



KAPCI
COATINGS

For professional use only

Issue date: July 2010

Superseded TDS: July 2008

22

Kapci 9999 2K MS Clear Coat

Product description

Kapci 9999 is a 2K medium solids acrylic clear coat especially formulated for spraying over Kapci base coat. It combines accelerated drying with good final appearance.

Suitable substrates and preparations

Kapci 9999 clear coat should only be applied over:

1. Kapci 670 basecoats;
2. Kapci 640 ready mixed basecoats;
3. Kapci Dima 9670 waterborne basecoats;
4. 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

www.kapci.com



Kapci Car
Refinishes
System

Product Process

	Kapci 9999 2K Clear Coat
	Kapci 654 Normal
	600F Fast, 600 Normal, 601 Slow, 602 Extra slow
 	3:1:1 Note: Use appropriate thinner for size of repair and temperature. Use ruler Kapci No°3
	15-18 sec (DIN4 at 20°C)
	Pot life at 20°C: 3 hours
	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 is 50-60 microns.
	Flash off: 5-10 minutes between coats; 15 minutes before baking
	Air dry at 20°C Hardener 654 Dust free: 25 min Tack free: 2.5 h Hard dry: 13 h
	Bake at a metal temperature of 60°C Hardener 654 Hard dry: 30 min * Baking times are for quoted metal temperature.
	Short wave: 10-15 min Medium wave: 15-20 min

General process notes

Choice of thinner

Kapci offers a range of thinners to adjust the viscosity of Kapci 2K acrylic products under all temperature conditions and different size of repairs.

Fast thinner 600F is recommended for temperatures up to 20°C and small size of repair.

Normal thinner 600 is used for all repairs at temperatures up to 25°C.

Slow thinner 601 can be used for all size car repairs, at temperatures up to 30°C.

Extra Slow thinner 602 should be used when the temperature exceeds 35°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 1-5 mass % prior to thinner addition.

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

Recoatibility

Kapci 9999 is fully recoatable after hard dry time.

Painting plastic

For painting plastic see TDS "Painting plastic substrates".

Rectification and polishing

Kapci 9999 clear coat does not require polishing because it offers a very good 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.

Fade out process

Kapci 9999 clear can be applied over the whole panel or faded out. If the clear is fading-out then be sure that the clear coat covers base coat 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.