

# Technical Data Sheet.



## Permasolid® Texture Additive

**SA 101 coarse / SA 102 fine**

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Permasolid® Texture Additive SA 101 coarse and  
Permasolid® Texture Additive SA 102 fine

are additives for

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

and can be used to convert these top coats into  
textured top coats.

This textured top coat can then be used both for  
painting plastic parts of vehicles and for producing  
textured finishes in general.

**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.

(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.

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			
	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 2 coats = 50–60 µm Apply first coat as normal. Adjust second coat to produce the desired textured effect.			
	Number of coats	Permacron® Automotive Top Coat Series 257 3 coats = 50–60 µm Apply three thin coats with 5 minutes flash-off between coats.			

## Special notes



1. It is not necessary to add Permasolid® Elastic Additive 9050
2. Permasolid® Texture Additive SA 101 coarse and Permasolid® Texture Additive 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 Additive SA 101 coarse and Permasolid® Texture Additive SA 102 fine are thixotropic and become 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 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

### SA 101 coarse

### SA 102 fine

Solids content:

45.0 % by weight

49.0 % by weight

37.0 % by vol.

44.0 % by vol.

Specific weight:

1.0 g/cm<sup>3</sup>

0.98 g/cm<sup>3</sup>

VOC value:

553 g/l

493 g/l

## Storage



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

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SPIES HECKER GMBH  
Fritz-Hecker-Str. 47 - 107 D - 50968 Köln  
Phone (0)2 21 - 37 06-06 Fax (0)2 21 - 37 06-410