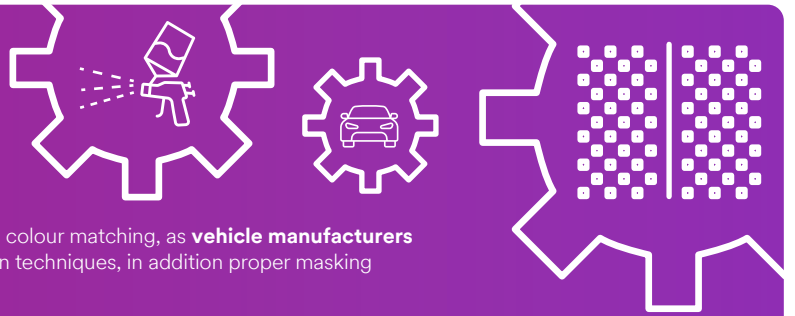


Simplifying complex paint processes.

# Matching new challenging textures.



Painters now face the challenge of **matching texture**, in addition to colour matching, as **vehicle manufacturers introduce a variety of textures**. Spray gun setup, expert application techniques, in addition proper masking techniques are key to matching these new challenging textures.

## Matching Undercoats (Stone Chip)

Undercoat or stone chip textures, which once had a uniform appearance across almost every vehicle, now vary significantly across vehicle makes and models. Here are some tips for achieving different textures and transition lines:

➤ A spray out is recommended prior to applying texture to determine if any adjustments need to be made. Keep in mind, topcoating with sealer, base, and clear can affect the look of the texture. All topcoats should also be applied to the spray out to verify the final texture.



### Coarse texture:

- Fluid should be wide open and very low air pressure is needed.
- Multiple coats may be necessary to achieve very coarse textures.
- Spray the coarsest texture possible in the first coat and ensure it fully flashes before stacking more texture on top.



### Medium texture:

- Air pressure should be increased compared to spraying a coarse texture.
- The higher air pressure will help atomise the stone chip or undercoating a bit more.
- If a second coat is needed, ensure the first coat is fully flashed to avoid the two coats flowing together (which flattens out the texture).



### Fine texture:

- Set up your spray gun to have high air pressure and low fluid.
- If the texture still doesn't seem fine enough, try using a smaller tip size to atomise even finer.
- If applying multiple coats, be sure to fully flash in between.



### Hard transition line:

- A crisp line where the texture coating stops.
- Using a quality masking tape, or even a vinyl tape, can help achieve an ultra-crisp line.
- Be sure to peel the tape off before the undercoating fully dries.



### Soft transition line:

- Follow the same process used for a hard transition line, but use a soft edge style masking tape, such as a foam or smooth transition tape.
- Another technique techs use is folding the edge of the masking tape before applying to the vehicle, but this can lead to inconsistencies (why a soft edge masking solution is recommended).



### Long transition line:

- To achieve the softer edge needed for a long transition line, back masking techniques are often used.
- This typically involves masking paper that is folded or rolled back over itself to help create a very soft edge.



### Smooth texture blend:

- On some vehicles, there is no noticeable line. Instead, the texture slowly transitions into the regular texture of the rest of the panel.
- This method is the hardest to achieve as it requires full control of the spray gun and the overspray.
- No masking materials can be used.

COARSE	Tip size: 2.0 Fan knob, turns*: 1 H/O knob, turns*: 1 Fluid knob, turns*: 2 Inlet Air pressure, psi (bar): 3 - 5 (0.20 - 0.35)	
	Tip size: 2.0 Fan knob, turns*: 1 H/O knob, turns*: 1 (full) Fluid knob, turns*: 1 Inlet Air pressure, psi (bar): 10 (0.70)	
	Tip size: 2.0 Fan knob, turns*: 1 H/O knob, turns*: 1 (full) Fluid knob, turns*: 3/4 Inlet Air pressure, psi (bar): 20 (1.38)	

## Dialing in your 3M™ Performance Spray Gun to help achieve three basic undercoat textures.

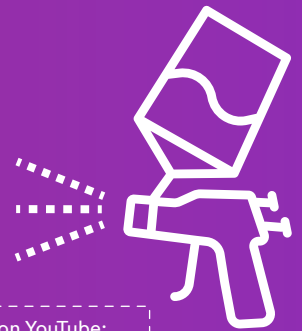
✔ Build a spray out panel with different textures and note the settings for your spray gun to achieve those. Refer to your panel to help dial in your spray gun each time.

⚠ These settings are **starting points** (specifically when using 3M™ Performance Spray Gun). Each user will have their own desired pattern and the spray gun can be adjusted accordingly to optimise the performance for the application.

↺ \*Turns are measured from closed in full 360 degree rotations, counter-clockwise outward.



Watch full demo on YouTube:  
Texture Matching Series



## Matching Topcoats (Clearcoat Texture)

Vehicles today have noticeable differences in surface texture (orange peel). When it comes to matching orange peel in clearcoat, the goal is to replicate the texture of the surrounding panels (for an invisible repair). Here are some tips for achieving different clearcoat textures:



Generally, the higher the air pressure to fluid ratio, the finer the texture. For finer or flatter surface texture, either increase air pressure or turn in the fluid control knob (vice versa for a more coarse texture).



Tip size can also have an effect on the resulting texture. In general, a larger tip size will result in coarser texture and a smaller tip size results in a finer texture.



Texture can be varied by changing application techniques. Spray gun distance, overlap amount, and application speed, all affect texture. Experiment by making adjustments to these techniques to see how it changes your final result.

There are many options for spraying high-viscosity or texture coatings. The **3M™ Performance Spray Gun System** enables more pattern control than body schutz or aerosol applications.

### The system includes:



3M™ Performance Spray Gun



3M™ Performance Spray Gun H/O Conversion Pack



3M™ PPS™ Series 2.0 Type H/O Pressure Cup