

CENTARI® 6000

12.12.2014

XB-47606 JET BLACK LOW EMISSION BASECOAT

DESCRIPTION

XB-47606 is a factory packed jet black basecoat that can be used to refinish jet black finishes, where applicable, and to tint *CENTARI®* 6000 solid, metallic and pearl colours.
Composition based on acrylic copolymer.

PRODUCTS

XB-47606	Jet Black Low Emission Basecoat
XB383	Standard Thinner
XB387	HI-Temp Thinner
BK220	Basecoat Chip Protector

PROPERTIES

- Provides accurate colour matching for high jetness black tone colours.
- The addition of 10% BK220 is mandatory.
- The excellent hiding, coverage balance gives significant saving in application time and consumption.
- Can be used for spot, panel and overall repair.

SUBSTRATES

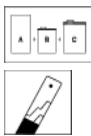





- All OEM finishes, Axalta primer surfacers or Axalta surfacers.

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PRODUCT PREPARATION

 Mixing Ratio			15 – 25°C		> 25°C	
			Volume	Weight	Volume	Weight
	C6000 ready mix (include XB-47606)	2.7	100	2.7	100	
	BK220	0.3	10	0.3	10	
	XB383	1-1½	30-50	-	-	
	XB387	-	-	1-1½	30-50	
VOC	669-742 g/l					
 Pot life at 20°C	Activated	8 hr				
 Spray viscosity at 20°C	DIN 4 FORD 4	18-25 s 18-25 s				
 Spray equipment	Compliant guns (HVLPT/HE) Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure		
					According to supplier's specifications	
	Conventional guns 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	15-20 cm 15-20 cm 15-20 cm	2-2.5 bar 2-2.5 bar 2-2.5 bar	
 Number of coats	1.5 - 2					
 Flash time	5-10 min between coats; 15-30 min before clearcoating (Please refer to CENTARI®6000 TDS for Metallic and Pearl colours.)					
DFT	Solids - Pearls	20-30 µm				
	Metallics	15-20 µm				
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.						

SURFACE PREPARATION

- Clean surface with water and soap. Rinse and dry.
- Degrease with a correct Cromax® preparatory cleaner. Wipe dry with a clean cloth.
- Repair according to damage.
- Sand surface:
 - mechanical P360 - P400 - P500;
 - wet P1000 - P1200.
- Remove all traces of sanding dust by blowing with oil-free and contaminant-free compressed air.
- Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
- Tack rag.

2/5 AUS XB-47606-0

This Technical Data Sheet supersedes all previous issues

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BASECOAT APPLICATION

On well prepared surface, apply 1.5 - 2 coats with flash between coats of 5-10 min.
(Please refer to CENTARI®6000 TDS for Metallic and Pearl colours.)

CLEARCOAT APPLICATION

Allow basecoat to flash off for 15-30 minutes before the application of clearcoat.
(Please refer to CENTARI® 6000 TDS for Metallic and Pearl colours.)
Maximum time before clearcoating is 3 days

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

REMARKS

- XB-47606 has to be thoroughly mixed before weigh-out and has to be mixed immediately after weigh-out.
- The addition of 10% BK220 before thinning of the basecoat is mandatory.
- Application is same as CENTARI® 6000.
- XB-47606 is a specific tint for CENTARI® 6000 and cannot be used for CENTARI® 500HB, 501, 5035 or 600.
- Material has to be at room temperature (18-25°C) before use.

Remarks for colour matching:

- Follow colour formula.
- XB-47606 has binder included; XB-47606 doesn't need to add additional XB155 binder for tinting

PRODUCT DATA

Theoretical coverage: 12-16 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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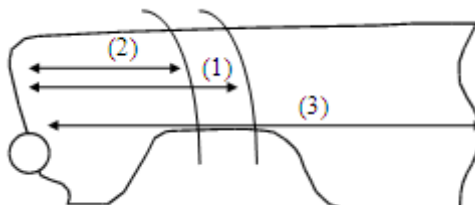
SPOT REPAIR

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct Cromax[®] 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 Cromax[®] 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 XB165 with XB383: 2/1

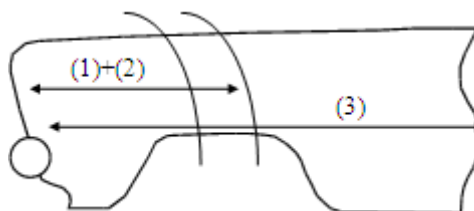
- (1) Apply mid-coat, flash till completely flat.
- (2) Apply 1.5-2 coats of basecoat, extending 2nd coat beyond the previous one. Flash time: 5-10 min.
- (3) Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.
(Flash time: 15-30 min)



Spray pressure: spot repair area: 2-2.5 bar.

WITHOUT USE OF MID-COAT

- (1) + (2) Apply 2 to 3 coats Centari[®] 6000, 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.
(Flash time: 15-30 min)



Spray pressure: spot repair area: 2-2.5 bar.

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