



TEXTURE COAT TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

Texture Coat duplicates texture commonly found on automotive plastic bumper covers, lower valances, wheel lip moldings, rocker molding and various other parts.

FEATURES

- Texture and top coat in one product
- Excellent UV stability and durability
- Fast dry time
- 2.8 voc compliant
- Easy to apply

SUITABLE SUBSTRATES

PROPERLY PREPPED (SEE PREPARATION SECTION)

- Raw plastics
- Epoxy primer
- 2K urethane primer
- **Plastic Primer**

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
4P-15-014	Texture Coat - Black	Black	Flat Top Quart
4P-15-064	Texture Coat - White Tint	White	Flat Top Quart
4P-15-046	Texture Coat Activator	Clear	Cone Top ½ Pint

PRODUCT SPECIFICATIONS

RTS VOC:	< Less than 2.8 VOC
Pot Life @ 70°F (21°C) and 50% R.H.:	30 Minutes
Dust Free Time:	30 minutes
Handling Time:	45-60 minutes

Always follow local VOC regulations for your area.



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Always wear OSHA required (PPE) Personal Protection Equipment as outlined on the SDS and product label to ensure your safety.



PREPARATION

FLEXIBLE, OLEFIN-BASED PLASTIC

1. Clean repair area with **Scuff & Clean** and a red scuff pad. Rinse with water and dry or wipe with a clean, damp cloth until removed.
2. Next, clean with **Plastic & Leather Prep**, **SEM Solve** or **XXX Universal Surface Cleaner**. Surface must be completely dry; avoid saturating panel with cleaner.
3. Re-sand the surface with a red scuff pad or P180-320 grit sandpaper, blow off dust and tack clean.
4. Apply one full wet coat of **Adhesion Promoter**.
5. Allow to flash 3 – 5 minutes before applying **Plastic Primer** or **Texture Coat**. If topcoat time exceeds 24 hours, scuff, tack, and reapply adhesion promoter.

IMPORTANT! **Texture Coat** will not stick to polyethylene, even with the use of an adhesion promoter.

PLASTIC PRIMER, EPOXY PRIMER, 2K URETHANE PRIMER

IMPORTANT! User must determine if selected primer is suitable for the application/substrate. Follow manufacturer's instructions on prep and application

1. Sand with a red scuff pad, or P180-320 grit.
2. Blow off and re-clean with **Plastic & Leather Prep**, **SEM Solve** or **XXX Universal Surface Cleaner**.



MIXING

Note: **Texture Coat - Black** may be tinted with **Texture Coat – White Tint** in 5% increments to achieve varying grades of gray. Mix products together prior to the addition of **Texture Coat Activator**.

	Texture Coat	Texture Coat Activator
Mix by ratio	7 parts	1 part

Note: Mix/stir well after activation.



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APPLICATION

STANDARD SPRAY APPLICATOR

Tip Size:	1.4
Coats:	2-3 light coats
Flash Time between Coats: (see section below for high heat and/or humidity applications)	5 – 10 minutes @ 70°F (21°C)
Air Pressure & Distance:	5 psi @ 6 – 8" from panel for heavier texture 15 psi @ 12 – 15" from panel for lighter texture

Variations in temperature, air pressure, distance from substrate and applicator used will affect texture.

High heat / humidity applications: To aid with the short pot life during application in areas of high heat and/or humidity, several options can be used. The first option would be to shorten the flash time to within 1 to 5 minutes between coats. In extreme cases, **Texture Coat** can be over-reduced with slow urethane reducer up to 10%, however, this addition will change the final product's VOC content and texture. Always follow local VOC regulations for your area.

Note: While two techniques are given in chart above as a reference to producing heavy and light textures, factors such as the type of spray equipment (HVLP, RP, Non-HVLP) and the amount of trigger pull can provide even more variations. Additionally, a final drop coat can be applied to lower gloss and adjust texture. Always spray a test panel to ensure desired texture.



CLEAN UP

Use appropriate cleaning materials compliant with VOC regulations in your area.



STORAGE

Products should be stored between 60 – 80°F (16 – 27°C). The shelf life for **Texture Coat - Black**, **Texture Coat – White Tint** and **Texture Coat Activator** is 3 years when stored under ideal conditions.



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RELATED PRODUCTS

Part:	Product:	Size:
38373	SEM Solve	20 oz. Aerosol
38353	Plastic & Leather Prep	16 oz. Aerosol
4P-15-034	Plastic Primer	Quart
4P-15-053	Adhesion Promoter	16 oz. Aerosol
38398	Scuff & Clean	16 oz. Tube
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart
77763	XXX Universal Gun Cleaner	20 oz. Aerosol

Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

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