## 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")

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

Permacron® Reducer 3380 Permacron® Reducer 3385 slow

Pot life:

Reducer:

Method of application:

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

Reducer at +20°C material temperature:

Spray nozzle\*:

Spray pressure\*:

Atomising pressure\*:

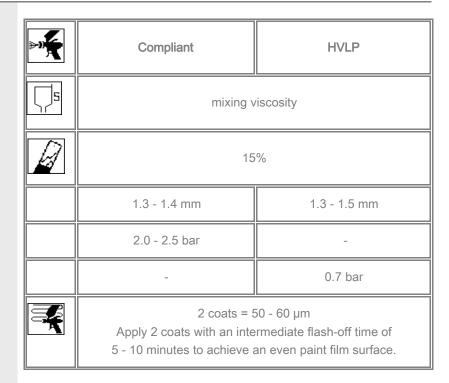
Number of coats:

### Special notes.

#### Drying.

Air drying:

Force drying:



- 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.
- Permasolid® Texture Component SA 101 coarse and Permasolid® Texture Component SA 102 fine are thixotropic and become liquid after stirring.



At +20°C ambient temperature:

dust dry:30 - 50 minutesdry for handling:4 - 6 hoursdry:overnight



Flash-off time: 5 - 10 minutes



Drying time at

+60°C metal temperature: 30 - 40 minutes

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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