



PRODUCT INFORMATION

SEM GLADIATOR XC KITS

PRODUCTS:

SEM GLADIATOR XC 1L BLACK BED LINER KIT	SEM-56650/1L
SEM GLADIATOR XC 4L BLACK BED LINER KIT	SEM-56650/4L
SEM GLADIATOR XC 1L TINT BED LINER KIT	SEM-56670/1L
SEM GLADIATOR XC 4L TINT BED LINER KIT	SEM-56670/4L

PRODUCT DESCRIPTION:

Gladiator XC is a high quality, 2K urethane, texture coating that provides a durable, chemical and fade resistant protective finish for truck beds, recreational vehicles, industrial equipment, restoration and more.

- Tough and durable coating
- Produce a variety of textures
- Excellent fade resistance and UV stability
- Outstanding adhesion to most surfaces when used with a primer
- Easy application with the SEM Gladiator XC Gun or with a HVLP gun, roller, or brush

PREPARATION OF SUBSTRATE:

BARE METAL, ALUMINUM, GALVINIZED, POLYESTER FILLER, AND EXISTING OEM PAINT



Pressure wash the surface if needed. Clean with SEM Solve or a wax and grease remover. Sand the surface with P180 grit sandpaper or red scuff abrasive. Blow off and tack clean.

Prime any bare metal and aluminum areas with a 2-pack epoxy or etch primer. Scuff the primer with a red scuff abrasive. Blow off dust and tack clean.

FIBERGLASS, PLASTIC, AND SMC



Clean with SEM Solve. Surface must be completely dry; avoid saturating panel with cleaner. Sand the surface with P180 grit sandpaper, blow off dust and tack clean.

If applying to plastics, apply one full wet coat of a Plastic Adhesion Promoter. Allow to flash 3 – 5 minutes before applying Gladiator XC. If topcoat time exceeds 24 hours, scuff, tack, and reapply adhesion promoter.

IMPORTANT! Gladiator XC will not stick to polyethylene, even with the use of an adhesion promoter.

Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.



PREPARATION OF SUBSTRATE CONTINUED:

E-COAT

Clean with SEM Solve or a wax and grease remover. Scuff the surface with a coarse abrasive pad, taking care to not scuff through the e-coat. Blow off dust and tack clean.

Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

MIXING GUIDE:

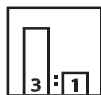


Gladiator XC is a shake-and-spray system.

Pour 250mL can of Hardener (SEM-56648) in the 750mL can of bedliner (SEM-56650/SEM-56670) to create 1L. Close lid and shake to mix for 2 minutes per can.

Refer to the below chart for appropriate mix ratios. Note that reduction is not needed when applying with SEM Gladiator XC Gun or roller.

MIXING RATIO:



GLADIATOR XC BLACK	Coating (SEM-56650)	Tint	Hardener (SEM-56648)	Reducer (Optional)*
Shake-and-Spray	1 Can	N/A	1 Can	0-10%
Mix by Ratio	3 Parts	N/A	1 Part	Up to 10%

GLADIATOR XC TINT	Coating (SEM-56670)	Tint	Hardener (SEM-56648)	Reducer (Optional)*
Shake-and-Spray	1 Can	50-100g	1 Can	0-10%
Mix by Ratio	3 Parts	5-10%	1 Part	Up to 10%

Note: Tint with premium automotive solvent based DG/2K tinters ONLY such as Delfleet, Selemix, Paraglaze or Deltron tinters. Do not use water-based tint. Tint coating (SEM-56670) and mix well prior to adding hardener (SEM-56648).

Reducer is only required for HVLP gun application to reduce viscosity. Only use solvent based reducers (recommended to thin with F3325, DT820, PS-6200 or PUR20). For a fine texture coat, reduce Gladiator XC by 10% and for a medium texture coat reduce by 5%.

APPLICATION

SEM GLADIATOR GUN



COATS:	1 light coat followed by 2-3 medium coats
FLASH TIME:	10-15 minutes @ 21°C
AIR PRESSURE:	2-4 bar

Note: A final drop coat will lower gloss and change texture. Always spray a test panel to ensure desired texture.

IMPORTANT! Variations in temperature, air pressure, distance from substrate and applicator used will affect texture.



HVLP SPRAY GUN



COATS:	2-3 medium coats
FLASH TIME:	10 -15 minutes @ 21°C
AIR PRESSURE:	0.7-2 bar
NOZZLE SIZE:	1.8-2.2mm

IMPORTANT! In hot and/or humid conditions, you must apply lighter coats and allow longer flash times between coats. The first coat should not achieve full coverage and subsequent coats should be applied in the same manner.

ROLL



Cut in hard-to-reach areas with a brush prior to rolling. Using the Heavy Texture Roller, slowly apply product in one medium wet coat using medium pressure. Texture can be increased with additional rolling after product starts to set up.

Note: For uniform appearance, complete all rolling while product is still wet. To avoid trapping solvent do not over apply. Any pooled or over-applied areas should be brushed or rolled out. Do not apply more than one coat.

DRYING TIMES:



TOUCH DRY:	30 minutes
HARD DRY:	24 hours
BAKING:	10-minute flash, 30-minute bake at 60°C

Allow up to 7 days for through cure before full use.

Note: Drying times can vary dependent on temperature, flash off between coats, film builds, and number of coats applied.

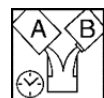
TOPCOATING:



GLADIATOR XC can be painted over with most paint systems.

If top coating, let GLADIATOR XC dry for 24 hours. Scuff with a fine abrasive pad, blow off dust and tack clean. Follow paint manufacturer's instructions for paint application.

POT LIFE:



Activated material is useable for up to 1 hour at 25°C.

CLEAN UP:



Remove all masking tape while final coat is still wet. Use appropriate cleaning materials compliant with VOC regulations in your area.

STORAGE:

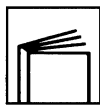


Gladiator XC should be stored between 16 – 27°C.

The shelf life for Gladiator XC and Gladiator XC Activator is 3 years when stored under ideal conditions.



HEALTH AND SAFETY:



Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.

Good ventilation and extraction must be provided in the working environment.

When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.

Do not smoke whilst using this material.

PPG INDUSTRIES AUSTRALIA PTY LIMITED

McNaughton Road
Clayton VIC Australia 3168
Tel: 13 2424
Fax: 1800 800 819

PPG INDUSTRIES NEW ZEALAND PTY LIMITED

5 Vestey Drive Mt. Wellington
Auckland New Zealand
Tel: 0800 320 320
Fax: 0800 320 322

