



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Kapci 870 2K Epoxy Primer

Product description

Kapci 870 is 2K epoxy primer with high anticorrosion properties, fast drying, outstanding chemical resistance and good adhesion over steel, stainless steel, galvanized steel, and aluminum. Kapci 870 can be recoated with 2K fillers, 2K topcoats, and basecoats/clearcoats.

Substrates

Kapci 870 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.

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

Galvanized still/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.

Aluminum: 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.

These products are for the professional painting of automotive vehicles only after reference to the manufacturer's Material Safety Data Sheets (MSDS).

Application



Mixing ratio by volume:

100:25:25-30

100 % Kapci 870 2K Epoxy Primer;

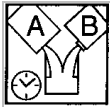
25 % Kapci 871 Epoxy Hardener;

25-30 % Kapci 885 Epoxy thinner or Kapci 886 Epoxy Fast thinner

For airless spraying add approximately 10% of Kapci Epoxy thinner.



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Pot life at 20°C:
5 h



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.



Pressure pot:
1.0-1.4mm

Airless:

0.28-0.38 mm

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

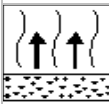
Refer to the spraying equipment manufacturer's recommendation.



Number of coats:

Apply 2 coats

Total dry film thickness 50-70 microns. For optimum protection of steel the minimum DFT should be 50 microns.



Flash off time:

10-15 min/20°C between coats.

20-30 min/20°C before baking.



Drying time at 20°C: 10 h

Baking at 60°C: 30 min

Dry to recoat: for wet-on-wet, minimum after 2 hours up to 16 hours. For prolonged time (more than 16 hours), the surface must be sanded before recoating.



Machine dry sanding: P240 or finer sanding paper

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;

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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- Wipe off surplus degreaser with a clean dry cloth; do not allow the degreaser to dry on the surface.

Recoatible

Kapci 870 is recoatable for wet-on-wet application after minimum 2 hours. 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. Temperature below 15°C and high relative humidity adversely affect drying time.

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.