



PercoTop[®] KH140

1K High Bake Alkyd Topcoat

Description

PercoTop[®] KH140 is a 1K high bake topcoat.
Composition based on alkyd melamine resin.

Products

XXX	Tints
PercoTop [®] KH140	PercoTop [®] KH140 1K High Bake Alkyd Topcoat
CS992	PercoTop [®] KH140 Binder
CS201	PercoTop [®] 1K Matting Agent
CS620	PercoTop [®] Thinner Standard
CS630	PercoTop [®] Thinner Slow

Colours

- Industrial and standard colour registers.
- Various gloss levels available in combination with CS201.
- 3 extra flattening levels can be retrieved from the ColourSolutions colour tool.

Properties

- Baking temperature is 140°C object temperature.
- Other baking temperatures are possible by adjustment of drying time.
- Can also be used on powder based primers and contiguously be recoated with a powder based clearcoat.





Substrates

- Cured, solvent resistant, well preserved and scuff sanded old finish.
- PercoTop[®] primer surfacers.

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1K High Bake Alkyd Topcoat

Surface preparation

Substrates must be free from all contaminants.	
Apply to	PercoTop® Primer/Primer Surfacer or old paintwork.
	Thoroughly clean old paintwork.
Either	 Sand dry with orbital sander and dust exhaust P320-P500.
	or  Sand wet with sandpaper P600-P800.
	Before further treatment, carefully clean sanded areas once more to remove all dust, paint residues from sanding and other impurities.

VOC value ready for use (EU Directive 1999/13/EC)	
• RAL 9010: 503 g/l	+ 15 % CS630.
• RAL 9005: 526 g/l	+ 20 % CS630.







Product preparation

Thinner	CS620 CS630
Recommended dry film thickness	35-50 µ

PercoTop® KH140

1K High Bake Alkyd Topcoat

Application

		Application viscosity DIN 4 at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	16-20	15-20	1.2-1.4	3.0-5.0	2
	Suction feed					
	(High pressure spraying)					
	HVLP	16-20	15-20	1.3-1.4	2.0-2.5	2
	(Low pressure spraying)					
	Airless	20-25	5-15	0.18	2.0-3.0 air	2
	Airmix				Ca 100 material	
	Pressure pot	16-20	15-20	1.1-1.2	3.0-5.0 air	2
	Membrane pump				0.5-2.0 material	
	(High pressure spraying)					
	Electrostatic	According to the advice of the Technical Representative.				

Drying

Forced drying	Flash time: 10 minutes at room temperature of 20°C. Depending on film thickness.					
Drying time(minutes)	40	20	17	15	10	5
Object temperature (°C)	130	140	150	160	170	180

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Product data

Package viscosity	100-140 s DIN 4
Flash point	24°C

	Solids Weight (%) +/- 1	Density (kg/l) +/- 0.01	Theoretical coverage (at 50 µ) (m²/kg)	Theoretical material consumption (at 50 µ) (g/m²)
White Packaged	64.4	1.19	8.5	117
Black Packaged	56.9	1.02	9.7	103


Remarks

	<ul style="list-style-type: none"> • Material has to be at room temperature before use. • Stir mixing pastes and binders thoroughly before use. • Stir the mixture well after the weigh-out of the components. • Stir CS201 (PercoTop® 1K Matting Agent) thoroughly each time before use in colour formulae, in order to secure reproducible gloss levels.
	<ul style="list-style-type: none"> • Axalta recommends the customer should perform a quick colour-check of products before use.
Shelf life at 5°C to 35°C	<ul style="list-style-type: none"> • Refer to the label on the original can.



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Note on safety:	
	This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application.
	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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