



**Technical Data Sheet**

Issue date January 2024

for professional use only

## Kapci 873 2K Epoxy Primer High Build

### Product description

Kapci 873 is a high build fast dry 2K epoxy primer especially designed for one coat application over blast cleaned steel. It can also be applied in a standard mode by using a spray gun and can be applied over different substrates including galvanized steel, aluminum, GRP and old finishes thoroughly dry. Kapci 873 has excellent corrosion resistance and outstanding application properties offering fast drying, high build and easy application onto vertical surfaces.

### Substrates

**Steel:** For maximum durability steel should be prepared by blast cleaning/sanding. Alternatively, sand with P80-P180 sanding machine discs. Thoroughly degrease with Kapci 606 degreaser.

**Galvanized steel/weathered:** Degrease the surface with Kapci 606 degreaser and sand with P180-320 sanding machine discs. Repeat the degreasing step after sanding.

**Galvanized steel/hot dipped:** Degrease the surface with Kapci 606 degreaser and sand with P320 or finer sanding machine discs. Repeat the degreasing step after sanding.

**Aluminium:** Light sand with P240-P320 sanding machine discs. Degrease the surface after sanding.

**GRP/Fiberglass:** Light sand with P240-P320 sanding machine discs. Degrease the surface after sanding.

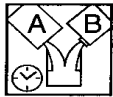
**Old finishes thoroughly dry:** Light sand with P320-P400 sanding machine discs. Repeat the degreasing step after sanding.

### Application

	<b>Mixing ratio:</b>			
	Kapci 873 Epoxy primer	Kapci 874 hardener	Kapci 885 or kapci 886 Epoxy thinner	
	100%	25%	25% For airless add only 10%	
	<b>Use mixing ruler</b>			

**Application viscosity at 20°C:**

18-20 sec/F4 (for spray gun)  
28-30 sec/F4 (for airless)

**Pot life at 20°C:**

2 h

**Airless:**

0.28-0.38 mm

Approx. 100-200 bar (1500-3000 psi)

Refer to the spraying equipment manufacturer's recommendation.

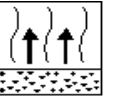
Apply 1 single coat to give 80-120 µm. Maximum DFT: 200 µm

**Spray gun:**

	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.7-1.8mm	2 bars (26- 29 psi)	
HVLP	1.7-1.8mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.7-1.8mm	3-3.5 bar (45-50 psi)	

Refer to the spray gun manufacturer's recommendation.

Apply 2 single coats to give 100-120 µm.

**Flash off time:**

7-10 min between coats

15-20 min before baking

**Drying time at 20°C:**

Dry to sand: 4 h

Dry to overcoat (wet-on-wet):

After 1 hour up to 12 hours. For prolonged time, more than 12 hours, the surface must be sanded before recoating.

**Baking at 60°C:**

20-30 min (object temperature)

Allow cooling down the surface before sanding.

**Sanding:**

Machine dry sanding: P240 sanding paper.

For optimum corrosion protection, minimum DFT (dry film thickness) should be 50 microns.

### General notes

#### Drying time

The quoted drying times will vary on film thickness and drying conditions. The drying times will be extended by poor air movement or excessive film thickness. Temperature below 15°C and high relative humidity of 80% and above, adversely affect the drying time.



**KAPCI**  
COATINGS

### **Overcoating**

Kapci 873 can be overcoated with 2K fillers, 2K topcoats, and basecoats. For optimum performance, allow drying over night. For wet-on-wet application, allow minimum 1 hour drying.

### **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.