



KAPCI
COATINGS

For professional use only

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Kapci 650 2K MS Clear Coat

Product description

Kapci 650 is a 2K medium solid clear coat especially formulated for applying over Kapci basecoats 670 and Kapci 640 ready mixed basecoats. It gives high gloss, good durability and weathering resistance.

It is used in conjunction with MS range of Kapci standard hardeners 651-normal, 652-fast, 653-extra fast and 656-slow, without affecting gloss and excellent final finish.

Suitable substrates

Kapci 650 clear coat should only be applied over:

1. Kapci 670 basecoats;
2. Kapci 640 ready mixed basecoats;
3. Properly prepared paint work in sound conditions.

Existing job should be sanded and degreased with Kapci 605 Degreaser.











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

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Kapci Car
Refinishes
System

Product Process

Product	Kapci 650 2K Clear Coat				
Hardeners	653 Extra fast, 652 Fast, 651 Normal, 656 Slow				
Thinners	600F Fast, 600 Normal, 601 Slow, 602 Extra slow				
	2:1:30% Note: Use appropriate hardener and thinner for size of repair and temperature. Use ruler Kapci No°1				
	15-18 sec (DIN4 at 20°C)				
	Pot life at 20°C: 4 h				
	Fluid tip 1.3-1.4 mm Pressure: 3.0-3.5 bar (45-50 psi inlet) Refer to manufacturer's recommendation.				
	Fluid tip 1.3-1.4 mm Pressure: 2.0 bar (30 psi inlet) Refer to manufacturer's recommendation.				
	2 full coats Recommended dry film thickness 50-60 microns.				
	Flash off: 5-10 minutes between coats. 15 minutes before baking.				
	Air dry at 20°C				
	Hardener	653	652	651	656
	Dust free:	20 min	25 min	35 min	55 min
	Tack free:	2.5 h	3 h	3.5 h	4 h
	Hard dry:	8 h	10 h	14 h	17 h
	Bake at a metal temperature of 60°C				
	Hardener	653	652	651	656
	Hard dry:	20 min	35 min	40 min	40 min
	* Baking times are for quoted metal temperature.				
	Short wave: 10-15 min; Medium wave: 15-20 min				

General process notes

Choice of hardener

Kapci offers a range of hardeners to meet every type and size of car refinish under all conditions.

Extra fast hardener 653 is recommended for temperatures below 20°C and for small size of repair.

Fast hardener 652 is used for medium sized repair and for temperatures up to 25°C.

Normal hardener 651 is suitable for large areas, i.e. for all repairs at temperatures up to 30°C.

Slow hardener 656 should be used when the temperature exceeds 30°C.

Use of accelerator 6510

Kapci 6510 is an additive for acceleration of drying time and may be added in the mixture of clear and hardener at a level of 4-9 mass % prior to thinner addition.

NOTE: Addition of accelerator 6510 will reduce pot life to 2-3 hours.

Recoatibility

Kapci 650 is fully recoatable after hard dry time.

Rectification and polishing

Kapci 650 clear coat does not require polishing because it offers an excellent gloss. In a case that some dirt has occurred, denib with P1500 or finer and then polish by hand or machine. Polishing is easiest up to 24 h after hard dry time.

Painting plastic

For painting plastic see TDS "Painting plastic substrates".

Fade out process

Kapci 650 clear can be applied over the whole panel or faded out. If the clear is fading-out then be sure that clear coat covers basecoat edges and only fade-out into the prepared, i.e. flatted surface.

Other tips

1. For optimum application, ensure that both spray booth temperature and paint temperature is above 20°C.

2. Clean the gun thoroughly immediately after use 2K products.

Health and Safety

1. For full Health and Safety information please refer to Material Safety Data Sheet;

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;

This information is the result of our knowledge but given without warranty.