KAPCI
COATINGS

DIMA WATERBORNE BASECOAT SYSTEM



CONTENT

Kapci 351 Soft PE Putty	**2**
Kapci 352 Rapid PE Putty	**4**
Kapci 370 Lightweight Body Filler	**6**
Kapci 626 2K HS Fast Drying Filler	**8**
Kapci 633 2K HS Acrylic Filler-VOC Compliant	**12**
Kapci 634 2K HS High Build Fast Drying Filler	**14**
Kapci 6030 2K HS Clearcoat	**16**
Kapci 6050 2K HS Anti-Scratch Clearcoat	**18**
Kapci 6080 UHS Express Clearcoat	**20**
Kapci Dima 9670 waterborne basecoat	**22**

Kapci 351 Soft PE Putty



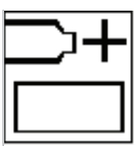
Product Description

Kapci 351 is a soft fine pigmented polyester putty that ensures very easy application, compactness, pore-fee surface, and easy sanding.

Substrates

Kapci 351 is used for treating a variety of substrates including steel, galvanized steel, GRP, and properly prepared old finishes in sound conditions.

Application



Mixing ratio by weight: 100% Kapci 351 Soft PE Putty
100:1-3 1-3% Kapci PE Putty Hardener

Pot life (working time) of the mixture is 4-6 min/ 20°C



Application:
Apply by a metal knife. (For edges or curve surfaces use a plastic knife).



Drying time at 20°C:
Dry to sand: less than 30 min
The drying time and pot life of a PE putty mixed with the putty hardener will considerably depend on temperature and the amount of the hardener used.
"At lower temperature add 2-3 % of the hardener, at higher temperature add 1%."



Machine or manual dry sanding:
Start sanding with sandpaper grit P120 and finish with P240.





IR Drying:
Short wave*: 5-8 min
*Guideline for short wave IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

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.

For professional use only

General Notes

Other tips

• For long-lasting anticorrosion protection over large surface, it is recommended to apply Kapci 2K Epoxy primer before applying PE putties.
• Do NOT apply PE Putty over 1K etch primers, 2K wash primers and thermoplastic acrylic paints.
• Add 1-3% of PE Putty hardener. The use of more than 3% of the hardener can cause a problem of bleaching/staining.
• Do NOT apply paints directly over PE putties.
• Wet sanding of PE putties is NOT recommended.
• In colder conditions, the warming (infrared or oven) of panels can assist in curing prior to applying of PE putties.
• After applying PE putties, clean all used tools with strong solvents immediately (e.g., NC thinners).

VOC (2004/42/EC)
2004/42/IIB(b)(250)230
The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 250 g/liter of VOC. The VOC content of this product in ready for use form is maximum 230 g/liter.

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.

Kapci 352 Rapid PE Putty



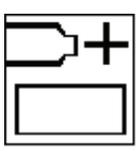
Product Description

Kapci 352 is a general-purpose Rapid putty based on polyester resins. It provides the best foundation for all Kapci paint systems combining easy application, easy sanding and fast drying.

Substrates

Kapci 352 Rapid PE putty can be applied over variety of substrates such as bare metal, galvanized original car panels, aluminium, glass fibre reinforced plastic (GRP), and properly sanded and prepared old finishes in sound conditions. Prior to applying Kapci 352 Rapid PE putty the surface should be clean and degreased.

Application



Mixing ratio by weight: 100% Kapci 352 PE Putty
100:1-3 1-3% Kapci PE Putty Hardener

Pot life (working time) of the mixture is 3-4min/ 20°C.



Application:

- Apply by a metal knife. (For edges or curve surfaces use a plastic knife).
- For deep filling, apply in several layers allowing drying between the layers (No sanding in-between is required).



Drying time at 20°C:
Dry to sand: 20 min

The drying time and pot life of a PE putty mixed with the putty hardener will considerably depend on temperature and the amount of the hardener used.

"At lower temperature add 2-3 % of the hardener, at higher temperature add 1%."



