



**KAPCI**  
COATINGS

## Technical Data Sheet

Issue date January 2024

for professional use only

# Kapci 6040 2K HS Clearcoat

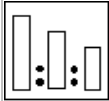
### Product description

Kapci 6040 is a 2K high solids acrylic clearcoat suitable for all kind repairs. It delivers high viscosity and high film build, high gloss and long-lasting finish.

### Substrates

Kapci 6040 HS clearcoat should be applied over Kapcibase 670/640 solvent-based basecoats, Kapci Dima 9670 waterborne basecoats, and properly prepared paint work in sound conditions.

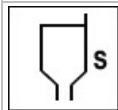
### Application



#### Mixing ratio:

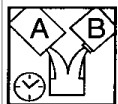
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Kapci 6030 HS Clearcoat	Kapci HS Hardeners	Kapci 2K Thinners:
100%	50%	5-10%
	6033 Fast 6035 Normal 6037 Slow	600F Fast, 600 Normal, 601 Slow 602 Extra Slow



#### Application viscosity:

22-24 s (DIN4/20°C)



#### Pot life:

3 h at 20°C



#### Spray gun tips:

	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.3-1.4mm	2 bars (26- 29 psi)	
HVLP	1.3-1.4mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.3-1.4mm	3-3.5 bar (45-50 psi)	

For best overall results, refer to the spray gun manufacturer's recommendation.

**IMPORTANT NOTE:** These TDS are for information purposes only without any obligation as we do not have control over the quality and conditions of the surface or application.



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	<p><b>Number of coats:</b> Apply 1 light and 1 normal coat. Total dry film thickness max.90 microns.</p>															
	<p><b>Flash off time:</b> 8-10 min/20°C between coats; 30 min/20°C before baking</p>															
	<p><b>Drying time:</b></p> <table border="1" data-bbox="236 817 1343 1008"> <thead> <tr> <th>Hardener</th> <th>20°C</th> <th>60°C</th> </tr> </thead> <tbody> <tr> <td>6037 Slow</td> <td>16-18h</td> <td>35</td> </tr> <tr> <td>6035 Normal</td> <td>14-16h</td> <td>30min</td> </tr> <tr> <td>6033 Fast</td> <td>12-14h</td> <td>25min</td> </tr> <tr> <td>6031 Extra Fast</td> <td>6-8h</td> <td>20min</td> </tr> </tbody> </table>	Hardener	20°C	60°C	6037 Slow	16-18h	35	6035 Normal	14-16h	30min	6033 Fast	12-14h	25min	6031 Extra Fast	6-8h	20min
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	<p><b>IR Drying:</b> Short wave*: 10-15 min *Guideline for IR equipment. Refer to the IR equipment manufacturer's instructions for set up.</p>															

### General notes

#### Choice of hardeners and thinners

- Kapci offers a range of hardeners to meet every type and size of car refinish under all conditions.
- The recommendations below are for guidance only:

Choice of hardener and thinner	Size of repair and temperature			
	Spot and partial repair		Whole car repair	
Temperature	Up to 25°C	Up to 25-30°C	More than 30°C	
Hardener	6033	6035	6037	
Thinner	600F	600	601 more than 30	602 more than 35

#### Rectification and polishing

Kapci 6040 clearcoat does not require polishing as it offers very good gloss. In a case that some dirt has occurred, denib with P2000 or finer and polish by machine using Kapci K40 Polish compound. Polishing is easiest up to 24 h after the drying time.

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### **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

### **VOC (2004/42/EC)**

2004/42/II B(e) (840)510

The EU limit value for this product (product category: II B.e) in ready for use form is maximum 840 g/l of VOC.

The VOC content of this product in ready for use form is maximum 510 g/l.

### **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.