

CENTARI® 500 HIGH BUILD

27.08.2014

2K ENAMEL

DESCRIPTION

2-component topcoat system for solid colours for use on cars, buses and trucks.
Composition based on acrylic copolymer.

PRODUCTS

AM	Centari® MasterTint®
AK100	2K Binder
AK260	High Solids Activator
256S	Activator Fast
AK360	High Solids Thinner

PROPERTIES

- Gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Its lower solvent content at spray viscosity gives a reduction in VOC emission.
- Can be used for spot, panel and overall repair.

SUBSTRATES


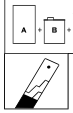







- All OEM and cured repair finishes, 2K primer-surfacers or 2K surfacers

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PRODUCT PREPARATION

	Cromax® colour tools	See colour formula.				
	Mixing ratio	Centari® 500 AK260 256S AK360	Fast		Standard	
			3		3	
			-		1	
			1		-	
			0.6		0.6	
	VOC					
	Pot life at 20°C	2 hr				
	Spray viscosity at 20°C	DIN 4 FORD 4	18-22 s 19-23 s			
	Spray equipment	Compliant guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure According to supplier's specifications	
			1.2-1.4 mm	10-15 cm		
			1.4-1.6 mm	10-15 cm		
			1.0-1.2 mm	10-15 cm		
		Conventional guns Gravity feed Suction feed Pressure feed	1.2-1.5 mm	15-20 cm	2-2.5 bar	
			1.4-1.8 mm	15-20 cm	2-2.5 bar	
			1.0-1.2 mm	15-20 cm	2-2.5 bar	
	Number of coats	2				
	Flash time	10 min between coats. No flash required before bake.				
	DFT	50-70 µm				
	Drying	Dust-free Dry to handle Tape-free	AK260		256S	
			20°C	30 min x 60°C	20°C	20 min x 60°C
			50 min	imm.	30 min	imm.
		6 hr	20 min	2 hr	20 min	
		O.N.	30 min	6 hr	30 min	
	IR drying*	Flash time	5 min			
		Distance	80 cm			
		Half power	5 min			
		Full power	15-20 min			
* Guideline for short/medium wave IR equipment.						
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.						

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SURFACE PREPARATION

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair according to damage.
4. Sand surface:
 - a. mechanical P320 - P400 (finally with P500 will give best results);
 - b. wet P800 - P1000.
5. Remove all traces of sanding dust, blowing oil-free compressed air.
6. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
7. Tack rag.

TOPCOAT APPLICATION

On well prepared surface, apply 2 full coats with 10 min flash between coats.

CHEMICAL RESISTANCE

When fully cured, Centari[®] 500 HB is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	toluene
hydrochloric acid	20 %	xylene
phosphoric acid	20 %	glycol
ammonia	10 %	brake fluid, petrol

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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RECOATABILITY

At any time after tape-free time. After 24 hr, scuff sanding is required.

REMARKS

- Centari® MasterTints® have to be thoroughly mixed before weigh-out and the Centari® 500 HB colour has to be mixed immediately after weigh-out.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- To spray interiors, use of 421R is recommended.
- For structured and/or flat colours, see specific TDS.
- For flexible systems, see specific TDS.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Theoretical coverage: 7.5-8 m²/l at recommended DFT - ready-to-spray

SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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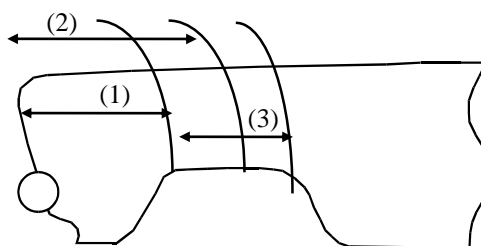
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SPOT REPAIR

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area with a non silicone containing rubbing compound or sand wet with P1200.
6. Rinse with water and dry.
7. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
8. Tack rag.
9. The following spot repair method can be used:
- AK350 Fade-out Thinner method.

AK350 FADE-OUT THINNER METHOD

- (1) Apply 1st coat Centari® 500 HB.
Flash time: 10 min.
- (2) Extend 2nd coat Centari® 500 HB beyond the previous one.
- (3) Smoothen out the fade-out area with AK350.



OPTIONAL: dilute 1 part ready-to-spray Centari® 500 HB with 1 part AK350 in the 2nd or 3rd coat. If necessary, balance out the gloss level by polishing with a non silicone containing polishing compound or a non silicone containing final glaze, after complete hardening of the repair.

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All other products referred to in the paint system build-up are from Cromax[®]. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax[®], unless explicitly indicated otherwise.

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