Machine dry sanding:
The following grades of sanding papers and steps are recommended:
P80-P120 and finish with P180



Manual dry sanding:
The following grades of sanding papers and steps are recommended:
P80-P120 and finish with P180



IR Drying:
Short wave*: 4-6 min
*Guideline for short wave IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

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.

For professional use only

General Notes

Recoatable

Kapci 352 is recoatable after sanding. For maximum durability apply Kapci 2K Epoxy primer over bare metal before applying Kapci 352 PE Putty.

Other tips

• Mix carefully PE Putty with the hardener to avoid forming of air bubbles in the mixture.
• For long-lasting anticorrosion protection over large surfaces, it is recommended to apply Kapci 2K Epoxy primer over bare metal surfaces before applying PE Putty.
• For small surfaces/damages, PE Putty can be applied over well sanded and degreased bare steel, aluminium, and galvanized steel (original OEM car panels). Use appropriate sanding papers for each surface.
• Do NOT apply PE Putty over 1K etch primers, 2K wash primers, and thermoplastic acrylic paints.
• PE Putty can be applied over 2K Epoxy primers and underneath of 1K Etch Primers and 2K Wash Primers.
• Add 1-3% of PE Putty hardener. Do NOT add less or more the hardener than recommended. The use of too much (more than 3%) or too little (less than 1%) of the hardener can cause a problem of bleaching/staining.
• Do NOT apply paints (2K topcoats, basecoats, etc.) directly over 2K PE putties.
• Do NOT sandwich PE putty between two layers of topcoats.
• Wet sanding of PE putties is NOT recommended.
• In colder conditions, the warming (infrared or oven) of panels can assist in curing prior to applying of 2K PE putties.
• After applying PE putties clean all used tools with strong solvents immediately (e.g., NC thinners).

VOC (2004/42/EC)
2004/42/IIB(b) (250)230
The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 250 g/liter of VOC.
The VOC content of this product in ready for use form is maximum 230 g/liter.

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.

Kapci 370 Lightweight Body Filler



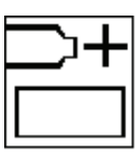
Product Description

Kapci 370 is an ultra lightweight general purpose body filler with significantly lower specific weight than common standard body fillers, thereby combining easy application with compact surface and easy sanding.

Substrates

Kapci 370 can be applied over variety of substrates including steel, galvanized steel, GRP, and properly sanded and prepared old finishes in sound conditions.

Application



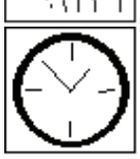
Mixing ratio by weight:
100:1-3

100% Kapci 370 Lightweight Body Filler
1-3% Kapci PE Hardener

Pot life (working time) of the mixture is 4-5 minutes at 20°C.



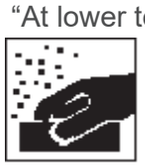
Application:
Apply by a metal knife.



Drying time at 20°C:
Dry to sand: approximately 30 min
The drying time and pot life of PE Putty mixed with the putty hardener will considerably depend on temperature and the amount of the hardener used.

"At lower temperature add 2-3 % of the hardener, at higher temperature add 1%."





Machine or manual dry sanding:
Coarse sanding: P80-P120
Finish: P180-P240



IR Drying:
Short wave*: 5-8 min
*Guideline for short wave IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

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.

For professional use only

General Notes

Other tips

• Mix carefully PE Putty with the hardener to avoid forming of air bubbles in the mixture.
• For long-lasting anticorrosion protection over large surface, it is recommended to apply Kapci 2K Epoxy primer before applying PE body filler.
• Do NOT apply PE body filler over 1K etch primers, 2K wash primers and thermoplastic acrylic paints.
• Add 1-3% of PE hardener. The use of more than 3% of the hardener can cause a problem of bleaching/staining.
• Do NOT apply paints directly over PE body filler.
• Wet sanding of PE body filler is NOT recommended.
• In colder conditions, the warming (infrared or oven) of panels can assist in curing prior to applying of PE body filler.
• After applying PE body filler, clean all used tools with strong solvents immediately (e.g. NC thinner).

VOC (2004/42/EC)
2004/42/IIB(b)(250)230
The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 250 g/liter of VOC.
The VOC content of this product in ready for use form is maximum 230 g/liter.

