

## CENTARI® 6000

01.03.2014

### 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	MS Standard Thinner
XB383	Standard Thinner
AB385	MS HI-Temp Thinner
XB387	HI-Temp Thinner
XB390	Very Slow Thinner
BK220	Basecoat Chip Protector

#### PROPERTIES

- 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.
- Can be used for spot, panel and overall repair.

#### SUBSTRATES


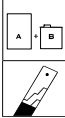
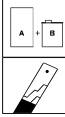





- All OEM and cured repair finishes, 2K primer-surfacers or 2K surfacers

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#### PRODUCT PREPARATION

	<b>Cromax® colour tools</b>	See colour formula.								
	<b>Mixing ratio</b>		<b>15-25°C</b>		<b>20-30°C</b>		<b>&gt;25°C</b>		<b>&gt;30°C</b>	
		Centari® 6000	3		3		3		3	
		AB380/XB383	1		-		-		-	
		AB385	-		1		-		-	
		XB387	-		-		1		-	
	XB390	-		-		-		-		
	<b>Mixing ratio Reinforced basecoat</b>		<b>V</b>	<b>W</b>	<b>V</b>	<b>W</b>	<b>V</b>	<b>W</b>	<b>V</b>	<b>W</b>
		Centari® 6000	2.7	100	2.7	100	2.7	100	2.7	100
		BK220	0.3	10	0.3	10	0.3	10	0.3	10
		AB380/XB383	1	30	-	-	-	-	-	-
		AB385	-	-	1	30	-	-	-	-
		XB387	-	-	-	-	1	30	-	-
	XB390	-	-	-	-	-	-	1	30	
	<b>VOC</b>	669-742 g/l								
	<b>Pot life at 20°C</b>	Standard	Not applicable.							
		Reinforced	8 hr							
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	18-25 s							
		<b>FORD 4</b>	18-25 s							
		<b>AFNOR 4</b>	20-27 s							
	<b>Spray equipment</b>	<b>Compliant guns</b>	<b>Fluid tip</b>		<b>Distance</b>			<b>Pressure</b>		
		Gravity feed	1.2-1.4 mm		10-15 cm			According to supplier's specifications		
		Suction feed	1.4-1.6 mm		10-15 cm					
		Pressure feed	0.8-1.1 mm		10-15 cm					
		<b>Conventional guns</b>								
		Gravity feed	1.2-1.4 mm		15-20 cm			3-4 bar		
	Suction feed	1.4-1.6 mm		15-20 cm			3-4 bar			
	Pressure feed	1.0-1.2 mm		15-20 cm			3-4 bar			
	<b>Number of coats</b>	2								
	<b>Flash time</b>	1-2 min between coats.								
		Till flat between coats for transparent and bright colours and before clearcoating.								
		Tack rag-free after 20 min.								
	<b>DFT</b>	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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#### 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 P360 - P400 - P500;
  - 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 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 1<sup>st</sup> coat.

For transparent and very bright colours, apply 2 coats. Flash till flat between coats.

#### CLEARCOAT APPLICATION

Clear must be applied when basecoat is completely flat.

Maximum time before clearcoating is 3 days.

#### EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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#### 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.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

#### PRODUCT DATA

Theoretical coverage: 12-16 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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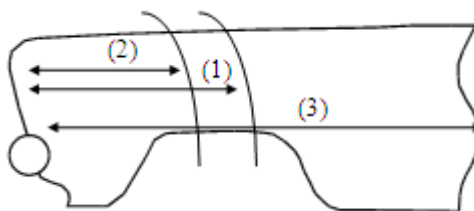
#### SPOT REPAIR

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 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.
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

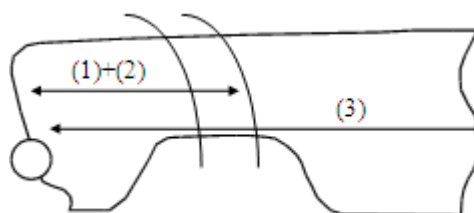
- (1) Apply mid-coat, flash till completely flat.
- (2) Apply 2 coats of basecoat, extending 2<sup>nd</sup> coat beyond the previous one. Flash time: 3 min.
- (3) Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



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

#### WITHOUT USE OF MID-COAT

- (1) + (2) Apply 2 to 3 coats Centari® 6000, 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.

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### **LOW EMISSION BASECOAT**

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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