

**bedliner.com**

**SUPERIOR SPRAY ON BEDLINERS**



# Who is Simmons Industries?

- Simmons Industries, Inc. is a family owned and operated business located in Austin, Texas with over 35 years of experience in the urethane coatings industry.
- [Bedliner.com](http://Bedliner.com)
- Constant research for new technologies.



# 500 Hour Xenon-Arc weatherometer

	<b>SIL LINERS</b>	Brand "X"	Brand "R"	Others
<b>THICKNESS</b>	<b>0.060-0.250"</b>	0.060-0.250"	0.060-0.250"	0.060-0.250"
<b>2 YEAR EXPOSURE</b>	<b>GLOSSY &amp; STRONG</b>	OXIDIZED WEAK FADED	OXIDIZED WEAK FADED	OXIDIZED WEAK FADED
<b>HARDNESS</b>	<b>Med-hard</b>	Hard	Soft	Soft-Hard
<b>STATED STRENGTH</b>	<b>4000 PSI</b>	2500	2500	2000-4000
<b>ACTUAL STRENGTH</b>	<b>4000 PSI</b>	1200	1100	1200-1500
<b>ACTUAL STRENGTH AFTER 500 HOURS</b>	<b>3900 PSI</b>	800	900	600-1100



It simply isn't possible for a polyurethane made from LESSER, LOWER performing components to be stronger and more weather resistant than **HIGH GRADE polyurea components @**

**bedliner.com**  
Superior Spray On Coatings



**BRAND "R"**

***bedliner.com***

*Superior Spray On Coatings*

After ONLY 6 MONTHS of natural outdoor exposure....

**Which liner would you prefer?**

# Other Products and Services

- Top Coat™
- Graphic Stencils for spray on graphics
- SuperWraps™
- Window Graphics





