

# DURABAK APPLICATION INSTRUCTIONS

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Durabak is a high quality, one part polyurethane. With other truck bed liner products, either you need expensive equipment to apply or you must hire a professional. Durabak pickup bedliner is a Do-It-Yourself application that can be applied by roll, spray, or brush onto the surface without these high cost hassles.

Durabak will **increase the value** of your truck immensely. We have a 98% success rate for customers purchasing Durabak. It can be applied to the interior and undercarriage of your truck as well to protect from debris/gravel. Not only will it protect and upgrade, but it will look great as well.

Directions to apply Durabak are just as easy. All you need is to roughen (to remove the shine) and clean the surface, mix contents and apply. Recommended usage is 2 coats of Durabak. One gallon covers a 6 foot truck bed with the recommended 2 coats and one gallon plus one quart will cover an 8 foot truck bed with the recommended 2 coats.

Durabak (aromatic version) and Durabak 18 (aliphatic version) may be used for as a truck bed liner. However, Durabak 18 is recommended for maximum UV protection where there is exposure to sunlight.

Durabak and Durabak 18 may be applied by brush, special stipple roller, or a specific type of spray gun.

**6 foot truck bed** - is covered by 1 gallon with the recommended 2 coats.

**8 foot truck bed** - is covered by 1 gallon and 1 quart with the recommended 2 coats.

Thickness after applying 2 coats is approximately 25-30 mils.

## What you need:

- ✓ Durabak
- ✓ Xylene
- ✓ (2) 4" Special stipple rollers
- ✓ Masking tape
- ✓ 60-grit sandpaper
- ✓ Rubber gloves
- ✓ Rags
- ✓ Electric drill with paint mixer attachment

## Application Steps:

- ✓ Clean the surface with TSP or similar cleaning agent.
- ✓ Rinse with water and dry well.
- ✓ Using a 60-grit sandpaper, score the surface.
- ✓ Wipe with xylene.
- ✓ Mask off area not to be coated.
- ✓ Apply a first coat of the DURABAK coating using 4" special stipple roller. (If a spray application is desired, please see spray gun specs.)
- ✓ When first coat is touch dry, apply second coat.
- ✓ Allow application to thoroughly dry 12 hours or more

Please note that all surfaces **must be dry and clean before applying Durabak**. If the Durabak will be applied by roller, please use our special stipple roller sleeve. Use of a regular roller will cause clumping.

Mask all areas not to be coated. Remove masking tape after application of second coat. If tape sticks, cut along edge with razor.

### **IMPORTANT -- READ CAREFULLY!**

Durabak contains flammable solvents. Ensure proper ventilation and fire precautions.

## BRUSH APPLICATION

Durabak can be applied with a soft paint brush in two coats at right angles to one another. (Durabak is not a paint, and should be laid onto the surface, in one direction, not brushed out as an oil or latex paint.) Between coats, clean brush only with recommended thinner/cleaner (xylene). The second coat can be applied as soon as the first coat is tacky or touch-dry (usually within one hour). Extreme climatic conditions of heat, cold and humidity can shorten or lengthen this period.

## COVERAGE

One quart covers a flat area of about 15 square feet in two coats; one gallon covers 55 to 60 square feet, with a final dry coat thickness of 29-39 mils.

### IMPORTANT ADVICE!

- Durabak should be stirred thoroughly before applying -- preferably with an electric paint mixer -- as shaking the can will not mix rubber granules evenly.
- Stir periodically to maintain rubber granules in suspension.
- Do not apply Durabak too thickly, or pooling and "mud cracking" may occur, resulting in loss of slip resistance.
- If Durabak goes on too thickly, wait until the surface begins to get tacky and go over it with a relatively dry stipple roller in one direction.

