



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Kapci 888 2K MS Clearcoat

Product description


Kapci 888 is a 2K medium solids acrylic clearcoat especially formulated for applying over solvent-based basecoats. It delivers high gloss, high durable and long-lasting finish when used in conjunction with Kapci MS hardeners 651 Normal, 652 Fast, 653 Extra Fast or 656 Slow.

Substrates

Kapci 888 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



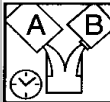
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Mixing ratio by volume:


| | | |
|------------------------|---|---|
| Kapci 888 MS Clearcoat | Kapci MS Hardeners | Kapci 2K Thinners: |
| 100% | 50% | 30% |
| | 653 Extra Fast, 652 Fast 651 Normal 656 Slow | 600F Fast, 600 Normal, 601 Slow 602 Extra 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.

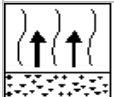
IMPORTANT NOTE: These TDS are for information purposes only without any obligation as we do not have control over the quality and conditions of the surface or application.



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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 |
|----------------|--------|-------|
| 656 Slow | 16-18h | 35 |
| 651 Normal | 14-16h | 30min |
| 652 Fast | 12-14h | 25min |
| 653 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 set up.

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 | 653 | 652 | 651 | 656 | |
| Thinner | 600F | 600/600F | 600 | 601 more than 30 | 602 more than 35 |

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

Kapci 888 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/IIIB(e) (840)560

The EU limit value for this product (product category: IIB.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.