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.

Kapci 626 2K HS Fast Drying Filler
VOC Compliant



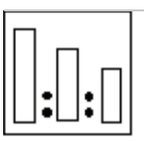
Product Description

Kapci 626 is fast drying 2K HS acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats. It delivers fast drying combined with good application, leveling and sanding properties as well as good colors hold out. Kapci 626 can also be used as non-sanding (wet on wet) filler by changing the mixing ratio and the application process.

Substrates

Kapci 626 can be applied over 2K PE putties, 2K Epoxy Primers, 2K Wash primers, 1K Etch Primers, original factory primers, glass fibre reinforced plastic (GRP) and well sanded old finishes in sound condition. If it is used as non-sanding filler, Kapci 626 must not be applied over 2K PE Putties.
To reach optimum performances, the surface should be properly sanded, cleaned, and degreased with Kapci 605 Degreaser.

Application as sanding filler



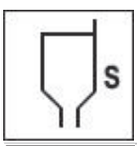
(5:1:1)

Mixing ratio by volume:

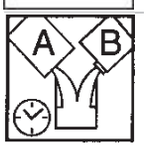
Kapci 626	MS Hardeners	Thinner
100%	20% 653 Extra Fast, 652 Fast 651 Normal	20% 600F Fast, 600 Normal 601 Slow

Mixing ratio by weight:

100:12:10



Application viscosity:
26-28 s (DIN4/20°C)



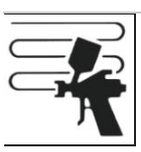
Pot life at 20°C:
4.5h



Spraygun tips:

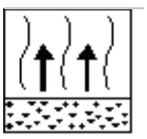
	Spray Nozzle	Inlet pressure	Atomization pressure
HVLP	1.7-1.8 mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.7-1.8 mm	3-3.5 bar (45-50 psi)	

.
Refer to the spray gun manufacturer's recommendation.



Number of coats:
Apply normal 2 coats.

Total dry film thickness 90-110 microns.



Flash off time at 20°C:
Between coats: 3-5 min
Before baking: 10-15 min

Depending on film thickness and drying conditions.

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.

For professional use only



Drying time:
45-90 min at 20°C
20-30 min at 60°C



IR Drying:
Short wave*: 8-12 min
*Guideline for IR equipment.
Refer to the IR equipment manufacturer's instructions for sets-up.

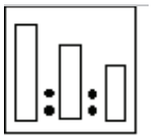


Machine dry sanding:
P320-P400/P500



Manual wet sanding:
P800 or P1000

Application as non-sanding filler



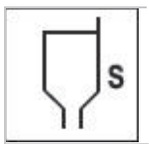
Mixing ratio by volume:

Kapci 626	MS Hardeners	Thinner
100%	20% 653 Extra Fast, 652 Fast 651 Normal 656 Slow	40% 600F Fast, 600 Normal 601 Slow 602 Extra Slow

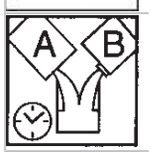
(5:1:2)

Mixing ratio by weight:

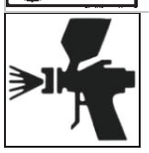
100:12:20



Application viscosity:
15-18 s (DIN4/20°C)



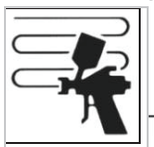
Pot life at 20°C:
4h



Spraygun tips:

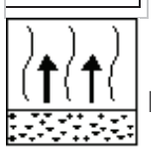
	Spray Nozzle	Inlet pressure	Atomization pressure
HVLP	1.4 mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.4 mm	3-3.5 bar (45-50 psi)	

Refer to the spray gun manufacturer's recommendation.



Number of coats:
Apply 1 coat

Total dry film thickness 30-35 microns.



Flash off time for wet-on-wet application (at 20°C):
15-20 min
Note: The flash off time depends on used hardener, thinner, and drying conditions.

