

CENTARI® 600

27.08.2014

BASECOAT LACQUER

DESCRIPTION

Basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on cars, trucks and buses.

Composition based on acrylic copolymer.

PRODUCTS

AM	Centari® MasterTint®
AB150	Basecoat Binder
AB160	Basecoat Binder
AB380	MS Standard Thinner
XB383	Standard Thinner
AB385	MS HI-Temp Thinner
XB387	HI-Temp Thinner
XB390	Very Slow Thinner
BK220	Basecoat Chip Protector

PROPERTIES

- Provides ease of application and accurate colour matching.
- This fast air drying basecoat quality covers at low film thickness (10-20 µ), applies smoothly with perfect aluminium flake control in metallics.
- For superior film properties, the use of BK220 is recommended.
- Can be used for spot, panel and overall repair.
- Suited for multi-tone striping and design work.

SUBSTRATES


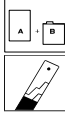
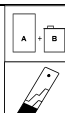





- All OEM finishes, primer-surfacers or surfacers.

CENTARI® 600

27.08.2014

BASECOAT LACQUER

PRODUCT PREPARATION

	Cromax® colour tools	See colour formula.								
	Mixing ratio	Centari® 600 AB380/XB383 AB385 XB387 XB390	15-25°C		20-30°C		>25°C		>30°C	
			1	0.8	1	-	1	-	1	-
			-	-	0.8	-	-	-	-	-
			-	-	-	-	0.8	-	-	-
			-	-	-	-	-	-	0.8	-
	Mixing ratio Reinforced basecoat	Centari® 600 BK220 AB380/XB373 AB385 XB387 XB390	V	W	V	W	V	W	V	W
			9	100	9	100	9	100	9	100
			1	10	1	10	1	10	1	10
			8	80	-	-	-	-	-	-
			-	-	8	80	-	-	-	-
			-	-	-	-	8	80	-	-
		-	-	-	-	-	-	8	80	
	VOC	756-791 g/l								
	Pot life at 20°C	Standard Reinforced	Not applicable. 8 hr							
	Spray viscosity at 20°C	DIN 4 FORD 4	15-16 s 15-16 s							
	Spray equipment	Compliant guns	Fluid tip		Distance		Pressure			
		Gravity feed Suction feed Pressure feed	1.2-1.4 mm 1.4-1.6 mm 0.8-1.1 mm		10-15 cm 10-15 cm 10-15 cm		According to supplier's specifications			
		Conventional guns	1.2-1.4 mm 1.4-1.6 mm 1.0-1.2 mm		15-20 cm 15-20 cm 15-20 cm		2-2.5 bar 2-2.5bar 2-2.5 bar			
	Number of coats	2								
	Flash time	Till flat between coats and before clearcoating. Tack rag-free after 20 min.								
	DFT	10-20 µm								
<p>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.</p>										

CENTARI[®] 600

27.08.2014

BASECOAT LACQUER

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 - P400 - P500;
 - b. wet P1000 - P1200.
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.

BASECOAT APPLICATION

On well prepared surface, apply 2 full coats and flash till flat between coats.
Spray a mistcoat 1-2 min after last coat if needed.

CLEARCOAT APPLICATION

Clear must be applied when basecoat is completely flat. Maximum time before clearcoating is 3 days.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

CENTARI® 600

27.08.2014

BASECOAT LACQUER

REMARKS

- Centari® MasterTints® have to be thoroughly mixed before weigh-out and the Centari® 600 colour has to be mixed immediately after weigh-out.
- For improved stone chip resistance and superior adhesion cohesion, addition of 10 % BK220 before dilution is recommended.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Theoretical coverage: 6-8 m²/l at recommended DFT - ready-to-spray

SAFETY

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

CENTARI® 600

27.08.2014

BASECOAT LACQUER

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 methods can be used:
 - with use of mid-coat;
 - without use of mid-coat.

WITH USE OF MID-COAT

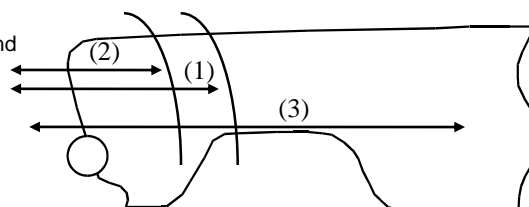
Preparation of mid-coat: reduce AB160 with AB380: 1/0.8

(1) Apply mid-coat, flash till completely flat.

(2) Apply 2 coats of basecoat, extending 2nd coat beyond the previous one.
Flash time: 3 min.

(3) Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.

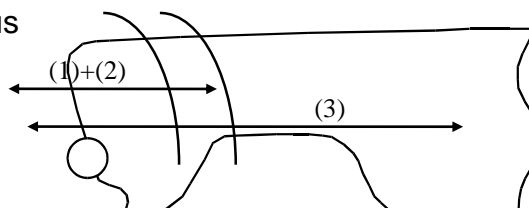
Spray pressure: spot repair area: 1-1.5 bar.



WITHOUT USE OF MID-COAT

(1) + (2) Apply 2 to 3 coats Centari® 600, extending each one beyond the previous one.

(3) Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



Spray pressure: spot repair area: 1-1.5 bar.



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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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