



KAPCI
COATINGS

For professional use only

Issue: June 2018
Superseded: May 2017

Kapcibase 640 Ready Mixed Basecoat

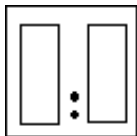
Product description

Kapcibase 640 is solvent-based ready mixed basecoat for repainting of passenger cars and commercial vehicles. Kapcibase 640 offers ready mixed solid color, metallic, pearlescent, and special effect basecoats. When used in conjunction with a Kapci range of clearcoats, Kapcibase 640 ready mixed colors deliver a durable and high gloss finish.

Substrates

Kapcibase 640 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 640, 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

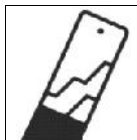


Mixing ratio:

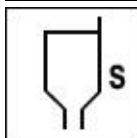
100:100
(1:1)

100% Kapcibase 640
100% Kapci 2K thinners: 610 Metallic, 600 Normal,
600F Fast, or 601 Slow

Note: Do NOT use Kapci 602 Extra Slow thinner!



Use mixing ruler



Application viscosity:

16-18 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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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) at the air inlet
For best overall results, refer to the spray gun manufacturer's recommendation.



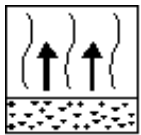
Number of coats:

Metallic, pearlescent, and special effect basecoat color

Apply 2 normal coats (to get opacity) plus a mist coat to even metallic appearance. Recommended total dry film thickness is 15-20 microns, depending on the shade to get opacity.

Solid basecoat color

Apply 2 normal coats (to get opacity). Recommended total dry film thickness is 15-20 microns, depending on the shade to get opacity.



Flash off time:

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



Overcoating:

Apply Kapci 2K clearcoat

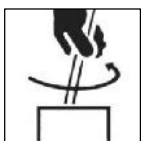
General notes

Rectification

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

Other tips

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 640 basecoat color well.

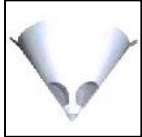


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It is always recommended to filter the basecoat before spraying.

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.

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.

Rev (03) 06/2018