The only source for PROFESSIONAL grade
Spray-on Truck Bed lining and **Coatings** via
DIY systems

**** Call With Any Installation Questions ****

Spray Lining Support
1-855-545-4900 (option 3)
service@spray-lining.com

Using the spray-lining formula (SLPV family) for applications requiring high-spec strength

** WARNING: Mix only the amount you can apply within 15 minutes (use small quantities until you are familiar with our product to avoid premature curing) **

1-TRUCK BEDS 2 -WATERSCAPES 3-THICK FLOOR LINING 4-SHOCK BUMPERS 5-ANTI-STICK 6-STRESSED PARTS ***DISCLAIMER:**
"Standards" for shop flooring, pools, walkways; most exterior element protection require the range of 15 to 30 mils of a protective coating as polyurethanes, epoxies & acrylic formulas provide. These coating standards are more generalized than the specific or unique lining applications which the SLPV family is designed for.

** This document refers to 5 different formulas with similar characteristics- use common sense or call tech support for walk thru. Certain material will not stick to chrome & some plastics- test 1st before accepting unique jobs. **

BONDS TO CEMENT, METALS, MARINE, FARM, IND'L PARTS, AND FLOORS WITH EQUIPMENT, BY SPRAY GUN OR SPECIALIZED ROLLER….. BASIC DIRECTIONS – **** READ ENTIRELY FIRST ****

1. **PREP BY USING ANY METHOD TO CLEAN SURFACE'S PORES, DOUBLE CHECK INSURING NO DEBRIS (WAX/OILS) EXIST**
   - A- If paint, previous coating or corrosion is in poor condition, reasonable cleaning methods include muriatic acid etching, sand or soda blasting. Slight imperfections or rust spots are ok but best practice is to remove any/all loose particles.
   - B- Your mix will etch through auto paints & primers, so there's minimal scuffing requirement. If primer or paint are removed or its new metal, a 1:1 epoxy primer or high-quality poly primer is necessary.
   - C- Fiberglass, wood & certain cement may not require primer- call support.
   - **D-** Aluminums - as common 6061-7075 need scuffing & any high-grade adhesion promotor**.**
2. **Tape & cover** all remaining uncoated surfaces. **Green 3m 233+ masking tape** or similar product (bed liner and custom applications).
3. **CRITICAL - FIRST PREMIX** ALL **A's** together in one container and ALL **B's** together in another container **PRIOR TO Mixing them together!! USE ANY (2-16 OZ) CUPS FOR MEASURING RATIO.**
   - **A- VERY IMPORTANT!** When combining A to B: mix for 2 to 3 minutes *minimum* @ 70ºf average temperature; if under 60ºf mix longer, if over 80ºf, mix less (not less than 90 seconds).
   - **B- Helix drill mixer bit**  & drill mixing is required. Paddles or hand mixing often fails to mix properly.
4. **MIX 2 PARTS A TO 1 PART B. NOTE: CERTAIN PARTS OF A or B MAY BE MARKED AR or BR. THESE ARE STILL CONSIDERED A or B.**
5. ***ADD PART C POLY POWDER:*** add into mixed A & B where a wide range of 20% to 200% of the total liquid mixture is possible. Average bed liner is 1 part of mixed liquid (2a+1b) to 1 parts (by volume- not weight) of part c. For this usual low profile orange peel profile, part c is proportioned as 2 parts LP80 + 1 part LP40. Pure LP80 = smooth where pure LP40 = very coarse. More powder raises mil height & creates profile … excess powder will reduce adhesion & quality. The mix thickens. Use lacquer thinner only to thin – see 6.
6. ***VISCOSITY WARNING***: Extra powder requires adding lacquer thinner to flow thru gun & atomize. Viscosity range for correct atomization is 3,000 cps to 10,000 cps; like between molasses & honey at 70ºf… (Rice pudding is too thick).
   - a. ***POWDER TYPES:*** LP40 = orange peel or slip-proof. LP80 = smooth. Combinations create "medium" profiles … there are many are other types… call support for extreme slip-proofing (rough) or anti-stick (smooth) powders.
   - b. **NOTE:** More powder = faster drying; if too thick, use lacquer thinner to reduce viscosity… mixture's viscosity must flow into & spray thru gun's cavities & tip.
   - c. **TO ROLL**: Spray or pour to spread out within reason. Squeegee or roll to self-level.
7. If possible heating the surface speeds dry; with sun, heater, with heat lamp or by any reasonable means.
8. Certain mixes will get warm. Timing depends on ambient temp, mix ratio, amount of powder, mixing speed & how long mix is static in cup. Pot life is at 70ºf = 15-30 minutes & shorter depending on above acceleration methods used. Yet set time (once spread out) is much longer. So, to speed up set time without solidifying the mix in the pot, you'd get the mix into a temperature "range" where viscosity appears ok to flow well … (approx 80-120º f). Too thin & it runs or sags on verticals; too thick & it won't flow-- viscosity range is the main skill to control.. Practicing with tiny amount on a flat surface is smart.
9. Flat horizontal surfaces can be fully coated at once. But verticals will run if too much is applied before it gels. With heat, gel (dry-to-touch) time speeds up. On verticals, it is best to mist a fine layer- let it tack (10-12 minutes), re-mist- re-tack… until layer is over 40 mils… continue misting & layering as you

spray other zones . As tack coat thickens, more may be applied. That's because the more it dries, the more it will accelerate any new layers to dry. This includes future top coating with same formula months or years later.