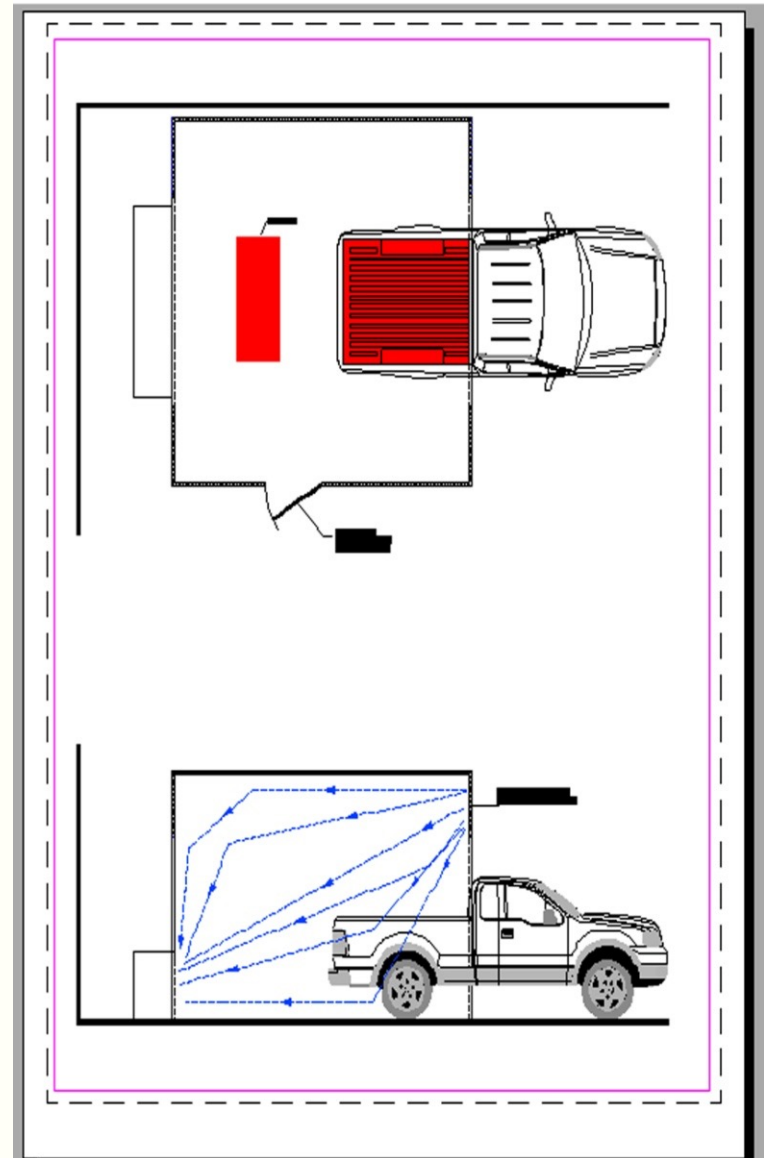
# Setting up Shop



- Storage of Material
- Fire Proof Cabinets are ideal
- Paint storage room
- Metal Cabinet
- Metal Shelving

# Mixing Station and Application Area

- Mixing Station
- Application Area
- Proper Lighting
- Tools for fast and easy preparation
- Tools for cleanup





# Before we get Started!

- Always think and use safety first!!!
- Be sure to have a full-face piece respirator with organic vapor filter
- Polypropylene Paint Protective Coveralls
- Chemical Resistant gloves
- Safety glasses
- Half face mask respirator
- For Chemical Emergency Call: **INFOTRAC**  
**1-800-535-5053**



# Preparing the Surface for Adhesion

- Make sure the surface or substrate is clean and that there is no debris or dirt on the surface before you sand.
- If necessary, wash the surface with a degreaser, rinse and let it dry thoroughly before you start to sand.



# Protection

- When spraying truck beds, cover the cab with a tarp. You may want to put a drop cloth or sheet under the tarp so that you do not scratch the truck.
- If you are not spraying it cover it up!
- Covering the truck with plastic and tarps should take about 20-30 minutes.
- Removal of tie downs and bed bolts are not required but recommended.

# Masking a vehicle

- When masking the vehicle use a good quality masking tape like 3M. Cheap tape may leave a residue or tear easily in some situations and can cause a big headache.
- You can use  $\frac{3}{4}$  inch tape for laying cut lines.
- $1\frac{1}{2}$  - 2 inch for masking over the cut tape so that you can attach the plastic or paper to the flap.





# Tape

- When masking a truck for an over the rail applications 3M Green 233 Plus works very well. This tape bends more without tearing.
- Wire Tape is not needed with SL-Products™.



# Over the rail

- When taping for over the rail applications start at the head wall and attach the tape to the back of wall.
- Stretch the tape from the front to the back end of the truck. Pull tight and look back up toward the front of the truck to insure you have a straight line.



# Wrapping the vehicle



- Find a light weight plastic. Painters plastic is .31 mil thick and works well. The roll of plastic is 9 foot by 400 foot.
- Paper may also be used.



# Cover it Up

- There is no wrong way to mask a vehicle just remember one rule:
  - If you don't want it sprayed then **COVER IT UP!!**





# Sanding

- Sanding can be done using a variety of tools.
- Air Sanders i.e.. Dynabrade, DA
- Electrically hand held sanders.
- These tools work very well on the larger surfaces, but can be cumbersome in tighter areas.
- It is best to sand by hand in hard to get to spots such as corners, edges, and near your tape lines.



# Sandpaper

- 40 grit sandpaper is recommended. 3M 40e Green Corps Sticklts work well.
- This is NOT like sanding for a paint job. Therefore, the rough surface caused by the sanding is going to be beneficial and will be covered by SuperLiner™.
- Sanding should take about 20-30 minutes.
- **SAFETY FIRST:** Make sure to wear safety glasses and half face mask respirator when sanding



# Did I Sand Enough?



- You are not removing the paint. You are etching the clear coat to achieve a good bond.
- Some bare metal is normal.
- On older vehicles rust may be encountered.
- Sand the best you can. Then treat rusty areas with a rust stop spray.

