



KAPCI
COATINGS

Technical Data Sheet

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for professional use only

Kapci 633 2K HS Acrylic Filler- VOC Compliant





Product description

Kapci 633 is a 2K high solids acrylic filler developed for use under waterborne basecoats, solvent-based basecoats, and 2K acrylic topcoats. It delivers easy application, very good leveling and sanding properties, and excellent color hold out and finish.

Substrates

Kapci 633 can be applied over PE putties/body fillers, 2K Epoxy Primers, 2K Wash primers, 1K Etch Primers, original factory primers, GRP, and well sanded old finishes in solid condition.

Application

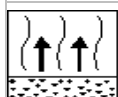
	Mixing ratio by volume:			Mixing ratio by weight 100:13:11
	(5:1:1)	Kapci 633 100%	MS Hardeners 20%	
		653 Extra Fast, 652 Fast 651 Normal 656 Slow	600F Fast, 600 Normal 601 Slow 602 Extra Slow	
	Application viscosity: 26-28 s (DIN4/20°C)			
	Pot life at 20°C: 4h			
	Spray gun tips:			
		Spray Nozzle	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.				



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Number of coats:
Apply normal 2 coats. Total dry film thickness 100-120 microns



Flash off time at 20°C:
Between coats: 5-10 min
Before baking: 20 min



Drying time:
3-4h 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 instructions for set up.



Machine dry sanding:
P320-P400/P500



Manual wet sanding:
P800 or P1000

General notes

Overcoating

Kapci 633 is recoatable after sanding. It can be overcoated with Dima 9670 waterborne basecoats, Kapcibase basecoats, and Kapcicryl 2K acrylic topcoats.

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



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Painting plastic

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 use of 2K products.

VOC (2004/42/EC)

2004/42/II B(c) (540)535

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 535 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.