



PercoTop®

CS340/CS342/CS343/CS345

2K HS Primer 040

Features

- PercoTop® 2K HS Primer 040 is a polyacrylic based low VOC 2K primer/filler.
- Developed to address the most demanding requirements of the commercial vehicles, ACE segment and general industry.
- It is fast drying and can be used as primer or primer surfacer.

Products

CS340/CS342/CS343
CS345
XXX

PercoTop® 2K HS Primer 040
PercoTop® 2K HS Primer 040 Base
Tints

Activators

CS710
CS711

PercoTop® Activator VHS Fast
PercoTop® Activator VHS Standard

Thinners

CS610
CS620

PercoTop® Thinner Fast
PercoTop® Thinner Standard

Also possible:

Activators

CS704
CS705
CS706
CS714
CS726

PercoTop® Activator 3840
PercoTop® Activator 4040
PercoTop® Activator 4060
PercoTop® Activator 3845
PercoTop® Activator 4065

Thinners

CS600
CS602

PercoTop® Thinner Standard
PercoTop® Thinner 2K

Colours

- CS340: light grey
- CS342: white
- CS343: black
- CS345: base
CS345 can be used to mix other colours.

For professional use only!

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Substrates

- Steel (sandblasting recommended), iron- and zinc phosphated steel.
- Galvanised, sendzimir and hot dip galvanised steel.
- Aluminium (pre-check recommended).
- Sanded EP and UP-GRP.

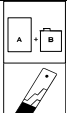

Surface preparation

- 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".
- Sandblasting is recommended for steel substrates.

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

- < 540 g/l 10 : 1 by weight with VHS Activator + 25% Thinner
 5 : 1 by weight with HS Activator + 10% Thinner

Product preparation






	Mixing ratio	VHS		HS		
		Volume	Weight	Volume	Weight	
		CS340/CS342/CS343/CS345	9	10	4	5
		CS710/CS711/CS704/CS705/CS706	1	1	-	-
		CS714/CS726	-	-	1	1
	Thinner	CS610, CS620, CS600				
	Pot life at 20°C	2-8 hours depending on activator.				
	Recommended dry film thickness	Indoor use: 25-30 µm. Outdoor use with exposure to humid and wet conditions: at least 40 µm. Outdoor use with exposure to chemicals: at least 80 µm.				

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Application

		Undercoat	Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	Adhesion promoter	18	HS: 20 VHS: 25	1.3-1.5	2.5-3.0	1-2
	Suction feed	Primer	25	HS: 15 VHS: 20	1.5-1.8		2-3
		Primer surfacer	30	HS: 10 VHS: 15	1.8-2.0		2-3
(High pressure spraying)							
	HVLP	Adhesion promoter	18	HS: 20 VHS: 25	1.3-1.5	2.0-2.5	1-2
		Primer	25	HS: 15 VHS: 20	1.5-1.8		2-3
		Primer surfacer	30	HS: 10 VHS: 15	1.8-2.0		2-3
(Low pressure spraying)							
	Airless	Adhesion promoter	20	HS: 18 VHS: 25	0.23-0.28	2.0-3.0 air	1
	Airmix	Primer	40	HS: 10 VHS: 15	0.28-0.33		ca. 80-120 material
			Primer surfacer	50	HS: 0-5 VHS: 5	0.28-0.33	
	Pressure pot	Adhesion promoter	18	HS: 20 VHS: 25	1.1	2.5-3.0 air	1-2
	Membrane pump	Primer	25	HS: 15 VHS: 20	1.1-1.2		1.0-2.0 material
			Primer surfacer	30	HS: 10 VHS: 15	1.2	
(High pressure spraying)							
	Electrostatic	According to the advice of the Technical Representative.					



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Drying

Air drying at 20°C	40 µm dry film thickness
Dust dry	15 minutes
Dry to handle	1 hour
Dry to recoat	1 hour
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

Recoatability

Recoatable	With PercoTop® Topcoats.
Remarks	Recoating with above mentioned products without sanding between coats is still possible after 4 weeks. A wet-on-wet application with PercoTop® EP Topcoats is not possible.

Product data

	Solids	Density	Theoretical coverage	Theoretical material consumption
	Weight (%) +/- 1	(kg/l) +/- 0.01	(at 40 µm) (m ² /kg)	(at 40 µm) (g/m ²)
Light Grey				
Packaged	66	1.38	-	-
Mixed with CS706 + 25% CS600	57	1.26	7.7	129





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Remarks

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

Note on safety:	
	<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>
<p>Observe the precautionary notices displayed on the container.</p>	

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

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