Technical Data Sheet

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		Weight	Volume
	CS388G/CS388R	12	6
	CS786N	1	1
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 **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

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

	• 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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