



PercoTop[®]

CS381

2K Epoxy Primer

Features

- PercoTop[®] 2K Epoxy Primer is a chemically resistant, zinc chromate-free solventborne 2K primer/filler based on epoxy resins.
- It provides excellent adhesion and corrosion protection on a number of substrates.

Product

CS381 PercoTop[®] 2K Epoxy Primer

Activator

CS781 PercoTop[®] Activator Epoxy Primer

Thinner

CS681 PercoTop[®] Thinner Epoxy Primer

Also possible:

CS620 Thinner Standard
CS630 Thinner Slow

Colours

- CS381: light grey

Substrates

- Steel, iron and zinc phosphated steel.
- Galvanised, sendzimir and hot dip galvanised steel.
- Aluminium (pre-check is recommended).
- Sanded EP and UP-GRP.

For professional use only!

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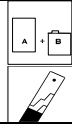

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<p>Surface preparation</p> <ul style="list-style-type: none"> • Substrates must be free from all contaminants. • Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test. See data sheet "Metal Substrates - Treatment before Coating".

<p>VOC value ready for use (EU Directive 1999/13/EC)</p> <ul style="list-style-type: none"> • < 540 g/l 9:1 by weight with CS781 + 25% CS681.

Product preparation








	<p>Mixing ratio</p>	<p>CS381</p> <p>CS781</p>	<p>Volume</p> <p>5</p> <p>1</p>	<p>Weight</p> <p>9</p> <p>1</p>
	<p>Thinner</p>	<p>CS681</p>		
	<p>Pot life at 20°C</p>	<p>8 hours</p>		
<p>Recommended dry film thickness</p>		<p>40-80 µm</p>		
<p>Reaction temperature</p>		<p>At least 15°C.</p>		

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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)	18-22	15-25	1.4-1.8	3.0-4.0	1-2
 HVLP (Low pressure spraying)	18-22	15-25	1.4-1.8	2.0-2.5	1-2
 Airless Airmix	25-35	5-15	0.33-0.36	2.0-3.0 air ca. 100 material	1-2
 Pressure pot  Membrane pump (High pressure spraying)	18-22	15-25	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.				

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Drying

Air drying at 20°C	40 µm dry film thickness
Dust dry	30 minutes
Dry to handle	2 hours
Dry to recoat	1 hour
Dry to assemble	16 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	Density	Theoretical coverage	Theoretical material consumption
	Weight (%) +/- 1	(kg/l) +/- 0.01	(at 40 µm) (m ² /kg)	(at 40 µm) (g/m ²)
Packaged	74	1.63	-	-
Mixed with CS781 + 25% CS681	61	1.39	7	144



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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.
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