



KAPCI
COATINGS



Technical Data Sheet
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Primacryl 8600 2K Acrylic Mixing System

Product description

Primacryl 8600 is a 2K acrylic mixing system for repainting of passenger cars and commercial vehicles.

- Primacryl 8600 delivers 2K acrylic-urethane direct gloss topcoats having high gloss.
- Excellent durability.
- Excellent coverage.
- In conjunction with a range of Kapci MS hardeners, Primacryl 8600 2K topcoats can be used for any size of repair jobs.



Substrates

Primacryl 8600 2K topcoats should be applied over properly prepared

- Kapci 2K fillers.
- 2K primers.
- 1K sealers.
- 2K sealers.
- and old finishes in sound conditions.

For sanding prior to applying Primacryl 8600, use paper grit P400 dry or P800 wet. Degrease the surface with Prima 8080 Degreaser before the application of the 2K topcoat color.








Application

 <p>Mixing ratio: 100:50:30</p> <p>(2:1:0.6)</p>	<p>100% Primacryl 8600 50% Prima MS Hardeners: 8500 - Extra Fast. Or 8530 - Fast. Or 8550 - Normal. Or 8570 - Slow. 30% Prima 2K thinners: 8410 Fast. Or 8420 Normal. Or 8430 Slow.</p>
 <p>Use measuring stick</p>	

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	Application viscosity: 16-18 s (DIN4/20°C)																
	Pot life: 4 h at 20°C																
	Spray gun tips: <table border="1"><thead><tr><th></th><th>Spray Nozzle</th><th>Inlet pressure</th><th>Atomization pressure</th></tr></thead><tbody><tr><td>Compliant</td><td>1.2-1.3</td><td>2 bars (26- 29 psi)</td><td></td></tr><tr><td>HVLP</td><td>1.2-1.3</td><td>2 bars (26- 29 psi)</td><td>0.7bar (8-10 psi)</td></tr><tr><td>Conventional</td><td>1.2-1.3</td><td>3-3.5 bar (45-50 psi)</td><td></td></tr></tbody></table>		Spray Nozzle	Inlet pressure	Atomization pressure	Compliant	1.2-1.3	2 bars (26- 29 psi)		HVLP	1.2-1.3	2 bars (26- 29 psi)	0.7bar (8-10 psi)	Conventional	1.2-1.3	3-3.5 bar (45-50 psi)	
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	Number of coats: Apply 2 normal coats (to get opacity). Recommended total dry film thickness is 40-50 microns.																
	Flash off time: Between coats: 4-7 min																
	Drying time: 12 h/20°C 30 min/60°C																
	IR Drying: Short wave*: 8-10 min *Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for sets up.																

General notes

Choice of hardener

- Prima offers a range of hardeners to meet every type and size of car refinish under all conditions.
- The recommendations below are for guidance only:
- Prima 8500 Extra Fast hardener is recommended for temperatures below 20°C and for small size of repair.
- Prima 8530 Fast hardener is used for medium sized repair and for temperatures up to 25°C.
- Prima 8550 Normal hardener is suitable for large areas, i.e., for all repairs at temperatures up to 30°C.
- Prima 8570 Slow hardener should be used when the temperature exceeds 30°C.

Recoating

Prima 8600 is recoatable after the drying time.

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Rectification and polishing

- Prima 8600 2K Acrylic topcoat does not require polishing as it offers excellent gloss.
- In case that some dirt has occurred, denib with P2000 or finer paper grit, and polish by machine using Kapci K40 Polish Compound.
- Polishing is easiest up to 24 h after the drying time.

Other tips

1. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C.
2. Clean the spray gun thoroughly immediately after use of 2K products.

Health and Safety

1. For full Health and Safety information please refer to Material Safety Data Sheet (MSDS).
2. Observe the precautionary notices displayed on the container.
3. Goggles and suitable protective equipment must be worn while using these products.
4. Good ventilation must be provided in the working environment.