



**Technical Data Sheet**

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for professional use only

## Kapci 630 2K HS Acrylic Filler - VOC Compliant

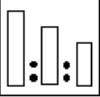

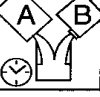

### Product description

Kapci 630 is a 2K high solids acrylic filler developed for use under solvent-based and waterborne basecoat colors and 2K topcoats. It provides easy application, easy sanding, and good color hold out and finish.

### Substrates


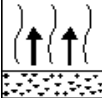




Kapci 630 filler can be applied over PE putties/body fillers, 2K Epoxy Primers, 2K Wash Primers, 1K Etch Primers, original OEM primers, GRP, and over well sanded old finishes in solid condition.

### Application

	<b>Mixing ratio by volume:</b>			<b>Mixing ratio by weight:</b> 100:19:17
	<b>Kapci 630</b> 100%	<b>Kapci 631</b> 30%	<b>Kapci 2K Thinners</b> 0-5% 600F Fast 600 Normal 601 Slow 602 Extra Slow Or 10% For VOC compliant	
100:30:0-5  (3:1:0-5%)				
	<b>Application viscosity:</b> 20-25 sec (DIN4 at 20°C)			
	<b>Pot life:</b> 4h at 20°C			
	<b>Spray gun tips:</b>			
		<b>Spray Nozzle</b>	<b>Inlet pressure</b>	<b>Atomization pressure</b>
	Compliant	1.7-1.8mm	2 bars (26- 29 psi)	
	HVLP	1.7-1.8mm	2 bars (26- 29 psi)	0.7bar (8-10 psi)
Conventional	1.7-1.8mm	3-3.5 bar (45-50 psi)		
For best overall results, refer to the spray gun manufacturer's recommendation.				



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COATINGS

	<b>Number of coats:</b> Apply 2 normal coats. Total dry film thickness 80-100 microns.
	<b>Flash off time:</b> Between coats: 5-10 minutes at 20°C Before baking: 20 min at 20°C
	<b>Drying time:</b> 4 h at 20°C 30 min at 60°C
	<b>IR Drying:</b> Short wave*: 10-15 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

### Overcoating

Kapci 630 can be overcoated after sanding. It is overcoated with 2K acrylic topcoats Kapcicryl and Laticocryl, and with Kapcibase, Kapci Dima and Laticobase basecoat colors.

### 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.

### VOC (2004/42/EC)

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

**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.



**KAPCI**  
COATINGS

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.