

PercoTop® 449 2K Structure Topcoat

Features

- PercoTop® 449 2K Structure Topcoat is a polyurethane based 2K structure topcoat with a high mechanical resistance.
- It has an excellent resistance to solvents and other chemicals.
- Different structures can be produced (cf. PercoTop® fandeck, leaflets 17-20).

Products

Base paint

PercoTop® 449	PercoTop® 449 2K Structure Topcoat
CS949	PercoTop® 2K Structure Binder
CS944	PercoTop® 2K Matt Structure Binder
CS209	PercoTop® Gloss Agent 2K
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
CS600	PercoTop® Thinner Standard

Also possible:

CS702	PercoTop® Activator Fast
CS704	PercoTop® Activator 3840
CS706	PercoTop® Activator 4060
CS602	PercoTop® Thinner 2K

Colours

- Industrial and standard colour registers.

Substrates





- All PercoTop® primers, primer surfacers and surfacers.
- Old coatings and GRP.

For professional use only!

PercoTop[®] 449

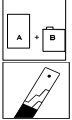

2K Structure Topcoat

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)
<ul style="list-style-type: none"> < 420 g/l Activated as given below without thinner.






Product preparation

	Mixing ratio	PercoTop [®] 449 All activators. <u>Remarks:</u> <ul style="list-style-type: none"> Use CS706 only for indoor application. 	Volume	Weight
			4	5
			1	1
	Pot life at 20°C	About 2 hours with CS710-CS712 activators.		

PercoTop[®] 449

2K Structure Topcoat

Application

		Structure	Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	Coarse	As mixed	0	3.0	2.5-3.0	2
	Suction feed	Fine	As mixed	0	2.0		2
		Smooth	25-30	30-35	1.6-1.8		2
(High pressure spraying)		Spatter effect	As mixed	0	1.0-2.5		1
	HVLP	Coarse	As mixed	0	3.0	2.0-2.5	2
		Fine	As mixed	0	2.0		2
		Smooth	25-30	30-35	1.6-1.8		2
	(Low pressure spraying)		Spatter effect	As mixed	0	1.0-2.5	
	Airless	Coarse	As mixed	0	0.50	2.0-3.0 air	2
	Airmix	Fine	As mixed	0	0.41	ca. 80-120 material	2
		Smooth	25-30	30-35	0.28		2
	Pressure pot	Coarse	As mixed	0	1.3	2.5-3.0 air	2
	Membrane pump	Fine	As mixed	0	1.2		2
		Smooth	25-30	30-35	1.1	1.0-1.5 material	1
	(High pressure spraying)		Spatter effect	As mixed	0	1.0-2.0	
	Electrostatic	According to the advice of the Technical Representative.					
Remarks for spatter effect		Pre-spray with thinned material (25 s DIN 4 mm). The pre-sprayed coat should not dry longer than 6 hours and should not be baked.					
Recommended dry film thickness		40-80 µm Depending on the structure, thicker coats can be obtained.					

PercoTop[®] 449

2K Structure Topcoat

Drying

Air drying at 20°C	50 µm dry film thickness
Dust dry	30-50 minutes
Dry to handle	3 hours
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

Remarks	Add CS215 to the base paint to accelerate the drying of the product following recommendations from the Technical Representative.
----------------	--



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	68	1.31	-	-
Ready for use	69	1.28	9	115
Black				
Packaged	64	1.17	-	-
Ready for use	65	1.16	10	106

PercoTop[®] 449

2K Structure Topcoat

Remarks

	<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. • Different structured effects can be produced. It should be noted that the available gloss levels are only indicative of the visual impression in a medium structure. When PercoTop[®] 449 is sprayed in a very fine structure or in a smooth coat, the finish will be significantly lower in gloss: it may be advisable to order/mix a higher gloss level formula in this case. Likewise, a formula sprayed in a very coarse structure will be more glossy than in a medium structure. • Refer to table 1 and 2 of specifications of industrial paint if chemical or heat resistance is required.
	<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.
<p>Storage conditions</p>	<ul style="list-style-type: none"> • Refer to the label on the original can.

<p>Safety</p> <p>Consult the Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.</p>



PercoTop[®] 449

2K Structure Topcoat

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.

This Technical Data Sheet supersedes all previous issues.

Copyright © 2014, Axalta Coating Systems, LLC and all affiliates. All rights reserved. The Axalta logo, Axalta™, Axalta Coating Systems™ and all products denoted with ™ or ® are trademarks or registered trademarks of Axalta Coating Systems, LLC and its affiliates. Axalta trademarks may not be used in connection with any product or service that is not an Axalta product or service.