



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

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

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

## Basic Mixing Directions – for Trucks Beds, Flooring, Waterscapes, etc.

**\*\* 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) \*\***

### Summarized Instructions and Techniques

- Spray mixed coating on wood, metals, concrete, ceramic, certain plastics\*, fiberglass. To Squeegee OR Roll call support to slow dry time.
- Use common sense or call tech support for walk thru. Material will not stick to chrome & some plastics- so test 1st before accepting unique jobs.

### Pre-mixing

1. Pre-mix the part A-Colors before combining with part B or B-R. That's because part A-Colors separate.
2. Parts A-Clear, B, or B-R won't separate, so no pre-mixing needed.

### Prep

1. Prep by using any method to clean surface's pores. Double check insuring no debris (wax/oils) exists.
2. Tape & cover all remaining uncoated surfaces. Green 3m 233+ masking tape is highly recommended.

### Batch mixing – liquid and powder

1. mix 2 parts A : 1 part B or BR
  - a. Mix very well for 3-5 minutes; all A & B must be fully combined prior to adding filler. Note: parts A-R & B-R are the soft or “rubbery” versions of parts A & B. All may be combined at 2A to 1B.
  - b. Mixing is most important! Mix for 2 to 3 minutes minimum under normal conditions. Helix drill bit mixing is REQUIRED. Never hand mix.
  - c. < 60 f : mix 5-8 minutes | 70-80 f : mix 3 minutes | >80 f : mix 2 minutes | > 90 f : mix 1 minute
2. Add Poly Powder:
  - a. Add into mixed A/A-R & B/B-R where approx. 20% to 200% the total mixture is powder. More powder creates profile. Use high grade NON-GREEN lacquer thinner only to thin material (5-25%).
  - b. Viscosity warning: Powder requires adding lacquer thinner to atomize.
  - c. Powder types: LP40 = orange peel or slip-proof. LP80 = smooth. Combinations create “medium” profiles ... there are many other types... call support for extreme slip-proofing (rough) or anti-stick (smooth) powders.
  - d. (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 or pour out within reason to squeegee or roll to level.)



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## Gel /Set /Spray/Acceleration

1. If possible heat the surface; with sun, heater, or heat lamp.
2. The mix 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 15-30 minutes & shorter depending on above acceleration methods you may use. 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 still flow well ... (approx. 110-130 degrees f). Too thin & it'll run or sag 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.
3. Flat horizontal surfaces can be fully coated at once. But verticals will run if too much is applied before it gels. With heat, gel or dry-to-touch time speeds up:
  - a. **On verticals:** it is ok to heat, let cool, re-mist, re-heat, re-mist, re-heat, continue misting & heating. As tack coat thickens, more may be applied. That's because the more a layer is dried, the more it will accelerate any new layers to dry.

## **Specialized Application Techniques and Notes**

Clear bug, chip, rock, salt guard: pure Clear & Color with no filler behaves different. Call for support.  
Tinting the clear- topcoat: mix minimal qty non acrylic auto or marine grade paint color into the clear mixture. Our colors are also available. Note that these colors will soften the lining's cure; so use as little color as possible to get powder to match.

For complete color throughout lining: mix minimal qty non acrylic auto or marine grade color into powder until powder matches color. 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 trial & error - call tech support to minimize waste & time. .

Cover non-lined areas with waxed paper, cardboard or tarp.

On verticals, press tape on tight to prevent bleeding for clean straight lines- this is more important when taping "below" the lining as opposed to above or on the side of lining.

Practice on safe area first before a sensitive parts. Again: mix rate (the a to b ratio), mixing speed, mixing time, standing time, ambient temperature, filler % & types & surface temperature all affect material's viscosity, cure time, spraying or rolling character & look.

Liquid binder ratio is always any 2 parts of A or A-R to any 1 part of B or B-R: The amount of poly powder solids varies with different surface behavior requirements.

Guns: hopper gun is, "constant air"... use smallest tip & a basic on/off switch between air line & gun. This prevents compressor tank from emptying quickly. Allow over 40 psi into gun to atomize the mix properly. More psi & distance creates "tinier" orange peel texture.... Over 150 psi is ok. Call support for airless, pressure-pot, fusion & other equipment information.

guns & rollers: simplest gun is our hopper gun giving more control- more control is with our hvhp paint type- for more jobs or larger areas our pressure or pump—driven equipment deliver more gpm with extreme control (see website)... these & all equipment can be no cost (loaners) when enough material is bought (call support for details). 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.