

## PercoTop<sup>®</sup> 611 2K DTM Topcoat

### Features

- PercoTop<sup>®</sup> 611 2K DTM Topcoat is a 2K topcoat based on polyacrylate resin.
- 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.
- 5 gloss levels: high gloss to matt (c.f. PercoTop<sup>®</sup> Fandeck)

### Products

#### Base Paint

PercoTop <sup>®</sup> 611	PercoTop <sup>®</sup> 611 2K DTM Topcoat
CS911	PercoTop <sup>®</sup> 2K DTM Binder
XXX	Tints

#### Activators

CS710	PercoTop <sup>®</sup> Activator VHS Fast
CS711	PercoTop <sup>®</sup> Activator VHS Standard
CS712	PercoTop <sup>®</sup> Activator VHS Slow

#### Thinners

CS610	PercoTop <sup>®</sup> Thinner Fast
CS620	PercoTop <sup>®</sup> Thinner Standard
CS630	PercoTop <sup>®</sup> Thinner Slow
CS600	PercoTop <sup>®</sup> Thinner Standard

#### Also possible:

CS704	PercoTop <sup>®</sup> Activator 3840
CS706	PercoTop <sup>®</sup> Activator 4060
CS603	PercoTop <sup>®</sup> Thinner Fast

### Colours

- Industrial and standard colour registers.

### Substrates

- Steel and aluminium.
- Galvanic, sendzimir and hot dip galvanised steel.

### For professional use only!

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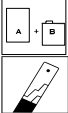


### Surface preparation

- 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".

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

- ≤ 550 g/l                      10:1 by weight with CS706 + 25% CS600.







## Product preparation

	<b>Mixing ratio</b>		
		Volume	Weight
	PercoTop <sup>®</sup> 611	9	10
	All activators.	1	1
<b>Thinner</b>	CS610, CS620, CS630, CS600		
	<b>Pot life at 20°C</b>	8 hours with CS710-CS712 activators.	

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### Application

	Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
 <b>Gravity feed</b>  <b>Suction feed</b> (High pressure spraying)	20-22	15-30	1.4-1.8	2.5-3.0	2-3
 <b>HVLP</b> (Low pressure spraying)	20-22	15-30	1.4-1.8	2.0-2.5	2-3
 <b>Airless</b> <b>Airmix</b>	30-35	10-15	0.23-0.28	2.0-3.5 air  ca. 80-120 material	2
 <b>Pressure pot</b> <b>Membrane pump</b> (High pressure spraying)	20-22	15-30	1.1	2.5-3.0 air  1.0-1.5 material	2
 <b>Electrostatic</b>	According to the advice of the Technical Representative.				
<b>Recommended dry film thickness</b>	60-100 µm				



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### Drying

<b>Air drying at 20°C</b>	60 µm dry film thickness.	
	With CS710	With CS706
<b>Dust dry</b>	Approx. 20 minutes	Approx. 30 minutes
<b>Dry to handle</b>	Approx. 1 hour	Approx. 3 hours
<b>Dry to assemble</b>	24 hours	24 hours
<b>Forced drying</b>	Flash time: 10 minutes. Depending on film thickness.	
<b>Drying time</b>	30 minutes	
<b>Drying temperature</b>	60°C object temperature	
<b>Remarks</b>	Add CS215 to the basic paint to accelerate the drying of the product following recommendations from the Technical Representative.	

### Product data



	<b>Solids</b>  Weight (%) +/- 1	<b>Density</b>  (kg/l) +/- 0.01	<b>Theoretical coverage</b> (at 60 µm) (m <sup>2</sup> /kg)	<b>Theoretical material consumption</b> (at 60 µm) (g/m <sup>2</sup> )
<b>White</b>				
Packaged	60	1.19	-	-
Ready for use	49	1.12	7	147
<b>Black</b>				
Packaged	51	1	-	-
Ready for use	43	1	7	135



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### Remarks

	<ul style="list-style-type: none"> <li>• 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.</li> <li>• Refer to table 1 and 2 of specifications of industrial paint if chemical or heat-resistance is required.</li> </ul>
	<ul style="list-style-type: none"> <li>• Stir well before use.</li> </ul>
	<ul style="list-style-type: none"> <li>• Axalta recommends the customer should perform a quick colour-check of products before use.</li> </ul>
<b>Storage Conditions</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.



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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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