



**KAPCI**  
**COATINGS**

For professional use only

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05

# Kapci 641 Ready mixed 2K Acrylic top coats

## Product description

Kapcicryl 641 is 2K acrylic ready mixed topcoat paint for car refinishing. Kapcicryl 641 offers high accurate color matching, gloss, hard and durable finish with very good coverage. In conjunction with Kapci range of hardeners 653, 652,651 and 656 can be easily applied and it is suitable for any type of car repair work

## Suitable substrates

Kapcicryl 641 should be applied over Kapci fillers, wet-on-wet primers and existing paint work in sound condition.

Kapci 2K fillers must be properly sanded wet with paper P800 or finer or dry D/A machine sanding with P320 or finer and followed with P400.

On original OEM panels that have been coated with original primer, it is recommended to apply Kapci 2K filler prior to topcoating.

All work prior to application must be thoroughly 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

<b>Product</b>	Kapci 641 Ready mixed 2K Acrylic top coats																				
<b>Hardeners</b>	653 Extra fast, 652 Fast, 651 Normal, 656 Slow																				
<b>Thinners</b>	600F Fast, 600 Normal, 601 Slow, 602 Very slow																				
	2:1:30% Use ruler Kapci No°1																				
	16-18 sec (DIN4 at 20°C)																				
	Pot life at 20°C: 4 h																				
	<b>Fluid tip</b> 1.3-1.4 mm Pressure: 3.0-3.5 bar (45-50 psi inlet) Refer to manufacturer's recommendation.																				
	<b>Fluid tip</b> 1.3-1.4 mm Pressure: 2.0 bar (30 psi inlet) Refer to manufacturer's recommendation.																				
	Apply 2 single coats (to get opacity) Recommended dry film thickness is 40-50 microns (depending on colors);																				
	Flash off: 5-10 minutes between coats. Allow drying 15 minutes prior to baking.																				
	<b>Air dry at 20°C</b> <table border="1"> <thead> <tr> <th>Hardener</th> <th>653</th> <th>652</th> <th>651</th> <th>656</th> </tr> </thead> <tbody> <tr> <td>Dust free:</td> <td>15 min</td> <td>15 min</td> <td>20 min</td> <td>25 min</td> </tr> <tr> <td>Tack free:</td> <td>1.5 h</td> <td>2 h</td> <td>3 h</td> <td>5 h</td> </tr> <tr> <td>Hard dry:</td> <td>4.5 h</td> <td>7 h</td> <td>12 h</td> <td>16 h</td> </tr> </tbody> </table>	Hardener	653	652	651	656	Dust free:	15 min	15 min	20 min	25 min	Tack free:	1.5 h	2 h	3 h	5 h	Hard dry:	4.5 h	7 h	12 h	16 h
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	<b>Bake at a metal temperature of 60°C</b> <table border="1"> <thead> <tr> <th>Hardener</th> <th>653</th> <th>652</th> <th>651</th> <th>656</th> </tr> </thead> <tbody> <tr> <td>Hard dry:</td> <td>15 min</td> <td>25 min</td> <td>30 min</td> <td>45 min</td> </tr> </tbody> </table> <p>* Baking times are for quoted metal temperature.</p>	Hardener	653	652	651	656	Hard dry:	15 min	25 min	30 min	45 min										
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	Short wave: 8-10 min Medium wave: 12-14 min																				

## General process notes

### Choice of hardener

Kapci offers a range of hardeners to meet every type and size of car refinish under all conditions.

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

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

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

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

### Use of accelerator 6510

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

Kapcicyl 641 paints are recoatable after hard dry time.

### Rectification and polishing

Polishing is not required. Nevertheless, in a case that some dirt has occurred, denib with P1200 or finer and polish by hand or machine. Polishing is easiest up to 24h after hard dry time.

### Painting plastic

For painting plastic see TDS "Painting plastic substrates".

### 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.**