



Previous Issues

[Technique](#) **February '08**

[The Mix](#) **March '08**

Check out previous issues by clicking on the above links.

Batch Timing

At least 80% of all tech questions are about texture – how do I get this or that texture?

Textures are a combination of several factors.

1. The mix of the product.
2. How long the window is between mix time and spray time.
3. Gun pressure.
4. Technique.

The next tip or trick we are going to cover is **batch timing**, which basically means that you use the pot life to your advantage.

Let's start with the simplest way which is giving your batch a chance to set up before spraying. Normally allowing your batch to sit mixed for 5 minutes can significantly change its texture. Keep in mind that the looser (or fresher) the material, the better the air from the tip will atomize it. So this means that spraying a freshly mixed batch results into a finer, smoother texture over all.

Also keep in mind that we spray with multiple batches for a reason, it allows each batch to cure up a bit before the next batch is sprayed over it. This allows the 1st batch to hold the weight of the 2nd and that is what builds texture. If you were to mix 2 large batches at the same time, their pot life is identical, so they would melt together, thus smoothing out. While on the subject of batch timing, let's talk about the accelerator. From my experience, it's wonderful for producing texture, though I have found that it can actually produce too much texture or "popcorning" as we call it. Popcorning is where the drops build so well on top of each other, that holes will actually form (much like a bowl of popcorn or the shipping "popcorn" that annoys us all when we spend weeks cleaning it out of our shops). One way to avoid this is to not run Accelerator in every batch of your applications. Instead save it till the end. Remember that temperature plays a big part in your pot life as well. As the cold subsides and the summer approaches, you might find that you won't even need the accelerator to produce the easy and quick texture. The warmer the material, the

Tech Tips

TRUCK BED LININGS

SCORPION



looser it sprays, but the faster it will dry. Basically, "Mother Nature" will handle the texture in your trucks, unless you control chemical temperature by other means.

One of the most frequently asked questions is: How can I produce the "Line-X" texture in my truck. I get asked that at least once a week. Most of us (including myself) or our customers like that texture. Air pressure and technique play a big part in achieving it, but that is a tip for another month. Line-X achieves it because of their fast tack time. Each pass put down is smooth and dries in seconds. So when they are near the end of their spraying process on a truck, they stand outside of the truck and "dust" it with a texture pass (much like we do). So how do you duplicate it? Simply let the material dry up. Keep in mind that unless you happen to have an expensive roll of wire tape in your shop, or the world's steadiest hand with a razor knife, then you need to keep from spraying your tape lines until you have finished applying your dust pass. I suggest running accelerator in your final texturing batch, because it seems to produce more of a distinct rounded texture that stands up more than without accelerator. It usually takes at least 30-40 minutes before the bed is ready for the Line-X texture pass. Usually a small patch is enough to achieve the kind of texture you are looking for.

Next month we will talk about air pressure and how it affects the outcome of your applications. Until then, have a great month! As always, I would be more than happy to help you with a tech questions that might arise. Please feel free to call me or email me at brad@scorpioncoatings.com anytime!!

Brad Tomasino
Technical Support (800-483-9087)
brad@scorpioncoatings.com

Motivation, Good Techniques, Proper Tools = Profit

www.scorpioncoatings.com

800 483-9087