



**Technical Data Sheet**

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for professional use only

## 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.


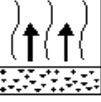




To reach optimum performances, the surface should be properly sanded, cleaned, and degreased with Kapci 605 Degreaser.

### Application

	<b>Mixing ratio by volume:</b>			<b>Mixing ratio by weight</b>  100:14:5-10
	Kapci 634 100%	MS Hardeners 25%	Thinner 10-20%	
		653 Extra Fast, 652 Fast 651 Normal 656 Slow	600F Fast, 608 Fast 600 Normal 601 Slow 602 Extra Slow	
	<b>Application viscosity:</b> 40-45 s (DIN4/20°C)			
	<b>Pot life at 20°C:</b> 45 min			
	<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)		
Refer to the spray gun manufacturer's recommendation.				



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	<b>Number of coats:</b> Apply normal 2 coats. Total dry film thickness 120 -140 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> 1h at 20°C 20 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

### 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:

Choice of hardener and thinner	Size of repair and temperature				
	Spot and partial repair		Whole car repair		
Temperature	Up to 20°C	Up to 25°C	Up to 30°C	More than 30°C	
Hardener	653	652	651	656	
Thinner	600F/608	600/600F	600	601 more than 30	602 more than 35

### 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.

**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.



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### **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.
3. Goggles and suitable protective equipment must be worn while using these products.
4. Good ventilation must be provided in the working environment.