# SAFETY FIRST

## Always Wear:

- Polypropylene Paint Protective Coveralls
- Full-face piece respirator with organic vapor filter
- Chemical Resistant gloves

## When Using Solvents!

For Chemical Emergency Call: INFOTRAC 1-800-535-5053





# Cleaning the Surface

- Before wiping your surface area down, it is best to blow off the surface using an air tool.
- Use a shop rag that doesn't leave lint. The red shop towels work well for this because they don't tear or leave bits of cloth behind.
- Use some type of fast evaporating solvent like Acetone, Lacquer Thinner, or Non Chlorinated break wash for wiping down your surface.
- Make sure the rag is WET and not damp.
- Whichever solvent you use to wipe a surface down with, **CAN NOT** contain any petroleum products.

# Wipe Down



- When wiping the truck down start at the head wall and work toward the bottom of the bed.
- Then proceed to the sides and then wheel wells.
- Next start on the floor and wipe toward the back of the truck. Be sure to keep your motion going top to bottom not side to side.
- This motion will take any remaining dust or debris out the back.

# Keep the Rag Wet

- Be sure to keep your rag wet. If it dries then you will be smearing dirt.
- Rub your hand across the surface to check for dust left behind.
- Your surface is now ready to spray AP Primer adhesion promoter.

# Mixing and Applying AP Primer

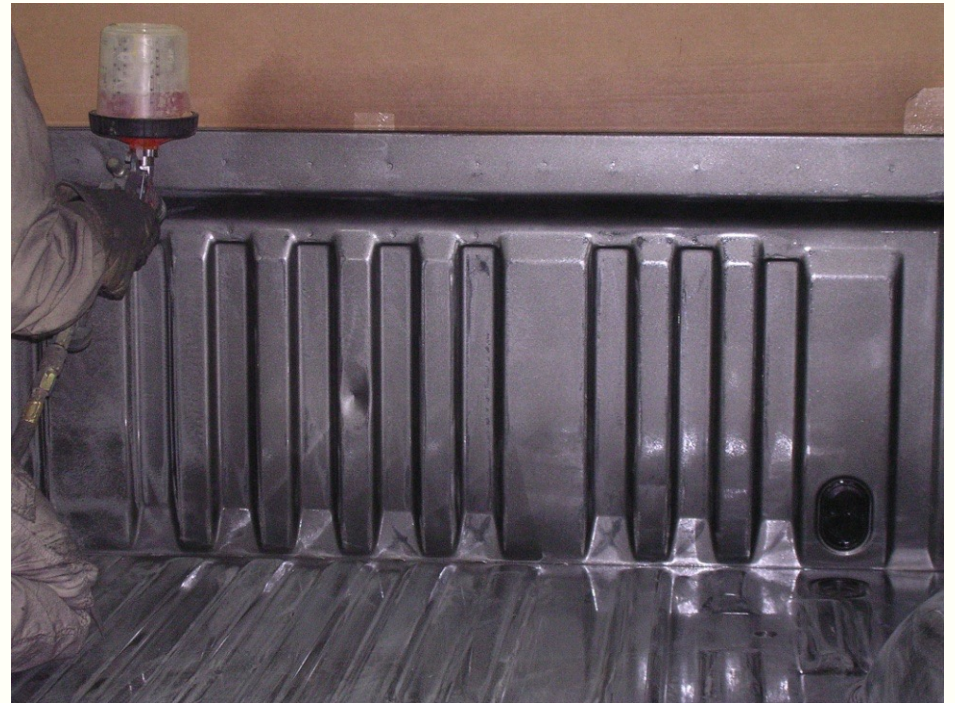
- AP Primer is mixed at a 1:1 ratio.
- HVLP Paint Gun
- For Mini trucks i.e. Toyota, Nissan, S-10, Ranger, Dakota etc. Use 200 ml of A side and 200 ml of B side for a total of 400 ml.
- Full Size Short Bed trucks or 6' beds use 250 ml of A side and 250 ml of B side for a total of 500 ml.
- Full Size Long Bed trucks or 8' beds use 300 ml of A side and 300 ml of B side for a total of 600 ml.
- Additional Primer 450 may be needed when spraying over the rail or additional areas.





