



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Kapci 375 Lightweight Body Filler

Product description

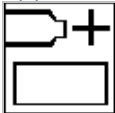
Kapci 375 is a lightweight low viscosity general purpose body filler based on polyester resins. Due to lower viscosity, Kapci 375 delivers very easy application, and easy sanding and compact surface as well.

Substrates

Kapci 375 Lightweight Body Filler can be applied over variety of substrates such as bare metal, galvanized original car panels, aluminum, glass fibre reinforced plastic (GRP), and properly sanded and prepared old finishes in sound conditions.

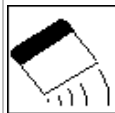
Prior to applying Kapci 375, the surface should be clean and degreased. For degreasing and cleaning of sanding dust, it is recommended to use Kapci 605 Degreaser.

Application



Mixing ratio by weight:
100:1-3

100% Kapci 375 Lightweight Body Filler
1-3% Kapci 3333 PE Hardener



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). Pot life (working time) of the mixture is 4-5 minutes at 20°C.



Drying time at 20°C:

Dry to sand: 20-30 min

The drying time and pot life will considerably depend on temperature and the amount of the hardener used.

At lower and normal 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*: 5-8 min

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

Recoatable

Kapci 375 is recoatable after sanding. For maximum durability, apply Kapci 2K Epoxy primer over bare metal before applying Kapci 375.

Other tips

- Mix carefully body filler with 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 body filler.
- For small surfaces/damages, body filler can be applied over well sanded and degreased bare steel, aluminum, and galvanized steel (original OEM car panels). Use appropriate sanding papers for each surface.
- Do NOT apply body filler over 1K etch primers, 2K wash primers, and thermoplastic acrylic paints.
- Body filler can be applied over 2K Epoxy primers and underneath of 1K Etch Primers and 2K Wash Primers.
- Add 1-3% of PE 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 body filler.
- Do NOT sandwich body filler between two layers of topcoats.
- Wet sanding of body filler is NOT recommended.
- In colder conditions, the warming (infrared or oven) of panels can assist in curing prior to applying of body filler.
- After applying body filler, 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.