



KAPCI
COATINGS

For professional use only

Issue: June 2015
Superseded: March 2015

Kapci 625 2K Acrylic Filler

Product description

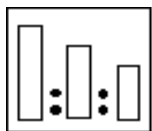
Kapci 625 is 2K acrylic filler especially developed for use under 2K acrylic paints and solvent-based basecoats. It delivers easy application and sanding and provides a good final finish.

Substrates

Kapci 625 filler can be applied over 2K PE putties, 2K Epoxy Primers, 2K Wash Primers, 1K Etch Primers, original OEM primers, glass fibre reinforced plastic (GRP) previously primed with Kapci 615 Plastic Primer, and over well sanded old finishes in a solid condition.

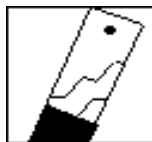
To reach optimum performances, the surface should be properly cleaned and degreased with Kapci 605 Degreaser.

Application



Mixing ratio:
100:25:25
(4:1:1)

100% Kapci 625 2K Acrylic Filler
25% Kapci 621 hardener
25% Kapci 2K Thinners: 600F Fast, 600 Normal, 601 Slow or 602 Extra Slow



Use mixing ruler



Application viscosity:
16-20 sec (DIN4 at 20°C)

This product is for the professional painting of automotive vehicles only after reference to the manufacturer's Material Safety Data Sheet (MSDS).

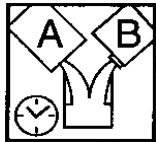


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Pot life:
4h at 20°C



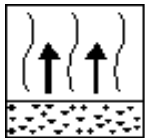
Spraygun tips:
1.7-1.8 mm
Conventional:
3.0-3.5 bar (45-50 psi inlet)
HVLP: 2 bar/30 psi inlet

Refer to the spraygun manufacturer's recommendations.

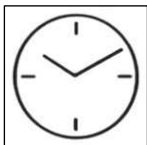


Number of coats:
Apply 2 normal coats.

Total dry film thickness 80-100 microns.



Flash off time:
Between coats: 5-7 minutes at 20°C
Before baking: 20 min at 20°C



Drying time:
3.5-4 h at 20°C
30 min at 60°C



IR Drying:
Short wave*: 10-15 min
*Guideline for IR equipment.

Refer to the IR equipment manufacturer's instructions for sets-up.



Machine dry sanding:
P320-P400/P500



Manual wet sanding:
P800 or P1000



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General notes

Recoating

Kapci 625 is recoatable after sanding. It can be recoated with 2K Acrylic topcoats and basecoat colors.

Other tips

1. For optimum application ensure that both spray booth temperature and paint temperature are between 20°C and 25°C.
2. Clean the spraygun thoroughly immediately after the use of 2K products.

Health and Safety

1. For full Health and Safety information 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.