# Applying AP Primer

- Start at the front of the truck or near the cab. Next, proceed to the sidewalls and wheel wells. Finish by spraying your way out of the vehicle. The pressure needed to spray is 15-30psi. A lower pressure is more efficient and will keep the primer from fogging or wasting AP Primer. This is also key in minimizing your costs.



# Did I Spray Enough?



- Spray a coat until the surface has a satin finish. Usually one pass will do. Finish spraying any leftover AP Primer. Wait until the AP Primer loses its tackiness before spraying SL Liner™ (about 30 minutes). You have a 4-hour window in which to spray SL Liner™ over the AP Primer.
- Be sure to clean your spray gun immediately after applying AP Primer.

# Hopper Gun Assembly

- Start by attaching the Hopper to the top of the Gun.
- The hopper handle will face away from you.
- We recommend using a medium tip to shoot with.
- You want to make sure the connections for the air hose are attached to the bottom of the gun.
- Spray Pam or a Silicone into the hopper and wipe the excess out. This will help in clean up.





# Mixing Components of SL1000™



- SL1000™ is a 3:1 mix.
- There are 3 different components to mixing SL1000™.
  - The Gallon can marked “A-side”
  - The F-style quart can marked “B-side”
  - Cup of color



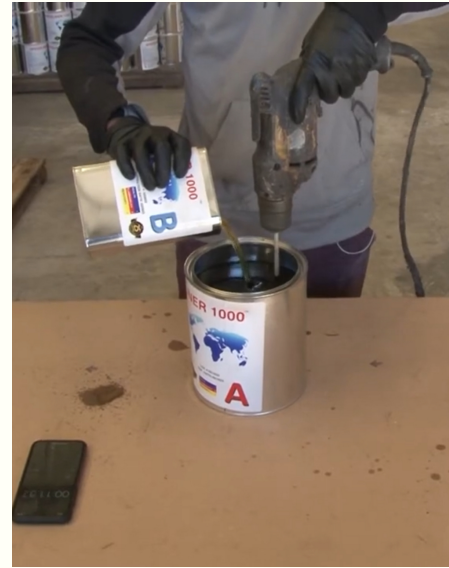


# Custom Colors

- If you need a color match to a vehicles paint code we recommend PPG's Omni AU MTK color, PPG's Concept color, or PPG's DCC color.
- The amount of color used is 6 - 8 ounces per A-Side.
- Lighter colors may need an additional gallon because they may appear transparent.



# Mixing SL1000™



- Take the color jar and stir if the pigment has separated from the solvent. Then pour the pigment into the A-Side gallon can and stir with the Jiffy Mixer™ to disperse the color evenly. Some colors are thicker and may have to be scooped out.
- Next, pour the can marked “B-Side” into the can marked “A-Side”
- Be sure to use all of the contents of the B-side, otherwise, the mixture will not properly cure.
- Attach the stainless steel Jiffy Mixer™ to a drill and mix the SL1000™ in the A gallon can for 40-45 seconds. (Drill speed can affect mix time) Be sure to mix all the sides and up and down to disperse the catalyst evenly throughout the resin.

# Mixing SL1000™

- Once the SL1000™ is mixed, pour all of the contents into the hopper.
- Mixing instructions are listed on the cans.



