



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 GENERAL INSTRUCTIONS: SL&C 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. GENERAL NOTES:

- PARTS MAY BE MARKED COLORS: A or AR (e.g. "A-Clear", "AR-Clear"), B or BR –All are referred to as "A or B" here
- REQUIRED: STIR PART A PRODUCTS THOROUGHLY (INCLUDING CLEAR) FIRST, BEFORE COMBINING WITH B. (A PRODUCTS SEPARATE IN CONTAINER AND MUST BE RECOMBINED)
- 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



- HELIX MIXING BIT & drill mixing is highly recommended. Paddles or hand mixing do not work as well.
- RECOMMENDED: ON/OFF VALVE – in constant air sprayers... simple 3/8 thread on/off switch at air entry point.
- With Multiple Gun Tips: Start with Middle-Size tip 1st. Coating interior of gun with mold release agent can aid in cleanup, but is not required. - See GUN AND EQUIPMENT PREP on next page.

2. PREPARATION: PREP BY USING ANY GENERAL METHOD TO CLEAN SURFACE, AND ENSURE NO RESIDUE, WAX, OR OILS REMAIN

- 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.
- 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.
- Fiberglass, wood & most cement usually won't require primer- call support if in doubt.
- Aluminum - as common 6061-7075 needs scuffing & any high-grade adhesion promotor. Hardened steel requires scuffing / priming.
- 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. Remove tape prior to full dry, or run razor along tape edge to cut through bedliner.

3. MIXING RATIOS: MIX PARTS A AND B LIQUIDS AS PER LABEL ON CONTAINERS (MOST PRODUCTS ARE 2 A:1 B MIX, BUT MAY ALSO BE 1 A:1 B). Always refer to any specific instructions, or the instructions on the containers to ensure proper ratios.

4. POLY POWDER: After A & B are mixed, add part c poly powder to thicken. A wide range (20% to 150%) of total powder to liquid mixture is possible. Bed liner is generally advised as a 50:50 powder to liquid ratio (by volume- not weight). For truck beds, part C is proportioned as 2 parts LP80 + 1 part LP40. **NOTE:** Pure LP80 = smooth where pure LP40 = coarser. 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). Practice with common products such as drywall mud, or even pancake batter to learn how texture is achieved. ALWAYS CALL with questions to ensure your project is a success.

5. VISCOSITY ADVICE: Extra part C requires adding lacquer thinner to flow thru gun & atomize. Viscosity range for correct atomization is generally between molasses & honey at 75°F... (Pudding is too thick – Water is too thin). * Test your application FIRST *

- PART C TYPES: LP40 = Coarse or slip-proof. LP80 = smooth. Combinations create "medium" profiles ... there even smoother (finer) or rougher (coarser) types... call support for extreme slip-proofing (rough) or anti-stick (smooth) textures.
- NOTE:** More powder = faster curing and coarser texture. If too thick, use lacquer thinner to reduce viscosity... mixture's viscosity must flow into & spray thru gun's cavities & tip. Too thin & it runs or sags on verticals; too thick & it won't flow.
- 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.

6. POT LIFE: Once A and B are combined; the product will start to warm in mixing container or gun. Pot Life (amount of time you have to apply) depends on product temperature, surface temp, mix ratio, amount of part C, and time spent mixing. Pot life when the initial product temperature is 75°F = 15-20 minutes with 50/50 powder/liquid ratio. **** Leaving in container longer than 20 minutes can result in premature product flashing: causing immediate hardening due to rapid heat buildup. ****



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7. **CURE TIME:** Once applied to the surface, the product will not be able to continue to develop heat, so actual cure time is much longer than if left in the mixing container. General guidelines before applying second coats, or final texture coat is 2-3 hours for spray application, and approximately 4 hours if rolling additional coat. Heating the surface speeds cure; stagnant heat is best, use sun, heat lamp or by any reasonable means.
8. **TEXTURE CONTROL:** Practicing with small amount (e.g. 1 cup A, ½ cup B, 1 cup C) on a flat surface is always advised. As mentioned, use commonly available products to practice first if unsure about the process. To achieve any texture, you must first let the previous coat become cured to at least “thumbprint tacky” (soft, but not coming off on your finger) stage. Otherwise, the previous coat will self-level the intended texture coat. The texture coat is done by increasing the spray distance, lowering air pressure, increasing the viscosity, or a combination of the above. Once a light pass over the surface area is complete, you must stop and wait for it to become thumbprint tacky, or additional passes will also self-level. Think of raindrops on a windshield... At first, they are droplets, as more occur, they connect and become a sheet of water. Also... If more texture is desired, remember that the same viscosity next coat will tend to bridge some of the valleys in your first texture coat, so you may want to thicken the product a bit more.
9. **COATS REQUIRED:** Flat horizontal surfaces can be fully coated at once. But verticals will run if too much is applied before it gels. On verticals, it is best to mist a fine mist- let it tack (10-12 minutes), and continue misting while watching for signs that dripping would become an issue with additional coats. At this point, wait until thumbprint tacky before applying additional layers. Single coats on verticals are usually approximately 12 mils before dripping, but depend on viscosity of your mix.
10. **SPRAY EQUIP & ROLLERS:** Our hopper gun provides multiple settings for control and are the recommended method of application. More control is available with our HVLP gun for finer texture, but usually requires thinning of the product. Specialized HVLP guns with larger orifices are available for thicker application using this equipment as well. Commercial grade 18” yoke bracket, and rollers are also available. Squeegees are used on jobs where spraying isn’t required, and can be obtained by local home supply stores.
11. **GUN AND EQUIPMENT PREP AND CLEANING:** It is often found that applying a thin layer of mold release agent to the inside of the hopper spray gun aids in final cleanup. Though not required, lecithin is the best mold release material, & available online through outlets such as Amazon. Original PAM cooking oil is similar & may also be used. If using: spray the mold release agent 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. Uncured, or semi-cured bedliner will often wash out with hot water or pressure washing to large extent, especially if gun was coated previously. Straight lacquer thinner removes any remaining SL&C coatings or residue before they cure fully. Any cured materials require scraping or wire brush to remove. NOTE: Do NOT soak spray equipment in lacquer thinner as this will soften the rubber gaskets and rings.
12. **SPECIFIC APPLICATIONS:** ** ALWAYS refer to any additional application instructions included with your specific product **

TECH SUPPORT REQUIREMENTS:

To ensure prompt available support, you **MUST** make an appointment prior to any application. You’ll be given a clear walk through for your specific products. If deemed necessary, we will schedule availability during your planned application.

Support calls are handled on an “as available” basis if not scheduled in advance, so calling at least 24 hours in advance is recommended.