General Notes

Recoating

Kapci 626 is recoatable after sanding. It can be overcoated with Dima 9670 basecoats, Kapcibase 670 basecoats, and Kapcicryl 660 2K acrylic topcoats. When applied as wet on wet filler, it can be overcoated after 15-20 minutes at 20°C with recommended Kapci hardeners and thinners.

Choice of hardeners

Kapci offers a range of hardeners to meet every type and size of car repair under every application 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 20°C	Up to 25°C	Up to 30°C	More than 30°C	
Hardener	653	652	651	656	
Thinner	600F	600/600F	600	601 more than 30	602 more than 35

Painting plastic

When painting plastics, it is necessary to use Kapci 616 Adflex Flexible Additive for Plastic. Please refer to the technical data (TDS) for KAPCI 616 Adflex.

Other tips

1. Do not apply Kapci 626 filler for spot repair over TPA (thermoplastic acrylic paint) and old 1K finishes. Apply to complete panels only.
2. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C
3. Clean the spray gun thoroughly immediately after use of 2K products.

VOC (2004/42/EC)
2004/42/IIB(c)(540)535
The EU limit value for this product (product category: IIB.c) in ready for use form is maximum 540 g/liter of VOC. The VOC content of this product in ready for use form is maximum 535 g/liter.

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.



KAPCI
COATINGS

EFFECTIVE SOLUTIONS
FOR A PERFECT FINISH

Kapci 633 2K HS Acrylic Filler
VOC Compliant



Product Description

Kapci 633 is a 2K high solids acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats. It delivers easy application, very good leveling and sanding properties, and excellent color hold out and finish.

Substrates

Kapci 633 can be applied over PE putties/body fillers, 2K Epoxy Primers, 2K Wash primers, 1K Etch Primers, original factory primers, GRP, and well sanded old finishes in sound condition.

Application



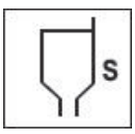
(5:1:1)

Mixing ratio by volume:

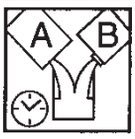
Kapci 633	MS Hardeners	Thinner
100%	20% 653 Extra Fast, 652 Fast 651 Normal 656 Slow	20% 600F Fast, 600 Normal 601 Slow 602 Extra Slow

Mixing ratio by weight

100:13:11



Application viscosity:
26-28 s (DIN4/20°C)



Pot life at 20°C:
4h



Spray gun tips:

	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)	

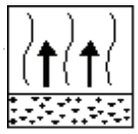
For best overall results, refer to the spray gun manufacturer's recommendation.



Number of coats:
Apply normal 2 coats. Total dry film thickness 100-120 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.

For professional use only



Flash off time at 20°C:
Between coats: 5-10 min
Before baking: 20 min



Drying time:
3-4h at 20°C
30 min at 60°C



IR Drying:
Short wave*: 10-15 min
*Guideline for IR equipment. Refer to the IR equipment manufacturer's instructions for set up.



Machine dry sanding:
P320-P400/P500



Manual wet sanding:
P800 or P1000

General Notes

Overcoating

Kapci 633 is recoatable after sanding. It can be overcoated with Dima 9670 water-borne basecoats, Kapcibase basecoats, and Kapcicryl 2K acrylic topcoats.

Choice of hardeners

Kapci offers a range of hardeners to meet every type and size of car repair under every application 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 20°C	Up to 25°C	Up to 30°C	More than 30°C	
Hardener	653	652	651	656	
Thinner	600F	600/600F	600	601 more than 30	602 more than 35

Painting plastic

When painting plastic, it is necessary to use Kapci 616 Adflex flexible additive for plastic. Please refer to the TDS "Kapci 616 Adflex Flexible Additive for Plastic".

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/IIB(c)(540)535
The EU limit value for this product (product category: IIB.c) in ready for use form is maximum 540 g/liter of VOC. The VOC content of this product in ready for use form is maximum 535 g/liter.

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.

Kapci 634 2K HS High Build Fast Drying Filler VOC Compliant



Product Description

Kapci 634 is fast drying 2K HS acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats. It delivers fast drying combined with good application, leveling and sanding properties as well as good colors hold out.

