Technical Data Sheet

# PercoTop®

## CS357/CS358/CS359
## 2K HS WOW Filler

**Features**

- PercoTop® 2K HS WOW Filler is a 2K wet-on-wet Filler and especially suitable for commercial vehicles.
- Composition based on an acrylic resin.
- It is easy to apply and has a good overspray absorbtion.

| | |
|---|---|
| **Products** | |
| CS357/CS358/CS359 | PercoTop® 2K HS WOW Filler |
| **Activators** | |
| CS710 | PercoTop® Activator VHS Fast |
| CS711 | PercoTop® Activator VHS Standard |
| CS712 | PercoTop® Activator VHS Slow |
| **Thinners** | |
| CS610 | PercoTop® Thinner Fast |
| CS620 | PercoTop® Thinner Standard |
| CS630 | PercoTop® Thinner Slow |
| **Also possible:** | |
| CS640 | PercoTop® Thinner Extra Slow |

**Colours**

- CS357: grey
- CS358: white
- CS359: black

**Substrates**

- Primed surfaces.
- Cathodic dip coating (E-coat).
- Coil and powder primer.
- Old sanded paintwork and UP-GF (cleaned and sanded).

**For professional use only!**

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| **Surface preparation** |
|---|
| • NA |

| **VOC value ready for use** (EU Directive 1999/13/EC) | |
|---|---|
| < 540 g/l | 4:1 by volume with CS711 and 35% CS620. |

## Product preparation

| | | |
|---|---|---|
| **Mixing ratio** | CS357/CS358/CS359<br>CS710/CS711/CS712 | **Volume**<br>4<br>1 |
| **Thinner** | CS610<br>CS620<br>CS630<br>CS640 | |
| **Pot life at 20°C** | Ready for use 1–3 hours.<br>(depending on application viscosity and activator) | |
| **Recommended dry film thickness** | Approx. 30 µm | |

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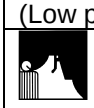
## Application

| | 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) | 18-20 | 30-35 | 1.4-1.6 | 3.0-4.0 | 1-2 |
| HVLP **HVLP** (Low pressure spraying) | 18-20 | 30-35 | 1.3-1.5 | 2.0-2.5 | 1-2 |
|  **Airless** **Airmix** | Not recommended | | | | |
|  **Pressure pot** **Membrane pump** (High pressure spraying) | 18-20 | 30-35 | 1.0 - 1.1 | 2.5-3.5 air 1.0-2.0 material | 2-3 |
|  **Electrostatic** | According to the advice of the Technical Representative. | | | | |

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## Drying

| | |
|---|---|
| **Air drying at 20°C** | 30-40 µm dry film thickness |
| **Dust dry** | 10-20 minutes |
| **Dry to handle** | 60 minutes |
| **Dry to assemble** | overnight |

| | |
|---|---|
| **Forced drying** | flash-off time: approx.10-15 minutes<br>(depending on film thickness) |
| **Drying time** | Approx. 20 minutes |
| **Drying temperature** | 60°C object temperature |

## Recoatability

| | |
|---|---|
| **Recoatable** | 0.5-2 hours |
| **Recoat with** | PercoTop® Topcoats. |

## Product data

| | **Solids**<br><br>Weight (%)<br>+/- 1 | **Density**<br><br>(kg/l)<br>+/- 0.01 | **Theoretical coverage**<br><br>(at 30 µm)<br>($m^2$/kg) | **Theoretical material Consumption**<br>(at 30 µm)<br>($g/m^2$) |
|---|---|---|---|---|
| **CS357** | | | | |
| Packaged | 67 | 1.30 | - | - |
| Ready for use | 54 | 1.17 | 11 | 88 |

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## Remarks

| | |
|---|---|
|  | • Stir well before use. |
| **Storage conditions** | • Refer to the label on the original can. |

**Safety**

Consult the Safety Data Sheet prior to use.
Observe the precautionary notices displayed on the container.

**Information**

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.
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