

PercoTop®

CS353/CS353W

2K HS Rail Filler

Features

- PercoTop® CS353/CS353W 2K HS Rail Filler is a 2-component filler specially developed for high quality coating of large surfaces.
- Corresponds in composition and properties to "Stoff 1.2, TL 918300, Anhang B, Blatt 34" of Deutsche Bahn AG.
- Composition based on acrylic resin.
- The product offers excellent filling and sanding properties.

Products

CS353/CS353W PercoTop® 2K HS Rail Filler.

Activator
CS711 PercoTop® Activator VHS Standard

Thinner
CS620 PercoTop® Thinner Standard

Also possible:
CS710 PercoTop® Activator VHS Fast
CS712 PercoTop® Activator VHS Slow
CS610 PercoTop® Thinner Fast
CS630 PercoTop® Thinner Slow

Colours

- CS353 sand yellow
- CS353W white

Substrates





- Primed substrates.
- Coil and powder primer.
- Well preserved and lightly sanded original or old paintwork.
- UP-GF (cleaned and sanded).

For professional use only!

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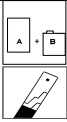

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Surface preparation

Substrates must be free from all contaminants.	
Apply to	PercoTop® Primer/Primer Surfacer or old paintwork.
	Thoroughly clean old paintwork.
Either	 Sand dry with orbital sander and dust exhaust P320-P500.
or	 Sand wet with sandpaper P600-P800.
	Before further treatment, carefully clean sanded areas once more to remove all dust, paint residues from sanding and other impurities.

VOC value ready for use (EU Directive 1999/13/EC)
<ul style="list-style-type: none"> < 540 g/l 6:1 by volume with CS711 + 10% CS620.

Product preparation







	Mixing ratio	CS353/CS353W	Volume	Weight
		CS710/CS711/CS712	6	100
			1	11
Thinner	CS610 CS620 CS630	Remarks - Use CS610 on small objects at 15-25°C. - Use CS620 on medium sized objects at 20-25°C. - Use CS630 on large objects at 20-30°C.		
	Potlife at 20°C	> 4 hours (depending on spray viscosity and hardener used)		

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Application

	Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
 Gravity feed  Suction feed (High pressure spraying)	20-26	ca. 10	1.6-1.8 1.7-1.8	2.5-3.0	2-3
 HVLP (Low pressure spraying)	20-26	ca. 10	1.5-1.9	2.0-2.5	2-3
 Airless Airmix	40-50	0-5	0.23-0.28	2.0-3.0 air ca. 80-100 material	1-2
 Pressure Pot Membrane Pump (High pressure spraying)	20-26	ca. 10	1.1-1.3	2.5-3.5 air 1.0-2.0 material	2-3
 Electrostatic	According to the advice of the Technical Representative.				
Recommended dry film thickness	60-125 µm				

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Drying

Air drying at 20°C	60 µm dry film thickness
Dust dry	10-15 minutes
Drying stage TG1 at 23° C	90 minutes
Dry to handle	60 minutes
Dry	overnight
Drying stage TG6 at 23° C	> 6 hours
Ready for sanding	overnight

Forced drying	Flash-off time: approx. 10-15 minutes. (depending on film thickness)
Drying time	60 minutes
Drying temperature	60° C object temperature

Recoatability


Minimum waiting time, at 60 µm DFT and 23 °C	7-8 hours
Maximum waiting time	72 hours
Recoatable with	PercoTop® Topcoats after fine sanding with P320-P500.


Product Data

	Solids Weight (%)	Density (kg/l)	Theoretical coverage (at 100 µm) (m ² /kg)	Theoretical material consumption (at 100 µm) (g/m ²)
Sand yellow				
Packaged	68.6	1.55		
Mixed	64.8	1.43	3.1	325

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Remarks

	<ul style="list-style-type: none"> Stir well before use.
<p>Storage conditions</p>	<ul style="list-style-type: none"> Refer to label on the original can.

<p>Note on safety:</p>	
	<p>This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application.</p>
<p>Observe the precautionary notices displayed on the container.</p>	

<p>Information</p> <p>The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This Technical Data Sheet supersedes all previous issues.</p>

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