



**KAPCI**  
COATINGS

For professional use only

Issue: February 2016  
Superseded: June 2015

## Kapci 6050 2K HS Anti-Scratch Clearcoat VOC Compliant

### Product description

Kapci 6050 is a high solids anti-scratch clearcoat especially designed for application over waterborne basecoats. It offers scratch resistant, a high durable and gloss finish. Kapci 6050 gives optimal performance and final finish when baked.

Kapci 6050 HS Anti-Scratch Clearcoat complies with the 420g/l VOC limit in accordance to the EU legislation.

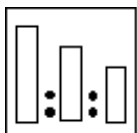
### Substrates

Kapci 6050 HS anti-scratch clearcoat should be applied over Dima 9670 waterborne basecoat, Kapcibase 670 solvent-based basecoat, and properly prepared original paint work in sound conditions.

Existing job should be properly sanded and degreased.

For cleaning and degreasing the surface prior to applying the waterborne basecoat, it is recommended to use Dima Degreaser 9605.

### Application



#### Mixing ratio:

100:50:5-10  
(2:1:0.1-0.2)

100% Kapci 6050 HS Anti-Scratch Clearcoat  
50% Kapci HS Hardeners: 6054 Fast, 6055 Normal or 6056 Slow  
5-10% Kapci 2K Thinners: 600F Fast, 600 Normal, 601 Slow or 602 Extra Slow

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

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

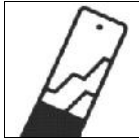
Rev (02) 02/2016



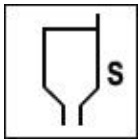
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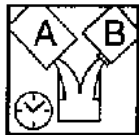
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Use mixing ruler



**Application viscosity:**  
19-21 s (DIN4/20°C)



**Pot life:**  
2 h at 20°C



**Spraygun tips:**

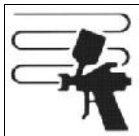
1.4 mm

Conventional:

3.0-3.5 bar/45-50 psi inlet

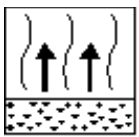
HVLP: 2 bar/30 psi inlet

Refer to the spraygun manufacturer's recommendation.



**Number of coats:**

Apply 1 light and 1 normal coat. Total dry film thickness 60-70 microns.



**Flash off time:**

3-10 min/20°C between coats (depending on used hardener and thinner)

15-20 min/20°C before baking



**Drying time:**

8-10 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 Kapci HS Hardeners and 2K thinners*



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Kapci offers a range of HS hardeners and thinners to adjust the viscosity of Kapci 2K products under all temperature conditions and different size of repairs.

The recommendations below are for guidance only:

Kapci 6054 HS Fast hardener is suitable for spit repair and a panel repair, i.e. for small size repairs at temperatures up to 20°C.

Kapci 6055 HS Normal hardener is suitable for large areas, i.e. for all repairs at temperatures between 20°C and 25°C.

Kapci 6056 HS Slow hardener should be used when temperature exceeds 30°C.

Kapci 600F Fast thinner is recommended for temperatures up to 20°C and small size of repair.

Kapci 600 Normal thinner is used for all repairs at temperatures up to 25°C.

Kapci 601 Slow thinner can be used for all size repairs at temperatures up to 35°C.

Kapci 602 Extra slow thinner should be used when temperature exceeds 35°C.

Generally, use a slower thinner in fast air movement booths, for large repairs, and for high temperature application. Use a faster thinner in slow air movement booths, for small repairs and applications at lower temperatures.

### ***Rectification and polishing***

Kapci 6050 HS Anti-Scratch clearcoat does not require polishing as it offers very good gloss. In a case that some dirt has occurred, denib with P1500 or finer and polish by machine using a high quality polish. Polishing is easiest up to 24 h after the drying time.

### ***Other tips***

1. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C. This is particularly important for high solid systems.
2. To reach optimum performances of high solids clearcoats, baking is recommended.
3. Clean the spraygun thoroughly immediately after use of 2K products.

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

2004/42/IIB(d)(420)418

The EU limit value for this product (product category: IIB.d) in ready for use form is maximum 420 g/liter of VOC.

The VOC content of this product in ready for use form is maximum 418 g/liter.



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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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