



# PercoTop®

CS399

Clear Carbon Fibre Sealer

## Features

- PercoTop® CS399 Clear Carbon Fibre Sealer is a polyurethane sealer designed to fill porosity in all grades of carbon fibre, resulting in fewer process steps and reduced material usage over processes using only clearcoat.
- For maximum UV protection, it is essential that a recommended clearcoat is applied over this sealer.
- It has an excellent flow, is easy to apply and is fast drying.

## Products

CS399 PercoTop® Clear Carbon Fibre Sealer

**Activator**  
CS703 PercoTop® Activator UV-Resistance

**Thinners**  
CS600 PercoTop® Thinner Standard  
CS602 PercoTop® Thinner 2K

### Special remark:

To ensure maximum UV protection of substrate, this sealer should be over-coated with either RK69240 (exterior automotive use) or DP6940 (for Marine use). For general industrial use, PercoTop® clearcoats, CS802 or CS805 may be used. Refer to separate TDS.

## Colour

- Transparent.

## Substrate

- Carbon fibre.

**For professional use only!**

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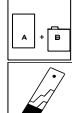


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<p><b>Surface preparation</b></p> <ul style="list-style-type: none"> <li>• Clean parts with CS410 or 3608S degreaser.</li> <li>• Lightly sand with P500-P600 (avoid heavy sanding).</li> <li>• For difficult areas use Red Scotchbrite, or equivalent, with CS410 or 3608S degreaser.</li> <li>• Clean parts again with CS410 or 3608S degreaser. Wipe on, wipe off (with clean, lint-free cloth).</li> </ul>
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<p><b>VOC value ready for use (EU Directive 1999/13/EC)</b></p> <ul style="list-style-type: none"> <li>• 460 g/l                      4:1 by volume with CS703 + 20% CS600.</li> </ul>
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## Product preparation




	<p><b>Mixing ratio</b></p> <p>PercoTop® CS399 CS703</p>	Volume	Weight
		4 1	4 1
	<p><b>Thinner</b></p> <p>CS600 CS602</p>		
	<p><b>Pot life at 20°C</b></p> <p>CS703</p>	2-3 hours	
<p><b>Recommended dry film thickness</b></p>	40-60 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>	20-22	CS600	20-30	1.3 -1.5	4.0-5.0	2 (5-10 mins flash between)
	<b>Suction feed</b> (High pressure spraying)		CS602				
	<b>HVLP</b> (Low pressure spraying)	20-22	CS600	20-30	1.3 – 1.5	2.0-2.5	



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## Drying

<b>Air drying at 20°C</b>	40-60 µm dry film thickness
<b>Dust dry</b>	1 hour 30 minutes
<b>Dry to handle</b>	4-8 hours
<b>Dry to assemble</b>	24-30 hours

<b>Forced drying</b>	Flash time: >10 minutes.
<b>Drying time</b>	35 minutes
<b>Drying temperature</b>	60°C object temperature

## 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> )
CS399	56.6	1.02	-	-
mixed	62.1	1.04	10.8	93




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## Remarks

	<ul style="list-style-type: none"> <li>Ensure product is mixed thoroughly after addition of activator and thinner.</li> </ul>
<p><b>UV protection</b></p>	<ul style="list-style-type: none"> <li>To ensure maximum UV protection of substrate, this primer should be over-coated with either RK69240 (exterior automotive use) or DP6940 (for Marine use). For general industrial use, PercoTop® clearcoats, CS802 or CS805 may be used. Refer to separate TDS.</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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