



KAPCI
COATINGS

For professional use only

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Kapci 625 2K Filler 4:1:1

Product description

Kapci 625 is a flattable 2K acrylic filler developed for use under 2K acrylic paints Kapci 660/641 or Kapci 670 base coats. It is easy to apply and flat giving good final appearance.

Suitable substrates and preparations

Kapci 625 can be applied over original factory primers, 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.

Filler 625 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 should be applied first.

Not recommended for spot repair over thermoplastic acrylic and old 1K synthetic 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

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Kapci Car
Refinishes
System

Product Process

	Product	Kapci Filler 625
	Hardeners	Kapci 621
	Thinners	600F Fast/600 Normal/601 Slow
	Mixing ratio	4:1:1
		Use ruler No°4
		16-20 sec (DIN4 at 20°C)
		Pot Life,20°C: 4 hours
	Fluid tip	1.6 mm-1.8 mm Pressure: 3.0-3.5 bar (45-50 psi inlet) Refer to manufacturers recommendations.
	Fluid tip	1.6 mm-1.8 mm Pressure: 2.0 bar (30 psi inlet). Refer to manufacturers recommendations.
		Apply 2 coats to reach dry film thickness of 60-80 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
		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 and drying conditions. The longer drying time, the better final appearance. Filler Kapci 625 can be recoated with Kapci 2K acrylic or basecoat paints.

Painting plastics

Kapci filler 625 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 flattening and drying properties.

For painting plastic use the next guidelines:

	Flexible plastic		Very flexible plastic	
	Filler 625 Adflex 616	5 parts 1 part	Filler 625 Adflex 616	3 parts 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 filler 625 can be tinted with maximum 5% of Kapcicyl 660 2K acrylic paints. Then into the mixture should be added hardener and thinner in the normal way.

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

NOTE: Do NOT add more than 5% of Kapcicyl 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.