

Application Guidelines for **TuffGrip-803™** Synthetic Rubber Bed Liner with **Walcom Airgun** and **Foam Roller**

SURFACE PREPARATION

- 1.) All surfaces to be coated with **TuffGrip-803™** must be completely clean of all contaminants prior to application, as if the surface was to be painted. This includes existing non-patent (peeling) paint, oil, grease, dirt, water, etc. Heavy rust should be coarsely sanded to remove loose particles; light rust and “flash” are okay. After any prep, especially sanding, a solvent wipe-down or water rinse should be done to remove dust, etc.
- 2.) It is mandatory to allow adequate time for evaporation following water rinse, to assure maximum adhesion.
- 3.) Properly mask-off area to be coated. Use drapes to protect cab, rear bumper area, and adjacent vehicles. Position truck for optimum sunlight into bed and walls.

*FULLY READ ALL INSTRUCTIONS BEFORE MIXING **TuffGrip-803™***

Equipment & materials required:

- ▶ Walcom airgun, Model IA/L-FG or IA/LU-FG, USA threads
- ▶ 1-quart “Mono-top” application cans
- ▶ “Wet Film Thickness” (WFT) gauge;
- ▶ 1' wide x 4" long foam rollers (10-each per contractors pack);
- ▶ Roller handle for foam pads;
- ▶ Standard automotive masking tape, paper and plastic drapes
- ▶ Toluene as cleaning solvent.

GUN PREPARATION

- 1.) Permanently attach proper “Quick Connect” fitting to threaded gun handle.
- 2.) Assure all orifices and passageways of gun, tips and tubes are clear of debris. Old, cured **TuffGrip-803™** may be carefully removed with a narrow, sharp blade. “Air hole” for application can should be clear of debris. Using sharp narrow blade, widen original hole diameter.
- 3.) Attached tip to gun using minimum threads, allowing longest profile possible. Lock into place with threaded collar.
- 4.) Attach brass intake tip into underside of gun. Do not cross-thread plastic threads. Use 9/16" wrench to snug fit only. Do not crack plastic body by over-tightening. Press draw tube firmly onto brass tip. Cut new tube to length (allowing proper clearance below draw tube when inserted into empty application can). Blow air into tip to assure clear path through draw tube.
- 5.) “Operating” air pressure should be approximately 100 p.s.i. A small, gauged regulator can be attached between the gun handle base and the “Quick Connect” fitting, to reduce high air pressure to approximately 100 p.s.i. With empty gun attached to air supply, pull trigger to note “operating” air pressure on gauge. Excessive air pressure can adversely affect the application pattern of **TuffGrip-803™**.

TuffGrip-803™ Application Guidelines (continued)

APPLICATION:

- 1.) Thoroughly mix yellow **TuffGrip-803™ Curing Agent** into black **TuffGrip-803™ Base Compound** until uniform, as outlined on *Base* label and **TuffGrip-803™ Data Sheet**. During mixing, use mixing stick to downward scrape inside of can to insure full mixing of all *Base Compound*.
- 2.) Carefully pour **TuffGrip-803™** into application can, and carefully thread-attach filled can to gun. Re-cover *Base* can with lid.
- 3.) Start application pattern on inside of sidewall nearest open tailgate. Gun distance from surface should be 1½- to 2-feet. Continuously move gun to prevent excessive build-up.
- 4.) Do not attempt to completely hide surface with initial application. Original color should “peek” through initial application. Use foam roller to evenly distribute **TuffGrip-803™** over all surfaces to be coated, hiding original color. Immediately spray-apply first “texture” coat onto newly rolled **TuffGrip-803™**. Excessive application will “flow” together, defeating texturing.
- 5.) Occasionally “bang” bottom of can onto palm of hand to drop **TuffGrip-803™** inside can which will enable longer spraying between re-fills.
- 6.) Continue initial application across first sidewall, front wall, and second sidewall, ending at open tailgate. An assistant should follow initial application, using foam roller to evenly distribute **TuffGrip-803™**, and a small brush for seams and comers. Continue to immediately spray first “texture” coat onto newly rolled **TuffGrip-803™**, completely and evenly texturing sidewalls.
- 7.) During re-fill of application can, disconnect airgun and unscrew can from gun. Watch for dripping **TuffGrip-803™**. Remember short potlife of **TuffGrip-803™**. Do not delay resumption of spray application.
- 8.) Begin “bed” spraying against front wall. Generously spray-apply initial **TuffGrip-803™** approximately 18" deep *across* bed, followed by roller and “texture” re-spray. Continue 18" sections for length of bed, including open tailgate, which should get heaviest coating. Stipple repair any “dings” to wet textured surfaces with small brush. When tacky, re-spray for texture.
- 9.) Allow 15- to 30-minutes between repeat “texture” coatings, depending on ambient temp. Texture sidewalls from opposite side of truck. Texture bed from front to back, following raised bed pattern. Keep gun moving, at least 2' from surface, to prevent excessive application. Tailgate and bed should be covered more heavily than side walls. From a distance of 4- to 5-feet, “rain” **TuffGrip-803™** into bed to blend entire surface to uniform appearance.
- 10.) Allow at least 4-hours before pulling tape from cured coating. Always pull tape 90° from cured coating and parallel to surface to assure razor sharp edges. Do not use truck bed for at least 24-hours. Immediately clean “over-spray” with toluene on cloth.
- 11.) Remove tip, plastic tube, and brass tube fitting from gun body. Use small cylindrical “gun brush” with toluene to clean small components and inside passageways of gun.

TuffGrip-803™ is a pending registered trademarks of:

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