

# System description sheet

Working instructions for painting PVC window frames with PercoTop

Mask the parts, which are not to be painted

Remove the protection foil in an equal way to avoid extra electrically charging of the surface.

Blow the window frame with deionised air to remove any static electric charges, this to avoid dust attraction to the PVC.

Clean the PVC with the Special cleaner CS410 colourless

Flash off time before painting minimal 15 minutes

Apply the paint 2K HS Structured or Non Structured at room temperature  
(18° to max 30°)

Preparation of the paint is 5 to 1 with CS703 activator short and put to the right viscosity of 20 to 22 seconds dyn cup 4 with CS600 Universal thinner. The paint has to be applied in two layers with interval of 10 minutes. The mentioned viscosity is the one specific for the spraying equipment of the customer, a HVLP type spraygun with opening 1.3  
If other equipment is being used please take contact for advice

If a window frame is sprayed this should be in the same direction and not by crossing on the edges, this to avoid building up and more glossy spots on the edges. If possible paint the frames vertically

After flash off time of 30 minutes, curing can be done at 40° for  
At least one hour.

If there is a specific drying room where no application is being done, then 35° for one night  
(12 hours) is ideal. Is economically the best solution.

After cooling down to room temperature one can finish the window frames.

Placement on site is best to be done at least 5 days after spraying if possible when can be planned.

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