

CENTARI® 610

BASECOAT LACQUER



PRODUCT DESCRIPTION

One component economy basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on cars, trucks, buses. Composition based on acrylic copolymer. If non Axalta Refinish / Cromax, clearcoat is used then the use of BK220 is required for optimum film properties.

All-round solventborne refinishing performance

FEATURES

- 01** Provides easy, effortless and smooth application.
- 02** Provides coverage at low film thickness (15-20 μ).
- 03** Suitable for multi-tone striping and design work.
- 04** Can be used for spot, panel and overall repair.
- 05** Provides ease of application and suitable colour matching.
- 06** For superior film properties, use with BK220.

TECHNICAL DATA SHEET

CENTARI® 610

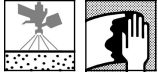


BASECOAT LACQUER

Product preparation - application for 2-stage colours



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned
Cromax Primer-Surfacer or Surfacer, sanded and cleaned
Cromax Primer-Surfacer or Surfacer, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



15-25°C	25-35°C
AB380	AB385

			Chip Protector	Thinner
		C610	BK220	AB380 / AB385
Standard	All colours	1	-	0.8
Standard Activated	All colours	0,9	0.1	0.8

Mixing ratio's are on volume.
For superior film properties, the use of BK220 is recommended.



Activated: 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4 mm	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



3 - 3.5 coats with intermediate and final flash-off until flat



Clearcoat

VOC compliant

This product mix is not VOC compliant.

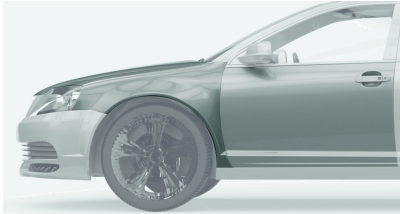
TECHNICAL DATA SHEET

CENTARI® 610

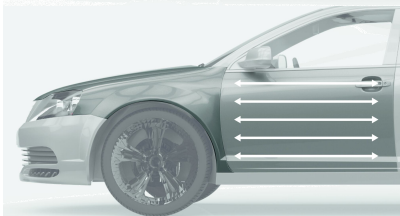


BASECOAT LACQUER

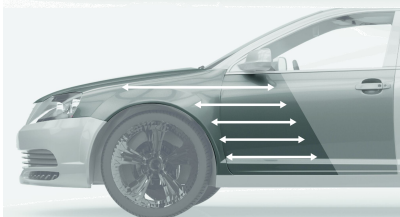
Centari Blend in Standard application



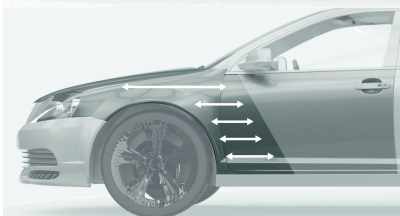
Adjacent panel:
sand panel with suitable abrasive e.g. Trizact - P1000
New part / repair: sand surfacer (minimum P500)



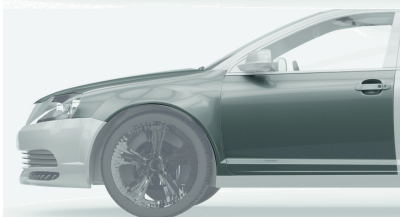
Apply the blender avoiding the extreme edges of the panel.
Remark: Blender can be wet or preferably dry.
Recommended to use slow thinners.
Note: Blender Centari 610 BE151 / AB Thinners - 1/0.8



Apply the 1st coat of basecoat to the widest area on the complete repair and allow to dry.



Spray the 2nd coat of basecoat inside the 1st coat on the complete repair and allow to dry.
Do not extend beyond the 1st coat. If required a 3rd coat may be applied but remain inside the previous coat.
Remark: Apply a mistcoat for metallics and pearls.



Apply clearcoat to finish the repair.

