Technical Data Sheet

PercoTop® 611

2K DTM Topcoat

Description

PercoTop® 611 is a solvent borne 2K topcoat.
Composition based on polyacrylate.

Products

PercoTop® 611	PercoTop® 611 2K DTM Topcoat
CS911	PercoTop® 611 DTM Binder
CS / PT	PercoTop® CS / IFL PT Tints
CS704	PercoTop® Activator 3840
CS706	PercoTop® Activator 4060
CS600	PercoTop® Thinner Standard
CS603	PercoTop® Thinner Fast

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Colours

- Industrial and standard colour registers

Properties

- The special binder/pigment formula makes a high protection against corrosion possible when applying on metallic substrates.

Substrates

- Steel and Aluminium
- Galvanised Steel, Sendzimir and Hot Dip Galvanized Steel

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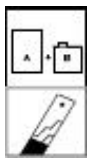
Surface preparation of metals listed in the substrate section on page 1.

- The substrate must be free of all contaminants and corrosion.
- Clean the substrate with CS600 thinner by wiping on and removing with clean lint free Sontara® Cloths, renew Sontara® cloths as required. Repeat this process with new Sontara® cloths and CS600 to ensure the substrate is thoroughly clean.
- Mechanical treatment,
  Aluminium – thoroughly abrade with a Red Scotch Pad.
  Steel and Galvanised Steel – thoroughly abrade with P180 dry sanding paper.
- Remove sanding residue then re-clean with CS600 as above prior to the application of properly mixed and activated Percotop® 611 2K DTM Topcoat.
- For sand blasted Steel substrates ensure the blast profile does not exceed 50 microns and that the dry film thickness of Percotop® 611 2K DTM Topcoat is at least 60 microns above the top of the blast profile.
- Because of the wide variety of substrates and their manufacturing processes, a preliminary test should be carried out on the respective substrate to ensure that the pre-treatment is sufficient to guarantee perfect adhesion. For further information on substrate and respective surface preparation, refer to the supplier's specifications.

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

- RAL 9010: 548 g/l 9:1 by volume with CS706 + 25 % CS600
- RAL 9005: 543 g/l 9:1 by volume with CS706 + 25 % CS600

Product Preparation

 **Mixing Ratio**	PercoTop® 611 CS704/CS706	**Volume** **5 1 For improved chemical resistance**	**9 1 For pressure pot only**
Thinner	CS600/CS602 CS603	For Thinner addition, please see Application chart on the following page.	
 **Pot Life at 20°C**	8-16 hours, when mixed 9:1 (less when mixed 5:1)		
Recommended dry film thickness	60-80 µm		

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Application

	Application viscosity DIN 4 at 20°C (s)	Thinner (%)	Spray Nozzle (mm)	Pressure (bar)	Number of coats
 **Gravity Feed** **Suction Feed** (High pressure spraying)	20-22	20	1.6-1.8	2.5-3.5	2-3
 **HVLP** (Low pressure spraying)	20-22	20	1.6-1.8	2.0-2.5	2
 **Airless** **Airmix**	30-35	20	0.28	2.0-3.0 air Ca 100 material	2
 **Pressure Pot** **Membrane Pump** (High pressure spraying)	20-22	20	1.1 – 1.2	2.5-3.5 air 1.0-2.0 material	2
 **Electrostatic**	According to the advice of the DPC Technical Representative				

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Drying

Air Drying	60 µm dry film thickness	
Dust Dry	CS704 CS706	20 minutes 30 minutes
Dry to handle	CS704 CS706	1 hour 3 hours
Dry	CS704 CS706	24 hours At least 24 hours

Forced Drying	Flash time: 10 minutes. Depending on film thickness.
Drying Time	30 minutes
Drying Temperature	60°C object temperature
Remarks	To accelerate drying of the product follow recommendations from the DPC Technical Representative.

Product Data

Package viscosity	90-100 s DIN 4 @20°C
Flash point	28°C

	Solids Weight (%) +/- 1	**Density** (kg/l) +/- 0.01	**Theoretical coverage** (at 60 µm) (m^2/kg)	**Theoretical material consumption** (at 60 µm) (g/m^2)
White				
Packaged	64.6	1.27	-	-
Mixed	65.1	1.25	6.8	146
Black				
Packaged	57.4	1.08	-	-
Mixed	59.0	1.09	7.7	129

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Remarks

	● Stir the tinters and binders thoroughly each time before use ● Stir the mixture well after the weigh-out of the components.
	● Before application a colour comparison is recommended.
Storage Conditions	● Material has to be stored at a temperature between 5°C and 35°C.
Shelf Life at 5°C to 35°C	● 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 DPC cannot anticipate all variations in actual end-use conditions DuPont 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.