



KAPCI
COATINGS

For professional use only

Issue: December 2018

North America

Kapcibase 670 Basecoat

Low VOC Basecoat

Product description

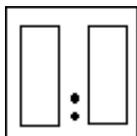
Kapcibase 670 is a solvent-based basecoat color for repainting of passenger cars and commercial vehicles. Kapci 670 is a Low VOC basecoat which may be used in Low VOC jurisdictions.

Kapcibase 670 includes solid, metallic, pearlescent and special effect basecoat colors. The basecoat is featured with ease of use and is fast drying having very good coverage. When used in conjunction with a range of Kapci 2K clearcoats, Kapcibase 670 delivers a long-lasting finish.

Substrates

Kapcibase 670 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 670, 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

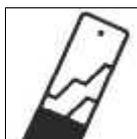


Mixing ratio:

100:100
(1:1)

Low VOC Compliance

100% Kapcibase 670
100% Kapci 8324 ZERO VOC Reducer Standard



Use mixing ruler

This product is for the professional painting of automotive vehicles only after reference to the manufacturer's Material Safety Data Sheets (MSDS). If used as instructed, this product complies with VOC standards in low VOC jurisdictions.

Rev (01) 12/2018

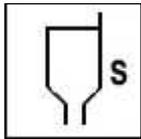


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Application viscosity:
16-18 s (DIN4/20°C)



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



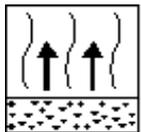
Number of coats:

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

Application of three-stage basecoat colors

This application requires 3 steps - spraying of a ground, solid basecoat color as a first step; spraying of transparent layers of a special effect pigments basecoat color in second step, and spraying of a clearcoat in third step.

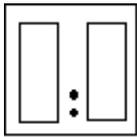


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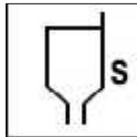


Mixing ratio:
100:100
(1:1)

Low VOC Compliance
100% Kapcibase 670
100% Kapci 8324 ZERO VOC Reducer Standard



Use measuring stick



Application viscosity:
16-18 s (DIN4/20°C)



Spray gun tips:

Compliant: 1.2-1.3 mm; Air pressure: 2 bar (26-29 psi) at the air inlet
HVL P: 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.



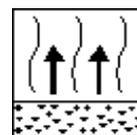
Number of coats:

Ground (Solid) basecoat color

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

Metallic, Pearlescent, and Special Effect basecoat color

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



Flash off time:

Between coats: 3-4 min

Before applying clearcoat: 20 min



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Overcoating:

Apply Kapci 2K clearcoat

General notes

Color checking

Color checking is required before painting of a vehicle with all refinish systems.



1. Prior to checking, look up the motor manufacturer color code and color name in the Kapci Color Boxes and refer to Kapci ColorMix Software or Kapci SC Software to find the color formulation.

2. Prepare test panels. Apply the basecoat to the test panels to give opacity. The basecoat is normally applied in 2 coats (for metallics apply a mist coat as per given the application procedure), but some colors may require more coats. After recommended flash off time, apply Kapci 2K clearcoat and identify the color which most accurately matches with the vehicle.

3. For a three-stage basecoat color, use at least two test panels and first apply a ground basecoat color. Then apply a pearlescent/special effect pigment basecoat color over the test panels to identify the number of coats required to achieve the most accurate color. Apply 2 coats over the first panel, 3 coats over the second test panel, etc. After required flash off time, apply Kapci 2K clearcoat to compare which of the test panel colors match the best with the vehicle.

Important notes:

-) Pearlescent and special effect pigment basecoat colors are transparent.
-) 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.
-) Maximum dry film thickness for a three-stage color for 4 coats (excluding a clearcoat) is around 40 microns.

Rectification

Rev (01) 12/2018



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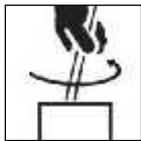
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Visible defects can be removed only after the basecoat is fully dry by light manual sanding with paper grit P1500 or finer. For smoother sanding, the sanding paper can be slightly soaked with water.

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 670 basecoat color well.



It is always recommended to filter the basecoat before spraying.

VOC Regulated Area (Low VOC 3.5 lb/gal)

The VOC value for this product in ready to spray form (RTS) when mixed with Kapci 8324 ZERO VOC thinner, is less than 3.5 lb/gal (420 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.



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IMPORTANT NOTE: This product is 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.