KAPCI COATINGS

Technical Data Sheet

Issue date January 2024 **for professional use only**

Kapci 380 Aluminium PE Putty

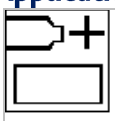
Product description

Kapci 380 is 2K polyester-based putty which contains fine aluminium flakes providing increased film thickness and resistance to vibrations. It can be used over bare steel, galvanized steel, aluminium and glass fibre reinforced plastic (GRP) for filling of irregularities and cavities.

Substrates

Kapci 380 Aluminum PE Putty can be applied over variety of substrates such as bare metal, galvanized original car panels, aluminium, glass fibre reinforced plastic (GRP), and properly sanded and prepared old finishes in sound conditions. Prior to applying Kapci 380 Aluminium PE Putty, the surface should be clean and degreased. For degreasing and cleaning of sanding dust it is recommended to use Kapci 605 Degreaser.

Application



Mixing ratio by weight:
100:1-3

100% Kapci 380 Aluminum PE Putty
1-3% Kapci PE Putty Hardener

Pot life (working time) of the mixture is 4-5 minutes at 20°C.

Application:
Apply by a metal knife. For edges or curve surfaces use a plastic knife.
For deep filling apply in several layers allowing drying between the layers (no sanding in-between is required).

Drying time at 20°C:
Dry to sand: 20-30 min
The drying time and pot life of PE Putty mixed with the putty hardener will considerably depend on temperature and the amount of the hardener used.
At lower temperature add 2-3 % of the hardener, at higher temperature add 1%.

Machine dry sanding:
The following grades of sanding papers and steps are recommended:
P80-P120 and finish with P180

Manual dry sanding:
The following grades of sanding papers and steps are recommended:
P80-P120 and finish with P180

IR Drying:
Short wave*: 5-8 min
*Guideline for short wave IR equipment. Refer to the IR equipment manufacturer's instruction for sets-up.

Recoatable

Kapci 380 is recoatable after sanding. For maximum durability apply Kapci 2K Epoxy primer over bare metal before applying Kapci 380 Aluminium PE Putty.

Other tips

- Mix carefully PE Putty with the hardener to avoid forming of air bubbles in the mixture.
- For long-lasting anticorrosion protection over large surfaces, it is recommended to apply Kapci 2K Epoxy primer over bare metal surfaces before applying PE Putty.
- For small surfaces/damages, PE Putty can be applied over well sanded and degreased bare steel, aluminium, and galvanized steel (original OEM car panels). Use appropriate sanding papers for each surface.
- Do NOT apply PE Putty over 1K etch primers, 2K wash primers, and thermoplastic acrylic paints.
- PE Putty can be applied over 2K Epoxy primers and underneath of 1K Etch Primers and 2K Wash Primers.
- Add 1-3% of PE Putty hardener. Do NOT add less or more the hardener than recommended. The use of too much (more than 3%) or too little (less than 1%) of the hardener can cause a problem of bleaching/staining.
- Do NOT apply paints (2K topcoats, basecoats, etc.) directly over PE putties.
- Do NOT sandwich PE Putty between two layers of topcoats.
- Wet sanding of PE putties is NOT recommended.
- In colder conditions, the warming (infrared or oven) of panels can assist in curing prior to applying of PE putties.
- After applying PE putties clean all used tools with strong solvents immediately (e.g. NC thinners).

VOC (2004/42/EC)

2004/42/IIB(b) (250)230

The EU limit value for this product (product category: IIB.b) in ready for use form is maximum 250 g/liter of VOC.
The VOC content of this product in ready for use form is maximum 230 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.