Substrates

Kapci 634 can be applied over 2K PE putties, 2K Epoxy Primers, 2K Wash primers, 1K Etch Primers, original factory primers, glass fibre reinforced plastic (GRP) and well sanded old finishes in solid condition.
To reach optimum performances, the surface should be properly sanded, cleaned, and degreased with Kapci 605 Degreaser.

Application

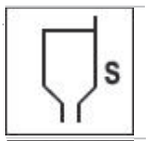


Mixing ratio by volume:

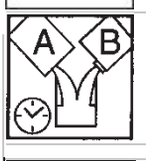
Kapci 634	MS Hardeners	Thinner
100%	25% 653 Extra Fast, 652 Fast 651 Normal 656 Slow	10-20% 600F Fast, 608 Fast 600 Normal 601 Slow 602 Extra Slow

Mixing ratio by weight

100:14:5-10



Application viscosity:
40-45 s (DIN4/20°C)



Pot life at 20°C:
45 min



Spraygun tips:

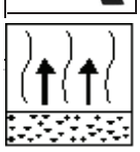
	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.7-1.8mm	2 bars (26- 29 psi)	
HVLP	1.7-1.8mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.7-1.8mm	3-3.5 bar (45-50 psi)	

Refer to the spray gun manufacturer's recommendation.



Number of coats:
Apply normal 2 coats.

Total dry film thickness 120 -140 microns.



Flash off time at 20°C:
Between coats: 3-5 min
Before baking: 10-15 min

Depending on film thickness and drying conditions.

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.

For professional use only



Drying time:
1h at 20°C
20 min at 60°C



IR Drying:
Short wave*: 8-12 min
*Guideline for IR equipment.

Refer to the IR equipment manufacturer's instructions for sets-up.



Machine dry sanding:
P320-P400/P500



Manual wet sanding:
P800 or P1000

General Notes

Recoating

Kapci 634 is recoatable after sanding. It can be overcoated with Dima 9670 base-coats, Kapcibase 670 basecoats, and Kapcicryl 660 2K acrylic topcoats. When applied as wet on wet filler, it can be overcoated after 15-20 minutes at 20°C with recommended Kapci hardeners and thinners.

Choice of hardeners

Kapci offers a range of hardeners to meet every type and size of car repair under every application 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 20°C	Up to 25°C	Up to 30°C	More than 30°C	
Hardener	653	652	651	656	
Thinner	600F/608	600/600F	600	601 more than 30	602 more than 35

Painting plastic

When painting plastics, it is necessary to use Kapci 616 Adflex Flexible Additive for Plastic. Please refer to the technical data (TDS) for KAPCI 616 Adflex.

Other tips

1. Do not apply Kapci 634 filler for spot repair over TPA (thermoplastic acrylic paint) and old 1K finishes. Apply to complete panels only.
2. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C
3. Clean the spray gun thoroughly immediately after use of 2K products.

VOC (2004/42/EC)
2004/42/IIB(c) (540)500
The EU limit value for this product (product category: IIB.c) in ready for use form is maximum 540 g/liter of VOC. The VOC content of this product in ready for use form is maximum 500 g/liter.

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.

Kapci 6030 2K HS Clearcoat
VOC Compliant



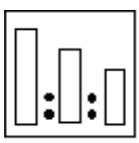
Product Description

Kapci 6030 is a high solids VOC compliant 2K acrylic clearcoat which can be used over Kapci Dima 9670 waterborne basecoats. It is suitable for all types of repairs and delivers high gloss and durable finish.

Substrates

Kapci 6030 HS clearcoat should be applied over Kapci Dima 9670 waterborne basecoats, Kapcibase 670/640 basecoats, and properly prepared paint work in sound conditions.

