Technical Data Sheet

PercoTop®

CS391 / CS392
2K HS Primer 049

Features

- PercoTop® 2K HS Primer 049 is a low VOC 2K Primer/Filler. Composition based on polyacryl.
- Can be used as adhesion promoter, primer or primer surfacer.
- Excellent sandability when used with CS705.
- Perfect adhesion on metal substrates as listed below.

Products	
CS391/CS392	PercoTop® 2K HS Primer 049
Activators	
CS705	PercoTop® Activator 4040
CS710	PercoTop® Activator VHS Fast
CS711	PercoTop® Activator VHS Standard
CS718	PercoTop® Activator HS Slow
CS719	PercoTop® Activator HS Standard
CS720	PercoTop® Activator HS Fast
Thinners	
CS610	PercoTop® Thinner Fast
CS620	PercoTop® Thinner Standard
CS630	PercoTop® Thinner Slow
Optional:	
Activators	
CS704	PercoTop® Activator 3840
CS706	PercoTop® Activator 4060
CS714	PercoTop® Activator 3845
CS726	PercoTop® Activator 4065
Thinners	
CS600	PercoTop® Thinner Standard

Colors

- CS391: Grey
- CS392: Ivory.

For professional use only!

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Substrates

- Steel.
- Galvanic, sendzimir and hot dip galvanized steel.
- Sanded EP and UP-GF.

Surface preparation

- Substrates must be free from all contaminants.
- Because of the wide variety of substrates and their manufacturing processes, a preliminary test should be carried out on the respective substrate to ensure that the pretreatment is sufficient to guarantee a perfect adhesion. For information on substrate and respective surface preparation, refer to the supplier's specifications.

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

- < 540 g/l 9:1 by volume with CS706 + 15 vol% CS600.

Product preparation

		VHS		HS		MS	
Mix ratio		Volume	Weight	Volume	Weight	Volume	Weight
	CS391/CS392	9	10	5	6	4	5
	CS710/CS711/ CS704/CS705/ CS706	1	1				
	CS718/CS719/ CS720			1	1		
	CS714/CS726					1	1
Thinners	CS600, CS610, CS620, CS630 Remarks: - Use CS630 for optimal flow on large objects.						
Potlife at 20°C	5 Hours						
Recommended dry film thickness	Indoor use: 25-30 µ. Outdoor use with exposure to humid and wet conditions: at least 40 µ. Outdoor use with exposure to chemicals: at least 80 µ.						

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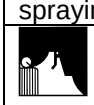
Application

		Application viscosity DIN 4 at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
 **Gravity Feed**	Adhesion promoter	18	20	1.3-1.5		1-2
 **Suction Feed**	Primer	25	15	1.5-1.8	3.0-4.0	2-3
(High pressure spraying)	Surfacer	30	10	1.8-2.0		2-3
HVLP **HVLP**	Adhesion promoter	18	20	1.3-1.5		1-2
	Primer	25	15	1.5-1.8	2.0-2.5	2-3
(Low pressure spraying)	Surfacer	30	10	1.8-2.0		2-3
 **Airless**	Adhesion promoter	20	18	0.28	2.0-3.0 air	1
Airmix	Primer	40	10	0.33		1-2
	Primer surfacer	50	5	0.33	Ca 100 material	2-3
 **Pressure Pot**	Adhesion promoter	18	20	1.1	2.5-3.5 air	1-2
Membrane Pump	Primer	25	15	1.1-1.2		2-3
(High pressure spraying)	Primer surfacer	30	10	1.2	1.0-2.0 material	2-3
 **Electrostatic**	According to the advice of the Axalta Technical Representative.					

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Drying

Air drying at 20°C	40 µ dry film thickness
Dust dry	15 minutes
Dry to handle	1 hour
Dry to recoat	1 hour
Dry	2 hours

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

Recoatability

Recoatable	With PercoTop® topcoats.
Remarks	Recoating with above mentioned products without sanding between coats is still possible after 4 weeks.

Product data

	Solids Weight (%) +/- 1	**Density** (kg/l) +/- 0.01	**Theoretical coverage** (at 40 µ) (m^2/kg)	**Theoretical material consumption** (at 40 µ) (g/m^2)
Grey				
Packaged	69	1.49	-	-
Mixed 9:1 by volume with CS706 + 15 vol% CS600	63	1.38	7.8	128

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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.
This Technical Data Sheet supersedes all previous issues.