

SPI Bed Liner #1050-1

A Gallon Kit Includes:

- 1-¾ Gallon of Bed Liner
- 1-Quart of Part B Activator
- 1-Tube Black Tint

Only Use a GEO Bed Liner Gun!

Use only Geo gun part number **W4535** to spray this product with a regulator. The use of other guns that look alike do not have a big enough bore or pick up tube and will cause loss of strength and adhesion and you will lose a lot of the gallon to airborne over spray. In other words don't even consider using a different type of gun or *you* will have major problems! **If you don't use the GEO gun we already know the result so there is no need to call us because there is nothing we can do for you! All you need to do is buy another gallon kit and a GEO gun then start spraying all over again!**

Tinting Colors:

We only supply black tint with each kit, however you can make your own color. **USE ONLY** pure mixing color tints from a **quality** paint line! Do not use *mixed* base or single stage colors in the bed liner. Use a minimum of 4 ounces up to 8 ounces (for transparent colors) of tint per gallon kit of bed liner. Single stage color systems tend to produce glossier colors. Blacks and grays and will be the most UV stable. As with other bed liner companies some white tints have an adverse reaction with this bed liner as they can turn the white bed liner slightly yellow or green and this can happen as soon as you mix it or up to a month after you spray it. **We don't know why so don't tint this bed liner white!**

***Anti-Skid Option:**

In order to create a durable anti-skid coating with this bed liner you may add 2-6 ounces of *clean* and *dry* silica (sand blasting) sand to one gallon of sprayable bed liner.

Mixing the Product:

This step is very critical as this is not automotive paint, so follow directions very closely!

- 1) Pour the desired tint into part B can and hand shake.
- 2) Combine part A and B at a ratio of 3:1 and mix by hand with mixing stick for three minutes **very aggressively**.

You will notice the product if mixed for only 30 seconds will start to jell / thicken in the can. At this point just keep mixing and the product will thin down. Pot life is 45-60 minutes if mixed for about 3 minutes, but pot life will be only 5 minutes if mixed for 30 seconds. This is the opposite of paint so don't cheat here or it will be very costly to *you*.

In the first quart or two you may add up to 10% SPI 870 Urethane Grade Reducer (never 860) as this will allow the bed liner to lay down level and act like a sealer which will allow fast uniform coverage. Once the entire bed has been coated uniformly one time spray the left over bed liner un-reduced, which will give you the texture you desire. This is also very helpful on transparent colors. **We recommend spraying one coat of SPI Black Epoxy first when spraying black bed liner over a white bed for faster coverage.**

Prepping the Truck:

The paint should be cleaned with SPI wax and grease remover #700 or #710. The bed should be sanded with 180 by hand, 180 grit with a DA, **or** a red scuff pad and then cleaned again with wax and grease remover. Although the bed liner will stick to clean bare metal we do recommend that in the area you coat the bare metal first with SPI epoxy primer and let it set at least one hour and preferably over night before applying the bed liner. **Never use an Acid Etch primer under the bed liner.**

Also if the bed looks like it has been repainted before especially with what we refer to as a used car special (low quality paint and poor prep) it would be advisable that you coat the bed with two coats of SPI Epoxy Primer and let it set over night before spraying the bed liner. It's always best to use SPI Epoxy under this bedliner.

Masking the Truck:

The whole truck should be covered and we recommend that you use 18" or 36" paper to outline the area and then spray the rest of truck with Air Filtration's liquid spray mask. Areas where the bed liner will overlap the tape such as the top of the bed rails, the following procedure works best. Outline with ¾ inch tape and masking paper, then lay another piece of tape over the first piece with 2 inches extra at the end curled up. As soon as you are done spraying the bed liner you can pull the curl and the top layer of tape will be removed leaving the first layer until bed liner is dry. This will leave a very nice looking edge with out the cost of buying wire tape.

Spraying the Truck:

Adjust the **GEO** gun. The tip screwed in will cut back on the material and the further out the tip is the more material the gun will shoot. For the first time users we recommend you adjust the tip of the gun in about 75% of the way and air pressure at about 40-50 pounds. What we are trying to accomplish here is getting the gun to spray a fine spray just wet enough that we will hide and cover the paint with the first coat of bed liner. On our first coat when we're in the bed, all we care about is covering so no bleeding of paint can be seen. Then spray a coat on the bed as you walk out of the truck.

Now that we're out of the truck for the next coats you will need to adjust the fluid tip out so more material comes out and you may need a little more air pressure. Now we want to lean over side of bed and spray across the bed as this will even out the texture and then walk to the other side and do the same thing, follow this procedure until the gallon kit is gone.

Delivery:

The bed liner will be dry to the touch within 2 hours depending on air temperature and at this point untape the truck and carefully rinse off the liquid mask if used. *Light* water will not hurt the bed liner at this point. The truck can be driven but it is best not to use the bed for 48-72 hours depending on air temperature. Just like automotive clear coats or single stages this bed liner will cure very, very slow below 50 degrees and it is possible for this product to go nearly dormant. You may bake this bed liner around 110-120 degrees to speed up the curing in low temperatures.

Restorations and Street Rods:

When spraying inside the doors, trunk and floor pans if the car has been dipped, wash with SPI #700-1 or 710-1 and spray one or two coats of SPI epoxy let it set overnight then shoot the bed liner. If the vehicle is not stripped and it is a factory finish just clean as above and scuff with a red scuff pad and spray. On frames that have been sand blasted, our first choice would be epoxy as above but the bed liner will stick and seal the frame very well with out it. On raw fiberglass it is best to spray a coat of epoxy for safety sake, but the bed liner will stick very well to most fiberglass on its own.

Safety:

Always wear complete body and lung protective gear, see MSDS sheets and product label for complete information.

Caution:

We have referred to the use of epoxy quite a few times above. Please be aware all epoxy primers are not created equal! You should know the epoxy very well and how it reacts if you are considering using another epoxy under the SPI spray in bed liner. Some epoxies out there would need to set 3-4 days before our bed liner could be sprayed over them. This is not an area you want to gamble with!