Special application procedures

- **CLEAR BRA = BUG, CHIP, ROCK, SALT GUARD:** This became an alternative to paint protection films (DuPont™) s-l clear was used prior to ppf. Pure clear & color with no part c powder behaves differently than a bed liner. Part a-clear is different than a-color by s-l yet a-clear can be combined with all colors & b or br. Clear bra instructions are available. Call support.
- **TINTING GREY WITH CLEAR - TOPCOAT:** Mix (2-A-Clear to 1-B). Then add under 22% of SLC or any high-quality auto or marine grade, 1-part base coat to tint the clear. Base coat must be a urethane or polyurethane tint. Tint mixes into premixed 2 parts A-clear to 1-part B (no part C is used here). All colors are available. Minimal qty with no extra color is advised to tint clear as extra color reduces hardness.
- **FOR COMPLETE COLOR THROUGHOUT LINING: (NOT ADVISED)** 1st mix minimal Qty non-acrylic, non-latex auto or marine grade color into powder until powder matches color (no extra). 2nd pre-mix parts a-clear & b (ar or br) separate from the (now paste-like) color-powder. Now combine paste & liquid. Exact texture control requires trials - extra color isn't recommended to tint clear as it reduces hardness.
  **** COVER NON-LINED AREAS WITH WAXED PAPER, CARDBOARD OR TARP ****
- **ON VERTICALS (w/ bed liner), PRESS TAPE ON TIGHT TO PREVENT BLEEDING FOR CLEAN STRAIGHT LINES:** This is more important when taping "below" the lining (as under bed rails) as opposed to above or on the side of lining. Remove tape after it gels but prior to drying.
- **PRACTICE ON SAFE AREA FIRST BEFORE A SENSITIVE PARTS. REPEAT:** Mix rate (the A to B ratio), mixing speed, mixing time, standing time, ambient temperature, powder %, types and surface temperature all affect material's viscosity, cure time, flow, atomization, character & look.
- **LIQUID BINDER RATIO IS ALWAYS ANY 2 OR MORE PARTS OF A or AR to ANY 1 PART OF B or BR …** the amount of poly powder solids varies with different surface behavior requirements.
- **BASIC GUNS:** Hopper gun is, "constant air"… use 1st or 2nd smallest tip & a basic on/off switch between airline & gun. This prevents compressor tank from emptying quickly. 40 psi = low with minimal atomization- over 175 psi is ok for extreme atomization or distance. More psi & distance creates "tinier" orange peel texture…. Call support for hvhp, airless, pressure-pot, fusion & other equipment information.

→ **GUNS, EQUIP & ROLLERS:** Our hopper gun provides multiple settings for control- more control is with our hvhp or pressurized types- for more jobs or larger areas, high pressure or pump-driven equipment deliver more gpm with extreme control (see website)… these & all equipment can be no cost (loaners) with enough material ordered. Each gun has directions that include air pressure or airless pump speed, spray distance & general techniques… specialized yoke bracket rollers & squeegees are used on jobs where spraying isn't required. Pressurized roller systems are for specialized requirements.

→ **GUN AND EQUIPMENT PREP AND CLEANING:** **** IMPORTANT **** Lecithin is the best mold release material. The company called, Slide Inc., (www.slide.com) sells this. PAM cooking oil is similar & available in little spray cans. Spray Lecithin AFTER hopper or cup is attached to gun's reservoir so as never to slip off once attached. Excess affects SLC formula minimally, so spray sliding rod that passes through bushing into chamber since that cavity can get dried liner to become stuck. This must always move freely with return spring! If these are not available, any light oil or even silicone will suffice. Dried or semi-dried formula should simply wash out with hot water or pressure washing easily. Straight lacquer thinner with standard brush always removes SLC standard polies before they cure fully. Any cured materials require scraping or wire brush to remove.

WARNING - WHEN NOT TO USE TRUCK BED LINER MATERIALS: True bed lining formulas consist of polyureas or poly hybrids; as SLC basic is. In general these formulas are designed to be very thick, allowing long-term wear, shock or impact resistance, vibration-to-leakage control (as in icf waterproofing, pond lining or train cars), sub-terrain underlays including foundation crack prevention, dump truck anti-stick & similar high stress applications. **EXAMPLE – FLOOR COATINGS OR FIREPROOF COATINGS:** Unlike standard urethanes, polyurethanes, epoxies & acrylics which were designed to protect at under 8-20 mils (under 20/1000 inch thick), true "bed liner-grade" material should not be applied thin as a standard paint or coating. For standard flooring, a polyurea or hybrid may not last as long as hard epoxy or polyurethane at under 20 mils. Floor coating formulas were designed to withstand less shock but more spread out friction than a bedliner-like application might endure with adhesive & strength characteristics created specifically for flooring needs. Non-standard applications where s-l polyureas or hybrids are justified are excessive abusive conditions including chemical, atmospheric, high pressures, extreme friction, corrosive conditions that'll wear a standard coating height too rapidly to justify consistent repainting within short periods.

→ **TECH SUPPORT REQUIREMENTS:** First time applicators are advised to **MAKE APPOINTMENT** prior to our quick walk through. Ratios of A to B to C, the % of flexibility vs hardness, dry-to-touch and cure times can be adjusted easily to various jobs or conditions.