Technical Data Sheet

PercoTop®

CS314

1K Welding Primer

Features

- PercoTop® CS314 1K Welding Primer is a solvent borne zinc chromate-free 1K primer based on polyvinyl butyral.
- The Primer has a good corrosion protection when applied on steel parts.
- It will not produce harmful substances in the welding area through pyrolysis.
- CS314 possesses the internationally valid welding certificate.

Product

CS314	PercoTop® 1K Welding Primer

Thinner

CS600	PercoTop® Thinner Standard

Colour

- Reddish brown.

Substrates

- Steel.
- Aluminium.
- Galvanised steel panels.

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 25% CS600 inclusive.

Product preparation

Thinner	CS600
Recommended dry film thickness	15-25 µm

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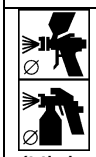
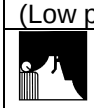
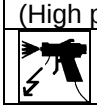
Application

	Application viscosity DIN 4 mm 20°C at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
 **Gravity feed** **Suction feed** (High pressure spraying)	18-20	25-30	1.3-1.4	2.5-3.0	2
HVLP **HVLP** (Low pressure spraying)	18-20	25-30	1.3-1.4	2.0-2.5	2
 **Airless** **Airmix**	30-35	10-15	0.28	2.0-3.0 air ca. 80-100 material	1-2
 **Pressure pot** **Membrane pump** (High pressure spraying)	18-20	25-30	1.1	2.5-3.5 air 1.0-2.0 material	2
 **Electrostatic**	According to the advice of the Technical Representative.				

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Drying

Air drying at 20°C	20 µm dry film thickness
Dust dry	10 minutes
Dry to handle	15 minutes
Dry to recoat	30 minutes
Dry to assemble	30 minutes

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

Recoatability

Recoatable	With all PercoTop® Topcoats with the exception of PercoTop® EP Topcoat.
Remarks	Recoating with above mentioned products without sanding is possible.

Product data

	Solids Weight (%) +/- 1	**Density** (kg/l) +/- 0.01	**Theoretical coverage** (at 25 µm) (m^2/kg)	**Theoretical material consumption** (at 25 µm) (g/m^2)
Reddish brown				
Packaged	44	1.14		
Mixed with 25% CS600	37	1.01	6.6	151

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Remarks

	• Stir well before use.
Storage Conditions	• 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 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.