

# Technical Data Sheet.



## Permasolid® Matting Additive MA 100

### Substrate

### Application

Permasolid® Matting Additive MA 100 is an additive for

### Special notes

Permasolid® HS Automotive Top Coat Series 270  
Permacron® Automotive Top Coat Series 257

### Drying

and produces a matt effect.

### Data

It gives the top coat a satin gloss and is suitable for painting plastic parts as well as for creating satin gloss finishes in general.

### Storage

**For professional use only!**



# Substrate



## Suitable substrates:

1. Fully cured, well preserved and lightly sanded original or old paintwork
2. Surfaces coated with primer and surfacer
3. Plastic parts coated with primer and surfacer

## Substrate pretreatment:



For plastic parts, see System Data Sheet "The Paint System for Plastic Parts" (VR Technical Data Sheet No. 903.1) or "Permahyd® / Permasolid® Paint System for Plastic Parts" (VR Technical Data Sheet No. 902.1).



Thoroughly clean original or old paintwork and surfacer, Dry sand with random orbital sander and dust extraction P 400–500 or wet with P 800.



Before further treatment, clean all substrates once more with Permanent Silicone Remover 7010 or Permalan® Silicone Remover 7799.

# Application



## Mixing ratio:



1:1 by volume with Permasolid® HS Automotive Top Coat Series 270 then mix this 3:1 by volume with a suitable Permasolid® HS hardener.

(see VR Technical Data Sheet No. 500.6)

or

0.8:1 by volume with Permacron® Automotive Top Coat Series 257 then mix this 2:1 by volume with a suitable Permacron® MS hardener

or

3:1 by volume with a suitable Permasolid® HS hardener. and 15% reducer









(see VR Technical Data Sheet No. 900.2, 990.8, 500.4, 500.5, 500.6).

## Pot life:

Ready for use 90–100 minutes at +20°C.

## Reducer:

Permacron® Reducer 3364

Method of application		High-pressure spraying/Compliant		HVLP	
		Gravity feed	Suction feed	Gravity feed	Suction feed
					
	Application viscosity at +20°C material temperature	mixing viscosity			
	Reducer at +20°C material temperature	With Permacron® Automotive Top Coat Series 257 mixed 3:1 with HS hardener 5% reducer must be added.			
	Spray nozzle	1.4–1.5 mm	1.7–1.8 mm	1.3–1.5 mm	1.8–2.2 mm
	Spray pressure	4–5 bar	4–5 bar	—	—
	Internal nozzle pressure	—	—	0.7 bar	0.7 bar
	Number of coats	Permasolid® HS Automotive Top Coat Series 270 1 1/2 coats = 50–60 µm			
	Number of coats	Permacron® Automotive Top Coat Series 257 2 coats = 50–60 µm			

## Special notes



1. It is not necessary to add Permasolid® Elastic Additive 9050
2. Permasolid® Matting Additive MA 100 is not suitable for matting clear coats.
3. The actual gloss level produced also depends on the hardener used, the film thickness and the drying method. Hardeners with a higher solids content, high film thicknesses and low baking always result in a lightly higher gloss level.
4. Permasolid® Matting Additive MA 100 is thixotropic and becomes liquid after stirring.

## Drying



### Air drying:



At +20°C ambient temperature  
Dust dry: 40–50 minutes  
Dry for assembly: 4–6 hours  
Through dry: overnight

### Force drying:



Flash-off: 5–10 minutes



Drying time and temperature: 40–45 minutes  
at +60°C metal temperature

### Infra-red drying:



Flash-off: 5 minutes



Drying time: medium wave 10–15 minutes  
short wave 15–20 minutes

## Data



Viscosity as supplied: thixotropic

Flash point: above +23°C

## Storage



**Guaranteed shelf life:** 6 months in sealed original containers

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