



Effective 1 March, 2005

CENTARI® 600

BASECOAT LACQUER

Description

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® |
| AB150 | Basecoat Binder |
| AB160 | Basecoat Binder |
| AB380 | Basecoat Thinner |
| AB385 | Hi-Temp Thinner |
| BK220 | Basecoat Chip Protector |

Properties

- Centari® 600 provides ease of application and accurate colour matching.
- This fast air drying basecoat quality covers at low film thickness (10-20 μ), applies smoothly with perfect aluminium flake control in metallics.
- For superior film properties, the use of BK220 is recommended but is optional for this system.
- Can be used for spot, panel and overall repair.
- Suited for multi-tone striping and design work.

Substrates

- all OEM finishes and DuPont primers


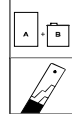
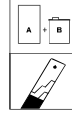








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PRODUCT PREPARATION

| | | | | | | |
|--|---|---|--|--|------------------|----------------------|
|  | Colour tools | See colour formula. | | | | |
|  | Mixing ratio | Centari® 600 AB380 AB385 | 15-25°C | | 25-30°C | |
| | | | 1 0.8 - | | 1 - 0.8 | |
|  | Mixing ratio Reinforced basecoat | Centari® 600 BK220 AB380 AB385 | Volume | Weight | Volume | Weight |
| | | | 9 1 8 - | 100 10 80 - | 9 1 - 8 | 100 10 - 80 |
| | VOC | 756-791 g/l | | | | |
|  | Pot life at 20°C | Standard Reinforced | Not applicable 8 hr | | | |
|  | Spray viscosity at 20°C | DIN 4 FORD 4 AFNOR 4 | 15-16 s 15-16 s 16-18 s | | | |
|  | Spray equipment | Gravity feed Suction feed HVLP Pressure feed | Fluid tip | Distance | | |
| | | | 1.2-1.4 mm 1.4-1.6 mm 1.2-1.4 mm 1.0-1.2 mm | 15-20 cm 15-20 cm 10-15 cm 15-20 cm | | |
|  | Spray pressure | Gravity feed Suction feed HVLP Pressure feed | Overall and panel repair | Spot repair | | |
| | | | 3-4 bar 3-4 bar 0.7 bar at nozzle 4-6 bar | 2-2.5 bar 2-2.5 bar 0.7 bar at nozzle - | | |
|  | Number of coats | 2 | | | | |
|  | Flash time | Till flat between coats and before clearcoating. Tack rag-free after 20 min. | | | | |
| | DFT | 10-20 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 2 full coats and flash till flat between coats.
Spray a mistcoat 1-2 min after last coat if needed.

Clearcoat application

DuPont clear must be applied when Centari® 600 basecoat is completely flat.
Maximum time before clearcoating is 3 days.

Equipment cleaning

Use 3608S.



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RECOMMENDED USE (con'd)

Recoatability

Any time after tack rag-free time.

Product data

Theoretical coverage: 6-8 m²/l at recommended DFT - ready-to-spray

| Products | Packages (l) | Shelf life 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 |
| AB150 | 4 | 2 |
| AB160 | 4 | 2 |
| AB380 | 1 - 5 - 20 | 2 |
| AB385 | 5 | 2 |
| BK220 | 1 | 2 |

Remarks

- Centari® MasterTints® have to be thoroughly mixed before weigh-out and the Centari® 600 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.

Safety

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



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REPAIR SYSTEMS

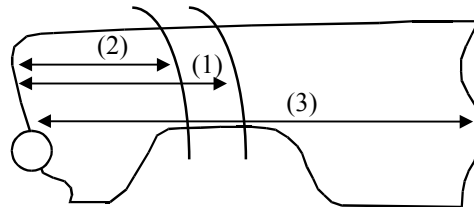
Spot repair

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 AB160 with AB380: 1/0.8

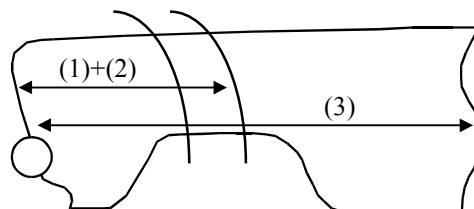
- ① Apply mid-coat, flash till completely flat.
- ② Apply 2 coats of basecoat, extending 2nd coat beyond the previous one.
Flash time: 3 min.
- ③ Apply the clearcoat on the entire panel after the last coat of the basecoat is completely flat.



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

WITHOUT use of mid-coat

- ① Apply 2 to 3 coats Centari® 600,
+ extending each one beyond the previous one.
- ②
- 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.