



KAPCI
COATINGS

Issue: June 2018
Superseded: April 2018

Technical Data Sheet

For professional use only

Kapci 6030 2K HS Clearcoat - VOC Compliant

Product description

Kapci 6030 is a high solids VOC compliant 2K acrylic clearcoat which can be used over Kapci Dima 9670 waterborne basecoats. It is suitable for all types of repairs and delivers high gloss and durable finish.

Substrates

Kapci 6030 HS clearcoat should be applied over Kapci Dima 9670 waterborne basecoats, Kapcibase 670/640 basecoats, and properly prepared paint work in sound conditions.

Application

	<p>Mixing ratio: 100:50:5-10 (2:1:0.1-0.2)</p>	<p>100% Kapci 6030 2K HS Clearcoat 50% Kapci HS Hardeners (for 420 g/l VOC compliant clearcoat): 6054 Fast/6055 Normal/6056 Slow or Kapci hardeners: 6031 Extra fast /6033 Fast/6035 Normal/6037 Slow 5-10% Kapci 2K Thinners: 600F Fast/600 Normal/601 Slow/ 602 Extra Slow</p> <p>Notes:</p> <ul style="list-style-type: none">a) For 420 g/l VOC compliant clearcoat use Kapci hardeners 6054 Fast/6055 Normal/6056 Slow.b) Select appropriate hardener and thinner according to ambient temperature, air movement, and size of the surface to be repaired
	<p>Use measuring stick</p>	



Issue: June 2018
Superseded: April 2018

	<p>Application viscosity: 18-20 s (DIN4/20°C)</p>																
	<p>Pot life: 4 h at 20°C</p>																
	<p>Spray gun tips:</p> <table border="1" data-bbox="347 963 1412 1198"> <thead> <tr> <th></th> <th>Spray Nozzle</th> <th>Inlet pressure</th> <th>Atomization pressure</th> </tr> </thead> <tbody> <tr> <td>Compliant</td> <td>1.3-1.4mm</td> <td>2 bars (26- 29 psi)</td> <td></td> </tr> <tr> <td>HVLP</td> <td>1.3-1.4mm</td> <td>2 bars (26- 29 psi)</td> <td>0.7bar (8-10 psi)</td> </tr> <tr> <td>Conventional</td> <td>1.3-1.4mm</td> <td>3-3.5 bar (45-50 psi)</td> <td></td> </tr> </tbody> </table>		Spray Nozzle	Inlet pressure	Atomization pressure	Compliant	1.3-1.4mm	2 bars (26- 29 psi)		HVLP	1.3-1.4mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)	Conventional	1.3-1.4mm	3-3.5 bar (45-50 psi)	
	Spray Nozzle	Inlet pressure	Atomization pressure														
Compliant	1.3-1.4mm	2 bars (26- 29 psi)															
HVLP	1.3-1.4mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)														
Conventional	1.3-1.4mm	3-3.5 bar (45-50 psi)															
<p>For best overall results, refer to the spray gun manufacturer's recommendation.</p>																	
	<p>Number of coats: Apply 1 light and 1 normal coat. Total dry film thickness 60-70 microns.</p>																
	<p>Flash off time: 5-7 min/20°C between coats; 20 min/20°C before baking</p>																
	<p>Drying time: 14-16 h/20°C 30 min/60°C</p>																
	<p>IR Drying: Short wave*: 10-15 min Refer to the IR equipment manufacturer's instructions for set up.</p>																

General notes

Choice of hardeners and thinners



KAPCI
COATINGS

Issue: June 2018
Superseded: April 2018

- 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. Use Kapci HS hardeners 6054, 6055 and 6056 for VOC compliant clearcoat.

- Kapci 6054 HS Fast hardener is suitable for spot repair and panel repair, i.e., for small size repairs at temperatures up to 20°C.
- Kapci 6055 HS Normal hardener is suitable for large areas, i.e., for all repairs at temperatures between 20°C and 25°C.
- Kapci 6056 HS Slow hardener should be used when temperature exceeds 30°C.
- Kapci 6031 Extra Fast hardener is recommended for temperatures below 20°C for spot and multi-
- Kapci 6033 Fast hardener is recommended for temperatures up to 25°C for spot and multi-panels repair.
- Kapci 6035 Normal hardener is suitable for whole vehicle respray up to 28°C.
- Kapci 6037 Slow hardener is suitable for whole vehicle respray above 30°C.
- Kapci 600F Fast thinner is recommended for temperatures up to 20°C and small size of repair.
- Kapci 600 Normal thinner is used for all size repairs at temperatures up to 28°C.
- Kapci 601 Slow thinner can be used for all size repairs at temperatures up to 35°C.
- Kapci 602 Extra slow thinner should be used when temperature exceeds 35°C.

- Generally, use a slower thinner in fast air movement booths, for large repairs, and for high temperature application. Use a faster thinner in slow air movement booths, for small repairs and applications at lower temperature.

Rectification and polishing

Kapci 6030 clearcoat does not require polishing as it offers very good gloss. In a case that some dirt has occurred, denib with P2000 or finer and polish by machine using Kapci K40 Polish compound. 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. Clean the spray gun thoroughly immediately after use of 2K products.

VOC (2004/42/EC)

2004/42/IIIB(d) (420)418

Rev (04) 06/2018



KAPCI
COATINGS

Issue: June 2018
Superseded: April 2018

The EU limit value for this product (product category: IIB.d) in ready for use form is maximum 420 g/liter of VOC.

The VOC content of this product in ready for use form is maximum 418 g/liter when mixed with Kapci 6054, 6055 and 6056 hardeners.

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.

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.

Rev (04) 06/2018