





# PercoTop<sup>®</sup>

CS321

1K Filler 021 Grey

## 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 "Metal Substrates - Treatment before Coating".

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

- < 540 g/l                      10% thinner included.

## Product preparation







Thinner	CS610 or CS600
Recommended dry film thickness	40-80 µm

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## Application

		<b>Application viscosity DIN 4 mm at 20°C (s)</b>	<b>Thinner (%)</b>	<b>Spray nozzle (mm)</b>	<b>Pressure (bar)</b>	<b>Number of coats</b>
	<b>Gravity feed</b>					
	<b>Suction feed</b>	24-26	10-15	1.6-1.8	2.5-3.0	1-2
(High pressure spraying)						
	<b>HVLP</b>	24-26	10-15	1.6-1.8	2.0-2.5	1-2
(Low pressure spraying)						
	<b>Airless</b>					
	<b>Airmix</b>	35-40	5-10	0.28-0.23	2.0-3.0 air ca. 80-100 material	1
	<b>Pressure pot</b>					
	<b>Membrane pump</b>	24-26	10	1.1	2.5-3.5 air 1.0-2.0 material	1-2
(High pressure spraying)						
	<b>Electrostatic</b>	According to the advice of your technical representative.				



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## Drying

Air drying at 20°C	40 µm dry film thickness	80 µm dry film thickness
Dust dry	10-15 minutes	1 hour 30 minutes
Dry to handle	1 hour 30 minutes	4 hours
Dry to recoat	30 minutes	4 hours
Dry to assemble	2 hours	6 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 without sanding is still possible after 4 weeks.

## Product data

	Solids	Density	Theoretical coverage	Theoretical material Consumption
	Weight (%) +/- 1	(kg/l) +/- 0.01	(at 40 µm) (m²/kg)	(at 40 µm) (g/m²)
Packaged	75	1.53		
Mixed with 10% CS610	69	1.47	8.5	118



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## Remarks

	<ul style="list-style-type: none"> <li>Stir well 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>

<b>Note on safety:</b>	
	<p>This product is classified according to regulation (EC) 1272/2008 (CLP). Please consult the Safety Data Sheet. It is strongly recommended to use appropriate personal protection equipment during application.</p>
Observe the precautionary notices displayed on the container.	

<p><b>Information</b></p> <p>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.</p> <p>This Technical Data Sheet supersedes all previous issues.</p>
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