



The only source for PROFESSIONAL grade **Spray-on Truck Bed Lining and Coatings** via DIY systems
ADVISED: Call with Installation Questions
Important: 1st job(s) read all below ENTIRELY


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

INSTRUCTIONS: Spray-Lining & Coatings (SL, SLPV & SLC Lines) for applications requiring high strength

WARNING: Mix only small quantities until you are familiar with application technique

1-TRUCK BEDS 2-WATERSCAPE 3-MARINE/BOAT LINING 4-BUMPERS 5-WALKWAYS 6-STRESSED PARTS 7- SLIP-PROOF OR ANTI-STICK

BONDS TO METALS, CEMENT, WOODS, FIBERGLASS, (CERAMICS & PLASTICS with specific priming), BY SPRAY or SPECIALIZED ROLLER

- 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 removal is necessary. Minor imperfections or slight corrosion is ok but remove any/all loose particles.
 - B-** Mix etches through auto paints & primers, so scuffing, while best are not required. If primer or paint is removed or its new metal, primer is advised- 1:1 auto-marine or similar grade, epoxy primer or high-quality poly primer is necessary.
 - C-** Fiberglass, wood & certain cement usually won't require primer- call support.
 - D-** Aluminum - as common 6061-7075 need scuffing & any high-grade adhesion promotor. Hardened steel requires scuffing / priming.
- 2. Tape & cover remaining uncoated surfaces. Lime Green 3M 233+ masking tape is advised or wire tape for perfect lines (as bed liner over rails). See taping & cover directions.**
 - A-** PARTS MAY BE MARKED COLORS: A or AR, A-Clear, B or BR –All are referred to as, "A or B" here
 - B-** REQUIRED: MIX PART A-COLORS ALONE 1ST, PREFERABLY IN ORIGINAL CONTAINERS BEFORE COMBINING WITH B (BECAUSE A-COLORS SEPARATE IN CONTAINER)
 - C-** A-GRAY TONES (such as A-white or A-black mixed with A-gray or other various tones) ARE COMBINED BEFORE MIXING WITH B TO ENSURE PROPER COLOR CONSISTENCY
 - D-** VERY IMPORTANT: Add approx 5% Lacquer Thinner to Mixed A to B for 2 to 3 minutes @ 70°F average; if under 60°F mix longer, if over 80°F, mix less (not less than 75 seconds)
 - E-**  HELIX MIXING BIT & drill mixing is required. Paddles or hand mixing is not advised.
 - F-** REQUIRED: ON/OFF VALVE – in constant air sprayers... simple 3/8 thread on/off switch at air entry point.
 - G-** With Multiple Gun Tips: Start with Middle-Size tip 1st. Coat interior of gun with mold release agent- see GUN AND EQUIPMENT PREP below.
- 3. MIX PARTS A TO PART B LIQUIDS AS PER LABEL ON CONTAINERS: Varied mixtures create different slip-proof to anti-stick finishes**
AFTER A & B ARE MIXED ADD PART C POLY POWDER: Add into mixed A & B (a wide range of 20% to 200%) of total mixed liquid mixture is possible. Bed liner is advised as SAME or SIMILAR VOLUME of mixed liquid to SAME or SIMILAR VOLUME of part C (by volume-not weight). For a low profile orange peel texture, part C is proportioned as 2 parts LP80 + 1 part LP40. **NOTE:** Pure LP80 = smooth where pure LP40 = coarse. More part C raises mil height & thickens ... excess powder will reduce adhesion & quality. The mix thickens. Use lacquer thinner only – The "Green" type is not advised -thin to viscosity between honey (thicker) & molasses (thinner).
- 4. VISCOSITY WARNING:** Extra part C 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 70°F... (Pudding is too thick – Water is too thin).
 - a. **PART C TYPES:** LP40 = Coarse or slip-proof. LP80 = smooth. Combinations create "medium" profiles ... there even smoother (tinier) or rougher (bigger) types... call support for extreme slip-proofing (rough) or anti-stick (smooth) textures.
 - 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.
- 5. Heating the surface speeds cure; stagnant heat is best, use sun, heat lamp or by any reasonable means.**
- 6. Certain mixes will get warm. Timing depends on ambient temp, mix ratio, amount of part C, mixing speed & how long mix stands in cup. Pot life is at 70°F = 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 80-105° F). Too thin & it runs or sags on verticals; too thick & it won't flow-- viscosity range is the main skill of control. Practicing with tiny amount on a flat surface is smart.**



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- 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 mist- 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.
- SPRAY 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 on HOPPERS**** Lecithin is the best mold release material. Mold Release fluid is inexpensive & available at retail stores. PAM cooking oil is similar & may be used. Spray Lecithin AFTER hopper or cup is attached to gun's reservoir so as never to slip off once attached. Excess affects SL&C formula minimally. Lubricate sliding rod that passes through bushing into chamber since that cavity can become stuck. Rod must always move freely with return spring! 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 SL&C before they cure fully. Any cured materials require scraping or wire brush to remove.

Special application procedures

- CLEAR BRA = BUG, CHIP, ROCK, SALT GUARD:** As alternative to Paint Protection Films (DuPont™), SL&C Clear was used prior to PPF. Pure clear & color with no part C powder is thinner than polyurea bed liner. Part A-clear is different than A-Color yet A-Clear can be combined with all colors, B or BR. Specific Clear Bra instructions are available. Contact support.
- TINTING BASE LINING WITH TINTED CLEAR - TOPCOAT:** Mix (2-A-Clear to 1-B). Add under 22% of SL&C 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 diffuses into premixed 2A-Clear to 1B (no part C is used here). All UV colors are available. Minimal qty with no extra color is advised to tint clear as extra color reduces hardness.
- 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 prior to full dry.
- 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, % of part C, types and surface temperature all affect material's viscosity, cure time, flow, atomization, character & look.
- BASIC SPRAY GUNS, CARTRIDGE SYSTEMS, LOW TO HIGH PRESSURE PROPORTIONER:** 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.

TECH SUPPORT REQUIREMENTS:

First time applicators must MAKE APPOINTMENT prior to any application. You'll be given a clear 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.