



# PercoTop®

CS340/CS342/CS343/CS345

2K HS Primer 040

Features	
<ul style="list-style-type: none"> <li>PercoTop® 2K HS Primer 040 is a polyacrylic based low VOC 2K primer/filler.</li> <li>Developed to address the most demanding requirements of the commercial vehicles, ACE segment and general industry.</li> <li>It is fast drying and can be used as primer or primer surfacer.</li> </ul>	

Products	
CS340/CS342/CS343	PercoTop® 2K HS Primer 040
CS345	PercoTop® 2K HS Primer 040 Base
XXX	Tints
Activators	
CS710	PercoTop® Activator VHS Fast
CS711	PercoTop® Activator VHS Standard
Thinners	
CS610	PercoTop® Thinner Fast
CS620	PercoTop® Thinner Standard
<u>Also possible:</u>	
Activators	
CS704	PercoTop® Activator 3840
CS705	PercoTop® Activator 4040
CS706	PercoTop® Activator 4060
CS714	PercoTop® Activator 3845
CS726	PercoTop® Activator 4065
Thinners	
CS600	PercoTop® Thinner Standard
CS602	PercoTop® Thinner 2K

Colours	
<ul style="list-style-type: none"> <li>CS340: light grey</li> <li>CS342: white</li> <li>CS343: black</li> </ul>	<ul style="list-style-type: none"> <li>CS345: base CS345 can be used to mix other colours.</li> </ul>

**For professional use only!**

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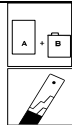

## CS340/CS342/CS343/CS345 2K HS Primer 040

Substrates
<ul style="list-style-type: none"> <li>• Steel (sandblasting recommended), iron- and zinc phosphated steel.</li> <li>• Galvanised, sendzimir and hot dip galvanised steel.</li> <li>• Aluminium (pre-check recommended).</li> <li>• Sanded EP and UP-GRP.</li> </ul>

Surface preparation
<ul style="list-style-type: none"> <li>• Substrates must be free from all contaminants.</li> <li>• 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".</li> <li>• Sandblasting is recommended for steel substrates.</li> </ul>

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 CS710/CS711/CS704/CS705/CS706 CS714/CS726	9	10	4	5
Thinner	-	-	1	1
 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
	<b>Gravity feed</b>	Adhesion promoter	18	HS: 20 VHS: 25	1.3-1.5	2.5-3.0	1-2
		<b>Suction feed</b>	Primer	25	HS: 15 VHS: 20	1.5-1.8	
		Primer surfacer	30	HS: 10 VHS: 15	1.8-2.0		2-3
(High pressure spraying)							
	<b>HVLP</b>	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)							
	<b>Airless</b>	Adhesion promoter	20	HS: 18 VHS: 25	0.23-0.28	2.0-3.0 air	1
	<b>Airmix</b>	Primer	40	HS: 10 VHS: 15	0.28-0.33	ca. 80-120 material	1-2
		Primer surfacer	50	HS: 0-5 VHS: 5	0.28-0.33		2-3
	<b>Pressure pot</b>	Adhesion promoter	18	HS: 20 VHS: 25	1.1	2.5-3.0 air	1-2
	<b>Membrane pump</b>	Primer	25	HS: 15 VHS: 20	1.1-1.2	1.0-2.0 material	2-3
		Primer surfacer	30	HS: 10 VHS: 15	1.2		2-3
(High pressure spraying)							
	<b>Electrostatic</b>	According to the advice of the Technical Representative.					

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## Drying

<b>Air drying at 20°C</b>	40 µm dry film thickness
<b>Dust dry</b>	15 minutes
<b>Dry to handle</b>	1 hour
<b>Dry to recoat</b>	1 hour
<b>Dry to assemble</b>	16 hours
<b>Forced drying</b>	Flash time: 15 minutes. Depending on film thickness.
<b>Drying time</b>	30 minutes
<b>Drying temperature</b>	60°C object temperature

## Recoatability

<b>Recoatable</b>	With PercoTop® Topcoats.
<b>Remarks</b>	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


	<b>Solids</b>  Weight (%) +/- 1	<b>Density</b>  (kg/l) +/- 0.01	<b>Theoretical coverage</b>  (at 40 µm) (m <sup>2</sup> /kg)	<b>Theoretical material consumption</b>  (at 40 µm) (g/m <sup>2</sup> )
<b>Light Grey</b>				
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"> <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>

**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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