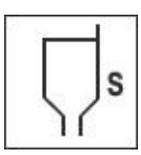
Application



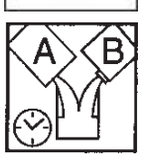
2:1:0.1-0.2

Mixing ratio by volume:

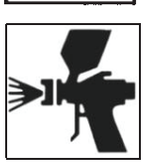
Kapci 6030 HS Clearcoat	Kapci HS Hardeners	Kapci 2K Thinners:
100%	50% 6054 Fast 6055 Normal 6056 Slow **(For VOC compliant)** Or 6031 Extra fast 6033 Fast 6035 Normal 6037 Slow **(For Non-VOC compliant)**	5-10% 600F Fast, 600 Normal, 601 Slow 602 Extra Slow



Application viscosity:
18-20 s (DIN4/20°C)



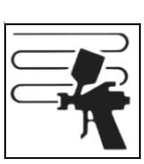
Pot life:
4 h at 20°C



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)	

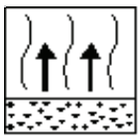
For best overall results, refer to the spray gun manufacturer's recommendation.



Number of coats:
Apply 1 light and 1 normal coat.
Total dry film thickness 60-70 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.

For professional use only



Flash off time:
5-7 min/20°C between coats;
20 min/20°C before baking



Drying time:

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



IR Drying:
Short wave*: 10-15 min
Refer to the IR equipment manufacturer's instructions for set up.

General Notes

Choice of hardeners and thinners

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. Use Kapci HS hardeners 6054, 6055 and 6056 for VOC compliant clearcoat.

Choice of hardener and thinner	Size of repair and temperature				
	Spot and partial repair		Whole car repair		
Temperature	Up to 20°C	Up to 25°C	Up to 30°C	More than 30•C	
Hardener	6031	6033/6054	6035/6055	6037/6056	
Thinner	600F	600/600F	600	601	602

Rectification and polishing

Kapci 6030 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.

Rectification and polishing

Kapci 6030 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.

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/IIB(d)(420)418

The EU limit value for this product (product category: IIB.d) in ready for use form is maximum 420 g/liter of VOC.

The VOC content of this product in ready for use form is maximum 418 g/liter when mixed with Kapci 6054, 6055 and 6056 hardeners.

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.

Kapci 6050 2K HS Anti-Scratch Clearcoat VOC Compliant



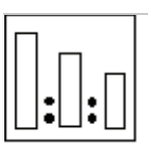
Product Description

Kapci 6050 is a 2K high solids acrylic clearcoat resistant to scratches. It delivers high gloss and durable finish which is resistant to abrasion and loss of gloss in modern car washes as well as in regular driving conditions.

Substrates

Kapci 6050 should be applied over Kapci Dima 9670 waterborne basecoats, Kapcibase 670/640 solvent-based basecoat, and properly prepared original paint work in solid conditions.

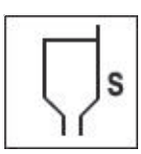
Application



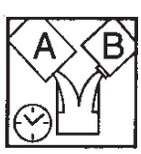
2:1:0.1-0.2

Mixing ratio:

Kapci 6050 HS Clearcoat	Kapci HS Hardeners	Kapci 2K Thinners:
100%	50% 6054 Fast 6055 Normal 6056 Slow	5-10% 600F Fast, 600 Normal, 601 Slow 602 Extra Slow



Application viscosity:
19-21 s (DIN4/20°C)



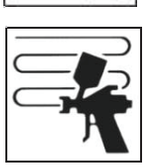
Pot life:
2 h at 20°C

Spray gun tips:

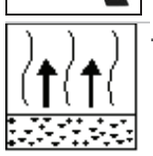
	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.3-1.4mm	2 bars (26- 29 psi)	
HVLP	1.3-1.4mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.3-1.4mm	3-3.5 bar (45-50 psi)	



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



Number of coats:
Apply 1 light and 1 normal coat.
Total dry film thickness 60-70 microns



Flash off time:
3-5 min/20°C between coats
15-20 min/20°C before baking

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.

