

PercoTop® 477

2K DTM Structure Topcoat

Features

- PercoTop® 477 2K DTM Structure Topcoat is a polyurethane based 2K structure topcoat with a high mechanical resistance.
- 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.
- Different structures can be produced (cf. PercoTop® fandeck, leaflets 17-20).

Products

Base paint

PercoTop® 477	PercoTop® 477 2K DTM Structure Topcoat
CS949	PercoTop® 2K Structure Binder
CS345	PercoTop® 2K HS Primer 040 Base
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 (only for indoor application)
CS602	PercoTop® Thinner 2K

Colours

- Industrial and standard colour registers.

Substrates

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

For professional use only!




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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 "Metallic Substrates - Treatment before Coating".
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<p>VOC value ready for use (EU Directive 1999/13/EC)</p> <ul style="list-style-type: none"> • < 420 g/l 5:1 by weight with CS711 (without thinner).






Product preparation

 	<p>Mixing ratio</p> <p>PercoTop[®] 477 All activators.</p>	Volume	Weight
		4 1	5 1
	<p>Pot life at 20°C</p> <p>About 2 hours with CS710-CS712 activators.</p>		

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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.					

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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.
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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	70	1.38	-	-
Ready for use	68	1.33	7	147
Black				
Packaged	65	1.24	-	-
Ready for use	62	1.21	10	100



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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. • 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>



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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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