# Don't Over Mix SL1000™

- You can over mix SL1000™! DO NOT mix the product longer than 1 minute. This might cause the mixture to not set up and cause curing issues. The product must be mixed thoroughly or the SL1000™ will not cure and could leave cracks through solvent popping.
- If you have any questions please call the technical support line for help.  
512-990-8808



# How Much Do I Use?

- Recommended amounts of SuperLiner™ for Vehicles:
- 2 Gallons = Mini trucks most imports
- 3 Gallons = 6' Beds
- 4 Gallons = 8' Beds
- 1 Gallon = Over the rail
- Additional gallons may be needed for over the rails or other options.
- SL1000™ Covers approximately 25 square feet per gallon at the thickness sprayed in a truck bed.

# What Pressure Do I Spray with?

- The air pressure should be set at **125-150 psi at the tank** and around **80-100 psi at the gun**. If you feel the texture is too thick simply raise the air pressure and if too thin lower the air pressure.
- The amount of trigger pull will also affect the look of the texture.
  - **More trigger pull = Heavy texture.**
  - **Less trigger pull = Finer texture.**
  - **Closer you are = Smoother Texture**
  - **Further away you are = Rougher Texture**
- ***Note: Spraying SL1000™ close to a surface will increase the chance of a rippling effect. If the liner begins to ripple you are too close.***
- For SL1000™ to have a fine and smooth spray start approximately 18 inches from the surface and a trigger pull of about a 1/2 inch. A wet look should be achieved while spraying. A glassy or glossy look means that you are spraying too much material in one area and you must move to another area. Come back to texture over it.
- ***Note: To achieve a fine sandpaper like texture keep the pressure high and the trigger pull light. To achieve a thicker more raindrop like texture, lower the pressure and apply more trigger pull.***

# Applying SL1000™

- Spray the tailgate from all four sides.
- Get in the bed of the truck and start at the front of the truck bed or near the cab and move to the sides of the bed and wheel wells. Spray top to bottom or side to side until you have approximately  $\frac{1}{4}$  of material left in the hopper. Then spray under the rails on each side.
- **The key is to make several passes to build up the thickness. Do not worry about texture at this time.**
- **Watch your hose, your feet and your backside as you might inadvertently scrape a wet area.**

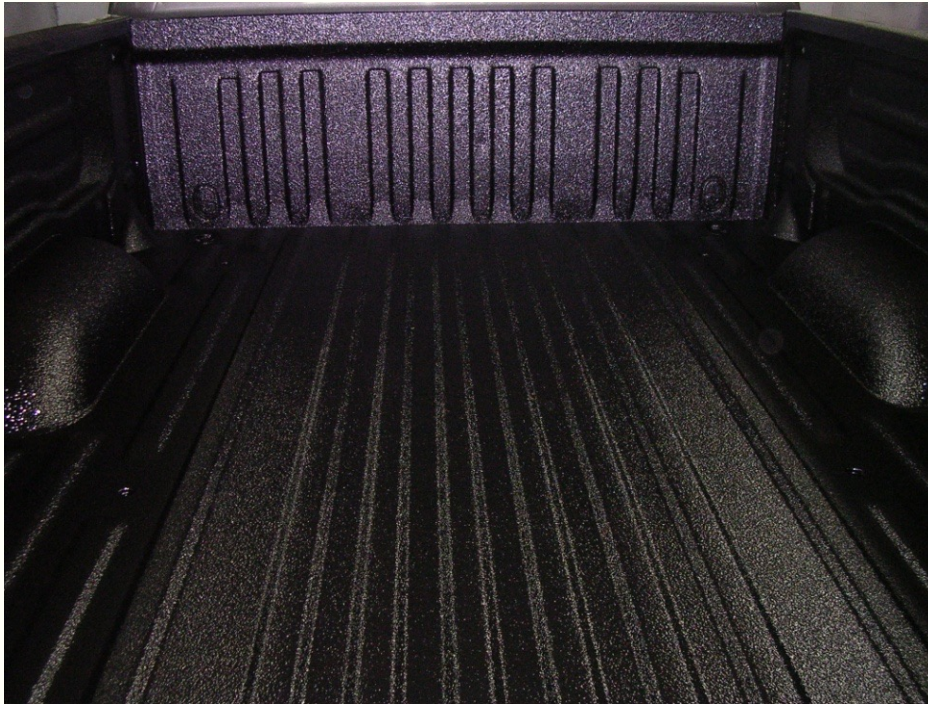
Spray SL1000™ making sure not to leave any truck surface from showing underneath the liner and work your way from the front to the back and then the sides of the truck

