



PercoTop® 611

2K DTM Topcoat

Features

- PercoTop® 611 2K DTM Topcoat is a 2K topcoat based on polyacrylate resin.
- The special binder/pigment formulation allows for one-stage application on metal substrates without primer
- It can be used straight onto steel, aluminium and galvanised substrates.
- 5 gloss levels: high gloss to matt (c.f. PercoTop® Fandeck)

Products

Base Paint

PercoTop® DTM	PercoTop® 611 2K DTM Topcoat
CS911	PercoTop® 2K DTM Binder
XXX	Tints

Activators

CS710	PercoTop® Activator VHS Fast
CS711	PercoTop® Activator VHS Standard
CS712	PercoTop® Activator VHS Slow

Thinners

CS610	PercoTop® Thinner Fast
CS620	PercoTop® Thinner Standard
CS630	PercoTop® Thinner Slow

Also possible:

CS718	PercoTop® Activator HS Slow
CS719	PercoTop® Activator HS Standard
CS720	PercoTop® Activator HS Fast

Colours

- Industrial and standard colour registers.

Substrates

- Steel and aluminium.
- Galvanic, sendzimir and hot dip galvanised steel.

For professional use only!

PercoTop® 611

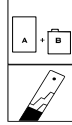

2K DTM Topcoat

Surface preparation

Substrates preparation
<ul style="list-style-type: none"> 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 "Metallic Substrates - Treatment before Coating".

VOC value ready for use (EU Directive 1999/13/EC)
<ul style="list-style-type: none"> < 550 g/l 5:1 by volume with CS719 + 20% CS620.







Product preparation

	Mixing ratio		HS	VHS
			Volume	Volume
		PercoTop® 611 DTM	5	9
		CS718/CS719/CS720	1	-
		CS710/CS711/CS712	-	1
	Thinner	CS610 CS620 CS630 CS640.		
	Pot life at 20°C	8 hours with CS710-CS712 activators.		

PercoTop® 611

2K DTM Topcoat

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)	20-22	15-30	1.4-1.8	2.5-3.0	2-3
 HVLP (Low pressure spraying)	20-22	15-30	1.4-1.8	2.0-2.5	2-3
 Airless Airmix	30-35	10-15	0.23-0.28	2.0-3.5 air ca. 80-100 material	2
 Pressure pot Membrane pump (High pressure spraying)	20-22	15-30	1.1	2.5-3.0 air 1.0-2.0 material	2
 Electrostatic	According to the advice of the Technical Representative.				
Recommended dry film thickness	50-100 µm				

PercoTop® 611

2K DTM Topcoat

Drying

Air drying at 20°C	60 µm dry film thickness
Dust dry	20-30 minutes
Dry to handle	1 hour - 3 hour
Dry to assemble	24 hours



Forced drying	Flash time: 10 minutes. Depending on film thickness.
Drying time	30 minutes
Drying temperature	60°C object temperature

Remarks	Add CS215 to the basic paint to accelerate the drying of the product following recommendations from the Technical Representative.
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Product data

	Solids Weight (%) +/- 1	Density (kg/l) +/- 0.01	Theoretical coverage (at 50 µm) (m ² /kg)	Theoretical material consumption (at 50 µm) (g/m ²)
White				
Packaged	60	1.19		-
Ready for use	49	1.12	7	147
Black				
Packaged	51	1.00	-	-
Ready for use	43	1.00	7	135

Remarks


	<ul style="list-style-type: none"> Stir well before use.
	<ul style="list-style-type: none"> Axalta recommends the customer should perform a quick colour-check of products before use.
Storage conditions	<ul style="list-style-type: none"> Refer to the label on the original can.



PercoTop® 611

2K DTM Topcoat

	<ul style="list-style-type: none"> • Different additives can be used to adjust application properties by brush and roll (CS211), elastification (CS210) and drying properties (CS215). See separate info sheet and contact your representative. • Refer to table 1 and 2 of specifications of industrial paint if chemical or heat-resistance is required.
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Note on safety:	
	<p>This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet.</p> <p>It is strongly recommended to use appropriate personal protection equipment during application.</p>
	<p>Observe the precautionary notices displayed on the container.</p>

<p>Information</p> <p>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.</p> <p>This Technical Data Sheet supersedes all previous issues.</p>

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