



**KAPCI**  
COATINGS

For professional use only

Issue: June 2018  
Superseded: May 2015

## Kapci 3100 2K MS Clearcoat

### Product description

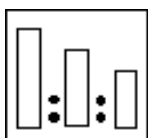
Kapci 3100 is a 2K medium solids acrylic clearcoat especially formulated for applying over solvent-based basecoats. It gives high gloss and “water like” final appearance. It offers high durability and weathering resistance. When used in conjunction with Kapci MS hardeners 651 Normal, 652 Fast, 653 Extra Fast or 656 Slow, Kapci 3100 delivers high gloss and excellent finish.

### Substrates

Kapci 3100 clearcoat should be applied over Kapcibase and Laticobase solvent-based basecoats and properly prepared paint work in solid conditions.

Existing job should be properly sanded and degreased prior to applying the basecoat. For cleaning and degreasing of the surface, it is recommended to use Kapci Degreaser 605

### Application



#### Mixing ratio:

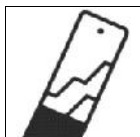
100:50:30  
(2:1:0.6)

100% Kapci 3100 2K MS Clearcoat

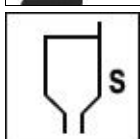
50% Kapci MS Hardeners: 653 Extra Fast, 652 Fast, 651 Normal or 656 Slow

30% Kapci 2K Thinners: 600F Fast, 600 Normal, 601 Slow or 602 Extra Slow

Note: Select appropriate thinner and hardener according to ambient temperature, air movement, and size of the surface to be clearcoated.



Use mixing ruler



#### Application viscosity:

15-18 s (DIN4/20°C)

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

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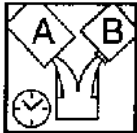


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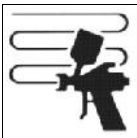
**Pot life:**  
4 h at 20°C



**Spray gun tips:**

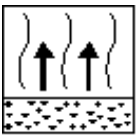
Compliant: 1.2-1.3 mm; Air pressure: 2 bar (26-29 psi) at the air inlet  
HVLP: 1.2-1.3 mm; Air pressure: 0.6-0.7 bar (8-10 psi) at the tip  
Conventional: 1.2-1.3 mm; Air pressure: 3.0-3.5 bar (45-50 psi) inlet

For best overall results, refer to the spray gun manufacturer's recommendation



**Number of coats:**

Apply 2 normal coats.  
Total dry film thickness 50-60 microns.



**Flash off time:**

5-10 min/20°C between coats  
20 min/20°C before baking



**Drying time:**

16 h/20°C  
30 min/60°C



**IR Drying:**

Short wave\*: 10-15 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.



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***Use of accelerator 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 4-9 mass % prior to the addition of the thinner. The addition of Kapci 6510 will reduce pot life to 2-3 hours.

Note: Kapci 6510 Accelerator must not be mixed with extra fast and fast drying hardeners and is recommended for the temperature range 10°C-20°C.

***Rectification and polishing***

Kapci 3100 clearcoat does not require polishing as it offers excellent gloss. In case that some dirt has occurred, denib with P2000 or finer and polish by machine using Kapci K40 Polish Compound.

***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.

**VOC (2004/42/EC)**

2004/42/IIB(e)(840)560

The EU limit value for this product (product category: IIB.e) in ready for use form is maximum 840 g/l of VOC.

The VOC content of this product in ready for use form is maximum 560 g/l.

**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.

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