



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Prima 8350 2K HS High Build - Fast Drying Filler VOC Compliant

Product description

Prima 8350 is fast drying 2K HS acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats.

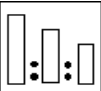

- It delivers fast drying combined with good application,
- Good leveling and sanding properties.
- Good colors hold out.

Substrates

Prima 8350 can be applied over

- 2K PE putties.
- 2K Epoxy Primers.
- 2K Wash primers.
- 1K Etch Primers.
- Original factory primers.
- Glass fibre reinforced plastic (GRP).
- Well sanded old finishes in solid condition.
- To reach optimum performances, the surface should be properly sanded, cleaned, and degreased with Prima 8080 Degreaser.

Application

	Mixing ratio by volume: 100:25:10-20% (4:1:10-20%)	100% Prima 8350 2K HS Fast Drying Filler. 25% Prima 2K MS Hardeners: 8500 - Extra Fast. Or 8530 - Fast. Or 8550 - Normal. Or 8570 - Slow. 10-20% Prima 2K thinners: 8420 - Normal. Or 8410 - Fast. Or 8430 - Slow.
	Use mixing ruler	

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



Pot life at 20°C:
45 min



Spray gun tips:

	Spray Nozzle	Spray Pressure	
HVLP	1.7-1.8	2 bars (26-29 psi)	Inlet pressure
Conventional	1.7-1.8	3-3.5 bar (45-50 psi)	Inlet pressure

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



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

General notes

Recoating

Prima 8350 is recoatable after sanding. It can be overcoated with Prima 8700 basecoat, Dima 9670 basecoats, Kapcibase 670 basecoats, and Kapcicryl 660 2K acrylic topcoats.

Choice of hardeners

The recommendations below to meet every application condition:

- Prima 8500 Extra Fast hardener is used for partial repair at temperature up to 20°C.
- Prima 8530 Fast hardener is used for partial repair at temperature up to 25°C.
- Prima 8550 Normal hardener is suitable for partial repair for temperatures up to 30°C.
- Prima 8570 Slow hardener is recommended for partial repair when temperature is above 30°C.

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Other tips

- Do not apply Prima 8350 filler for spot repair over TPA (thermoplastic acrylic paint) and old 1K finishes. Apply to complete panels only.
- For optimum application, ensure that both spray booth temperature and paint temperature are between 20°C and 25°C
- 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.