

CENTARI® 6000

LOW EMISSION BASECOAT

Description

Medium solids basecoat for use in clear over base systems for solid, metallic and pearl colours. Suitable for use on cars, trucks and buses.
Composition based on acrylic copolymer.

Products

AM	Centari® MasterTint®
XB155	Medium Solids Basecoat Binder
XB165	Medium Solids Basecoat Binder
AB380	Basecoat Thinner
XB383	Standard Thinner
AB385	Hi-Temp Thinner
XB387	High Temperature Thinner
BK220	Basecoat Chip Protector

Properties

- Centari® 6000 provides ease of application and accurate colour matching.
- The excellent hiding, coverage balance gives significant savings in application time and consumption.
- For superior film properties, the use of BK220 is recommended.
- Centari® 6000 MUST be used with BK220 Basecoat Chip Protector when applied over 2K Urethane Primer Fillers to obtain Lifetime Warranty performance.
- Can be used for spot, panel and overall repair.


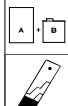
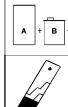






Substrates

- all OEM finishes and DuPont primers

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PRODUCT PREPARATION

	Colour tools	See colour formula.						
	Mixing ratio	Centari® 6000 AB380/XB383 AB385 XB387	15-25°C		20-30°C		> 25°C	
			3		3		3	
			1		/		/	
			/		1		/	
		/		/		1		
	Mixing ratio Reinforced basecoat	Centari® 6000 BK220 AB380/XB383 AB385 XB387	Volume	Weight	Volume	Weight	Volume	Weight
			2.7	100	2.7	100	2.7	100
			0.3	10	0.3	10	0.3	10
			1	30	/	/	/	/
			/	/	1	30	/	/
		/	/	/	/	1	30	
	VOC	669-742 g/li						
	Pot life at 20°C	Standard	Not applicable					
		Reinforced	8 h					
	Spray viscosity at 20°C	DIN 4	18-25 s					
		FORD 4	18-25 s					
		AFNOR 4	22-27 s					
	Spray equipment	Gravity feed	Fluid tip			Spray distance		
		Suction feed	1.2-1.4 mm			15-20 cm		
		HVLP	1.4-1.6 mm			15-20 cm		
		Pressure feed	1.2-1.4 mm			10-15 cm		
			1.0-1.2 mm			15-20 cm		
	Spray pressure	Gravity feed	Overall and panel repair			Spot repair		
		Suction feed	3-4 bar			2-2.5 bar		
		HVLP	3-4 bar			2-2.5 bar		
		Pressure feed	0.7 bar at nozzle			0.7 bar at nozzle		
			4-6 bar			/		
	Number of coats	2						
	Flash time	1-2 min. between coats. Till flat between coats for transparent and bright colours and before clearcoating. Tack rag-free after 20 min.						
	DFT	Solids - Pearls	20-30 µ					
		Metallics	15-20 µ					
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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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 P360 - P400 - P500;
wet P1000 - P1200.
5. Degrease with 3920S.
6. Wipe dry and tack rag.

Basecoat application

On well prepared surface, apply 1 medium coat followed by a light coat with flash between coats of 1-2 min. Do not cover in the 1st coat.
For transparent and very bright colours, apply 2 coats. Flash till flat between coats.

Clearcoat application

DuPont clear must be applied when Centari[®] 6000 basecoat is completely flat. Maximum time before clearcoating is 3 days.

Equipment cleaning

Use 3608S.

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RECOMMENDED USE (con'd)

Product data

Theoretical coverage: 12-16 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
XB155	4	2
XB165	4	2
AB380	1 - 5 - 20	2
XB383	1 - 5 - 20	2
AB385	5	2
XB387	5	2
BK220	1	2

Remarks

- Centari[®] MasterTints[®] have to be thoroughly mixed before weigh-out and the Centari[®] 6000 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 (LTW).
- 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.

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REPAIR SYSTEMS

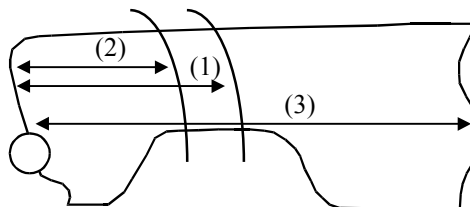
Spot repair

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 600S or sand wet with P1200.
6. Rinse with water and wipe dry.
7. Degrease with 3920S.
8. Wipe dry and tack rag.
9. The following spot repair methods can be used:
 - with use of mid-coat;
 - without use of mid-coat.

WITH use of mid-coat

Preparation of mid-coat: reduce XB165 with AB380 or XB383: 2/1

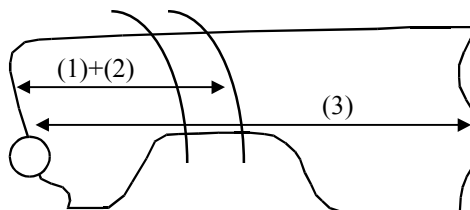
- ① Apply mid-coat, flash till completely flat.
- ② Apply 2 coats of basecoat, extending 2nd coat beyond the previous one.
Flash time: 3 min.
- ③ Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



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

WITHOUT use of mid-coat

- ① Apply 2 to 3 coats Centari® 6000,
+
② extending each one beyond the previous one.
- ③ Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



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