



Technical Data Sheet

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for professional use only

Kapcicryl 641 2K Acrylic Ready Mixed Topcoat

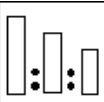

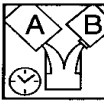


Product description

Kapcicryl 641 is a 2K acrylic ready mixed topcoat for repainting of passenger cars and commercial vehicles. Kapcicryl 641 delivers 2K acrylic-urethane direct gloss topcoats having high gloss, excellent durability and excellent coverage. In conjunction with a range of Kapci MS hardeners, Kapcicryl 641 2K topcoats can be used for any size of repair jobs.

Substrates

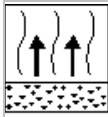
Kapcicryl 641 2K topcoats should be applied over properly prepared Kapci 2K fillers/2K primers, 1K sealers, 2K sealers, and old finishes in sound conditions. For sanding prior to applying Kapcicryl 641, use paper grit P400 dry or P800 wet. Degrease the surface with Kapci 605 Degreaser before the application of the 2K topcoat color.

Application

	Mixing ratio by Volume: <table border="1"><tr><th>Kapci 641 2K acrylic Ready Mixed</th><th>Kapci MS Hardeners</th><th>Kapci 2K Thinners:</th></tr><tr><td>100%</td><td>50%</td><td>30%</td></tr><tr><td></td><td>653 Extra Fast, 652 Fast 651 Normal 656 Slow</td><td>600F Fast, 600 Normal, 601 Slow 602 Extra Slow</td></tr></table>	Kapci 641 2K acrylic Ready Mixed	Kapci MS Hardeners	Kapci 2K Thinners:	100%	50%	30%		653 Extra Fast, 652 Fast 651 Normal 656 Slow	600F Fast, 600 Normal, 601 Slow 602 Extra Slow							
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	Application viscosity: 16-18 s (DIN4/20°C)																
	Pot life: 4 h at 20°C																
	Spray gun tips: <table border="1"><thead><tr><th></th><th>Spray Nozzle</th><th>Inlet pressure</th><th>Atomization pressure</th></tr></thead><tbody><tr><td>Compliant</td><td>1.2-1.3mm</td><td>2 bars (26- 29 psi)</td><td></td></tr><tr><td>HVLP</td><td>1.2-1.3mm</td><td>2 bars (26- 29 psi)</td><td>0.7bar (8-10 psi)</td></tr><tr><td>Conventional</td><td>1.2-1.3mm</td><td>3-3.5 bar (45-50 psi)</td><td></td></tr></tbody></table> <p>For best overall results, refer to the spray gun manufacturer's recommendation.</p>		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)	
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	Number of coats: Apply 2 normal coats (to get opacity). Recommended total dry film thickness is 40-50 microns.																



KAPCI
COATINGS



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 instruction for sets 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 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 at low temperature from 10°C-20°C. Also, it must not be mixed with Kapci 653 extra fast and Kapci 652 fast hardener. Kapci 6510 is added 1-5 mass% in the mixture of the topcoat and the hardener prior to adding the thinner. Note that addition of Kapci 6510 reduces the pot life to 2-3 hours.

Recoating

Kapci 641 is recoatable after the drying time.

Rectification and polishing

Kapci 641 2K acrylic topcoat does not require polishing as it offers excellent gloss. In case that some dirt has occurred, denib with P2000 or finer paper grit, 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.

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 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.