# Applying the 2<sup>nd</sup> Gallon

- Spray your tailgate again
- Get back in the bed of the truck, texture your headwall, and sidewalls pulling a quarter to half a trigger pull.
- Standing in the middle of the bed Spray the front 1/3<sup>rd</sup> of the floor by spraying up the corrugation of the bed not side to side.
- Because you are spraying on a flat surface you can apply the SL1000™ thicker and quicker because there is no chance for the product to run.
- Moving to the back, spray the middle of the bed, blending to the upper 1/3<sup>rd</sup> of the bed.
- Get out of the truck stand on a platform and spray the back 1/3<sup>rd</sup> of the truck and blend to the front over both areas you just sprayed.
- Move to the passenger side of the truck and spray across to sidewall working your way down into the bed moving from front to back of the truck. Move to the other side and repeat. Keep your gun and hopper on the outside of the truck so that you don't drop it in the bed.
- Do not spray directly underneath the gun. You should always spray from
- a distance to give the proper texture.
- Work your way out of the bed making sure you get around all screws and bolts as you go.
- Repeat process on the other side.



# Applying Final Coat



- The last gallon is used to get your final texture coat.
- Texture your tailgate
- Stand at the rear of the truck. Texture up toward the front starting on either side and work your way across.
- Move to the passenger side of the truck and spray across to the sidewall working your way down into the bed moving from front to back of the truck. Move to the other side and repeat. Keep your gun and hopper on the outside of the truck.
- Repeat until finished.
- When spraying over the rail you need to spray the rails with part of each gallon.

# Cleaning the Hopper and Gun

- When you are finished spraying a liner clean your gun with acetone and use the chemical resistant brush provided. To increase the life of the gun make sure that all material is removed. Make sure all “O rings” are wiped with Vaseline for your next use. Do not soak any of the parts that contain “o rings” too long because the Acetone will eat them up.
- Wait 6-8 hours before peeling the material out of the hopper.
- Multiple hoppers is always good to have on hand due to a different color selection.
- The material will peel out in a sheet and will take some effort. You are not required to use solvent to clean the hopper.

# Unmasking

- Begin unmasking the vehicle by pulling the tape towards the inside of the truck at a 45 degree angle creating your edge. The product is still wet so try not to touch SL1000™ with anything.
- Once you have finished unmasking, Check to make sure there is no over spray on the vehicle in unwanted areas.
- Any over spray on the vehicle can be removed with cleansing alcohol or Zep Big Orange Cleaner.





# Curing Time

- SL1000™ will be dry to the touch in 45 minutes to 1 hour in 50 degree weather.
- Curing happens faster at warmer temperatures.
- After 24 hours of cure time the liner can be used for **light loads only**.
- Allow 72 hours/ 3 days for full cure time.
- **Please note that the colder the temperature the slower the cure time.**





# Cleaning Off Overspray



- Zep Big Orange, Scrubs In a Bucket and Zep Hand Cleaner Towels all work well to remove overspray off of most surfaces.
- Cleansing Alcohol can also be used.

# Safety First!!!!!!!

- Simmons Industries, Inc. is concerned about your safety.
- Simmons Industries, Inc. always recommends taking the necessary precaution for ensuring safe working conditions and environment. Follow all local, state, and national safety requirements in your area at all times.
- **When spraying any hazardous material always wear protective gear including a full face piece charcoal vapor respirator, chemical resistant clothing, and gloves.** Empty cans of SL1000™ may be thrown in regular trash 3 days after use.
- Simmons Industries, Inc. will not be held liable nor are we responsible for any carelessness, misuse, irresponsibility, or abuse of our products.
- **For Chemical Emergency Call: INFOTRAC 1-800-535-5053**

