



PercoTop®

CS389

SupraProductive 2K EP Primer

Features

PercoTop CS389 provides excellent adhesion, humidity resistance and corrosion protection on various substrates.
It shows no yellowing and uses a bio-based activator.
Specifically designed to offer substantial productivity gain by combining excellent Wet-on-Wet properties (very short flash times before overcoating and excellent topcoat appearance)
On top of this it also cures extremely fast offering the ability to start assembling painted parts directly after bake.

Product

CS389 PercoTop® SupraProductive 2K EP Primer

Activator

CS786N Activator for High Build EP Primer CS388

Thinner

CS681 PercoTop® Thinner Epoxy Primer

Please contact your local Axalta technical representative for alternative thinners when working under extreme conditions.

Colours

- Light Grey

Substrates

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

For professional use only!

PercoTop[®]

CS389

SupraProductive 2K EP Primer

Surface preparation

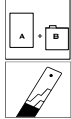

Substrates must be free from all contaminants.

Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test.

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

- 484 g/l 100:10.5 by weight with CS786 + ~10% CS681.

Product preparation







	Mixing Ratio	CS389	Weight	Volume
		CS786	100	6
	Thinner	CS681	10.5	1
	Pot life at 20°C	2 hours		
	Recommended dry film thickness	60 µm		
	Reaction temperature	At least 15°C.		

PercoTop®

CS389

SupraProductive 2K EP Primer

Application

		Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	25-40	5-10%	1.6-2.0	3.0-4.0	2
	Suction feed (High pressure spraying)					
	HVLP (Low pressure spraying)	25-40	5-10 %	1.6-2.0	2.0-2.5	2
	Airless Airmix	30-45	5-10	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.				



PercoTop®

CS389

SupraProductive 2K EP Primer

Recoatability

Recoatable	With PercoTop® Topcoats after 20 minutes flash of at room temperature
-------------------	---

Drying

Forced drying	Flash time: 15-25 minutes after topcoat application Depending on film thickness.
Drying time	20 minutes
Drying temperature	60°C object temperature

Dry to assemble	Immediately after bake of topcoat
------------------------	-----------------------------------

Product data

	Solids	Density	Theoretical coverage	Theoretical material consumption
	Weight (%) +/- 1.5	(kg/l) +/- 0.02	(at 60 µm) (m ² /kg)	(at 60 µm) (g/m ²)
Packaged	73.8	1.62	-	-
Mixed 100:10.5 by weight with CS786+ 10% CS681	61.4	1.45	5.02	200



PercoTop[®]

CS389

SupraProductive 2K EP Primer

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.

This Technical Data Sheet supersedes all previous issues.

Copyright © 2022, Axalta Coating Systems, LLC and all affiliates. All rights reserved. The Axalta logo, Axalta™, Axalta Coating Systems™ and all products denoted with ™ or ® are trademarks or registered trademarks of Axalta Coating Systems, LLC and its affiliates. Axalta trademarks may not be used in connection with any product or service that is not an Axalta product or service.