



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Kapci 3200 2K MS Clearcoat





Product description

Kapci 3200 is a 2K acrylic clearcoat especially formulated for applying over Kapcibase and Laticobase basecoat colors. When used in conjunction with standard Kapci hardeners - 651 Normal, 652 Fast, 653 Extra Fast or 656 Slow, Kapci 3200 delivers high gloss, durable and long-lasting finish.

Substrates

Kapci 3200 clearcoat should be applied over Kapcibase and Laticobase basecoat colors or over properly prepared old paint in sound condition. 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

 (2:1:0.6)	Mixing ratio:		
	Kapci 3100 MS Clearcoat 100%	Kapci MS Hardeners 50% 653 Extra Fast, 652 Fast 651 Normal 656 Slow	Kapci 2K Thinners: 30% 600F Fast, 600 Normal, 601 Slow 602 Extra Slow
	Application viscosity: 16-18 s (DIN4/20°C)		
	Pot life: 4 h at 20°C		
	Spray gun tips:		
		Spray Nozzle	Inlet pressure
	Compliant	1.2-1.3mm	2 bars (26- 29 psi)
	HVLP	1.2-1.3mm	2 bars (26- 29 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.

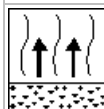


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**Number of coats:**

Apply 2 normal coats.

Total dry film thickness 50-60 microns.

**Flash off time:**

5-10 min/20°C between coats

15-20 min/20°C before baking

**Drying time:**

Hardener	20°C	60°C
656 Slow	14-16h	35
651 Normal	12-14h	30min
652 Fast	10-12h	25min
653 Extra Fast	8-10h	20min

**IR Drying:**

Short wave*: 10-15 min

*Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for set up.

General notes

Choice of hardener

- Kapci offers a range of hardeners to meet every type and size of car refinish under all conditions. The recommendations below are for guidance only:

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

Rectification and polishing

Kapci 3200 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.

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.

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VOC (2004/42/EC)

2004/42/IIIB(e) (840)570

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 570 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.