



Technical Data Sheet

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for professional use only

Kapci 635 2K Acrylic Filler

Product description

Kapci 635 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.


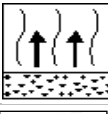




Substrates

Kapci 635 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 by volume:			Mixing ratio by Weight 100:14:13 For Non- VOC Complaint Or 100:14:6 For VOC compliant
	Kapci 635 100%	Kapci 621 25%	Kapci 2K Thinners 25% 600F Fast 600 Normal 601 Slow 602 Extra Slow Or 10% For VOC compliant	
	Application viscosity: 16-20 sec (DIN4 at 20°C)			
	Pot life: 4h at 20°C			
	Spray gun tips:			
		Spray Nozzle	Inlet pressure	Atomization pressure
	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.				



	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

Recoating

Kapci 635 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

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	600/600F	600	601 more than 30	602 more than 35

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



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COATINGS

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 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.