- Durabak is a moisture-cured product. An open or partially used can will thicken and eventually become unusable. Seal can well and turn upside down for a few minutes. This will seal any space in the can and may prolong the life of the unused portion of Durabak. You can also pour the unused Durabak into a smaller sealed container.
- If the product thickens slightly, but is still liquid, it can be thinned by using up to 15% of the recommended thinner/ cleaner xylene without affecting performance.  
IMPORTANT: Other solvents can cause product failure. Do not dilute product or clean rollers, brushes or spray guns with lacquer thinners.
- Once the consistency of the product has become pasty and unmixable, it should be discarded. If Durabak is thick but still liquid, it can be thinned with xylene and used.
- Normally, Durabak can be subjected to light foot traffic within 12 hours. This time can be reduced significantly by using accelerator. The coating should not be subjected to cleaning or chemical exposure until fully cured, in 2-4 days (approximately 96 hours). For specific extreme kinds of loading, contact us.

Durabak takes about **four days** to fully cure: fewer in hot humid conditions, and more in cold dry weather. With accelerator, curing time is reduced by up to 75%.

PLEASE NOTE that full curing time only affects the amount of time required to wait before subjecting the surface to cleaning and chemical exposure. Surface can be subjected to loading well before this minimum time requirement (see above).

## IMPORTANT ADVICE

- Remove any over-spray immediately with Xylene. Durabak is very difficult to remove once cured.
- Solvents released when spraying are flammable. Observe all fire precautions. Proper ventilation is required.
- Keep water out of hose line or foaming could occur.
- Clean spray gun between coats and immediately after job is completed. Use only approved thinner/cleaner Xylene.

## SPRAY APPLICATION

Durabak can be sprayed using a simple shutz gun, a hopper gun, or professional spray equipment. Make sure to thoroughly mix Durabak. A drill with a mixing adaptor works best. Durabak should flow through the spraygun easily and can be thinned with Xylene. Some recommended spray guns are:

- Spay schutz gun with a 1/4" orifice (and no filter), attached to a 45-60 PSI compressor.
- Binks #2001 gun, 59BSS x 559 needle assembly and a 251 internal mix nozzle. 15 (Cubic Feet per Minute) CFM is needed with a 3/8" fluid inlet. #71-3323 25 foot V2" Solvent resistant Fluid Hose Assembly (tank to gun)
- Binks #7D gun with a 57SS x R-30 internal mix nozzle. 16 CFM is needed with a V2" Fluid inlet. #71-283 25 foot V2" Fluid hose with #72-1333 and #72-1334 connectors  
Binks accessories:

#71-1205 25 foot 5/16" Air Hose Assembly (tank to gun) #83-5668 (2) gallon capacity tank with (2) regulators #6-228 tank liners: (Box of 96)

#71-1355 3/8" air hose (compressor to tank)

\*\* To remove contaminants from the air line, use Oil & Water extractors mounted at the pressure tank

- Sears Craftsman No. 15524 (or De Vilbiss AS 300) with external mix nozzle. Requires 7 CFM. Use compressor with 9 CFM at 50 psi. (For more information call De Vilbiss Air Power Tools at (901) 423-7983)
- Airless spraygun: Graco Bulldog 33:1 with air intake pressure = 6-7 bar (90-100psi). Outlet pressure = 200bar (+/- 3000psi). Tip: 0.035 ins to 0.039 ins (ie 35 - 39 thou). Delivery rate: 2.9 Gallons per minute.
- For smooth Durabak: Graco Bulldog 33:1 with 21 -23 thou. tip.
- Use a respirator with chemical absorbing cartridges. Such as Binks #40-128
- Before starting the job, spray a few short bursts away from the surface to test that everything is working properly.
- If Durabak does not spray easily and evenly, thin with enough xylene (up to 15%) to spray easily.
- Spray an even coat over the entire surface to be covered in a quick, "S"-shaped motion. Be careful not to apply coat too thickly.
- When surface becomes tacky, spray second coat. Extreme climatic conditions of heat, humidity and cold can shorten or lengthen the drying period.
- Intercoat / curing time can be significantly shortened by use of special accelerator (see section on accelerator).