



KAPCI
COATINGS

For professional use only

Issue: July 2018

Superseded: June 2015

Kapci 633 2K HS Acrylic Filler VOC Compliant

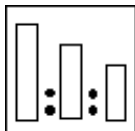
Product description

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.

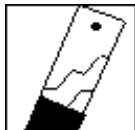
Application



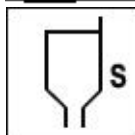
Mixing ratio by volume:

100:20:20
(5:1:1)

- 100% Kapci 633 2K HS Filler
- 20% Kapci 2K MS Hardeners: 653 Extra Fast, 652 Fast, 651 Normal or 656 Slow
- 20% Kapci 2K thinners: 600F Fast, 600 Normal, 601 Slow, or 602 Extra Slow

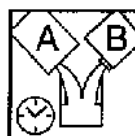


Use mixing ruler



Application viscosity:

26-28 s (DIN4/20°C)



Pot life at 20°C:

4h

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

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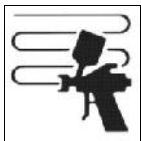
Spray gun tips:

Compliant: 1.7-1.8 mm; Air pressure: 2 bar (26-29 psi) at the air inlet

HVLP: 1.7-1.8 mm; Air pressure: 0.6-0.7 bar (8-10 psi) at the tip

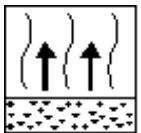
Conventional: 1.7-1.8 mm; Air pressure: 3.0-3.5 bar (45-50 psi) inlet

For best overall results, refer to the spray gun manufacturer's recommendation.



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:



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Kapci 653 Extra Fast hardener is used for small size of repair for temperatures from 15°C-18°C.

Kapci 652 Fast hardener is used for medium size repair for temperatures from 18°C-20°C.

Kapci 651 Normal hardener is suitable for large areas, i.e. for all repairs at temperatures up to 25°C.

Kapci 656 Slow hardener is recommended for large areas when temperature is above 25°C.

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/IIB(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.

IMPORTANT NOTE: These products are for professional use only. The information in this Technical Data Sheet is based on our best knowledge and given for information purposes only without any obligation as we do not have control over the quality and conditions of the surface, or over many factors affecting the use and application of the product. Always read the Material Safety Data Sheet and the Technical Data Sheet for this product if available.

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