



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Prima 8800 2K MS Clearcoat

Product description


Prima 8800 is a 2K medium solids acrylic clearcoat especially formulated for applying over solvent-based basecoats. It gives high gloss and "water like" final appearance. It offers high durability and weathering resistance. When used in conjunction with Prima MS hardeners 8550 Normal, 8530 Fast, 8500 Extra Fast or 8570 Slow, Prima 8800 delivers high gloss and excellent finish.

Substrates

Prima 8800 clearcoat should be applied over Kapcibase and Laticobase solvent-based basecoats and properly prepared paint work in solid conditions.

Existing job should be properly sanded and degreased prior to applying the basecoat. For cleaning and degreasing of the surface, it is recommended to use Kapci Degreaser 605


Application




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Mixing ratio by volume:


Prima 8800 MS Clearcoat	Kapci MS Hardeners	Kapci 2K Thinners:
100%	50%	30%
	8500 Extra Fast, 8530 Fast 8550 Normal 8570 Slow	8410 Fast, 8420 Normal, 8430 Slow



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



Pot life:
4 h at 20°C



Spray gun tips:

	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.2-1.3mm	2 bars (26- 29 psi)	
HVLP	1.2-1.3mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.2-1.3mm	3-3.5 bar (45-50 psi)	

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

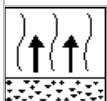
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Number of coats:
Apply 2 normal coats.
Total dry film thickness 50-60 microns.



Flash off time:
5-10 min/20°C between coats
20 min/20°C before baking



Drying time:

Hardener	20°C	60°C
8570 Slow	16-18h	35
8550 Normal	14-16h	30min
8530 Fast	12-14h	25min
8500 Extra Fast	6-8h	20min



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 hardener

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	8500	8530	8550	8570
Thinner	8410		8420	8430

Use of accelerator 6510

Kapci 6510 is an additive for acceleration of drying time and may be added in the mixture of the clearcoat and hardener at a level of 4-9 mass % prior to the addition of the thinner. The addition of Kapci 6510 will reduce pot life to 2-3 hours.

Note: Kapci 6510 Accelerator must not be mixed with extra fast and fast drying hardeners and is recommended for the temperature range 10°C-20°C.

Rectification and polishing

Prima 8800 clearcoat does not require polishing as it offers excellent gloss. In case that some dirt has occurred, denib with P2000 or finer and polish by machine using Kapci K40 Polish Compound.

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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 spraygun thoroughly immediately after use of 2K products.

VOC (2004/42/EC)
2004/42/II B(e) (840) 560

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 560 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.