

## Variable Texture Coating

Flextex VT is a variable texture coating formulated to simulate textured automotive plastics. It can be used over or under most finishes and may be top-coated with base/clear or single stage paint systems. Flextex VT has excellent durability and may be used as the finish coat where black texture is needed.

### Benefits:

- Simulates OEM textures
- Adjust texture size by varying reduction ratio & spray technique
- Compatible with all topcoat systems
- Does not require topcoating if black texture is desired

### Application:

- For best results, apply Flextex VT over a primer-surfacer sanded with 320 grit. See [www.polyvance.com](http://www.polyvance.com) for info sheets and instructional videos on texturing.
- To build texture, apply 3 to 5 light “speckle” coats allowing flash time between coats. Move gun quickly and don’t flow out the paint. Reduce fluid flow at gun for light coats. Let dry 30 minutes if light coats are applied and 2 to 3 hours for heavier applications before top coating. For more details on applying Flextex VT, see reverse side for application SOP.
- Flextex VT may be top coated with a lacquer-compatible topcoat system.
- Clean spray gun immediately after use with lacquer thinner.

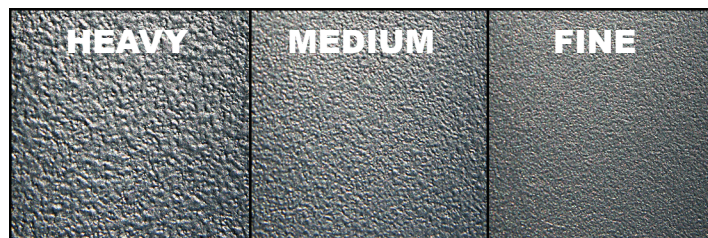
**Texturing Reference:** Use a test panel for determining the texture desired. Painting with limited amounts of reducer, larger nozzle, and low air pressure at the gun will produce the coarsest texture. For finer textures, reduce the paint with the appropriate Flextex VT reducer.

**Heavy Texture:** Spray Flextex VT mixed 8:1 (paint:reducer) using a 1.8 mm spray gun at 25 psi.

**Medium Texture:** Spray Flextex VT mixed 3:1 (paint:reducer) using a 1.4 mm spray gun at 25 psi.

**Fine Texture:** Spray Flextex VT mixed 1:1 (paint:reducer) using a 1.4mm spray gun at 25 psi.

Textures Shown Actual Size



### Product Specifications

Part Number	Shipping Weight	Dimensions
3804-1 Flextex VT	8.3 lbs 3.77 kg	6.5" dia x 7.5"h
3804-4 Flextex VT	2.4 lbs. 1.09 kg	4.25" dia x 5"h
3804N-4 Standard Reducer	2.25 lbs 1.00 kg	2.5"h x 4.75"w x 7.5"h
3804R-4 Zero VOC Reducer	2.25 lbs 1.09 kg	2.5"h x 4.75"w x 7.5"h
3804K Standard Kit	5.50 lbs 2.50 kg	5.0"h x 7.5"w x 8.25"h
3804KZ Low VOC Kit	5.50 lbs 2.50 kg	5.0"h x 7.5"w x 8.25"h

**3804-1, 3804-4 VOC: 2.74 lb/gal (328 g/L)**

**3804R-4 VOC: 0 lb/gal (0 g/L)**

**3804N-4 VOC: 6.3 lb/gal (755 g/L)**

See SDS and product label for additional safety information. SDS and technical data sheet may be downloaded from [www.polyvance.com](http://www.polyvance.com).



Product info and SDS

# Standard Operating Procedure: 3804 Flextex VT Texture Paint

**\*Use proper protective equipment while working around chemicals.\***

- Clean part with soap and water. Rinse and allow to dry. Clean 1001-4 EcoPrep or 1000-1 Super Prep Plastic Cleaner by applying a heavy, wet coat of the cleaner then wiping dry with a clean, lint-free towel.



- Compare the OEM texture to your previously-prepared texture reference cards to identify the proper Flextex VT reduction ratio and gun setup that will most closely simulate the grain. Texture will vary depending on spray gun and gun setup; the user is encouraged to make their own customized texture reference cards.



If you don't have any texture reference cards, mix 3804 Low VOC Flextex VT and 3804 Reducer by volume according to the following table.

Volume Mixing Ratios (fl. oz.)						
Texture Appearance & Reduction Ratio	8 fl. oz.		16 fl. oz.		32 fl. oz.	
	3804	3804 Reducer*	3804	3804 Reducer*	3804	3804 Reducer*
Coarse 8:1	7.1	0.9	14.2	1.8	28.4	3.6
Medium 3:1	6.0	2.0	12.0	4.0	24.0	8.0
Fine 1:1	4.0	4.0	8.0	8.0	16.0	16.0

\* Use 3804 Zero VOC reducer in low-VOC areas; 3804N regular reducer in National Rule areas

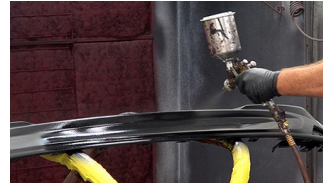
- Sand the repair area with 180 grit and gradually feather back from the repair area. If you choose to, you can also sand all of the texture down to give a more uniform appearance when finished. Afterward, sand the entire textured area lightly with 320 grit. You're not trying to sand all the texture down smooth; rather, you just want to level out the tops of the texture. Blow dust free.



- Scuff the entire textured area with a red scuff pad. Blow dust free.
- Spray 1051 Low VOC Plastic Magic (or 1050 Plastic Magic in National Rule areas) adhesion promoter with one or two medium wet coat over the area to be primed. Allow Plastic Magic to flash for 10-15 minutes.



- Spray 3043 All Seasons Black Jack waterborne primer surfacer (or your desired primer surfacer). Apply two medium wet coats, blending out from the repair area into the original texture and allowing some flash time between coats.



- When the primer dries, sand with 320 grit sandpaper. Fill imperfections with spot putty. Sand with 320 and reprime if necessary to smooth out any remaining TPO fuzz or 80 grit scratches.

Scuff the primer with a red scuff pad and feather back into the original texture. Blow dust free and wipe with a tack cloth. Apply 1050 or 1051 Plastic Magic over the entire area to be retextured. It is not necessary to apply Plastic Magic over primer.



- Fill an HVLP gravity-feed spray gun with Flextex VT reduced to match the texture determined in Step 2. Gun nozzle size, needle setting, and air pressure are all variables to be adjusted to fine-tune grain size. Adjust gun settings on a sprayout card before applying texture to the part.



- Begin retexturing by spraying two or three coats of Flextex VT on the primed area only, blending farther out onto the unprimed areas with each coat. It's very important to "speckle" the paint droplets onto the surface and let the droplets dry before applying another coat. Increasing the distance to work and increasing the speed of the pass helps to keep the paint droplets from flowing together. The most common error when applying Flextex is applying too wet of a coat and flowing out the paint.

If there are any shiny or blotchy areas, allow the paint to dry completely and scuff the entire part with a red scuff pad. Blow dust free and wipe with a tack cloth before applying more coats of Flextex VT to the entire part to even out the textured appearance.



- If a satin black appearance is desired, Flextex VT may be used without top coating. If a different color is required, after the Flextex VT is completely dry, scuff with red scuff pad, wipe with a tack rag, then top coat with base/matte clear or hardened basecoat.

