



# PercoTop®

CS384

2K High Performance EP Primer

## Features

PercoTop® 2K High Performance EP Primer is a chemically resistant, zinc chromate-free solventborne 2K primer based on epoxy resins.

It provides excellent adhesion, humidity resistance and corrosion protection on a number of substrates. It shows no yellowing and uses a bio-based activator.

## Product

CS384 PercoTop® 2K High Performance EP Primer

## Activator

CS784 Activator High Performance EP Primer

## Thinner

CS681 PercoTop® Thinner Epoxy

## Colours

- Beige
- Light Grey
- Black

## Substrates

- Steel, iron and zinc phosphated steel.
- Galvanized, sendzimir and hot dip galvanized steel.
- Aluminum
- Sanded EP and UP-GRP.

**For professional use only!**



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### Surface preparation

Substrates must be free from all contaminants.

Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test. See data sheet "Metal Substrates - Treatment before Coating".

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### VOC value ready for use (EU Directive 1999/13/EC)

- < 550 g/l                      12.5 : 1 by weight with CS784 + ~15% CS681.

## Product preparation







	<b>Mixing Ratio</b>	CS384	Weight	Volume
		CS784	12.5	7
			1	1
	<b>Thinner</b>	CS681		
	<b>Pot life at 20°C</b>	8 hours		
	<b>Recommended dry film thickness</b>	40-80 µm (15 – 25 µm in case of wet-on-wet with additional filler / surfacer)		
	<b>Reaction temperature</b>	At least 15°C.		

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## Application

		Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	<b>Gravity feed</b>	18-22	15-25	1.4-1.8	3.0-4.0	1-2
	<b>Suction feed</b>					
(High pressure spraying)						
	<b>HVLP</b>	18-22	15-25	1.4-1.8	2.0-2.5	1-2
(Low pressure spraying)						
	<b>Airless</b>	25-35	5-15	0.33-0.36	2.0-3.0 air	1-2
	<b>Airmix</b>				- 100 material	
	<b>Pressure pot</b>	18-22	15-25	1.1-1.2	2.5-3.5 air	1-2
	<b>Membrane pump</b>				1.0-2.0 material	
(High pressure spraying)						
	<b>Electrostatic</b>	According to the advice of the Technical Representative.				



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## Drying

<b>Air drying at 20°C</b>	40 µm dry film thickness
<b>Dust dry</b>	30 min
<b>Dry to handle</b>	2 hours
<b>Dry to recoat</b>	>40 min (>15 min in case of 15 – 25 µm wet-on-wet with filler / surfacer)
<b>Dry to assemble</b>	16 hours

<b>Forced drying</b>	Flash time: 15 minutes. Depending on film thickness.
<b>Drying time</b>	30 minutes
<b>Drying temperature</b>	60°C object temperature

## Recoatability

<b>Recoatable</b>	With PercoTop® Fillers and Topcoats
<b>Remarks</b>	Recoating with above mentioned products without sanding between coats is still possible after 4 weeks.

## Product data

	<b>Solids</b>	<b>Density</b>	<b>Theoretical coverage</b>	<b>Theoretical material consumption</b>
	Weight (%) +/- 1.5	(kg/l) +/- 0.02	(at 80 µm) (m <sup>2</sup> /kg)	(at 80 µm) (g/m <sup>2</sup> )
Packaged	73.8	1.63	-	-
Mixed 12.5 : 1 with CS784 + 15% CS681	63.5	1.40	3.5	289




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**Remarks**

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

**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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