

## CENTARI® 501

27.08.2014

### SUPER PRODUCTIVE 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®
AF101	Super Productive 2K Binder
AK260	High Solids Activator
256S	Activator Fast
AB380	MS Standard Thinner
AB385	MS HI-Temp Thinner
XB383	Standard Thinner
XB387	HI-Temp Thinner

#### PROPERTIES

- Gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Gives a fast set up time, superior polishability and resistance to waterspotting.
- Can be used for spot, panel and overall repair.

#### SUBSTRATES


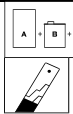







- All OEM finishes, primer-surfacers or surfacers.

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#### PRODUCT PREPARATION

	<b>Cromax® colour tools</b>	See colour formula.				
	<b>Mixing ratio</b>		<b>Standard</b>	<b>Fast</b>	<b>High temperature</b>	
	Centari® 501		4	4	4	
	AK260		1	-	1	
	256S		-	1	-	
	AB380/XB383		1	1	-	
	AB385/XB387		-	-	1	
	<b>VOC</b>	545-590 g/l				
	<b>Pot life at 20°C</b>	4 hr				
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	17-19 s	17-19 s		
	<b>Spray equipment</b>	<b>Compliant guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>	
		Gravity feed	1.2-1.4 mm	10-15 cm	According to supplier's specifications	
		Suction feed	1.4-1.6 mm	10-15 cm		
		Pressure feed	1.0-1.2 mm	10-15 cm		
		<b>Conventional guns</b>				
		Gravity feed	1.2-1.5 mm	15-20 cm	2-2.5 bar	
		Suction feed	1.4-1.8 mm	15-20 cm	2-2.5 bar	
		Pressure feed	1.0-1.2 mm	15-20 cm	2-2.5 bar	
	<b>Number of coats</b>	2				
	<b>Flash time</b>	10 min between coats. 10 min before bake.				
	<b>DFT</b>	50-60 µm				
	<b>Drying</b>	<b>With AK260</b>	<b>15°C</b>	<b>20°C</b>	<b>30°C</b>	<b>30 min x 60°C</b>
		Dust-free	12 min	10 min	9 min	imm.
		Dry to handle	3 hr 30 min	2 hr 30 min	1 hr 30 min	imm.
		Tape-free	6 hr	5 hr	4 hr	allow cool down
		<b>With 256S</b>	<b>15°C</b>	<b>20°C</b>	<b>30°C</b>	<b>20 min x 60°C</b>
		Dust-free	10 min	9 min	8 min	imm.
		Dry to handle	2 hr	1 hr 15 min	1 hr	imm.
		Tape-free	5 hr	4 hr	4 hr	allow cool down
	<b>IR drying*</b>	Flash time	5 min	* Guideline for short/medium wave IR equipment.		
		Distance	80 cm			
		Half power	5 min			
		Full power	15-20 min			

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<sup>®</sup> 501 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	10 %	battery acid
sulphuric acid	20 %	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® 501 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: 6-8 m<sup>2</sup>/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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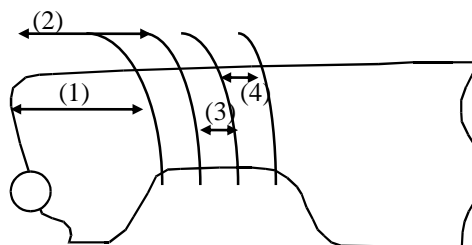
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#### SPOT REPAIR

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 2 coats Centari® 501, extending 2<sup>nd</sup> coat beyond the 1<sup>st</sup>.  
Flash time: 5 min.
- (2) Dilute 1 part of the remaining Centari® 501 with 1 part AK350. Apply 1 coat extending beyond the previous ones.
- (3) Dilute 1 part of the remaining paint with 1 part AK350. Apply another coat extending again further into the panel.
- (4) Mistcoat repair zone immediately with pure AK350.



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<sup>®</sup>. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax<sup>®</sup>, unless explicitly indicated otherwise.

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