

# Technical Data Sheet.

## Permasolid<sup>®</sup> Matting Additive MA 100

Permasolid<sup>®</sup> Matting Additive MA 100 is a special additive for Permacron<sup>®</sup> Series 257 top coats.

It gives the material a satin gloss, elastifying it at the same time, and is therefore suitable for painting plastic parts on vehicles as well as for satin gloss finishes in general.

This product is for professional painting of vehicles only.



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## Substrates

**Suitable Substrates:** Original or old paintwork (except reversible substrates, **Example:** lacquer)  
 Priomat® Primer/Surfacers  
 Permacron® Primer/Surfacers  
 Permahyd® Primer/Surfacers  
 Permasolid® Primer/Surfacers

**Special Note:** For plastic parts see System Data Sheet “The Paint System for Plastic Parts”. (VR Technical Data Sheet No. 901.1).

**Substrate pretreatment:**



Degrease and sand.



Before further treatment, clean all substrates once more with Permanent® Silicone Remover 7010 Slow, Permanent® Silicone Remover 7799 Fast, Permahyd® Silicone Remover 7085, Permahyd® Silicone Remover 7090, or Permahyd® Silicone Remover 7095.

## Application

**Mixing ratio:**








1:1 by volume\* with Permacron® 257 then add 3:1 by volume with a suitable Permasolid® HS Hardener.

\* **Special Note:** *It is possible to vary the degree of gloss by adding 20-100%, as an alternative to the standard ratio of 1:1.*

**Pot Life:** Ready for use approximately 1½ hours at 68°F/20°C.

**Reducer:** Permacron® Reducer  
 Ex. -Permacron® Dura Plus 8580 or  
 -Permacron® Reducer 3363 medium  
 For optimum reducer selection, refer to TDS # 780.0.

Method of application	HVLP 	Approved Transfer Efficiency 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3-1.4mm	1.2-1.3mm
 Application viscosity 4mm, 68°F/20°C, DIN 4	17 - 19 seconds	
 Reducer at 68°F/20°C material temperature	Up to 5%	
 Number of coats	<ul style="list-style-type: none"> <li>2 coats with Permacron® Acrylic Urethane Top Coat Series 257</li> </ul>	

**Recommended film thickness:** 2.0 – 2.5 mil dry film thickness

## Drying

### Air drying:



At 68°F/ 20°C

dust free:

40-50 minutes

dry for assembly:

4-6 hours

dry through:

12 hours

### Low baking:



Flash off time:

approx.5-10 minutes



Drying time and temperature:

40 minutes at 140°F/ 60°C  
metal temperature

## Special tips

1. The use of Permasolid® Elastic Additive 9050 is not necessary because the Matting Additive MA 100 is already elastified.
2. According to the gloss level required, less than 100% Matting Additive can be added in the case of hard plastic parts. The mixing ratio with hardener remains unchanged.
3. The actual gloss level produced also depends on the hardener used, the film thickness and the drying method. Hardeners with a higher solid content, high film thicknesses or baking always result in a slightly higher gloss level.
4. Permasolid® Matting Additive MA 100 is thixotropic, i.e. it becomes liquid after stirring.
5. Permasolid® Matting Additive MA 100 cannot be used in Clear Coats.
6. Permacron® Dura Plus 8580 may be added to improve dry time. (up to 10 %)

## Important Regulatory Information

Please see the appropriate VOC Wallchart for compliance for your area. This product is used in various products. The values for the coating are listed in the corresponding TDS for the Core product.

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.

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