



Steps	Equipment																																		
<p>1. Clean part with 1001-4 EcoClean Plastic Cleaner. If very dirty, use 1020 Scuff Magic Soap first.</p> <p><i>*Use proper protective equipment while working around chemicals.*</i></p>																																			
<p>2. Compare texture to texture reference cards to identify the proper Flextex VT letdown percentage and gun setup to most closely simulate the grain. Texture reference cards have three coats of Flextex VT applied, and all are sprayed with a 1.8 mm nozzle gun at 25 psi. Texture will vary depending on spray gun and gun setup; the user is encouraged to make their own customized texture reference cards.</p> <p>Mix 3804 Low VOC Flextex VT and 3804R Low VOC Reducer by volume according to the following table.</p>																																			
<p>Volume Mixing Ratios (fl oz)</p> <table border="1" data-bbox="302 1283 1320 1528"> <thead> <tr> <th rowspan="2">Texture Appearance and Ratio</th> <th colspan="2">8 fl oz</th> <th colspan="2">16 fl oz</th> <th colspan="2">32 fl oz</th> </tr> <tr> <th>3804</th> <th>3804R Reducer</th> <th>3804</th> <th>3804R Reducer</th> <th>3804</th> <th>3804R Reducer</th> </tr> </thead> <tbody> <tr> <td>Coarse 8:1</td> <td>7.1</td> <td>0.9</td> <td>14.2</td> <td>1.8</td> <td>28.4</td> <td>3.6</td> </tr> <tr> <td>Medium 3:1</td> <td>6.0</td> <td>2.0</td> <td>12.0</td> <td>4.0</td> <td>24.0</td> <td>8.0</td> </tr> <tr> <td>Fine 1:1</td> <td>4.0</td> <td>4.0</td> <td>8.0</td> <td>8.0</td> <td>16.0</td> <td>16.0</td> </tr> </tbody> </table>		Texture Appearance and Ratio	8 fl oz		16 fl oz		32 fl oz		3804	3804R Reducer	3804	3804R Reducer	3804	3804R 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
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3. Best results are achieved by sanding the texture and retexturing the entire area. Sand texture as smooth as possible with 180 grit sandpaper. Progress to 320 grit paper. Blow dust free.



4. Spray 1051 Low VOC Plastic Magic adhesion promoter with one medium wet coat over the area to be retextured. Allow Plastic Magic to flash for 10 minutes.



5. Spray 3043 All Seasons Black Jack waterborne primer surfacer over the entire area to be retextured. Allow 20-30 minutes to dry.



6. Sand with 240-320 grit sandpaper to remove underlying sandscratches. Fill imperfections with spot putty. Spray a second coat of 3043 Black Jack, dry, and sand again with 320. Achieve a smooth primered surface prior to application of 3804 Flextex VT.



7. Fill 1.8 mm HVLP gravity-feed spray gun with Flextex VT reduced to match the texture determined in Step 2. Adjust air pressure to 25 psi. Settings may be adjusted to fine-tune grain size.



8. Apply Flextex VT in light “splatter” coats from a distance of about 16 inches from the bumper. Move gun quickly to keep texture even and to avoid flowing the paint out. Allow five minutes of flash time between coats. Apply at least three coats to achieve desired textured appearance.



9. May be used without top coating or top coat with base/matte clear or hardened basecoat any time after completely dry.

Use proper protective equipment while working around chemicals.

