

CENTARI® 510

19.02.2015

2K ENAMEL

DESCRIPTION

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

PRODUCTS

AM	Centari® MasterTint®
BK110	2K Economy Binder
125S	Standard Activator
AB380	Thinner
AB385	Hi-Temp Thinner

PROPERTIES

- Centari® 510 gives good appearance, a high gloss finish, good hiding and average consumption.
- Can be used for spot, panel and overall repair.

SUBSTRATES


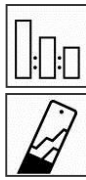








- All cured clean and sanded OEM finishes and Axalta 2K surfacers.

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PRODUCT PREPARATION

	Colour tools	See colour formula Mix C510 formula for the intended colour via Colorquick®			
	Mixing ratio	Centari® 510 125S AB380 AB385	Standard	High Temp.	Use AB385 Hi Temp thinner when temp. is above 25°C
			2 1 0.5 -	2 1 - 0.5	
	VOC	TBA g/l			
	Pot life at 20°C	4 – 6 h			
	Spray viscosity at 20°C	DIN 4 FORD 4	15 – 16 s 15 – 17 s		
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip	Distance	
			1.2 – 1.4 mm 1.4 – 1.8 mm 1.3 – 1.5 mm 1.0 – 1.2 mm	20 - 25 cm 20 - 25 cm 10 – 15 cm 20 - 25 cm	
	Spray pressure	Gravity feed Suction feed HVLP Pressure feed	3 – 4 bar 3 – 4 bar 0.7 bar at nozzle 4 – 6 bar		
	Number of coats	2 - 3			
	Flash time at 20°C	10 – 12 min between coats 10 min before bake			
	DFT	40 – 60 µm			
	Drying	Dust free Dry to handle Tape free	At 20°C	40 – 45' at 60°C	
			40 min 6 h overnight	imm. 30 min 1 h 30 min	
	IR Drying *	Flash time Distance Half power followed by Full power	5 min 80 cm 5 min 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 3 full coats with 10 min flash between coats.

CHEMICAL RESISTANCE

When fully cured, Centari[®] 500 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.

RECOATABILITY

At any time after tape-free time.

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REMARKS

- Centari[®] Tints[®] have to be thoroughly mixed before weigh-out and the Centari[®] 510 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.
- 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.

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.

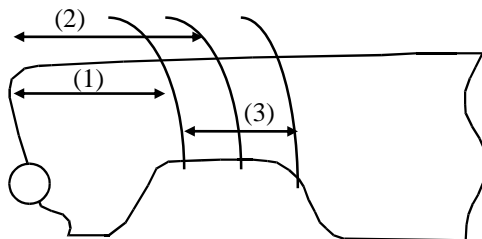
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AK350 FADE-OUT THINNER METHOD

- (1) Apply 1st coat Centari® 510 over primed area.
Flash time: 10 min.
- (2) Apply 2-3 coats of Centari®510 in total or till hiding is achieved whilst observing flash time between coats, sending each coat beyond previous.
- (3) Blend in the fade-out area with AB380 thinner



OPTIONAL: Dilute 1 part activated ready-to-spray Centari®510 with 1 part AB380 thinner in the 2nd or 3rd coat. To balance out the gloss level buff after complete hardening of the repair.

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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