

CENTARI® 5035

27.08.2014

LOW EMISSION 2K TOPCOAT

DESCRIPTION

Ultra high solids 2-component topcoat system for solid colours for use on cars, buses and trucks. Composition based on a unique, patented “star” polymer technology.

PRODUCTS

AM	Centari® MasterTint®
ZK135	Low Emission 2K Binder
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
ZK335	Low Emission Additive

PROPERTIES

- Gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES










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

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PRODUCT PREPARATION

	Cromax® colour tools colour tools	See colour formula. Amount of ZK335 is mentioned on the Cromax® colour tools.					
	Mixing ratio	Centari® 5035 XK203 XK205 XK206	Fast	Standard	Slow		
			3	3	3		
			1	-	-		
			-	1	-		
		-	-	-	1		
	VOC	420 g/l					
	Pot life at 20°C	XK203 XK205 XK206	45 min 1 hr 2 hr				
	Spray viscosity at 20°C	DIN 4 FORD 4	19-24 s 20-25 s				
	Spray equipment	Compliant guns Gravity feed Suction feed Pressure feed Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure		
			1.3-1.5 mm	10-15 cm	According to supplier's specifications		
			1.5-1.8 mm	10-15 cm			
			1.0-1.2 mm	10-15 cm			
			1.4-1.6 mm	15-20 cm	2-2.5 bar		
			1.6-1.8 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	Good hidrs: 0-3 min between coats - no flash before bake. Poor hidrs: 5 min between coats - 10 min before bake.					
	DFT	60-70 µm					
	Drying	Dust-free Dry to handle Tape-free	XK203		XK205		XK206
			20°C	20 min x 60°C	20°C	30 min x 60°C	40 min x 60°C
			40 min	imm.	1 hr	imm.	imm.
			3 hr	imm.	4 hr	imm.	1 hr
		6 hr	20 min	O.N.	20 min	2 hr	
	IR drying*	Flash time Distance Half power Full power	10 min 80 cm 5 min 10 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 P360 - P500;
 - 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

- Good hidiers: On well prepared surface, apply 1 light coat, followed by a full coat with maximum 0-3 min flash between coats.
- Poor hidiers: On well prepared surface, apply 2 full coats with 5 min flash between coats.

CHEMICAL RESISTANCE

When fully cured, Centari[®] 5035 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[®] 5035 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.
- 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: 7-9 m²/l at recommended DFT - ready-to-spray
Directive 2004/42/EC: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

SAFETY

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

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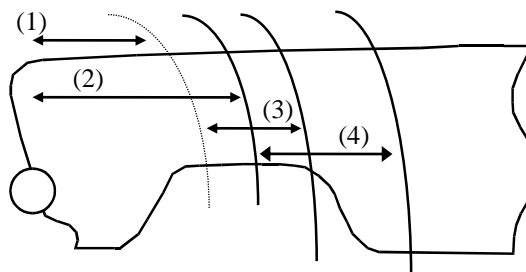
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SPOT REPAIR

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® 5035.
Flash 0-3 min maximum for good hidere, 5 min for poor hidere between coats.
- (2) Extend 2nd coat Centari® 5035 beyond the previous one.
- (3) Smoothen out the fade-out area with AK350 within 5 min maximum.
- (4) Optionally extend the fade-out area with AK350 within 5 min maximum.



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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