

Technical Data Sheet

Spectral UNDER 305-00

Epoxy filler



RELATED PRODUCTS









Spectral UNDER 305-00
Spectral UNDER 305-00
Spectral UNDER 305-00
Spectral H6305
Spectral SOLV 855
Spectral PLAST 775
Spectral PLAST 825

Epoxy filler white P1
Epoxy filler grey P3
Epoxy filler black P5
Hardener
Acrylic thinner: Standard
Elasticity increasing agent
Plastic adhesion increasing agent

PROPERTIES

- An epoxy filler for sanding and the final surface preparation before coating
- Excellent anti-corrosion resistance – can be applied DTM (directly to metal) and bare metal sanding locations
 - Very good insulating performance

SUBSTRATES				
Old coatings	Degrease and dry sand with P220 – P360.			
Polyester fillers	Dry sand for finishing levelling with P240 – P320.			
Steel	Degrease and dry sand with P120.			
Galvanised steel	Degrease, dry sand with P120, and degrease again.			
Aluminium	Degrease, dry sand with P280 – P360 or matt with abrasive cloth, and degrease again.			
OEM E-coated parts.	Degrease; no sanding required.			
Polyester laminates	Degrease and dry sand with P280.			
Plastics	See PL_SI_Coating of Plastics.			
GRADES OF GREY				
P1	P2	P3	P4	P5
P1: 100% P5: 0%	P1: 92% P5: 8%	P1: 75% P5: 25%	P1: 40% P5: 60%	P1: 0% P5: 100%
	P1: 78% P3: 22%		P3: 50% P5: 50%	
CAUTION: Mix the fillers or the additive at the recommended ratios (by weight or volume) before adding the hardener and the thinner.				
MIXING RATIO				
	Under 305-00 H 6305 SOLV 855	Volume ratio		Weight ratio
		4		100
		1		16
		0-0.4		0-6
NOTE: Application without a thinner is recommended. Do not exceed the maximum specified ratio of the SOLV 855 thinner.				
VISCOSITY				
	DIN 4/20°C	25-50 s		
VOC CONTENT				
VOC II/B/c limit*		540 g/l		
Actual VOC		500 g/l		
* For a ready for use mixture acc. to EU Directive 2004/42/CE				

APPLICATION CONDITIONS				
It is recommended to apply the filler above 10°C and 80% RH maximum.				
APPLICATION				
	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
		1.6-1.8 mm	Follow the tool manufacturer's guidelines	
	Number of layers	1-3		
	Single layer DFT	approx. 60 µm		
	Ready to use mixture yield for the specified dry film thickness range:	2.3 m ² /l at 180 µm		
	Flash-off time between layers at 20°C	10 min		
	Mixture life at 20°C	90 min		
CURING TIMES				
	20°C	60°C		
	6 h	20 min		
NOTE: The curing times are specified for 120 µm layer DFT and apply to the temperature of specific parts.				
COATABILITY				
Can be coated with all NOVOL topcoats.				
IR DRYING				
	Distance The time depends on the type and power of the lamp	Follow the recommendations of the equipment manufacturer. 15-20 min		
NOTE: Start IR heating no sooner than 10 minutes after applying the last layer.				
SANDING				
	Dry sanding	P360 - P500		
	Wet sanding	P600-1000		

Spectral PLAST 775 ELASTICITY INCREASING AGENT	
To increase the elasticity of the coating on plastic parts or to increase the gravel resistance of the coat (i.e. on the front fascia and the bonnet), add Spectral PLAST 775 at 10-20% of the ready-to-use mixture of Spectral UNDER 305-00 and the recommended hardener. Do not add any thinner.	
Spectral EXTRA 825 PLASTIC ADHESION INCREASING AGENT	
To increase the coating adhesion to plastic parts (especially if made of PP and its mixtures), add Spectral PLAST 825 at 30% (v/v) of Component A.	
EQUIPMENT CLEANING	
Epoxy thinner or NC solvent.	
STORAGE CONDITIONS	
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
Spectral UNDER 305-00	24 months/20°C
Spectral H 6305	24 months/20°C
SOLV 855	24 months/20°C
SAFETY	
See the Safety Data Sheet.	
OTHER INFORMATION	
Index number: 000024104.	
The effectiveness of our systems results from research in the laboratory and many years of experience. The data contained in this document reflects the current knowledge about our products and their application potential. We can ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship principles. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials. We cannot be held liable for defects if the final results are affected by factors beyond our control.	

ADDITIONAL INFORMATION			
4:1 mix of SPECTRAL UNDER 305-00; H6305 hardener			
COMPONENT QUANTITIES BY WEIGHT:			
CAUTION! It is very important to precisely dose the specific components to obtain a filler with suitable performance parameters.			
Mixture quantity	Spectral UNDER 305-00	Spectral H 6305	
0.10 L	109 g	18 g	
0.20 L	218 g	36 g	
0.30 L	326 g	54 g	
0.40 L	435 g	72 g	
0.50 L	544 g	90 g	
1.00 L	1088 g	180 g	
2.00 L	2176 g	360 g	
4:1+10% mix of SPECTRAL UNDER 305-00; H6305 hardener			
COMPONENT QUANTITIES BY WEIGHT:			
CAUTION! It is very important to precisely dose the specific components to obtain a filler with suitable performance parameters. Do not exceed the maximum specified ratio of the SOLV 855 thinner.			
Mixture quantity	Spectral UNDER 305-00	Spectral H 6305	Spectral SOLV 855
0.10 L	101 g	17 g	6.5 g
0.20 L	202 g	33 g	13 g
0.30 L	302 g	50 g	20 g
0.40 L	403 g	67 g	26 g
0.50 L	504 g	83 g	33 g
1.00 L	1007 g	167 g	66 g
2.00 L	2015 g	333 g	132 g

Example component amounts for the application of the Spectral PLAST 825 plastic adhesion increasing agent at 30 % (v/v) of Component A.			
4:1 mix of SPECTRAL UNDER 305-00; H6305 hardener			
Mixture quantity	Spectral UNDER 305-00	Spectral H 6305	Spectral PLAST 825
0.10 L	88 g	14 g	18 g
0.20 L	176 g	29 g	36 g
0.30 L	263 g	43 g	54 g
0.40 L	351 g	58 g	72 g
0.50 L	439 g	73 g	90 g
1.00 L	877 g	145 g	179 g
2.00 L	1755 g	290 g	359 g