



PercoTop®

CS382

2K Zinc Rich Epoxy Primer 053

Features

- PercoTop® CS382 2K Zinc Rich Epoxy Primer 053 is a 2K Primer with a high amount of zinc dust.
- Composition based on epoxy resin.
- It can be used as the first layer of paint systems for highest corrosion protection of heavy-gauge steel.
- This zinc rich primer has got an excellent barrier and cathodic protection and can be used with any suitable EP filler to produce a highly durable coating system.
- Highly heat resistant up to a continuous temperature of 180°C.

Product

CS382 PercoTop® 2K Zinc Rich Epoxy Primer 053

Activator

CS780 PercoTop® Activator Epoxy

Thinner

CS680 PercoTop® Thinner Epoxy

Colour

- Grey.

Substrates

- Sandblasted steel (SA 2.5).

For professional use only!

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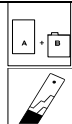

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| <p>Surface preparation</p> <ul style="list-style-type: none"> • Grit blast in surface preparation level SA 2.5 according to DIN EN ISO 12944-4. • Substrates must be free from all contaminants. • Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test. See data sheet "Metal Substrates - Treatment before Coating". |
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| <p>VOC value ready for use (EU Directive 1999/13/EC)</p> <ul style="list-style-type: none"> • < 550 g/l 15:1 by weight with CS780 + 10% CS680. |
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Product preparation








| | | | | |
|---|---------------------------------------|---------------|--------|--------|
|  | Mixing Ratio | CS382 | Weight | Volume |
| | | CS780 | 15 | 5 |
| | Thinner | CS680 | 1 | 1 |
|  | Pot life at 20°C | 3 hours | | |
| | Recommended dry film thickness | 60-80 µm | | |
| | Reaction temperature | At least 5°C. | | |

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Application

| | Application viscosity DIN 4 mm at 20°C (s) | Thinner (%) | Spray nozzle (mm) | Pressure (bar) | Number of coats |
|--|--|----------------|-------------------------|---|--------------------|
|  Gravity feed  Suction feed (High pressure spraying) | 21-23 | 5-10 | 1.8 | 2.5-3.0 | 2-3 |
|  HVLP (Low pressure spraying) | 21-23 | 5-10 | 1.8 | 2.0-2.5 | 2-3 |
|  Airless Airmix | As mixed | 0 | 0.39-0.43 | 2.0-3.0 air ca. 80-120 material | 2 |
|  Pressure pot Membrane pump (High pressure spraying) | 21-23 | 5-10 | 1.3-1.5 | 1.0-2.0 air 2.5-3.0 material | 2-3 |
|  Electrostatic | According to the advice of the Technical Representative. | | | | |
|  Brush and Roll | According to the advice of the Technical Representative. With thin-gauge steel fabrications or structures of complex configuration, the nominal prescribed filmbuild may be difficult to achieve, therefore additional application might be needed. | | | | |

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Drying

| | |
|---------------------------|--------------------------|
| Air drying at 20°C | 60 µm dry film thickness |
| Dust dry | 1 hour |
| Dry to handle | 2 hours |
| Fully cured | 96 hours |
| Dry to assemble | 4 hours |

| | |
|---------------------------|---|
| Forced drying | Flash time: 15 minutes. Depending on film thickness. |
| Drying time | 30 minutes |
| Drying temperature | 60°C object temperature |

Recoatability

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|-------------------|---|
| Recoatable | 1) With PercoTop® Primers/Surfacers. 2) For superior barrier protection with CS591 (PercoTop® Epoxy HS High Build Coating). |
| Remarks | Recoating with above mentioned products must be done within 5 days. |

Product data

| | Solids Weight (%) +/- 1 | Density (kg/l) +/- 0.01 | Theoretical coverage (at 80 µm) (m ² /kg) | Theoretical material consumption (at 80 µm) (g/m ²) |
|--------------------------------------|--|--|---|--|
| Packaged | 83 | 2.66 | - | - |
| Mixed 15:1 with CS780 + 10% CS680 | 74 | 2.07 | 2.3 | 431 |



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Remarks

| | |
|----------------------------------|---|
| | <ul style="list-style-type: none"> • Stir well before use. |
| <p>Storage conditions</p> | <ul style="list-style-type: none"> • Refer to the label on the original can. |

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 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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