Standard Preparation Procedures

	Sand Blast	Wire Wheel	120 Grit	40 Grit	Blow Off With Air Hose	Dawn soap De Greaser	Water Rinse	Fast Drying Solvent	Kiltz Primer	Epoxy Primer		SPX 460 *	Primer 450	SL1000/ Top Coat
Bare Metal	X				X			X		X			X	X
Bondo / Body Filler				X	X					X			X	X
Chrome	X				X			X		X			X	X
Diamond Plate Aluminum		X			X			X		X			X	X
Fiberglass				X	X			X				X		X
Foam Closed Cell					X				X				X	X
Foam Open Cell					X				X				X	X
Galvanized Metal	X				X			X		X			X	X
MDF					X								X	X
Other Liner Topcoat					X	X	X	X					X	X
Painted Aluminum				X	X			X		X			X	X
Painted Metal				X	X			X					X	X
Painted Truck Bed				X	X			X					X	X
ABS Plastic			X		X			X				X		X
Plywood					X								X	X
Powder Coat				X	X			X					X	X
Primed Metal				X	X			X		X			X	X
Rusted Metal				X	X			X		x			X	X
Sand Blasted Metal					X			X		X			X	X
Smooth Aluminum				X	X			X		X			X	X
Stainless Steel	X				X			X		X			X	X
Treated Lumber					X				X				X	X
Zinc Coated Material	X				X			X		X			X	X

\*SPX 460 can be interchanged with Primer 450 but not the other way around

Please call the office on any questions on above items or items not listed at: 512-990-8808

Add no more than 12 oz. fine sand blasting sand per gallon of material.

# Full Vehicle

- Bondo or Body Filler
  - Painted Metal
- We do not recommend wiping down the vehicle with Break Wash. This can contaminate the surface. Degreasing with Dawn dishwashing detergent works well.
1. Tape off
  2. Sand with 40 Grit
  3. Blow off with air hose
  4. Degrease and rinse
  5. Wipe down with Fast Drying Solvent(MEK, Acetone, etc.)
  6. Primer 450 or SPX 460
  7. SL1000™ or Top Coat™





# Top Coating Other Liners

- Rhino
- Linex
- Other



1. Pour a small amount of Acetone or MEK in a place where it won't be seen. If the liner does not turn to mush or lift you can proceed with Top Coat
2. Degrease and rinse
3. Wipe down with Acetone or a fast evaporating solvent.
4. Primer 450 or SPX 460
5. SL1000™ or Top Coat™

# Preparation of Other Surfaces

- Bare Metal
  - Chrome
  - Galvanized Metal
  - Stainless Steel
  - Zinc Coated Material
1. Sandblast
  2. Blow off with air hose
  3. Wipe down with Fast Drying Solvent(MEK, Acetone, etc.)
  4. Epoxy Primer
  5. Primer 450 or SPX 460
  6. SL1000™ or Top Coat™



# Other Surfaces

- Painted Metal
- Powder Coated Metal



1. Tape off
2. Sand with 40 Grit
3. Blow off with air hose
4. Wipe down with Fast Evaporating Solvent
5. Primer 450 or SPX 460
6. SL1000™ or Top Coat™



# Other Surfaces

- Diamond Plate Aluminum
  - Painted Aluminum
  - Smooth Aluminum
1. Wire Wheel
  2. Blow off with air hose
  3. Fast Evaporating Solvent
  4. Epoxy Primer
  5. Primer 450 or SPX 460
  6. SL1000™ or Top Coat™





# Other Surfaces

- Fiberglass
- Gel Coat

1. Sand with 40 Grit
2. Blow off with air gun
3. Fast Evaporating Solvent
4. SPX 460
5. SL1000™ or Top Coat™



# Other Surfaces

- Closed Cell Foam
  - Open Cell Foam
  - Plywood (Treated Lumber)
  - Plywood
  - MDF
1. Blow off with Air Hose
  2. Kiltz Primer
  3. Primer 450 or SPX 460
  4. SL1000™ or Top Coat™



