



**KAPCI**  
COATINGS

## Technical Data Sheet

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for professional use only

# Kapci 352 Rapid PE Putty

## Product description

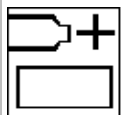
Kapci 352 is a general-purpose Rapid putty based on polyester resins. It provides the best foundation for all Kapci paint systems combining easy application, easy sanding and fast drying.

## Substrates

Kapci 352 Rapid PE putty can be applied over variety of substrates such as bare metal, galvanized original car panels, aluminium, glass fibre reinforced plastic (GRP), and properly sanded and prepared old finishes in sound conditions.

Prior to applying Kapci 352 Rapid PE putty the surface should be clean and degreased.

## Application



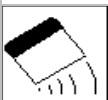
Mixing ratio by weight:

100:1-3

100% Kapci 352 PE Putty

1-3% Kapci PE Putty Hardener

Pot life (working time) of the mixture is 3-4min/ 20°C.



Application:

- Apply by a metal knife. (For edges or curve surfaces use a plastic knife).
- For deep filling, apply in several layers allowing drying between the layers (No sanding in-between is required).



Drying time at 20°C:

Dry to sand: 20 min

The drying time and pot life of a PE putty mixed with the putty hardener will considerably depend on temperature and the amount of the hardener used.

**"At lower temperature add 2-3 % of the hardener, at higher temperature add 1%."**



Machine dry sanding:

The following grades of sanding papers and steps are recommended:

P80-P120 and finish with P180



Manual dry sanding:

The following grades of sanding papers and steps are recommended:

P80-P120 and finish with P180



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IR Drying:

Short wave\*: 4-6 min

\*Guideline for short wave IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

### General notes

#### Recoatable

Kapci 352 is recoatable after sanding. For maximum durability apply Kapci 2K Epoxy primer over bare metal before applying Kapci 352 PE Putty.

#### Other tips

- Mix carefully PE Putty with the hardener to avoid forming of air bubbles in the mixture.
- For long-lasting anticorrosion protection over large surfaces, it is recommended to apply Kapci 2K Epoxy primer over bare metal surfaces before applying PE Putty.
- For small surfaces/damages, PE Putty can be applied over well sanded and degreased bare steel, aluminium, and galvanized steel (original OEM car panels). Use appropriate sanding papers for each surface.
- Do NOT apply PE Putty over 1K etch primers, 2K wash primers, and thermoplastic acrylic paints.
- PE Putty can be applied over 2K Epoxy primers and underneath of 1K Etch Primers and 2K Wash Primers.
- Add 1-3% of PE Putty hardener. Do NOT add less or more the hardener than recommended. The use of too much (more than 3%) or too little (less than 1%) of the hardener can cause a problem of bleaching/staining.
- Do NOT apply paints (2K topcoats, basecoats, etc.) directly over 2K PE putties.
- Do NOT sandwich PE putty between two layers of topcoats.
- Wet sanding of PE putties is NOT recommended.
- In colder conditions, the warming (infrared or oven) of panels can assist in curing prior to applying of 2K PE putties.
- After applying PE putties clean all used tools with strong solvents immediately (e.g., NC thinners).

#### VOC (2004/42/EC) 2004/42/IIB(b) (250)230

The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 250 g/liter of VOC.

The VOC content of this product in ready for use form is maximum 230 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.