

## PercoTop® HS

### 2K HS Topcoat

#### Features

- PercoTop® HS 2K HS Topcoat is a VOC compliant, high solids, 2K topcoat based on acrylic resin.
- For application on large machinery, cranes and industrial constructions.
- Various gloss levels available in combination with CS909.
- It has an excellent mechanical and chemical resistance and combines low material consumption with good sagging resistance and final appearance.

#### Products

##### Base Paint

PercoTop® HS	PercoTop® HS 2K HS Topcoat
CS905	PercoTop® 2K HS Binder
CS909	PercoTop® 2K HS Matt Binder
XXX	Tints

##### Activators

CS710	PercoTop® Activator VHS Fast
CS711	PercoTop® Activator VHS Standard
CS712	PercoTop® Activator VHS Slow

##### Thinners

CS610	PercoTop® Thinner Fast
CS620	PercoTop® Thinner Standard
CS630	PercoTop® Thinner Slow
CS640	PercoTop® Thinner Extra Slow

#### Colours

- Industrial and standard colour registers.

#### Substrates





- All PercoTop® primers, primer surfacers and surfacers.
- Cured, solvent resistant, well preserved and scuff sanded old finish.

**For professional use only!**

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### Surface preparation

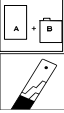



<b>Substrates must be free from all contaminants.</b>		
<b>Apply to</b>	PercoTop® Primer/Primer Surfacer or old paintwork.	
	Thoroughly clean old paintwork.	
<b>Either</b>		Sand dry with orbital sander and dust exhaust P320-P500.
<b>or</b>		Sand wet with sandpaper P600-P800.
	Before further treatment, carefully clean sanded areas once more to remove all dust, paint residues from sanding and other impurities.	

<b>VOC value ready for use</b> (EU Directive 1999/13/EC)		
• < 420 g/l	3:1 by volume with CS710 + 15% CS610.	

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### Product preparation

	Mixing ratio		Standard	Matt
			Volume	Volume
		PercoTop® HS CS710/CS711/CS712	3	5
			1	1
	Thinner	CS610 CS620 CS630 CS640 <u>Remarks:</u> - Use CS610 on small objects at 15-25°C. - Use CS620 on medium sized objects at 20-25°C. - Use CS630 on large objects at 20-30°C. - Use CS640 on large objects when exceeding 30°C.		
	Pot life at 20°C	2-3 hours		

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### Application

		<b>Application viscosity</b> <b>DIN 4 mm</b> <b>at 20°C</b>  (s)	<b>Thinner</b>  (%)	<b>Spray nozzle</b>  (mm)	<b>Pressure</b>  (bar)	<b>Number of coats</b>
	<b>Gravity feed</b>	22-26	10-15	1.4-1.6	2.5-3.5	1.5
	<b>Suction feed</b>					
(High pressure spraying)						
	<b>HVLP</b>	22-26	10-15	1.4-1.6	2.0-2.5	1.5
(Low pressure spraying)						
	<b>Airless</b>	30-35	0-5	0.23-0.28	2.0-3.0 air	1
	<b>Airmix</b>				ca. 80-100 material	
	<b>Pressure pot</b>	22-26	10-15	1.1	2.5-3.5 air	1.5
	<b>Membrane pump</b>				1.0-2.0 material	
(High pressure spraying)						
	<b>Electrostatic</b>	According to the advice of the Technical Representative.				
<b>Recommended dry film thickness</b>		50-80 µm				

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### Drying

<b>Air drying at 20°C</b>	70 µm dry film thickness
<b>Dust dry</b>	20 minutes - 1 hour
<b>Dry to handle</b>	4-6 hours
<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
<b>Remarks</b>	Add CS215 to the base 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 50 µm) (m <sup>2</sup> /kg)	<b>Theoretical material consumption</b> (at 50 µm) (g/m <sup>2</sup> )
<b>White</b>				
Packaged	73.1	1.21	-	-
Ready for use	67.6	1.23	10.3	97
<b>Black</b>				
Packaged	63.2	1.00	-	-
Ready for use	58.6	1.01	10.2	98

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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), drying properties (CS215), anti-cratering properties (CS213) and structuring (CS220-CS223).</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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