

Technical Data Sheet.



Permasolid® Texture Component SA 101 coarse / SA 102 fine.

Permasolid® Texture Component SA 101 coarse and Permasolid® Texture Component SA 102 fine are additives for Permasolid® HS Automotive Top Coat 275 and can be used to convert the top coat into a textured coating.

This top coat can then be used for painting plastic parts of vehicles.

For professional use only!
VR Technical Data Sheet No. EN / 0101_0102 / 02

Substrate.

Suitable substrates:

1. Fully cured, well maintained and lightly sanded original or old finish.
2. Plastic parts coated with a primer and surfacer

Substrate pretreatment:



For plastic parts, see System Data Sheet "The Paint System for Plastic Parts" (SYS 903.1).



Thoroughly clean original or old finish and surfacer with Permaloid® Silicone Remover 7010 or Permaloid® Silicone Remover 7799.



Sand dry with random orbital sander and dust extraction, P400 – 500 grade
or



wet with P800 grade.



Before further treatment carefully clean substrate with a suitable cleaning agent to remove dust and residues.

Application.

Mixing ratio:



1:1 by volume with Permasolid® HS Automotive Top Coat 275

Then mix this 4:1 by volume with a suitable Permasolid® VHS Hardener.
(see Technical Data Sheet "Permasolid® HS Automotive Top Coat 275")

Pot life:

Ready for use 90 - 100 minutes at +20°C.
(depending on hardener used)

Reducer:

Permacron® Reducer 3380
Permacron® Reducer 3385 slow

Method of application:

Application viscosity
4 mm, +20°C, DIN 53211:





Reducer at +20°C
material temperature:

Spray nozzle*:

Spray pressure*:

Atomising pressure*:

Number of coats:

	Compliant	HVLP
	mixing viscosity	
	15%	
	1.3 - 1.4 mm	1.3 - 1.5 mm
	2.0 - 2.5 bar	-
	-	0.7 bar
	2 coats = 50 - 60 µm Apply 2 coats with an intermediate flash-off time of 5 - 10 minutes to achieve an even paint film surface.	

Special notes.

1. It is not necessary to add:
Permasolid® Elastic Additive 9050
2. Permasolid® Texture Component SA 101 coarse and
Permasolid® Texture Component SA 102 fine are only
suitable for use on add-on parts (e.g. bumpers, spoilers).
3. Different effects can be achieved by using different spraying
techniques and film thicknesses.
4. Permasolid® Texture Component SA 101 coarse and
Permasolid® Texture Component SA 102 fine are thixotropic
and become liquid after stirring.

Drying.

Air drying:



At +20°C ambient temperature:

dust dry: 30 - 50 minutes
dry for handling: 4 - 6 hours
dry: overnight

Force drying:



Flash-off time:

5 - 10 minutes



Drying time at

+60°C metal temperature:

30 - 40 minutes

* See manufacturer's instructions!

Infrared drying:



Flash-off time:

5 minutes



medium wave:

15 - 20 minutes

short wave:

10 - 15 minutes

Note on safety:



This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

It is strongly recommended to use appropriate personal protection equipment during application.

Data.

Flash point:

above +23°C

VOC content:

2004/42/IIB(e)(840)600

The EU limit value for this product (product category IIB.e) in ready to use form is max. 840 g/litre of VOC.

The VOC content of this product in ready to use form is max. 600 g/l.

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