

## PercoTop<sup>®</sup> CS310/CS312/CS313 1K Primer 010

### Features

- PercoTop<sup>®</sup> 1K Primer 010 is a solventborne zinc chromate-free 1K primer based on polyvinyl butyral resins. It provides very good adhesion on metal substrates and is ideally suited for temporary and moderate corrosion protection levels.

### Products

CS310/CS312/CS313  
CS315  
XXX

PercoTop<sup>®</sup> 1K Primer 010  
PercoTop<sup>®</sup> 1K Primer 010 Base  
Tints

### Thinner

CS610

PercoTop<sup>®</sup> Thinner Fast

### Also possible:

CS600

PercoTop<sup>®</sup> Thinner Standard

### Colours

- CS310: light grey
- CS312: white
- CS313: black
- CS315: base  
CS315 can be used to mix other colours.

### Substrates

- Steel, aluminium and other non-ferrous metals.
- Galvanic and sendzimir zinc coated steel.

**For professional use only!**



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## 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)

- < 780 g/l                      30% thinner inclusive

## Product preparation

Thinner	CS610
Recommended dry film thickness	20-30 µm

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## Application

		Application viscosity DIN 4 mm at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	<b>Gravity feed</b>	18-20	25-30	1.3-1.4	2.5-3.0	2
	<b>Suction feed</b>					
	(High pressure spraying)					
	<b>HVLP</b>	18-20	25-30	1.3-1.4	2.0-2.5	2
	(Low pressure spraying)					
	<b>Airless</b>	30-35	10-15	0.28	2.0-3.0 air	1-2
	<b>Airmix</b>				ca. 80-120 material	
	<b>Pressure pot</b>	18-20	25-30	1.1	2.5-3.5 air	2
	<b>Membrane pump</b>				1.0-2.0 material	
	(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>	25 µm dry film thickness
<b>Dust dry</b>	10 minutes
<b>Dry to handle</b>	15 minutes
<b>Dry to recoat</b>	30 minutes
<b>Dry to assemble</b>	30 minutes

<b>Forced drying</b>	Flash time: 5 minutes. Depending on film thickness.
<b>Drying time</b>	10 minutes
<b>Drying temperature</b>	60°C object temperature

## Recoatability

<b>Recoatable</b>	With all PercoTop <sup>®</sup> Topcoats with the exception of PercoTop <sup>®</sup> EP Topcoat.
<b>Remarks</b>	Recoating with above mentioned products without sanding between coats is still possible after 4 weeks.

## Product data

	<b>Solids</b>	<b>Density</b>	<b>Theoretical coverage</b>	<b>Theoretical material consumption</b>
	Weight (%) +/- 1	(kg/l) +/- 0.01	(at 25 µm) (m <sup>2</sup> /kg)	(at 25 µm) (g/m <sup>2</sup> )
<b>White</b>				
Packaged	39	1.12	-	-
Mixed with 30% CS610	32	1.05	6	166



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**Remarks**

	<ul style="list-style-type: none"> <li>• Stir well before use.</li> </ul>
<p><b>Storage Conditions</b></p>	<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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