



**Technical Data Sheet**

Issue date January 2024

for professional use only

## Kapcibase 670 Basecoat Mixing System

### Product description

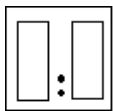
Kapcibase 670 is a solvent-based basecoat mixing system for repainting of passenger cars and commercial vehicles. It offers solid color basecoats, metallic basecoats, pearlescent and special effect basecoats.

- ✓ Kapcibase 670 basecoat color is easy to use.
- ✓ Fast drying.
- ✓ Has very good coverage and durability. When used in conjunction with a range of Kapci clearcoats, Kapcibase 670 delivers long-lasting high gloss finish.

### Substrates

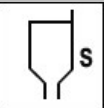
Kapcibase 670 should be applied over properly prepared Kapci 2K fillers/2K primers, 1K sealers, 2K sealers, and old finishes in sound conditions. For sanding prior to applying Kapcibase 670, use paper grit P500 dry or P1000 wet. Degrease the surface with Kapci 605 Degreaser before the application of the basecoat color.

### Application of two-stage basecoat colors



#### Mixing ratio by volume:

Kapci 670 MS Basecoat	Kapci 2K Thinners:
100%	100%
	600F Fast, 600 Normal, 601 Slow



#### Application viscosity:

16-18 s (DIN4/20°C)



#### Spray gun tips:

	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.2-1.3mm	2 bars (26- 29 psi)	
HVLP	1.2-1.3mm	2 bars (26- 29 psi)	0.7bar (8-10 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.

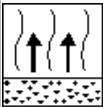


**KAPCI**  
COATINGS



**Number of coats:**

Metallic, pearlescent and special effect basecoat color	Solid basecoat color
Apply 2 normal coats + a mist coat DFT 15 -20 micron	Apply 2 normal coats DFT 15 -20 micron



**Flash off time:**

Between coats: 3-4 min  
Before applying clearcoat: 10-15 min

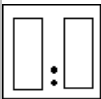


**Overcoating:**

Apply Kapci 2K clearcoat

**Application of three-stage basecoat colors**

This application requires 3 steps - spraying of a ground, solid basecoat color as a first step; spraying of transparent layers of a special effect pigments basecoat color in second step, and spraying of a clearcoat in third step.



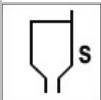
**Mixing ratio:**

(1:1)

Kapci 670 MS Basecoat	Kapci 2K Thinners:
100%	100%
	600F Fast, 600 Normal, 601 Slow



**Use measuring stick**



**Application viscosity:**

16-18 s (DIN4/20°C)



**Spray gun tips:**




	Spray Nozzle	Inlet pressure	Atomization pressure
Compliant	1.2-1.3mm	2 bars (26- 29 psi)	
HVLP	1.2-1.3mm	2 bars (26- 29 psi)	0.7bar (8-10 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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COATINGS

	<b>Number of coats:</b>	
	<b>Ground (Solid) basecoat color</b>	<b>Metallic, Pearlescent, and Special Effect basecoat color</b>
	Apply 2 normal coats DFT 15 -20 micron	Apply 2 normal coats + a mist coat DFT 15 -20 micron
	<b>Flash off time:</b>	
	Between coats: 3-4 min Before applying clearcoat: 20 min	
	<b>Overcoating:</b>	
	Apply Kapci 2K clearcoat	

### General notes

#### Color checking

Color checking is required before painting of a vehicle with all refinish systems.



1. Prior to checking, look up the motor manufacturer color code and color name in the Kapci Color Boxes and refer to Kapci ColorMix Software or Kapci SC Software to find the color formulation.
2. Prepare test panels. Apply the basecoat to the test panels to give opacity. The basecoat is normally applied in 2 coats (for metallics apply a mist coat as per given the application procedure), but some colors may require more coats. After recommended flash off time, apply Kapci 2K clearcoat and identify the color which most accurately matches with the vehicle.
3. For a three-stage basecoat color, use at least two test panels and first apply a ground basecoat color. Then apply a pearlescent/special effect pigment basecoat color over the test panels to identify the number of coats required to achieve the most accurate color. Apply 2 coats over the first panel, 3 coats over the second test panel, etc. After required flash off time, apply Kapci 2K clearcoat to compare which of the test panel colors match the best with the vehicle.

#### Important notes:

- Pearlescent and special effect pigment basecoat colors are transparent.
- With low opacity colors, it may be necessary to apply a coat more after the appropriate flash off time. Use appropriate shade of Kapci 2K grey fillers before applying the basecoat.
- Maximum dry film thickness for a three-stage color for 4 coats (excluding a clearcoat) is around 40 microns.

#### Rectification

Visible defects can be removed only after the basecoat is fully dry by light manual sanding with paper grit P1500 or finer. For smoother sanding, the sanding paper can be slightly soaked with water.

#### Other tips

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COATINGS

With low opacity colors, it may be necessary to apply a coat more after the appropriate flash off time. Use appropriate shade of Kapci 2K grey fillers before applying the basecoat.



Stir Kapcibase 670 basecoat color well.



It is always recommended to filter the basecoat before spraying.

### 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.