



**KAPCI**  
COATINGS

For professional use only

Issue: June 2015  
Superseded: March 2015

## Kapci 880 2K Epoxy Primer

### Product description

Kapci 880 is a 2K epoxy primer with excellent anticorrosion properties, outstanding chemical resistance and good adhesion over steel, stainless steel, galvanized steel, and aluminum. Kapci 880 can be recoated with 2K fillers, 2K topcoats, and basecoats.

### Substrates

Kapci 880 2K Epoxy Primer can be applied over different substrates such as steel, galvanized steel and aluminum. To reach optimum performance, surface should be properly cleaned and degreased.

### Preparation

*Steel:* For maximum durability steel should be prepared by blast cleaning/sanding. Alternatively, sand using P80-P180 sanding machine discs. Thoroughly degrease with Kapci 606 degreaser.

*Galvanized still/weathered:* Degrease the surface with Kapci 606 degreaser and sand using P180-320 sanding machine discs. Repeat the degreasing step after sanding.

*Galvanized still/hot dipped:* Degrease the surface with Kapci 606 degreaser and sand using P320 or finer sanding machine discs. Repeat the degreasing step after sanding.

*Stainless steel:* Degrease with Kapci 606 degreaser and sand with P180-P240 sanding machine discs. Repeat the degreasing step after sanding.

*Aluminium:* Light sand using P240-P320 sanding machine discs. Degrease the surface after sanding.

*GRP/Fiberglass:* Light sand using P240-P320 sanding machine discs. Degrease the surface after sanding.

*Old finishes (2K) in good conditions:* Light sand with P320-P400 sanding machine discs. Repeat the degreasing step after sanding.

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

Rev (01) 06/2015



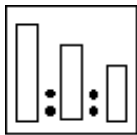
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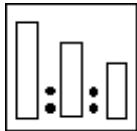
## Application



**Mixing ratio by volume:**  
100:50:30

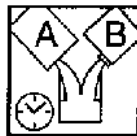
Note: Use mixing ruler

100% Kapci 880 2K Epoxy Primer;  
50% Kapci 881 Epoxy Hardener;  
30% Kapci 885 Epoxy thinner or Kapci 886 Epoxy Fast thinner.  
For airless spraying add cca.10% Kapci Epoxy thinner.

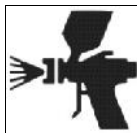


**Mixing ratio by weight:**  
100:30:30

100% Kapci 880 2K Epoxy Primer;  
30% Kapci 881 Epoxy Hardener;  
30% Kapci 885 Epoxy thinner or Kapci 886 Epoxy Fast thinner.  
For airless spraying add cca. 10% Kapci Epoxy thinner.



**Pot life at 20°C:**  
6 h



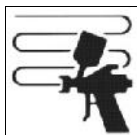
**Spraygun tips:**  
1.7-1.8 mm  
Conventional:  
3.0-3.5 bar/45-50 psi inlet  
HVLP: 2 bar/30 psi inlet

Refer to the spraygun manufacturer's recommendation.



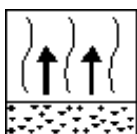
**Pressure pot:**  
1.0-1.4mm  
**Airless:**  
0.28-0.38 mm  
Approx. 100-200 bar (1500-3000 psi)

Refer to the spraying equipment manufacturer's recommendation.



**Number of coats:**  
Apply 2 coats

Total dry film thickness 50-70 microns.  
For optimum protection of steel the minimum DFT should be 50 microns.



**Flash off time:**  
Approximately 10-15 min/20°C between coats.  
Approximately 15-20 min/20°C before baking.

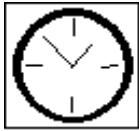


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**Drying time at 20°C:** 16 h

**Baking at 60°C:** 1 h

**Dry to recoat:** for wet-on-wet, after minimum 3 hours up to 24 hours. For prolonged time (more than 24 hours), the surface must be sanded before recoating.



**Machine dry sanding:** P240 or finer sanding paper

### General notes

#### ***Degreasing***

Kapci 606 Degreaser is recommended. However, in case of a lack of Kapci 606, Kapci 605 Degreaser can be helpful as well.



- Saturate a clean cloth with Kapci 606 Degreaser;
- Apply to areas to be painted and adjacent panels;
- Wipe off surplus degreaser with a clean dry cloth; do not allow the degreaser to dry on the surface.

#### ***Recoatable***

Kapci 880 is recoatable after minimum 3 hours for wet on wet application.

For optimum performance allow drying over night. Temperatures below 15°C and high humidity adversely affect the product performance.

#### ***Drying time***

The quoted drying times will vary on film thickness and drying conditions.

The drying times will be extended by poor air movement or excessive film thickness.

Temperatures below 15°C and high relative humidity adversely affect drying time.

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

2004/42/IIB(b)(540)324

The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 540 g/l of VOC.

The VOC content of this product in ready for use form is maximum 324 g/l.



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### **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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