For professional use only

Drying time:

Hardener	20°C	60°C
6056 Slow	10-12	35
6055 Normal	8-10h	30min
6054 Fast	6-8 h	25min

IR drying:
Short wave*: 10-15 min
*Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

General Notes

Choice of hardeners and thinners

Choice of hardeners and thinners

- Kapci offers a range of HS hardeners and thinners to adjust the viscosity of Kapci 2K products under all temperature conditions and different size of repairs.
- 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	25-30°C	More than 30°C	
Hardener	6054	6055	6056	
Thinner	600F	600	601 more than 30	602 more than 35

Rectification and polishing

Kapci 6050 does not require polishing as it offers very good gloss. In 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 20 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. This is particularly important for high solid systems.
2. To reach optimum performances of high solids clearcoats, baking is highly recommended.
3. Clean the spray gun thoroughly immediately after use of 2K products.

VOC (2004/42/EC)
2004/42/IIB(d)(420)418
The EU limit value for this product (product category: IIB.d) in ready for use form is maximum 420 g/liter of VOC.
The VOC content of this product in ready for use form is maximum 418 g/liter.

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.

Kapci 6080 UHS Express Clearcoat
VOC Compliant



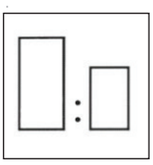
Product Description

Kapci 6080 is a fast dry 2K clearcoat based on latest technologies delivering ultra high solids content. It is especially designed for spot and partial repairs at air drying conditions and for use over Kapci Dima 9670 waterborne basecoats. Kapci 6080 Express clear coat dries fast offering greater productivity and cost saving in application. It reduces solvent content, saves energy costs, and makes the repair process efficient. Kapci Express clear coat is a versatile UHS clearcoat that can be applied in one coat or in single-visit application delivering high gloss and high build finish.

Substrates

Kapci 6080 clearcoat can be applied over Kapci Dima 9670 waterborne basecoat, Kapcibase 670/640 solvent-based basecoats, and properly prepared original paint in sound conditions.

Application

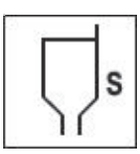


Mixing ratio:

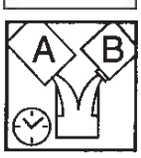
Kapci 6080 UHS Clearcoat	Kapci HS Hardeners
100%	50% 6083 Fast

(2:1)

Note:
In solvent-based basecoat add 5%hardener
In water-based basecoat add 5% water base hardener to the basecoat.



Application viscosity:
20-22 s (DIN4/20°C)



Pot life:
20-25 min 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 spray gun manufacturer's recommendation.

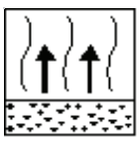
IMPORTANT NOTE:
These TDS are for information purposes only without any obligation as we do not have control over the quality and conditions of the surface or application.

For professional use only



Number of coats:

One-coat application:	Single-visit application:
Apply 1 normal coat. Recommended DFT: 40-45 microns	Apply a fast 1/2 coat followed with 1 normal coat without flash-off time, Recommended DFT: 60-70 microns



Flash off time between coats:
5-10 min



Drying time:
1.5-2 h/20°C



No

General Notes

Choice of hardeners and thinners

Kapci 6083 fast hardener is used for spot and panel respray at temperature up to 20°C.

Other tips

1) To ensure an optimal adhesion of base coat to the clearcoat and filler, add 5 % of MS hardener or HS hardener to the basecoat.
2) Contrary to conventional 2K high solids clearcoats, Kapci 6080 UHS clearcoat does not require baking as it cures fast at room temperature. With fast hardener, the polishing process is possible after 1.5-2 h.
3) Oven can be used only to speed up dry to touch time which is 15-20 min/60°C depending on the hardener used.
4) The use of IR lamp is not recommended.
5) Strictly follow the given mixing ratio 2:1. Do NOT add thinner since the addition of the thinner adversely affects hardness and the drying time of Kapci 6080 clearcoat.
6) Be aware of short pot life of the RFU mixture. Once mixed, the mixture should be spent within 20-25 min/20°C. Also be aware the higher the temperature, the shorter pot life time is.

VOC (2004/42/EC)
2004/42/IIB(d)(420)285
The EU limit value for this product (product category: IIB.d) in ready for use form is maximum 420 g/liter of VOC.
The VOC content of this product in ready for use form is maximum 285 g/liter.

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.

