

**For professional
use only**

Kapci 625 2K Filler

**Issue date:
February 2009.**

Product description

Kapci 625 is a flattable 2K acrylic filler developed for use under 2K acrylic paints Kapci 660, Kapci 641 ready mix or with base coats Kapci 670. 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 2K Etch Primer 805 or Kapci 1K Etch Primer 800.




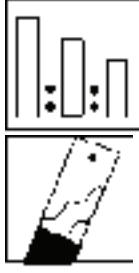





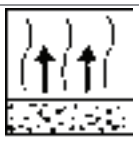

To reach optimum performance of Kapci paint systems over bare steel, Kapci Epoxy Primer 880 should first be applied.



Not recommended for spot repair over thermoplastic acrylic and old lacquer 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 Filler 625												
	Hardeners	Kapci 62 I												
	2K Thinners	600F, 600, 60 I												
	Mixing ratio	4:1:1												
	Viscosity, DIN 4/20°C	16-20 s												
	Pot Life, 20°C	4 hours												
	Fluid tip	Gravity or Suction feed: 1.6-1.8 mm Pressure: 3.0-3.5 bar/ 45-50 psi inlet												
	Fluid tip	Gravity or Suction feed: 1.6-1.8 mm Pressure: refer to manufacturers recommendation, normally 2 bar/30 psi inlet												
		Apply 2 coats to reach dry film thickness of 60-80 microns.												
		5-10 minutes between coats depending on film thickness and drying conditions; 20 minutes before baking;												
		<table border="1"> <tr> <td colspan="2">Drying time, Air dry/20°C</td> </tr> <tr> <td>3.5-4 hours;</td> <td>Depending on film thickness;</td> </tr> <tr> <td colspan="2">Drying time , Force dry/60°C metal temperature</td> </tr> <tr> <td colspan="2">30 min</td> </tr> <tr> <td colspan="2">Infra Red drying, short wave</td> </tr> <tr> <td colspan="2">8-12 min after 5 min flash</td> </tr> </table>	Drying time, Air dry/20°C		3.5-4 hours;	Depending on film thickness;	Drying time , Force dry/60°C metal temperature		30 min		Infra Red drying, short wave		8-12 min after 5 min flash	
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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, i.e. 2K acrylic paints; P320-P500 for Basecoat paints;
Recotability	When dry and sanded, filler 625 can be directly overcoated with Kapci 670 basecoat and Kapci 2K acrylic paints (series 660, ready mix series 641).

General process notes

Recoat

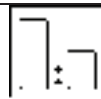

Drying time will depend on film thickness and drying conditions. The longer drying time, the better final appearance. Filler Kapci 625 can be recoated with Kapci 2K acrylic or basecoat paints.

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 flatting and drying properties.

For painting plastic use the next guidelines:

	Flexible plastic		Very flexible plastic	
	Filler 625	5 parts	Filler 625	3 parts
	Adflex 616	1 part	Adflex 616	1 part
	Then add hardener in the normal manner but without thinner.		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 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 flatting features.

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

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