

CENTARI® 500 HIGH BUILD

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®
AK100	2K Binder
AK260	High Solids Activator
256S	Activator Fast
AK360	High Solids Thinner
AK361	High Solids Thinner Slow
AK365	High Productivity Thinner

Properties

- Centari® 500 HB gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Its lower solvent content at spray viscosity gives a reduction in VOC emission.
- Can be used for spot, panel and overall repair.


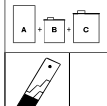








Substrates

- all OEM finishes and DuPont primers

CENTARI® 500 HIGH BUILD

2K ENAMEL

PRODUCT PREPARATION

	Colour tools	See colour formula.				
	Mixing ratio	Centari® 500 AK260 256S AK360 AK361 AK365	High productive	Fast	Standard	Slow
			3	3	3	3
			1	/	1	1
			/	1	/	/
			/	0.6	0.6	/
			/	/	/	0.6
		0.6	/	/	/	/
	VOC	517-558 g/li				
	Pot life at 20°C	2 h				
	Spray viscosity at 20°C	DIN 4	18-22 s			
		FORD 4	18-22 s			
		AFNOR 4	20-24 s			
	Spray equipment	Gravity feed Suction feed HVLP Pressure feed	Fluid tip		Spray distance	
			1.2-1.4 mm	20-25 cm		
			1.4-1.8 mm	20-25 cm		
			1.3-1.5 mm	10-15 cm		
			1.0-1.2 mm	20-25 cm		
	Spray pressure	Gravity feed	3-4 bar			
		Suction feed	3-4 bar			
		HVLP	0.7 bar at nozzle			
		Pressure feed	4-6 bar			
	Number of coats	2				
	Flash time	10 min. between coats. With AK365 no flash required. No flash required before bake.				
	DFT	50-70 µ				
	Drying	Dust-free Dry to handle Tape-free	AK260		256S	
			20°C	30 min. x 60°C	20°C	20 min. x 60°C
			50 min.	imm.	30 min.	imm.
			6 h	20 min.	2 h	20 min.
		O.N.	30 min.	6 h	30 min.	
	IR drying*	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.						

CENTARI[®] 500 HIGH BUILD

2K ENAMEL

RECOMMENDED USE

Surface preparation

1. Clean surface with water and soap.
2. Degrease with 3919S. Wipe dry with clean cloth.
3. Repair according to damage.
4. Sand:
dry mechanical P320 - P400 (finally with P500 will give best results);
wet P800 - P1000.
5. Degrease with 3920S.
6. Wipe dry and tack rag.

Topcoat application

On well prepared surface, apply 2 full coats with 10 min. flash between coats.
When reduced with AK365, apply 1 medium coat immediately followed by a full coat till full hiding is obtained.

Chemical resistance

When fully cured, Centari[®] 500 HB 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 3608S.

CENTARI[®] 500 HIGH BUILD

2K ENAMEL

RECOMMENDED USE (con'd)

Recoatability

At any time after tape-free time.

Product data

Theoretical coverage: 7.5-8 m²/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)
AM1x Centari [®] MasterTint [®]	1	2
AM94 Centari [®] MasterTint [®]	1	2
AM95 Centari [®] MasterTint [®]	1	2
AM7xx Centari [®] MasterTint [®]	1	3
AMxx Centari [®] MasterTint [®]	1 - 4	4
AK100	4	2
AK260	1 - 5	2
256S	1 - 5	2
AK360	5	2
AK361	5	2
AK365	5	2

Remarks

- Centari[®] MasterTints[®] have to be thoroughly mixed before weigh-out and the Centari[®] 500 HB colour has to be mixed immediately after weigh-out.
- Close can of AK260 and 256S tightly immediately after use, as these products will react with humid air and water and lose their hardening effect.
- To spray interiors, use of 421R (see specific TDS) is recommended.
- For structured and/or flat colours, see specific TDS.
- Material has to be at room temperature (18-20°C) before use.

Safety

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

CENTARI® 500 HIGH BUILD

2K ENAMEL

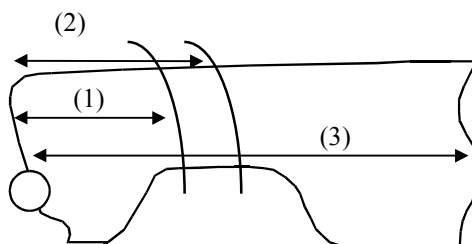
REPAIR SYSTEMS

Spot repair

1. Clean surface with water and soap.
2. Degrease with 3919S and wipe dry with clean cloth.
3. Repair with recommended undercoats.
4. Sand primed spots as recommended.
5. Prepare complete blending area with an ultra fine sanding pad or with 600S.
6. Degrease with 3920S.
7. Wipe dry and tack rag.
8. The following spot repair methods can be used:
 - AK450 Centari® Blending Clear method;
 - AK350 Centari® Blending Thinner method.

AK450 Centari® Blending Clear method

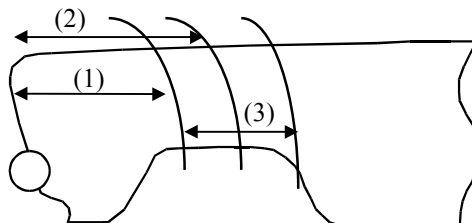
- ① Apply 1st coat Centari® 500 HB.
Flash time: 10 min.
- ② Extend 2nd coat Centari® 500 HB
beyond the previous one.
Flash time: 5 min.
- ③ Apply 1 coat of the activated
blending clear over the entire panel.



Activate 7 parts AK450 with 1 part AK260 or 4 parts AK450 with 1 part of 256S. Use mixing rod.

AK350 Centari® Blending Thinner method

- ① Apply 1st coat Centari® 500 HB.
Flash time: 10 min.
- ② Extend 2nd coat Centari® 500 HB
beyond the previous one.
- ③ Blend in the fade-out area with
AK350.



OPTIONAL: dilute 1 part ready-to-spray Centari® 500 HB with 1 part AK350 in the 2nd or 3rd coat.
If necessary, balance out the gloss level by polishing with 1500S or 3000S after complete hardening of the repair.