

## CENTARI® 610

27.08.2014

### 2K ENAMEL

#### DESCRIPTION

One component economy basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on cars, trucks, busses.  
Composition based on acrylic copolymer.

#### PRODUCTS

AM	Centari® Mixing Tinter
BE151	Economy Basecoat Binder
AB380	Basecoat Thinner
AB385	Hi-Temp Thinner

#### PROPERTIES

Centari® 610 provides ease of application and suitable colour matching. Can be used for spot, panel and overall repair. Suited for multi-tone striping and design work. If non Axalta Refinish / Cromax, clearcoat is used then the use of BK220 is required for optimum film properties.

#### SUBSTRATES


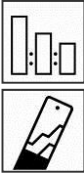






- All cured clean and sanded OEM finishes and Axalta primers.

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#### PRODUCT PREPARATION

	<b>Colour tools</b>	See colour formula Mix C610 formula for the intended colour via Colorquick®		
	<b>Mixing ratio</b>	Centari® 610 AB380 AB385	<b>15 - 25°C</b>	<b>25 - 30°C</b>
			1 0.8 -	1 - 0.8
	<b>VOC</b>	756 - 791 g/l		
	<b>Pot life at 20°C</b>	Not applicable		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	15 – 16 s 15 – 16 s	
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	<b>Fluid tip</b>	<b>Distance</b>
			1.2 – 1.4 mm	15 - 20 cm
			1.4 – 1.6 mm	15 - 20 cm
			1.2 – 1.4 mm 1.0 – 1.2 mm	10 – 15 cm 15 - 20 cm
	<b>Spray pressure</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	<b>Overall and panel repair</b> 3 – 4 bar 3 – 4 bar 0.7 bar at nozzle 4 – 6 bar	<b>Spot repair</b> 2 – 2.5 bar 2 – 2.5 bar 0.7 bar at nozzle -
	<b>Number of coats</b>	3 – 3.5		
	<b>Flash time</b>	Till flat between coats Tackrag free after 20 min		
	<b>DFT</b>	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

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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 (finally with P500 will give best results);
  - 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 a well prepared surface, apply 3 full coats and flash till flat between coats.  
Spray a mist-coat 1-2 min. after last coat if required.

### CLEAR COAT APPLICATION

Axalta / Cromax clearcoat must be applied when Centari® 610 basecoat is completely flat. Maximum time before clearcoating is 3 days.

### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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#### RECOATABILITY

At any time after tape-free time.

#### REMARKS

- Centari® Tints® have to be thoroughly mixed before weigh-out and the Centari® 610 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, but is optional for this system
- 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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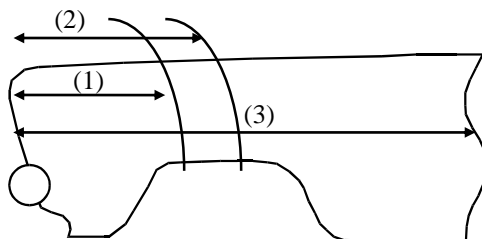
#### SPOT REPAIR

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 primed 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 :
  - without use of midcoat
  - with use of midcoat

#### WITH USE OF MIDCOAT

##### Preparation of midcoat: Reduce BE151 with AB380 : 1/0.8-1

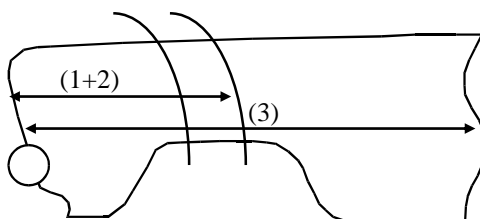
- (1) Apply midcoat, flash till completely flat.
- (2) Apply 3 to 3.5 coats Centari® 610, extending each one beyond the previous one and ensure that the colour is blended in sufficiently.
- (3) Apply the clear coat on the entire panel after the last coat of the basecoat is completely flat



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

#### WITHOUT USE OF MIDCOAT

- (1+2) Apply 3 to 3.5 coats Centari® 610, extending each one beyond the previous one and ensure that the colour is blended in sufficiently
- (3) Apply the clear coat on the entire panel after the last coat of the basecoat is completely flat.



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

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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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