



KAPCI
COATINGS

For professional use only

Issue: August 2016

Kapci 625 2K Acrylic Filler

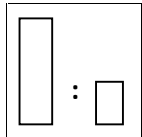
Product description

Kapci 625 is 2K acrylic filler especially developed for use under 2K topcoats and solvent-based basecoat colors. The product combines easy application and sanding with good color hold out of finishing.

Substrates

Kapci 625 filler can be applied over 2K PE putties, 2K Epoxy and 2K Wash Primers, 1K Etch Primers, OEM primers, GRP/Fiberglass, and properly prepared old paintwork. The surface should be clean and degreased prior to applying Kapci 625 filler. It is recommended to use Kapci 605 mild degreaser as a preparatory product for cleaning and degreasing.

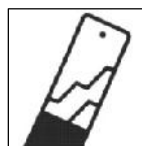
Application



Mixing ratio by volume:

100:25
(4:1)

100% Kapci 625 2K Acrylic Filler
25% Kapci 621 hardener

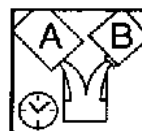


Use mixing ruler



Application viscosity:

20-25 sec (DIN4 at 20°C)



Pot life:
4h/20°C

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

Rev (01-EN) 08/2016



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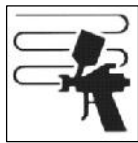
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Spraygun tips:

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

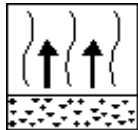
Refer to the spraygun manufacturer recommendation.



Number of coats:

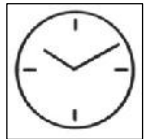
Apply 2 normal coats

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

Refer to the IR equipment manufacturer

*Guideline for IR equipment. instructions for sets-up.



Machine dry sanding:

P320-P400/P500



Manual wet sanding:

P800 or P1000

General notes

Recoating

Kapci 625 is recoatable after sanding. It can be overcoated with 2K topcoats and solvent-based 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.

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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, 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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