

For professional use only

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## Kapci 633 2K HS Filler 5:1:1 Low VOC

### Product description

Kapci 633 is a high solids, low VOC flattable filler based on acrylic resins. It delivers good application properties, good leveling, fast drying, good sanding and very good color hold out.

### Suitable substrates

Kapci HS filler 633 can be applied over original factory primer, GRP/fiberglass previously primed with Kapci 615 plastic primer, steel, polyester putty, well sanded existing finishes in solid condition, after degreasing with Kapci Degreaser 605.




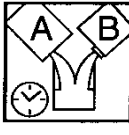



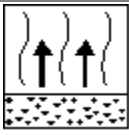

Kapci HS filler 633 can be applied over aluminium and galvanized metal after priming with Kapci 805 2K Wash Primer or Kapci 800 1K Etch Primer.




To reach optimum performance of Kapci paint systems over bare steel, Kapci 880 2K Epoxy Primer 880 should be applied first.

Not recommended for spot repair over thermoplastic acrylic and old 1K finishes. Apply to complete panels only.

*These products are for the professional painting of automotive vehicles only after reference to the manufacturer's Material Safety Data Sheets*

## Product process

Product	Kapci 633 2K HS Filler	
Hardeners	Extra fast 653/ Fast 652/ Normal 651/ Slow 656	
Thinners	600F Fast/600 Normal/601 Slow	
	Mixing ratio 5:1:1	Mixing ratio 5:1:0.5
	2K HS Filler 633     5	2K HS Filler 633     5
	MS Hardeners: 653/652/651/656     1	MS Hardeners: 653/652/651/656     1
	600F/600/601     1	600F/600/601     0.5
	Viscosity, DIN4/20°C: 26 s	Viscosity, DIN4/20°C: 40 s
	Pot life at 20°C: 4 h	Pot life at 20°C: 4.5 h
	Fluid tip 1.8 mm Pressure: 3.0-3.5 bar (45-50 psi inlet) Refer to manufacturers recommendations.	
	Fluid tip 1.8 mm Pressure: 2.0 bar (30 psi inlet) Refer to manufacturers recommendations.	
	Mixing ratio 5:1:1	Mixing ratio 5:1:0.5
	Apply 2 coats Dry film thickness 80-100 microns.	Apply 2 coats Dry film thickness 100-150 microns.
	Flash off time between coats 5-10 minutes, depending on film thickness and dry conditions.  20 minutes before baking.	
	Air dry at 20°C: 3.5-4 h, depending on film thickness Bake at a metal temperature of 60°C: 30 minutes	

Product	Kapci 633 2K HS Filler
Hardeners	Extra fast 653/ Fast 652/ Normal 651/ Slow 656
Thinners	600F Fast/600 Normal/601 Slow
	Short wave: 8-12 min
The above features are a guideline only and will depend on film thickness and drying conditions.	
	Wet flatting: Paper P800 or finer
	Machine sanding: P320-P400 for single layer coats (2K acrylic paints); P320-P500 for Basecoats;

## General process notes

### Recoat

Drying time will depend on film thickness, the hardener used and drying conditions. The longer drying time, the better final appearance is. Kapci HS filler 633 can be recoated with Kapci Dima 9670 Waterborne basecoat, Kapci 2K acrylic paints and Kapci basecoats.



### Choice of hardener

Extra fast hardener 653 is recommended for temperatures below 20°C and for small size of repair. Fast hardener 652 is used for medium sized repair and for temperatures up to 25°C. Normal hardener 651 is suitable for large areas, i.e. for all repairs at temperatures up to 30°C. Slow hardener 656 should be used when the temperature exceeds 35°C and for large surfaces.

### Painting plastics

Kapci HS Filler 633 can be applied over primed plastic. Addition of flexible additive Adflex 616 is necessary when painting flexible plastics. Adflex 616 is a plasticizing additive to enhance the flexibility of 2K fillers when used over flexible plastics.

Addition of Adflex 616 may adversely affect flatting and drying properties. For painting plastic use the next guidelines:

	Flexible plastic		Very flexible plastic	
	HS Filler 633	5 parts	HS Filler 633	3 parts
	Adflex 616	1 part	Adflex 616	1 part
	Then add hardener in the normal manner but without thinner.			

For more detailed information on the painting of plastics refer to the TDS "Painting plastic substrates".

### Tinting

Kapci 2K HS filler 633 can be tinted with maximum 5% of Kapcicryl 660 2K acrylic paints. Then into the mixture should be added hardener and thinner in the normal way.

Addition of Kapcicryl 660 may lead to deterioration of slower drying and flattening features.

NOTE: Do NOT add more than 5% of Kapcicryl 660.

### Other tips

1. For optimum application, ensure that both spray booth temperature and paint temperature is above 20°C.
2. Clean the gun thoroughly immediately after use 2K products.

### Health and Safety

1. For full Health and Safety information please refer to Material Safety Data Sheet;
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;

This information is the result of our knowledge but given without warranty.