

Technical Bulletin ETB004

Textured Finish Repair System

ENVIROBASE® High Performance textured finish is designed to provide a simple refinishing process for textured plastics. The textured finish system is a combination of components from the VIBRANCE COLLECTION® along with internal repair / engine bay ancillaries products. Once mixed, *Envirobase* High Performance texture finish is capable of providing an accurately matched finish on textured plastic body parts.

PREPARATION OF SUBSTRATE



Before and after any sanding operation the substrate must be thoroughly cleaned and degreased by using ONECHOICE® SWX350 H2O-SO-CLEAN® Waterborne Pre-Cleaner. Apply liberally with a clean cloth and wipe dry with another. Be sure to wipe the cleaner off completely and do not let it dry on the surface. If it dries prior to removal, re-wet the surface again and dry off completely.



Textured *Envirobase* High Performance system may be applied over most automotive plastics after proper preparation and cleaning. Bare plastics must be cleaned with *OneChoice* Plastic Prep System (See OC-1) and primed or sealed before application of the Textured *Envirobase* High Performance system. Painted surfaces must be lightly abraded with a fine gray scuff pad followed by a final cleaning with SWX350.

MIXING

Making Textured System Ready to Spray

VWM5556 Waterborne Midcoat	70% by weight
T510 Waterborne Engine Bay Converter	30% by weight
SL1999 Texture Additive	10% by weight

Stir Well Before Activating and Thinning

T581 Engine Bay & Basecoat Activator	15% by weight
T494 Thinner	10% by weight

Stir Well After Activating and Thinning

Mix Table for Textured System

The Parts (Grams) are Cumulative - DO NOT TARE / ZERO OUT THE SCALE BETWEEN ADDITIONS						
VWM5556	T510	SL1999	STIR WELL	T581	T494	Approx. RTS oz.
Parts (Grams)	Parts (Grams)	Parts (Grams)		Parts (Grams)	Parts (Grams)	oz.
69.0 (61.3)	98.7 (87.6)	107.6 (95.5)		123.3 (109.4)	133.1 (118.2)	4 oz.
138.0 (122.5)	197.4 (175.2)	215.2 (191.0)		246.5 (218.9)	266.2 (236.3)	8 oz.
207.1 (183.8)	296.1 (262.9)	322.8 (286.5)		369.8 (328.3)	399.4 (354.5)	12 oz.
276.1 (245.1)	394.8 (350.5)	430.4 (382.0)		493.1 (437.7)	532.5 (472.7)	16 oz.
414.1 (367.6)	592.2 (525.7)	645.5 (573.0)		739.6 (656.6)	798.7 (709.0)	24 oz.
522.1 (490.1)	789.6 (700.9)	860.7 (764.1)		986.2 (875.4)	1065.0 (945.4)	32 oz.

POTLIFE AND VISCOSITY

Potlife:	1 hour at 70° (21°C)
Spray viscosity:	24-30 seconds DIN4 at 70°F (21°C)

APPLICATION

Note: DO NOT STRAIN the textured mixture before application. If using a disposable paint cup system be sure to remove all strainers.

HVLP / Compliant System:	1.2-1.4 mm
Spray Pressure:	Refer to manufacturer’s recommendation for inlet air pressure
Application:	Apply 2 to 3 single light coats to achieve the desired appearance. Total film thickness of 0.5-1.0 mils

FLASH OFF

Flash Off:	For optimum process times blow dry between coats.
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RECOAT

After the final coat of textured finish has been applied and flashed off apply the un-textured waterborne basecoat color and clear coat according the product specific P-sheets and complete the repair.

TECHNICAL DATA

RTS Combination	VWM5556 : T510 : SL1999 : T581 : T494
Mix Ratio	70 : 30 : 10 : 15 : 10
Applicable Use Category	Other
VOC Actual (g/L)	85
VOC Actual (lbs. / US gal.)	0.70
VOC Regulatory (less water, less exempts (g/L))	228
VOC Regulatory (less water, less exempts lbs./ US gal.)	1.90
Density (g/L)	997
Density (lbs. / US gal.)	8.32
Volatiles wt. %	72.5
Water wt. %	63.4
Exempt wt. %	0.0
Water vol. %	63.3
Exempt vol. %	0.0
RTS Solids vol. %	27.5
Sq. Ft. Coverage 100% transfer efficiency at 1 mil.	441

