

## Technical Data Sheet

# PercoTop<sup>®</sup> Clear Carbon Fibre Sealer

CS399

### Description

PercoTop<sup>®</sup> Clear Carbon Fibre Sealer is a polyurethane sealer designed to fill porosity in all grades of carbon fibre, resulting in fewer process steps and reduced material usage over processes using only clearcoat.

For maximum UV protection, it is essential that a recommended clearcoat is applied over this sealer.

### Products

CS399

PercoTop<sup>®</sup> Clear Carbon Fibre Sealer

CS703

PercoTop<sup>®</sup> Activator LR Fast

CS600

PercoTop<sup>®</sup> Thinner Standard

CS602

PercoTop<sup>®</sup> Thinner 2K

To ensure maximum UV protection of substrate, this sealer should be over-coated with either RK69240 (exterior automotive use) or DP6940 (for Marine use). For general industrial use, PercoTop<sup>®</sup> clearcoats, CS802 or CS805 may be used. Refer to separate TDS.

### Colours

- Clear

### Properties

- Very good filling properties for all grades of carbon fibre.
- Excellent hardness.
- Low material consumption.
- Easy to apply.
- Excellent flow.
- Fast drying.

### Substrates

- Carbon fibre.

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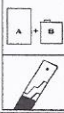



### Surface preparation

- Clean parts with CS410 or 3608S degreaser.
- Lightly sand with P500-P600 (avoid heavy sanding).
- For difficult areas use Red Scotchbrite, or equivalent, with CS410 or 3608S degreaser.
- Clean parts again with CS410 or 3608S degreaser. Wipe on, wipe off (with clean, lint-free cloth).

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

- 492 g/l                      4:1 by volume with CS703LR + 20 % CS600.

## Product preparation



	Mixing ratio	PercoTop® 399 CS703LR Thinner	Volume	Weight
			4 1 20-30%	4 1 20-30%
	Thinner	CS600 CS602		
	Pot life at 20°C	CS703LR	2-3 hours	
	Recommended dry film thickness	40-60 μ		

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## Application

		Application viscosity DIN 4 at 20°C (s)	Thinner (%)		Spray nozzle (mm)	Pressure (bar)	Number of coats
	<b>Gravity feed</b>	20-22	CS600 CS602	20-30	1.3 -1.5	4.0-5.0	2 (5-10 mins flash between)
	<b>Suction feed</b> (High pressure spraying)						
	<b>HVLP</b> (Low pressure spraying)	20-22	CS600 CS602	20-30	1.3 – 1.5	2.0-2.5	2 (5-10 mins flash between)



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## Drying

Air drying at 20°C	40-60 µ dry film thickness
Dust dry	1 hour 30 minutes
Dry to handle	4-8 hours
Dry	24-30 hours

Forced drying	Flash time: >10 minutes.
Drying time	35 minutes
Drying temperature	60°C object temperature
Remarks	

## Product data

Package viscosity	CS399
Flash point	24°C


	Solids	Density	Theoretical coverage	Theoretical material consumption
	Weight (%) +/- 1	(kg/l) +/- 0.01	(at 50 µ) (m <sup>2</sup> /kg)	(at 50 µ) (g/m <sup>2</sup> )
CS399	55.6	1.02	-	-
mixed	61.22	1.03	9.2	66.54

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### Remarks

	<ul style="list-style-type: none"><li>• Ensure product is mixed thoroughly after addition of activator and thinner.</li></ul>
<b>UV protection</b>	<ul style="list-style-type: none"><li>• To ensure maximum UV protection of substrate, this primer should be over-coated with either RK69240 (exterior automotive use) or DP6940 (for Marine use). For general industrial use, PercoTop<sup>®</sup> clearcoats, CS802 or CS805 may be used. Refer to separate TDS.</li></ul>
<b>Storage conditions</b>	<ul style="list-style-type: none"><li>• Material must be stored at a temperature between 5°C and 35°C.</li></ul>
<b>Shelf life at 5°C to 35°C</b>	<ul style="list-style-type: none"><li>• Refer to the label on the original can.</li></ul>

### 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 DuPont cannot anticipate all variations in actual end-use conditions DuPont 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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## **CS399 Carbon Fibre Prep and Paint Process**

1. Clean carbon fibre part using CS410 then sand all imperfections accordingly with P500/P600.
2. Clean part once again wipe on wipe off using CS410.
3. Apply 2 coats of CS399 giving a 10 minute intercoat flash.
4. After final coat flash 10 minutes and bake 35' X 60°C.
5. Sand part with P400.
6. Evaluate carbon part and if required repeat steps 1,2,3, and 4.
7. Clean part again with CS410 wipe on wipe off.
8. Apply two coats of CS802 Clearcoat (CS703 activator).
9. Flash 10 minutes and bake 35' X 60°C.

