



## SL&C RLA Cartridge Spray Bedliner Instructions

These instructions are provided to assist with application of the cartridge system when being applied to a truck box. They may also be used as a general guide to the application for other purposes as well.

Spray Lining and Coatings offers many different color options and pigments including colors off the primary color chart. These are in addition to supplying several shades of gray tan and red as standard color choices. Virtually any color can be created by blending these pigments.

Become familiar with the particular system you have, and read all user manuals provided with the equipment before starting your project. Be sure to identify each component and its function first to ensure you can adjust and apply our coatings properly.

Always be sure to use proper personal protective equipment while spraying our product. This includes a full-face air-purifying respirator, a full body spray suit, and nitrile gloves. Clean the truck box to be sure the truck bed is free from wax, grease, or other contaminants, and wipe with a clean flint free rag. Pre-cleaning will ensure that the masking will adhere and prevent contamination of the nylon brush or pad.

Use wire trim tape around all areas where the liner will need to be cut after spraying. Wire trim is used in place of a razor or cutting knife that may damage paint. Be sure the wire trim lays flat and is not lifting on any areas to avoid bleed.

Leave an extra 6 to 8 in of wire trim tape at all ends. This will make it easier to find the endpoints, and give enough length to use as a handle.

### Basic Preparation Steps:

- Remove any access panels on the tailgate to prevent permanently bonding the panel to the truck box (tie-down hooks and bed bolts may also be removed)
- Remove the backing on the wire trim tape at the front of the truck, and work your way back using masking tape around all edges that do not require wires for cutting
- Continue masking the box with masking paper or painter's plastic around all edges
- Be sure not to overlap masking tape over the wire in the wire trim tape
- Mask around the tailgate
- Mask off the latch mechanisms with a piece of masking paper
- Mask the remainder of the truck down to the shop floor with painter's plastic to prevent overspray on the truck
- Be sure to cover the entire truck cab

### Additional Surface Prep:

- Use red Scotch-Brite to scuff the edges by hand (this will help prevent removal of the masking and ensure that the edges are scuffed properly)
- Use a nylon cup brush on a multi speed polisher to scuff the truck box (slower speed setting works best with nylon cup brushes)
- The ideal surface is a dull clear coat, and paint removal is not recommended
- Blow the box out to remove as much dust as possible, holding the air nozzle approximately 6 to 8 inches from the surface
- Start from the front of the box and blow the dust out the back
- A second wipe with solvent is also recommended
- Always complete a final inspection to be sure there are no tears or gaps in the masking tape or plastic

## Cartridge Tube Prep and Tips:

- Remove the cartridges from the case
- Shake for 10 to 20 seconds and install the static mixing nozzles
- Be sure the cartridges are at least 75 degrees Fahrenheit for proper spraying
- Connect a gun to your air source and set the regulator on the handle to 100 psi
- Test for proper operation
- The speed of the main psi can be changed with the regulator on the handle
- Turn up 10 psi to speed up the distance, turn down the regulator to slow down
- Never exceed 110 psi
- Insert the cartridge label side down into the gun
- Be sure to hold upright at least 45 degrees to prevent cross-contamination in the static mixing nozzle
- Attach the air tube to the air atomizer on top of the static mixing nozzle
- Depress the trigger and open the valve to the aerator tip 1/4 turn
- Do not open the valve 100% as this may deplete air to the main piston pushing the chemical
- The valve should be opened just enough to create a good spray pattern
- Do not release the trigger until the cartridges are finished to avoid curing in the mixing tube

## Actual Product Application Steps:

- Spray the top of the rails if an over the rail application, or start from the back-side wall of the box for an under the rail application
- Continue around to the front bulkhead wall of the truck, down the opposite side wall, and finish at opposite end of the truck box
- The first cartridge will cover an entire side wall and the front bulkhead wall
- Always spray off target and release the trigger before the cartridge runs dry
- Do not let the cartridge run dry on the truck
- Change the empty cartridge and continue spraying from your last point
- The second cartridge will cover the remaining walls and start the front end of the floor
- The third cartridge will cover the remainder of the box floor
- The fourth cartridge will complete two coats on the tailgate and access panel
- The fifth cartridge is used for long beds to complete over-the-road application or to apply texture on short boxes
- The sixth cartridge is typically needed to apply texture on long boxes and/or over the rail applications
- The sixth cartridge is typically not required on short boxes

## Finishing the Truck Bed:

- Remove masking tape and stop at the wire
- Do not pull past exposed wire and pull at a 45-degree angle into the liner away from the tape using pliers
- Pliers will prevent any cuts from the wire
- Repeat to the other side of the truck and tailgate
- Reinstall any removed hardware
- Perform final inspection and carefully remove any imperfections using razor or other available tools

### **NOTE:**

This product requires an air compressor with a minimum of 10 CFM @ 110 PSI and an air dryer (part A is reactive with water until combined with part B) along with the safety equipment and processes outlined. Contact us for any additional information if required.