Kapci Dima 9670 waterborne basecoat



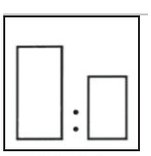
Product Description

Kapci Dima 9670 is a waterborne basecoat mixing system for repainting of passenger cars and commercial vehicles. The mixing system offers extensive basecoat color matching including solid, metallic, pearl, and xirallic basecoat finishes. Kapci Dima 9670 significantly reduces solvent emissions into the environment and complies with all current legislative requirements.

Substrates

Kapci Dima 9670 waterborne basecoat can be applied over properly prepared surfaces including Kapci 2K fillers and through-hardened finishes. Existing job should be correctly prepared and cleaned. Before applying Kapci Dima 9670 basecoat color, sand the surface with paper grit P500 for dry or with P800/P1000 for wet sanding. For cleaning and degreasing of the surface, use Kapci Dima Degreaser 9605.

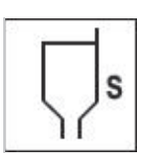
Application



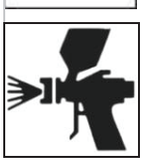
100:30

Mixing ratio:

Kapci Dima 9670 Basecoat	Kapci Dima 9610 Reducer
100%	30%



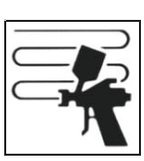
Application viscosity:
22-26 s (DIN4/20°C)



Spray gun tips:

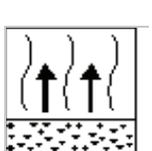
	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.3-1.4mm	2 bars (26- 29 psi)	
HVLP	1.3-1.4mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.3-1.4mm	3-3.5 bar (45-50 psi)	

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



Number of coats:

Metallic, Pearlescent and Special effect base coat colors	Solid Basecoat colors
2 Normal + a mist coat to even metallic appearance • Recommended DFT 15-20 µm	2 Normal coats



Flash off time:
Flash off thoroughly between coats and before applying clearcoat until matt and uniformly dry. If needed, use dry jet equipment to reduce flash off time.

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.

For professional use only



Overcoating:
Apply Kapci 2K HS or Kapci 2K UHS clearcoat.

General Notes

Hand-shaking of the toners

Hand-shake containers of Kapci Dima 9670 toners for a few seconds before use. Do not shake them vigorously.

Rectification of the basecoat

Visible defects can be removed only after the basecoat is fully dry by light manual sanding with paper P1500 or finer. For smoother sanding, the sanding paper can be slightly soaked with Kapci 605 Degreaser.

Other tips

- Use plastic containers for mixing of Kapci Dima 9670.
- For optimum performance, ensure that Kapci Dima 9670 basecoat color is applied between 20°C and 25°C.
- It is always recommended to filter the basecoat before spraying. Use nylon paint strainers designed for use with waterborne paints. Recommended mesh size is 125 microns.
- Clean and degrease the surface with Kapci Dima 9605 degreaser prior to applying the basecoat color.
- Heavy application must be avoided
- With low opacity colors, it may be necessary to apply 1 coat more. Use appropriate shade of Kapci 2K fillers before applying the basecoat.
- Do not use the spray gun as an air blower! Clean the spray gun with water immediately after the application
- When collect waste-disposal, always separate waterborne products from solvent-based ones.

Storage and handling

Kapci Dima 9670 should be stored and transported at temperature between 5°C and 35°C. Store and keep away from frost.

VOC (2004/42/EC)
2004/42/IIB(d)(420)410
The EU limit value for this product (product category: IIB.d) in ready for use form is maximum 420 g/liter of VOC.
The VOC content of this product in ready for use form is maximum 410 g/liter.

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.

KAPCI BLINK 5A

The most powerful color matching system ever



- 5 Angle Color Measurement
- Wireless Connection
- Touch Screen
- Self Calibration
- USB Charging

KAPCI
COATINGS

KAPCI
COATINGS

/Kapci.Coatings.Official /kapci_coatings /company/kapci-coatings

South Port Said Industrial Zone Port Said, Egypt P.O. Box 118 Port Said
Tel.: +2 066 377 0000/9 Fax: +2 066 377 0010 - +2 066 377 0000

www.kapci.com