



KAPCI
COATINGS

For professional use only

Issue: October 2019

Kapci 634 2K HS High Build - Fast Drying Filler VOC Compliant

Product description

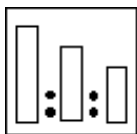
Kapci 634 is fast drying 2K HS acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats. It delivers fast drying combined with good application, leveling and sanding properties as well as good colors hold out.

Substrates

Kapci 634 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.

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

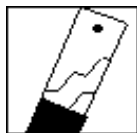
Application



Mixing ratio by volume:

100:25:10-20%
(4:1:10-20%)

100% Kapci 634 2K HS Fast Drying Filler;
25% Kapci 2K MS Hardeners: 653 Extra Fast, 652 Fast, 651 Normal or 656 Slow
10-20% Kapci 2K thinners: 608 Extra Fast Thinner for 634, 600F Fast Thinner, 600 Normal Thinner, 601 Slow Thinner or 602 Extra Slow Thinner



Use mixing ruler

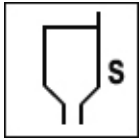
These products are for the professional painting of automotive vehicles only after reference to the manufacturer's Material Safety Data Sheets (MSDS)



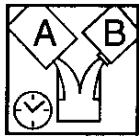
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Application viscosity:
40-45 s (DIN4/20°C)



Pot life at 20°C:
45 min



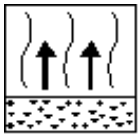
Spraygun tips:
1.7-1.8 mm
Conventional:
3.0-3.5 bar/45-50 psi inlet
HVLP: 2 bar/30 psi inlet

Refer to the spray gun manufacturer's recommendation.



Number of coats:
Apply normal 2 coats.

Total dry film thickness 120 -140 microns.



Flash off time at 20°C:
Between coats: 3-5 min
Before baking: 10-15 min

Depending on film thickness and drying conditions.



Drying time:
1h at 20°C
20 min at 60°C



IR Drying:
Short wave*: 8-12 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 634 is recoatable after sanding. It can be overcoated with Dima 9670 basecoats, Kapcibase 670 basecoats, and Kapcicryl 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:

Kapci 653 Extra Fast hardener is used for partial repair at temperature up to 20°C.

Kapci 652 Fast hardener is used for partial repair at temperature up to 25°C.

Kapci 651 Normal hardener is suitable for partial repair for temperatures up to 30°C.

Kapci 656 Slow hardener is recommended for partial repair when temperature is above 30°C.

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 634 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)500

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 500 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.



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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.