

# CENTARI® 510

## 2K ECONOMY MIXED COLOUR

### Description

2-component economy topcoat system for solid colours to use on cars, buses and trucks. Composition based on acrylic copolymer.

### Products

AM	Centari® mixing tinter
BK110	2K Economy binder
125S	2K Standard Activator
AB380	Thinner
AB385	Hi temp Thinner

### Properties

Centari® 510 gives good appearance, a high gloss finish, good hiding and average consumption.  
Can be used for spot, panel and overall repair.


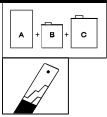








### Substrates

All cured clean and sanded OEM finishes and DuPont 2K surfacers.

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### PRODUCT PREPARATION

	<b>Colourmix</b>	***See colour formula- When mixing colour use Centari® 510 formula on ColorQuick®			
	<b>Mixing ratio</b>	Centari® 510 125S AB380 AB385	<b>Standard</b> 2 1 0.5 /	<b>High Temp</b> 2 1 / 0.5	Use AB385 Hi temp thinner when temperature is above 25°C
<b>VOC</b>					
	<b>Potlife at 20°C</b>	4-6 hours			
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b>	15-16 s 15-17 s		
	<b>Spray equipment</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP Gravity</b> <b>Pressure feed</b>	<b>Fluid tip</b> 1.2-1.4 mm 1.4-1.8 mm 1.3-1.5 mm 1.0-1.2 mm	<b>Spray distance</b> 20-25 cm 20-25 cm 10-15 cm 20-25 cm	
	<b>Spray pressure</b>	<b>Gravity feed</b> <b>Suction feed</b> <b>HVLP</b> <b>Pressure feed</b>	3-4 bar 3-4 bar 0.7 bar at nozzle 4-6 bar		
	<b>Number of coats</b>	3-3.5			
	<b>Flashtime</b>	10-12 min. between coats 10 min. before bake			
<b>DFT</b>		40-60 µm			
	<b>Drying</b>	<b>Dustfree</b> <b>Dry to handle</b> <b>Tape free</b>	<b>20°C</b> 40 min. 6 h overnight	<b>40-45° x 60°C</b> imm. 30 min. 1 h 30 min.	
	<b>IR Drying*</b>	Flash time Distance 1/2 Power followed by Full power	5 min. 80 cm 5 min. 15-20 min.  * guideline for short/medium wave IR equipment		
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 car with water and soap.
2. Degrease with 3919S (heavy duty silicone remover). Wipe dry with clean Sontara® wipes.
3. Repair in accordance to damage.
4. Sand :  
dry mechanical P320 - P400 (finally with P500 will give best results)  
wet P800 - P1000
5. Degrease with 3920S Degreaser (mild pre painting cleaner).
6. Wipe dry and Sontara® tack cloth.

### Topcoat application

On a well-prepared surface, apply 3 full coats with 10 min. flash between coats.

### Chemical resistance

When fully cured Centari® 510 is resistant to short exposures of the following chemicals:

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 Acrylic Thinner.

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## RECOMMENDED USE (con'd)

### Recoatability

At any time after tape free time.

### Product data

Theoretical coverage : 6 - 8 m<sup>2</sup>/L at recommended DFT - ready-to-spray.

Products	Packages (L)	Storability at 20°C (year)
AM tintings	1 - 4	2
BK110	4	2
125S	1 – 2.5	1
AB380	5 - 20	1
AB385	5 - 20	1

### Remarks

- Centari® tintings have to be thoroughly mixed before weigh-out and the Centari® 510 colour has to be mixed immediately after weigh-out.
- Activator container must be tightly closed immediately after use.
- To spray interiors, use of 421R is recommended. Replace thinner or blend with 421R.
- Material has to be at normal 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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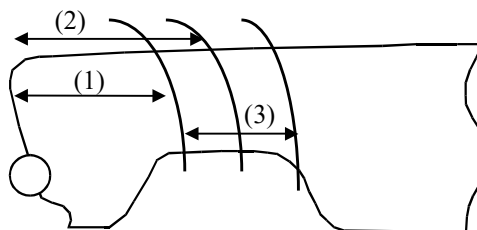
## REPAIR SYSTEMS

### Spot repair

1. Clean with water and soap.
2. Degrease with 3919S (heavy duty silicone remover) and wipe dry with clean Sontara® wipes.
3. Repair with recommended undercoats.
4. Sand primed spots as recommended.
5. Prepare complete blending area with Scotch pad ultra fine or with blending paste.
6. Degrease with 3920S Degreaser (mild pre painting cleaner).
7. Wipe dry and Sontara® tack cloth.

### Blending method

- ① Apply 1st coat Centari®510 over primed area. Flash time: 10 min.
- ② Apply 2-3 coats of Centari®510 in total or till hiding is achieved whilst observing flash time between coats, sending each coat beyond previous.
- ③ Blend in the fade-out area with AB380 thinner.



OPTIONAL : dilute 1 part activated ready-to-spray Centari®510 with 1 part AB380 thinner in the 2nd or 3rd coat. To balance out the gloss level buff after complete hardening of the repair.