

Technical Data Sheet.

Permasolid[®] Texture Additive

TA 101 coarse / TA 102 fine

Permasolid[®] Texture Additive's are special additives for Permacron[®] Series 257 topcoats. It gives the paint a coarse or fine texture and elastifies it at the same time.

It is mainly used for painting textured plastic parts on vehicles.

This product is for professional painting of vehicles only.



VR Technical Data Sheet No. 620.0(12/2000) Jan. 2007

Substrates

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



Hand stir or shake



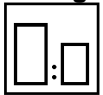
Degrease and sand.



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 Series then add 3:1 by volume with a suitable Permasolid® HS Hardener.

Pot Life:

Ready for use approximately 1½ hours at 68°F/20°C.

Reducer:

None

Method of application	HVLP gravity feed 	Approved Transfer Efficiency gravity feed 
	Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	
Spray Nozzle	1.3-1.4mm	1.3-1.4mm
 Application viscosity 4mm, 68°F/20°C, DIN 53211	Approximately 24 seconds	
 Reducer at 68°F/20°C material temperature	NA	
 Number of coats	<ul style="list-style-type: none"> 3 light coats with Permacron® Automotive Top Coat Series 257 	

Recommended film thickness: 2.0 - 2.5 mil dry film thickness.

Special Note: Remove in-line spray gun filter.

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 Texture Additives TA 101/102 are already elastified.
2. Permasolid® Texture Additive TA 101/102 is thixotropic, i.e. it becomes liquid after stirring.
3. For the application of textured metallic colors see VR Technical Data Sheet No.901.1.
4. Do not strain!
5. Not for use in clear coats.

Important Regulatory Information

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
257 Series Specialty Coating Structure	4.8 lbs/gal - 574 g/l	998 g/l	57.7%	0%

- **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.**
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