



**KAPCI**  
COATINGS

For professional use only

Issue: March 2015

Superseded: July 2010

## Kapcibase 670 Basecoat Mixing System

### Product description

Kapcibase 670 is a solvent-based basecoat mixing system for repainting of passenger cars and commercial vehicles. Kapcibase 670 offers solid color basecoats, metallic basecoats, pearlescent and special effect basecoats. When used in conjunction with a Kapci range of clearcoats, Kapcibase 670 basecoat colors deliver a durable, high gloss and excellent final finish.

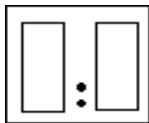
### Substrates

Kapcibase 670 basecoat colors should be applied over properly prepared Kapci 2K fillers/primers, 2K Sealers, and old finishes in sound conditions. For final sanding use sanding paper P500 dry or P1000 wet prior to applying Kapcibase 670 basecoat colors.

Existing job should be properly sanded and degreased.

For cleaning and degreasing the surface prior to applying the basecoat color, it is recommended to use Kapci 605 Degreaser.

### Two-stage application of basecoat colors

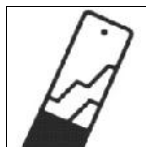


**Mixing ratio:**

100:100  
(1:1)

100% Kapcibase 670 basecoat color  
100% Kapci 2K thinners: 610 Metallic, 600 Normal, 600F Fast or 601 Slow

Note: Do NOT use Kapci 602 Extra Slow thinner!



Use measuring stick

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

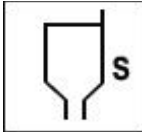


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**Application viscosity:**

16-18 s (DIN4/20°C)



**Spraygun tips:**

1.2-1.3 mm

HVLP: 1.8-2 bar/27-30 psi  
at the air inlet

Refer to the spraygun manufacturer's  
recommendation.



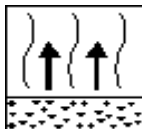
**Number of coats:**

*Metallic, pearlescent, and special effect pigment basecoat colors*

Apply 2 normal coats (to get opacity) plus 1 mist coat to even metallic appearance for metallic basecoat colors. Recommended total dry film thickness is 15-20 microns, depending on the shade to get opacity.

*Solid basecoat colors*

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 clearcoating: 10-15 min

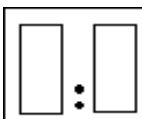


**Clearcoating:**

Apply Kapci 2K clearcoat

**Three-stage application of basecoat colors**

This application requires that in the first step is applied ground (solid or metallic) basecoat color, then pearlescent and special effect pigment basecoat colors, and as the final, third step clearcoat is applied.



**Mixing ratio:**

100:100

(1:1)

100% Kapcibase 670 basecoat color  
100% Kapci 2K thinners: 610 Metallic, 600  
Normal, 600F Fast or 601 Slow

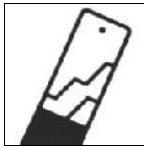
Note: Do NOT use Kapci 602 Extra Slow  
thinner!



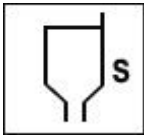
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Use measuring stick



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



Spraygun tips:  
1.2-1.3 mm  
HVLP: 1.8-2 bar/27-30 psi  
at the air inlet

Refer to the spraygun manufacturer's recommendation.



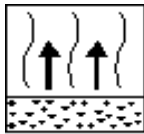
**Number of coats:**

*Ground (Solid or Metallic) basecoat colors*

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

*Pearlescent and special effect pigment basecoat colors*

Apply 2 normal coats. 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 clearcoating: 20 min



**Clearcoating:**

Apply Kapci 2K clearcoat



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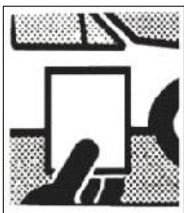
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### **General notes**

#### ***Color checking***

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



1. Prior to checking look up the motor manufacturer's color code and color name in the Kapci Color Boxes and refer to Kapci ColorMix to find the color formulation.
2. Prepare test panels. Apply Kapci basecoat to the test panels to give opacity. The basecoat is normally applied in 2 coats (for metallics apply one mist coat as per given the application procedure) but some colors require more coats. After recommended flash off time apply Kapci 2K clearcoat and identify the color which most accurately matches with the car.
3. For three-stage basecoat colors use at least two test panels and firstly apply ground basecoat color. Then apply pearlescent and special effect pigment basecoat color over the test panels to identify the number of coats required to achieve the most accurate color, e.g. apply 2 coats over the first panel, 3 coats to the second test panel, etc. After required flash off time apply Kapci 2K clearcoat to compare which the test panel color matches the car.

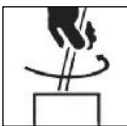
#### **Important Notes:**

- Pearlescent and special effect pigment basecoat colors are transparent hence they do not cover.
- 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 three-stage colors for 4 coats is approximately 40 microns.

#### ***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***



Stir Kapcibase 670 basecoat color well in order to ensure the color accuracy.



It is always recommended to filter the basecoat before spraying.



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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.