



The only source for PROFESSIONAL grade  
Spray-on Truck Bed Lining and Coatings  
available through DIY kits

DB Linings SL&C Support  
1-855-545-4900 (option 3)  
service@spray-lining.com


**\*\* Call for Professional Facts on Installation Questions \*\***

## DETAILED INSTRUCTIONS: Spray-Lining & Coatings brand products

**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 METAL, CEMENT, WOOD, FIBERGLASS, (CERAMIC & PLASTIC with specific primers), BY SPRAY, BRUSH, or ROLLER

1. PREP BY USING ANY GENERAL METHOD TO CLEAN SURFACE, AND ENSURE NO RESIDUE, WAX, OR OILS REMAIN
  - 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 bonds to auto paints & primers, but light scuffing is advised. If primer or paint is removed or its new metal, primer is advised- SL&C auto-marine or similar grade, epoxy primer or high-quality poly primer is recommended for most surfaces.
  - C- Fiberglass, wood & most cement usually won't require primer- call support if in doubt.
  - D- Aluminum - as common 6061-7075 needs 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 PRODUCTS THOROUGHLY (INCLUDING CLEAR) FIRST, BEFORE COMBINING WITH B. (A PRODUCTS SEPARATE IN CONTAINER AND MUST BE RECOMBINED)
  - 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-  HELIX MIXING BIT & drill mixing is highly recommended. Paddles or hand mixing do not work as well.
  - E- RECOMMENDED: ON/OFF VALVE – in constant air sprayers... simple 3/8 thread on/off switch at air entry point.
  - F- With Multiple Gun Tips: Start with Middle-Size tip 1<sup>st</sup>. Coat interior of gun with mold release agent- see GUN AND EQUIPMENT PREP below.
3. MIX 2 PARTS A TO 1 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 150%) of total mixed liquid mixture is possible. Bed liner is generally 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. As the mix thickens, use lacquer thinner only – The “Green” type is not advised to thin. Recommended viscosity is 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 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 (smaller) or rougher (bigger) types... call support for extreme slip-proofing (rough) or anti-stick (smooth) textures.
  - b. **NOTE:** More powder = faster curing; 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. Excessive “bumps” can be lightly brushed down to create a “wavy” texture.
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 = 15-20 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 small amount (e.g. 1 cup A, ½ cup B, 1 cup C) on a flat surface is smart.

7.



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8. Flat horizontal surfaces can be fully coated at once. But verticals will run if too much is applied before it gels. With heat, gel (thumb print tacky) 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.
9. **SPRAY EQUIP & ROLLERS:** Our hopper gun provides multiple settings for control- more control is available with our hvlp gun for finer texture. Specialized yoke bracket rollers & squeegees are used on jobs where spraying isn't required.
10. **GUN AND EQUIPMENT PREP AND CLEANING:** **\*\* IMPORTANT on HOPPERS \*\*** Lecithin is the best mold release material. Mold Release fluid is inexpensive & available online through outlets such as Amazon. Original 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. Wipe any excess off (leaving only a light coating). Ensure the trigger and sliding rod are moving freely. If not, 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 if gun was coated previously. Straight lacquer thinner with standard brush removes SL&C coatings 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 can be used. Pure clear & color with no part C powder is thinner than bed liner with part C. 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 up to 1 part of SL&C or any high-quality auto or marine grade, single part paint to tint the clear. If using base coat, it 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 required 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 1<sup>st</sup> or 2<sup>nd</sup> 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 hvlp, 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