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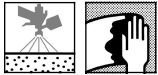


BASECOAT LACQUER

Product preparation - application for Tri-stage colours



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned
 Primer-surfacer or Surfacer, sanded and cleaned
 Surfaces must be prepared and cleaned correctly before application
 Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



15-25°C	25-35°C
AB380	AB385

			Chip Protector	Thinner
		C600	BK220	AB380 / AB385
Ground coat (Activated)	All colours	0,9	0.1	0.8
Standard	All colours	1	-	0.8

Mixing ratio's are on volume.
 For superior film properties, the use of BK220 is mandatory.



Activated: 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4 mm	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats ground coat with intermediate and final flash-off until flat
 2.5 - 3.5 coats effect/midcoat with intermediate and final flash-off until flat



Clearcoat

VOC compliant

This product mix is not VOC compliant.

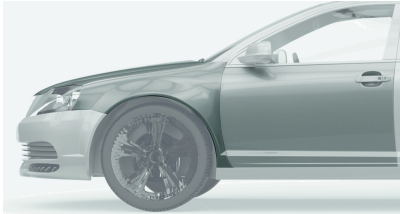
TECHNICAL DATA SHEET

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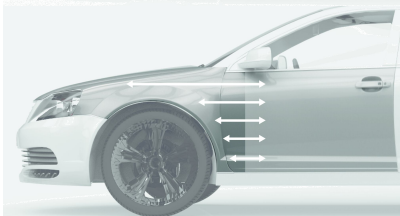


BASECOAT LACQUER

Centari Blend in Tri-stage application

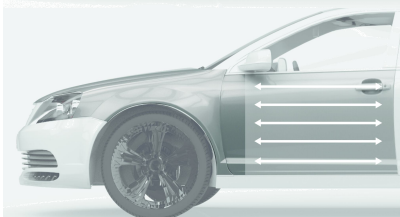


Adjacent panel:
sand panel with suitable abrasive e.g. Trizact - P1000
New part / repair: sand surfacer (minimum P500)



Apply the activated Ground coat until full hiding is achieved on the repair area. Extend into fade out area and allow to dry in between coats and before effect colour.

Note: Mixing colour / BK220 / thinner :
C610: 0.9/0.1/0.8

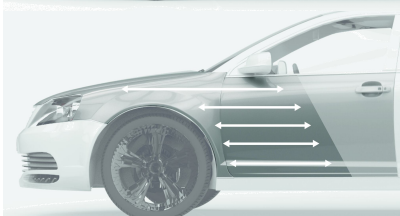


Apply a closed coat of Centari blender to adjacent blending area.

Remark: blender can be wet or preferably dry.

Recommended to use slow thinners.

Note: Blender C610: BE151/AB-Thinner - 1/0.8



Apply the required amount of effect coats followed by a light coat, fading out into the blender.



Apply clearcoat to finish the repair.

TECHNICAL DATA SHEET

CENTARI® 610



BASECOAT LACQUER

Products

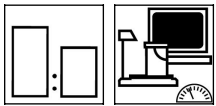
AMx Centari® MasterTint®
AMxx Centari® MasterTint®

BE151 Centari® 610 Basecoat Binder

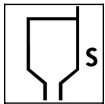
AB380 MS Standard Thinner
AB385 MS HI-Temp Thinner

BK220 Centari® Basecoat Chip Protector

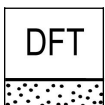
Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



DIN 4: 15 - 16 s at 20°C



15 - 20 µm



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Centari MasterTints have to be thoroughly mixed before weigh-out and the Centari C610 colour has to be mixed immediately after weigh-out.
- On well prepared surface, apply 3 full coats and flash till flat between coats. Spray a mistcoat 1-2 min after last coat if needed.
- Addition of 10% BK220 Basecoat Chip Protector before dilution is recommended. It gives increased quality features, improved stone chip resistance and superior adhesion cohesion.
- For Tri-stage colours it is mandatory to activate the Ground coat with 10% BK220 Basecoat Chip Protector.
- Maximum time before clearcoating is 3 days.

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

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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