



PercoTop®

CS388 RAIL

SupraSand 2K High Build EP Primer

Features

PercoTop® CS388 SupraSand 2K High Build 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.

Specifically designed to be used when excellent corrosion is needed in combination with high build and sanding. (e.g., to cover rough substrates) and excellent Wet-on-Wet properties (very short flash times before overcoating and excellent topcoat appearance)

Product

CS388G

PercoTop® SupraSand 2K High Build EP Primer Light Grey

CS388R

PercoTop® SupraSand 2K High Build EP Primer Red RAL3012

Activator

CS786N

Activator for High Build EP Primer CS388

Thinner

CS681

PercoTop® Thinner Epoxy Primer

CS684

PercoTop® Thinner Epoxy Primer Slow

CS685

PercoTop® Thinner Epoxy Primer Extra Slow

also possible:

CS620

PercoTop® Thinner Standard

CS630

PercoTop® Thinner Slow

Colours

- Light Grey, Red RAL 3012

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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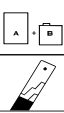

Surface preparation

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".

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

- <550 g/l 12:1 by weight with CS786 + ~10% CS681.

Product preparation








 Mixing Ratio	CS388G/CS388R CS786N	Weight	Volume
Thinner	CS681		
 Pot life at 20°C	4 hours		
Recommended dry film thickness	60 – 200 µm		
Reaction temperature	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
 Gravity feed  Suction feed (High pressure spraying)	25-40	5-10%	1.6-2.0	3.0-4.0	2-3
 HVLP (Low pressure spraying)	25-40	5-10 %	1.6-2.0	2.0-2.5	2-3
 Airless Airmix	45-100	0-10	0.28-0.33	2.0-3.0 air ~100 material	1-2
 Pressure pot  Membrane pump (High pressure spraying)	25-30	10-15	1.1-1.2	2.5-3.5 air 1.0-2.0 material	1-2
 Electrostatic	According to the advice of the Technical Representative.				



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Recoatability

Recoatable	With PercoTop [®] Topcoats after 30 minutes flash of at room temperature
Remarks	Recoating with above mentioned products without sanding possible till 72 hrs. after primer application

Drying not WOW application.

Air drying at 20°C	150 µm dry film thickness
Dust dry	30 min
Dry to handle	2 hours
Dry to assemble	16 hours

Forced drying	Flash time: 20-30 minutes after topcoat application Depending on film thickness.
Drying time	30 minutes
Drying temperature	60°C object temperature

Dry to assemble	Immediately after bake of topcoat
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Product data

	Solids Weight (%) +/- 1.5	Density (kg/l) +/- 0.02	Theoretical coverage (at 150 µm) (m ² /kg)	Theoretical material consumption (at 60 µm) (g/m ²)
Packaged	73.8	1.63	-	-
Mixed 12 : 1 by weight with CS786+ 10% CS681	63.5	1.40	2.01	490




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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 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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