# Other Surfaces: Plastic

- ABS Plastic
- Fender Flares
- Dash Parts



1. Sand with 120 Grit
2. Blow off with air hose
3. Degrease and rinse
4. Fast Evaporating Solvent
5. SPX 460
6. SL1000™ or Top Coat™

# Limited Warranty

## LIMITED LIFETIME TRUCK BED LINER WARRANTY

**CUSTOMER NAME:**

**ADDRESS:**

**PHONE:**

**DATE:**

### IMPORTANT NOTICE

The lining application process requires sanding and masking of the truck bed. Purchaser warrants the paint on their vehicle against damage due to trimming with a razor knife removal of tape. The bonded polyurethane lining is a permanent accessory. It is specifically stated that the product cannot be removed from the vehicle once applied. Mixing colors to match existing colors will not be exact. Allow color variance of approximately 25%.

### DAMAGE RELEASE WAIVER

**Your Company Name/ Dealer Name** will not be held liable of any pre-existing damages.

### WARRANTY

**Your Company Name/ Dealer Name** will repair without charge, the bonded polyurethane lining which under our examination, prove to be defective in material and/or workmanship. This warranty is valid only if the coating has not been misused, abused or subject to excessive wear. The forgoing is in lieu of any other warranty or guarantee expressed or implied, and we are not responsible for any expense including removal inconvenience, or consequential damage caused by items of our manufacture or sale. Some states do not allow exclusion or limitations found in this warranty so they may not apply to you. All **Your Company Name/ Dealer Name** linings purchased from dealer or distributor to maintain warranty. This warranty is not transferable. \*\*Keep this as proof of purchase. Warranty is void without proof of purchase.\*\*

### AUTHORIZATION

I hereby authorize the work described on this work order to be done on my vehicle. You and your employees may operate my vehicle for the purpose of product fitting, cleaning, inspection, collection and delivery. You will not held responsible for loss or damage to articles left in the vehicle in case of fire, theft, accident, or any other cause beyond your control. I have read and acknowledge receipt of estimate of this work.

**AUTHORIZED BY:** \_\_\_\_\_

**VEHICLE:** \_\_\_\_\_

**LISCENSE PLATE #** \_\_\_\_\_

**SUBTOTAL:** \_\_\_\_\_

**TAX:** \_\_\_\_\_

**TOTAL:** \_\_\_\_\_

**COLOR:** \_\_\_\_\_

**COLOR AGREED UPON:** \_\_\_\_\_





SUPERIOR SPRAY ON BEDLINERS

**CONVERSION CHART**

INCHES	MILS
1/32	31.25
1/16	62.50
3/32	93.75
<b>1/8</b>	<b>125</b>
5/32	156.25
3/16	187.50
7/32	218.75
<b>¼</b>	<b>250</b>
9/32	281.25
5/16	312.50
11/32	343.75
3/8	375
13/32	406.25
7/16	437.50
15/32	468.75
<b>½</b>	<b>500</b>
17/32	531.25
9/16	562.50
19/32	593.75
5/8	625
21/32	656.25
11/16	687.50
23/32	718.75
<b>¾</b>	<b>750</b>
25/32	781.25
13/16	812.50
27/32	843.75
7/8	875
29/32	906.25
15/16	937.50
31/32	968.75
<b>1"</b>	<b>1000</b>

Use 1,000 for calculating desired thickness required of SL1000

Use 1300 for calculating desired thickness required of Top Coat

1100 divided by the # of MILS = SqFt per gallon

# of sq.ft being coated divided by sq.ft. per gallon = # gallons needed for desired thickness.

Or

Sq.ft. x # of MILS = # of MILS  
# of MILS/ 1,100 = # of gal.

Same applies with TopCoat conversion, just plug in 1300 instead of 1 000 for your formula.