



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Kapcibase 640 Ready Mixed Basecoat

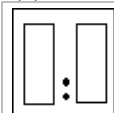
Product description

Kapcibase 640 is solvent-based ready mixed basecoat for repainting of passenger cars and commercial vehicles. Kapcibase 640 offers ready mixed solid color, metallic, pearlescent, and special effect basecoats. When used in conjunction with a Kapci range of clearcoats, Kapcibase 640 ready mixed colors deliver a durable and high gloss finish.

Substrates

Kapcibase 640 should be applied over properly prepared Kapci 2K fillers/2K primers, 1K sealers, 2K sealers, and old finishes in sound conditions. For sanding prior to applying Kapcibase 640, use paper grit P500 dry or P1000 wet. Degrease the surface with Kapci 605 Degreaser before the application of the basecoat color.

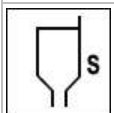
Application of two-stage basecoat colors



Mixing ratio:

Kapcibase 640	Kapci 2K thinner
100%	100%

(1:1)



Application viscosity:
16-18 s (DIN4/20°C)



Spray gun tips:

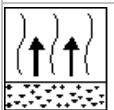
	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.2-1.3mm	2 bars (26- 29 psi)	
HVLP	1.2-1.3mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.2-1.3mm	3-3.5 bar (45-50 psi)	

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



Number of coats:

Metallic., pearlescent., And special effect basecoat color	Solid basecoat color
Apply 2 normal coats +a mist coat. DFT 15-20 microns,	Apply 2 normal coats DFT 15-20 microns.



Flash off time:

Between coats: 3-4 min

Before applying clearcoat: 10-15 min

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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Overcoating:
Apply Kapci 2K clearcoat

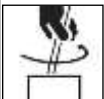
General notes

Rectification

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 water.

Other tips

With low opacity colors, it may be necessary to apply a coat more after the appropriate flash off time. Use appropriate shade of Kapci 2K grey fillers before applying the basecoat.



Stir Kapcibase 640 basecoat color well.



It is always recommended to filter the basecoat before spraying.

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.