 12-18 months if kept in a cool, dark place. DuraFil Hardener has a shelf life of 6 months. Place the hardener container in a Zip-Loc bag and refrigerate. Call 800-830-6677 if you have any questions or if you are not getting excellent results.

Always wear protective gloves, eyewear, and an approved respirator. Be in a well-ventilated area. Read all warnings and first aid information, and read and follow all instructions when using any DuraCoat® products.