



KAPCI
COATINGS

For professional use only

Issue: March 2015
Superseded: July 2010

Kapcicryl 660 2K Acrylic Mixing System

Product description

Kapcicryl 660 is a 2K acrylic mixing system for repainting of passenger cars and commercial vehicles. Kapcicryl 660 delivers 2K acrylic-urethane topcoats with high gloss, durability, and excellent coverage. When used in conjunction with a Kapci range of MS hardeners Kapcicryl topcoats can be used for any size of repair work.

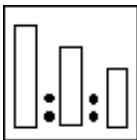
Substrates

Kapcicryl 660 2K topcoats should be applied over properly prepared Kapci 2K fillers/primers, 2K Sealers, and old finishes in solid conditions. For final sanding use sanding paper P400/P500 dry or P800/P1000 wet prior to applying Kapcicryl 660 2K topcoats.

Existing job should be properly sanded and degreased.

For cleaning and degreasing the surface prior to applying the topcoat, it is recommended to use Kapci 605 Degreaser.

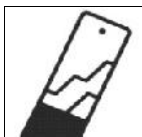
Application



Mixing ratio:

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

100% Kapcicryl 660 2K Acrylic Topcoat
50% Kapci MS Hardeners: 653 Extra Fast,
652 Fast, 651 Normal or 656 Slow
30% Kapci 2K thinners: 600F Fast, 600
Normal, 601 Slow or 602 Extra Slow



Use measuring stick

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

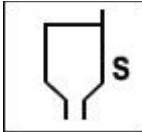


KAPCI
COATINGS

For professional use only

Issue: March 2015

Superseded: July 2010



Application viscosity:

16-18 s (DIN4/20°C)



Spraygun tips:

1.3-1.4 mm

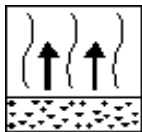
HVLP: 1.8-2 bar/27-30 psi
at the air inlet

Refer to the spraygun manufacturer's
recommendation.



Number of coats:

Apply 2 normal coats (to get opacity). Recommended total dry film thickness is 40-50 microns, depending on the shade to get opacity.



Flash off time:

Between coats: 4-7 min



Drying time:

12 h/20°C

30 min/60°C



IR Drying:

Short wave*: 8-10 min

*Guideline for IR equipment.

Refer to the IR equipment manufacturer's
instructions 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:

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

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



KAPCI
COATINGS

For professional use only

Issue: March 2015
Superseded: July 2010

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

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

Use of accelerator Kapci 6510

Kapci 6510 is an additive for acceleration of drying time and may be added in the mixture of the clearcoat and hardener at a level of 1-5 mass % prior to addition of the thinner.

NOTE: The addition of Kapci 6510 will reduce pot life to 2-3 hours.

Recoating

Kapci 660 is recoatable after the drying time.

Rectification and polishing

Kapci 660 2K Acrylic topcoat does not require polishing as it offers excellent gloss. In a case that some dirt has occurred, denib with P1500 or finer and polish by machine using a high quality polish. 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 spraygun thoroughly immediately after use of 2K products.

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.