



Total Coat Bedliner

Cleaning:

Apply on a clean, bare, primed or painted surface, free of oil, grease, dirt, release agents etc.

We recommend cleaning with a waterborne degreaser. Scuff/lightly sand the substrate. Always degrease BEFORE you sand /scuff. If substrate has to be degreased several days before TC/BL application, we recommend a wipe with a waterborne Final Prep shortly before application. Failure to properly clean and degrease the surface to be coated will result in the loss of adhesion and the dried coating will easily peel away in badly prepped areas.

Applying:

Apply at a min of 60°F at a wet thickness of 0.5 -1.0 mm (20 - 40 mil). When applying with the RA/88 Economy gun, use 40-80 psi and hold the gun 12 to 18 inches away from the substrate. Open gun nozzle minimum 75%.

A 20 - 30 mil coat can be applied in one pass. If a 30 - 40 mil coat is preferred, two applications are needed with a 1 hour drying time in between applications. These are very crucial requirements. Do not guess, consult an accurate thermometer that is measuring temperature in the spraying area. Temperatures do differ a lot from floor to ceiling. Be especially careful with opening of warehouse doors etc. which can bring in colder air.

DO NOT APPLY IN DIRECT SUNLIGHT.

Failure to apply at this min temperature or recommended thickness will result in the dried coating being cracked or easily removable.

Drying:

TC/BL should not be exposed to temp below 65°F during the application and curing process. The drying process actually exists of three different steps: "dry to the touch", "fully cured" and "fully cross linked".

TC/BL will be **dry to the touch** after:

90 min in ambient air of 75°F and RH 40%. More drying time might be required at higher RH.

30 min in a heated booth at 120°F (Allow 15 minutes flash-off at 75° F before entering the oven)

30 min (10 min flash off at 30" and 20 min full bake at 30") under Infra-Red lamps. (Max Temp of 120°F)

TC/BL will be **fully cured** after:

24 hours at ambient air of 75°F and RH 40%. More curing time might be required at higher RH.

60 min in oven at 120°F and a cool down period of 1 hr. at 75°F.

40 min (10 min flash off at 30" and 30 min full bake at 30") under the Infra-Red Lamps (Max Temp 120°F) and a 1 hr. cool down at 75°F.

TC/BL will be **fully cross linked** after 7 to 12 days.

Curing times can be considerably improved by adding air movement (fan) to the drying method.

Do not force dry at temps higher than 120°F or below 65°F.

For OEM high bake oven applications call 800 261 7976.

When the coating is "dry to the touch" the sprayed items can be moved, worked on, packaged etc. However they cannot be exposed to water and cold temperatures as this will cause thermal shock. Thermal shock will cause cracking of the coating and the TC/BL will be easily removable. Allow the coating to fully cure before exposing to water and cold weather. After the coating is fully cured, it can be painted. However during the next 7-12 days of cross linking, the coating will gain in hardness and strength. A fully cross linked coating has a hardness of: Shore A: 95-98. Do not expose the coating to heavy duty use before fully cross linked.

Storage:

TC/BL should be stored in a cool and dry place between 45°F and 85°F. Do not Freeze during storage or transport! Do not store in direct sunlight.