



**KAPCI**  
COATINGS

## Technical Data Sheet

Issue date January 2024

for professional use only

# Kapci 820 2K Weldable Primer

### Product description



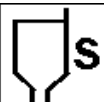
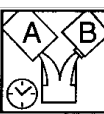



Kapci 820 is a 2K weldable primer based on epoxy resin which delivers excellent corrosion protection when applied over sandblasted steel components. This high performances 2K primer allows two metal surfaces to be primed prior to the welding process.

### Substrates

Kapci 820 2K Weldable Primer should be applied over previously sandblasted steel (the surface preparation level SA 2 ½).

To reach optimum performances, the surface should be free from all contaminants

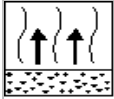
### Application

	<b>Mixing ratio by volume:</b> 100:40:10 (5:2:0.5)	100 % Kapci 820 2K Weldable Primer 40 % Kapci 825 Hardener 10 % Kapci 885 Thinner
	<b>Mixing ratio by weight:</b> 100:10:10 (10:1:1)	100 % Kapci 820 2K Weldable Primer 10 % Kapci 825 Hardener 10 % Kapci 885 Thinner
	<b>Application viscosity:</b> 18-20 s (F4/20°C)	
	<b>Pot life at 20°C:</b> 12 h	
	Stir well before the application.	
	<b>Spraygun tips:</b> 1.7-1.8 mm 4.0 bar	Refer to the spraygun manufacturer's recommendation. Note: Use brush for small areas only.
	<b>Number of coats:</b> Apply 2 coats. Total dry film thickness 50-70 microns.	

**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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**Flash off time:**

10-15 min/20°C before recoating



**Drying time at 20°C:**

Dry to touch: 15 min

Hard dry: 10 h

Fully cured: 72 h

Dry to recoat: minimum after 6 hours



**Baking at 60°C:**

30 min

**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.