



KAPCI
COATINGS

For professional use only

Issue: May 2015

Superseded: February 2015

Kapci 3300 2K MS Acrylic Fast Drying Clearcoat

Product description

Kapci 3300 is an extra fast drying 2K medium solids acrylic clearcoat for spot and panel repairs over solvent-based basecoats. It is designed to give the maximum in speed and productivity, while providing high gloss retention and excellent appearance when used in conjunction with Kapci MS hardeners 651 Normal, 652 Fast and 653 Extra Fast.

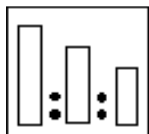
Substrates

Kapci 3300 MS fast drying clearcoat should be applied over:

1. Kapcibase solvent-based basecoat;
2. Properly prepared paint work in good conditions;

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

Application



Mixing ratio:

100:50:30
(2:1+30%)

100% Kapci 3300 MS Fast Drying Clearcoat
50% Kapci MS Hardeners: 653 Extra Fast,
652 Fast or 651 Normal
30% Kapci 2K Thinners: 600F Fast or 600
Normal

Note: Select appropriate thinner and hardener according to ambient temperature, air movement, and size of the surface to be clearcoated.

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

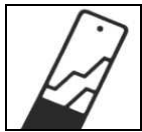


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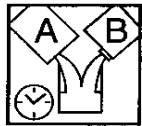
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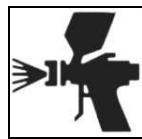
Use mixing ruler



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

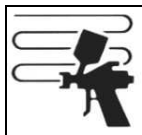


Pot life:
1.5-2.5h at 20°C



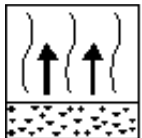
Spraygun tips:
1.3 mm
Conventional:
3.0-3.5 bar/45-50 psi inlet
HVLP: 2 bar/30 psi inlet

Refer to the spraygun manufacturer's recommendation.



Number of coats:
Apply 2 normal coats.

Total dry film thickness 50-60 microns.



Flash off time:
5-10 min/20°C between coats;
10-15 min/20°C before baking



Drying time:
1.5-4 h/20°C, depending on used hardener and thinner;
15-25 min/60°C



IR Drying:
Short wave*: 10-15 min
*Guideline for IR equipment.

Refer to the IR equipment manufacturer's instructions for set up.



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General notes

Choice of hardeners and thinners

The recommendations below are for guidance only:

Choice of hardener and thinner	Size of repair and temperature					
	Spot repair		Panel		Multi panels	
Temperature	15°C-20°C	20°C-25°C	15°C-20°C	25°C	15°C-20°C	20°C-25°C
Hardener	653	653	653	652	652	651
Thinner	600F	600	600F/600	600	600	600

Rectification and polishing

In a case that some dirt has occurred, denib Kapci 3300 with P1500 or finer and polish by machine using a high quality polish. Kapci 3300 can be polished after 1.5 hour at 20°C. Polishing is easiest up to 24 h after the drying time

Other tips

1. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C.
2. Do not add Kapci 6510 accelerator.
3. Clean the spraygun thoroughly immediately after use of 2K products.

VOC (2004/42/EC)

2004/42/IIB(e)(840)600

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 600 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.



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IMPORTANT NOTE: These products are for professional use only. The information in this Technical Data Sheet is based on our best knowledge and given for information purposes only without any obligation as we do not have control over the quality and conditions of the surface, or over many factors affecting the use and application of the product. Always read the Material Safety Data Sheet and the Technical Data Sheet for this product if available.