KAPCI COATINGS

Car Refinish System

Kapci 625 2K Acrylic Filler

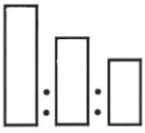
Product description

Kapci 625 is a 2K acrylic filler especially developed for use under Kapcicryl 2K acrylic topcoats and Kapcibase basecoat colors. It delivers easy application, easy sanding, good color hold out and finish.

Substrates

Kapci 625 filler can be applied over PE putties/body fillers, 2K Epoxy Primers, 2K Wash Primers, 1K Etch Primers, original OEM primers, GRP, and over well sanded old finishes in solid conditions. To reach optimum performance, the surface should be properly cleaned and degreased with Kapci 605 Degreaser.

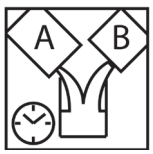
Application



Mixing ratio:
100:25:25
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

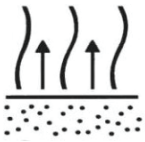
Application viscosity:
16-20 sec (DIN4 at 20°C)



Pot life:
4h at 20°C

Spray gun tips:
Compliant:1.7-1.8 mm; Air pressure: 2 bar (26-29 psi) at the air inlet
HVLP:1.7-1.8 mm; Air pressure: 0.6-0.7 bar (8-10 psi) at the tip
Conventional: 1.7-1.8 mm; Air pressure: 3.0-3.5 bar (45-50 psi) inlet
For best overall results, refer to the spray gun manufacturer's 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
*Guideline for IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

Machine dry sanding:
P320-P400/P500

Manual wet sanding:
P800 or P1000

General notes

Overcoating

Kapci 625 2K filler can be overcoated after sanding. It is overcoated with 2K topcoats Kapcicryl and Laticocryl, and with basecoat colors Kapcibase and Laticobase.

Choice of thinners

Kapci 600F Fast thinner is recommended for temperatures up to 20°C and small size of repair.
Kapci 600 Normal thinner is used for all size repairs at temperatures up to 28°C.
Kapci 601 Slow thinner can be used for all size repairs at temperatures up to 35°C. Kapci 602 Extra slow thinner should be used when temperature exceeds 35°C.
Generally, use a slower thinner in fast air movement booths, for large repairs, and for high temperature application. Use a faster thinner in slow air movement booths, for small repairs and applications at lower temperature. For detail information, please refer to the TDS "Kapci Thinners".

Painting plastic

When painting plastic, it is necessary to use Kapci 616 Adflex flexible additive for plastic. Please refer to the TDS "Kapci 616 Adflex Flexible Additive for Plastic".

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 spray gun thoroughly immediately after the use of 2K products.

Health and Safety

1. For full Health and Safety information, refer to the 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 fact ors 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.