



Effective 1 April, 2007

# CENTARI® 500

## 2K ENAMEL

### Description

2-component topcoat system for solid colours and 1-coat metallics for use on cars, buses and trucks.

Composition based on acrylic copolymer.

### Products

AM	Centari® MasterTint®
AK100	2K Binder
125S	2K Activator
AK321	2K Thinner
AK325	2K Accelerator Thinner
AK330	2K High Temperature Thinner

### Properties

- Gives excellent appearance, a high gloss finish, very good hiding and low consumption.
- Can be used for spot, panel and overall repair.

### Substrates

- All OEM finishes, DuPont Refinish primer surfacers or DuPont Refinish surfacers.












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## PRODUCT PREPARATION

	<b>DuPont Refinish colour tools</b>	See colour formula.			
	<b>Mixing ratio</b>		<b>Fast</b>	<b>Standard</b>	<b>High temperature</b>
		Centari® 500	2	2	2
		125S	1	1	1
		AK321	-	0.5	-
		AK325	0.5	-	-
		AK330	-	-	0.5
	<b>VOC</b>	575-610 g/l			
	<b>Pot life at 20°C</b>	4-6 hr			
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b>	15-16 s		
		<b>FORD 4</b>	15-16 s		
	<b>Spray equipment</b>		<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		<b>Conventional guns</b>			
		Gravity feed	1.2-1.5 mm	15-20 cm	3-4 bar
		Suction feed	1.4-1.8 mm	15-20 cm	3-4 bar
		Pressure feed	1.0-1.2 mm	15-20 cm	3-4 bar
		<b>Compliant guns (HVLP/HTE)</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	1.0-1.2 mm	10-15 cm	
	<b>Number of coats</b>	2			
	<b>Flash time</b>	10 min between coats. 10 min before bake.			
	<b>DFT</b>	40-60 µm			
	<b>Drying</b>		<b>20°C</b>	<b>30 min @ 60°C</b>	
		<b>Dust-free</b>	40 min	imm.	
		<b>Dry to handle</b>	6 hr	30 min	
		<b>Tape-free</b>	O.N.	1 hr 30 min	
	<b>IR drying*</b>	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.					



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## RECOMMENDED USE

### Surface preparation

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® wipes.
3. Repair according to damage.
4. Sand surface:
  - a. mechanical P320 - P400 (finally with P500 will give best results);
  - b. wet P800 - P1000.
5. Remove all traces of sanding dust by blowing with oil-free compressed air.
6. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
7. Tack rag.

### Topcoat application

On well prepared surface, apply 2 full coats with 10 min flash between coats.

### Chemical resistance

When fully cured, Centari® 500 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 a correct DuPont Refinish solventborne gunwash.



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## RECOMMENDED USE (con'd)

### Recoatability

At any time after tape-free time. After 24 hr, scuff sanding is required.

### Remarks

- Centari® MasterTints® have to be thoroughly mixed before weigh-out and the Centari® 500 colour has to be mixed immediately after weigh-out.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- To spray interiors, use of 431R is recommended.
- For structured and/or flat colours, see specific TDS.
- For flexible systems, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.

### Product data

Theoretical coverage: 6.5-7 m<sup>2</sup>/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
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	0.988
125S	0.5 - 1 - 5	2	0.953
AK321	1 - 5	2	0.891
AK325	5	2	0.891
AK330	5	2	0.893

### Safety

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



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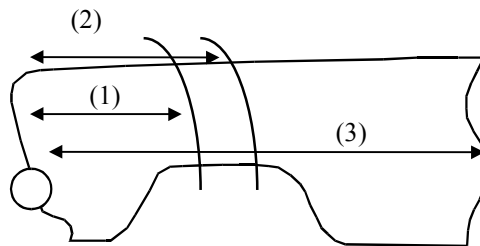
## REPAIR SYSTEMS

### Spot repair

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with clean Sontara® wipes.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area, sand wet with P1200 or white Scotch pad and flatting paste.
6. Rinse with water and dry.
7. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with clean Sontara® wipes.
8. Tack rag.
9. The following spot repair methods can be used:
  - AK450 Blending Clear method;
  - AK350 Fade-out Thinner method.

### AK450 Blending Clear method

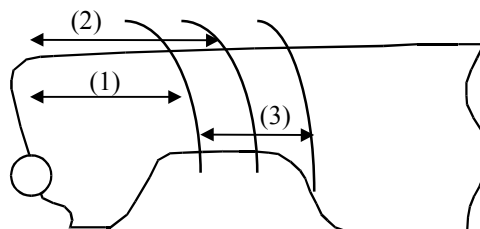
- ① Apply 1<sup>st</sup> coat Centari® 500.  
Flash time: 10 min.
- ② Extend 2<sup>nd</sup> coat Centari® 500  
beyond the previous one.  
Flash time: 10 min.
- ③ Apply 1 coat of the activated  
blending clear over the entire panel.



Activate 4 parts AK450 with 1 part AK210. Use mixing rod.

### AK350 Fade-out Thinner method

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



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