



**KAPCI**  
COATINGS

**Technical Data Sheet**

Issue date January 2024

for professional use only

## Kapci 626 2K HS Fast Drying Filler - VOC Compliant

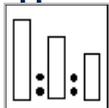
### Product description

Kapci 626 is fast drying 2K HS acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats. It delivers fast drying combined with good application, leveling and sanding properties as well as good colors hold out. Kapci 626 can also be used as non-sanding (wet on wet) filler by changing the mixing ratio and the application process.

### Substrates

Kapci 626 can be applied over 2K PE putties, 2K Epoxy Primers, 2K Wash primers, 1K Etch Primers, original factory primers, glass fibre reinforced plastic (GRP) and well sanded old finishes in solid condition. If it is used as non-sanding filler, Kapci 626 must not be applied over 2K PE Putties. To reach optimum performances, the surface should be properly sanded, cleaned, and degreased with Kapci 605 Degreaser.

### Application as sanding filler



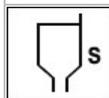
#### Mixing ratio by volume:

Kapci 626	MS Hardeners	Thinner
100%	20%	20%
	653 Extra Fast, 652 Fast 651 Normal	600F Fast, 600 Normal 601 Slow

(5:1:1)

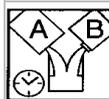
#### Mixing ratio by weight:

100:12:11



#### Application viscosity:

26-28 s (DIN4/20°C)



#### Pot life at 20°C:

4.5h

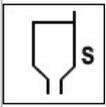
**IMPORTANT NOTE:** These TDS are for information purposes only without any obligation as we do not have control over the quality and conditions of the surface or application.



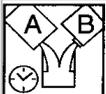
	<b>Spray gun tips:</b>												
	<table border="1"> <thead> <tr> <th></th> <th>Spray Nozzle</th> <th>Inlet pressure</th> <th>Atomization pressure</th> </tr> </thead> <tbody> <tr> <td>HVLP</td> <td>1.7-1.8 mm</td> <td>2 bars (26- 29 psi)</td> <td>0.7bar (8-10 psi)</td> </tr> <tr> <td>Conventional</td> <td>1.7-1.8 mm</td> <td>3-3.5 bar (45-50 psi)</td> <td></td> </tr> </tbody> </table>		Spray Nozzle	Inlet pressure	Atomization pressure	HVLP	1.7-1.8 mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)	Conventional	1.7-1.8 mm	3-3.5 bar (45-50 psi)	
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	Refer to the spray gun manufacturer's recommendation.												
	<b>Number of coats:</b> Apply normal 2 coats. Total dry film thickness 90-110 microns.												
	<b>Flash off time at 20°C:</b> Between coats: 3-5 min Before baking: 10-15 min Depending on film thickness and drying conditions.												
	<b>Drying time:</b> 45-90 min at 20°C 20-30 min at 60°C												
	<b>IR Drying:</b> Short wave*: 8-12 min *Guideline for IR equipment. Refer to the IR equipment manufacturer's instructions for sets-up.												
	<b>Machine dry sanding:</b> P320-P400/P500												
	<b>Manual wet sanding:</b> P800 or P1000												

### Application as non-sanding filler

	<b>Mixing ratio by volume:</b>	<b>Mixing ratio by weight:</b>									
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**Application viscosity:**  
15-18 s (DIN4/20°C)



**Pot life at 20°C:**  
4h



**Spray gun tips:**

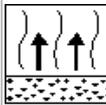
	Spray Nozzle	Inlet pressure	Atomization pressure
HVLP	1.4 mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.4 mm	3-3.5 bar (45-50 psi)	

Refer to the spray gun manufacturer's recommendation.



**Number of coats:**

Apply 1 coat  
Total dry film thickness 30-35 microns.



**Flash off time for wet-on-wet application (at 20°C):**

15-20 min

**Note:** The flash off time depends on used hardener, thinner, and drying conditions.

### Recoating

Kapci 626 is recoatable after sanding. It can be overcoated with Dima 9670 basecoats, Kapcibase 670 basecoats, and Kapcicyrl 660 2K acrylic topcoats. When applied as wet on wet filler, it can be overcoated after 15-20 minutes at 20°C with recommended Kapci hardeners and thinners.

### Choice of hardeners

Kapci offers a range of hardeners to meet every type and size of car repair under every application conditions.

The recommendations below are for guidance only:

Choice of hardener and thinner	Size of repair and temperature				
	Spot and partial repair		Whole car repair		
<b>Temperature</b>	Up to 20°C	Up to 25°C	Up to 30°C	More than 30°C	
<b>Hardener</b>	653	652	651	656	
<b>Thinner</b>	600F	600/600F	600	601 more than 30	602 more than 35



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### **Painting plastic**

When painting plastics, it is necessary to use Kapci 616 Adflex Flexible Additive for Plastic. Please refer to the technical data (TDS) for KAPCI 616 Adflex.

### **Other tips**

1. Do not apply Kapci 626 filler for spot repair over TPA (thermoplastic acrylic paint) and old 1K finishes. Apply to complete panels only.
2. For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C
3. Clean the spray gun thoroughly immediately after use of 2K products.

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

2004/42/IIB(c) (540)535

The EU limit value for this product (product category: IIB.c) in ready for use form is maximum 540 g/liter of VOC.

The VOC content of this product in ready for use form is maximum 535 g/liter.

### **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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