



**KAPCI**  
COATINGS

## Technical Data Sheet

Issue date January 2024

for professional use only

# Kapci 880 2K Epoxy Primer

## Product description

Kapci 880 is a 2K epoxy primer with excellent anticorrosion properties, outstanding chemical resistance and good adhesion over steel, stainless steel, galvanized steel, and aluminum. Kapci 880 can be recoated with 2K fillers, 2K topcoats, and basecoats.

## Substrates

Kapci 880 2K Epoxy Primer can be applied over different substrates such as steel, galvanized steel and aluminum. To reach optimum performance, surface should be properly cleaned and degreased.

**Density:** 1.49  
**Color:** Grey and light Green

## Preparation

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

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

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

**Stainless steel:** Degrease with Kapci 606 degreaser and sand with P180-P240 sanding machine discs. Repeat the degreasing step after sanding.

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

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

**Old finishes (2K) in good conditions:** Light sand with P320-P400 sanding machine discs. Repeat the degreasing step after sanding.

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**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.



## Application

	<b>Mixing ratio by volume:</b> <table border="1" data-bbox="263 571 1125 728"><tr><td>Kapci 880 Epoxy primer 100%</td><td>Kapci 881 hardener 50%</td><td>Kapci 885 or kapci 886 Epoxy thinner 30%</td></tr><tr><td colspan="3">For airless add only 10%</td></tr></table>	Kapci 880 Epoxy primer 100%	Kapci 881 hardener 50%	Kapci 885 or kapci 886 Epoxy thinner 30%	For airless add only 10%			<b>Mixing ratio by weight:</b> 100:30:30											
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	<b>Pot life at 20°C:</b> 6 h																		
	<b>Spraygun tips:</b> <table border="1" data-bbox="263 907 1356 1142"><thead><tr><th></th><th>Spray Nozzle</th><th>Inlet pressure</th><th>Atomization pressure</th></tr></thead><tbody><tr><td>Compliant</td><td>1.7-1.8mm</td><td>2 bars (26- 29 psi)</td><td></td></tr><tr><td>HVLP</td><td>1.7-1.8mm</td><td>2 bars (26- 29 psi)</td><td>0.7bar (8-10 psi)</td></tr><tr><td>Conventional</td><td>1.7-1.8mm</td><td>3-3.5 bar (45-50 psi)</td><td></td></tr></tbody></table> <p>Refer to the spray gun manufacturer's recommendation.</p>				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)	
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	<b>Pressure pot:</b> 1.0-1.4mm <b>Airless:</b> 0.28-0.38 mm Approx. 100-200 bar (1500-3000 psi) Refer to the spraying equipment manufacturer's recommendation.																		
	<b>Number of coats:</b> Apply 2 coats Total dry film thickness 50-70 microns. For optimum protection of steel the minimum DFT should be 50 microns.																		
	<b>Flash off time:</b> Approximately 10-15 min/20°C between coats. Approximately 15-20 min/20°C before baking.																		
	<b>Drying time at 20°C: 16 h</b> <b>Baking at 60°C: 1 h</b> <b>Dry to recoat:</b> for wet-on-wet, after minimum 3 hours up to 24 hours. For prolonged time (more than 24 hours), the surface must be sanded before recoating.																		
	<b>Machine dry sanding:</b> P240 or finer sanding paper																		



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### General notes

#### Degreasing

Kapci 606 Degreaser is recommended. However, in case of a lack of Kapci 606, Kapci 605 Degreaser can be helpful as well.



- Saturate a clean cloth with Kapci 606 Degreaser;
- Apply to areas to be painted and adjacent panels;
- Wipe off surplus degreaser with a clean dry cloth; do not allow the degreaser to dry on the surface.

#### Recoatable

Kapci 880 is recoatable after minimum 3 hours for wet-on-wet application.

For optimum performance allow drying over night. Temperatures below 15°C and high humidity adversely affect the product performance.

#### 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.

Temperatures below 15°C and high relative humidity adversely affect drying time.

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

2004/42/IIB(b)(540)324

The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 540 g/l of VOC. The VOC content of this product in ready for use form is maximum 324 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.