

SPECTRAL

COLOR TECHNOLOGY

Technical data sheet

Spectral UNDER 325

Two-component acrylic filler

RELATED PRODUCTS

Spectral UNDER 325

Spectral UNDER 325

Spectral UNDER 325

Spectral H 6525

Spectral SOLV 855

Spectral PLAST 775

Spectral PLAST 825

P1 white acrylic filler

P3 grey acrylic filler

P5 black acrylic filler

Hardener: Standard, Fast



Standard, fast, slow and Extra Slow
acrylic thinners









Elasticity increasing agent

Plastic adhesion increasing agent

PROPERTIES

- Acrylic “wet on wet” primer with reduced volatile organic compounds (VOC) content
 - Superb flowability
 - Smooth surface
 - Fast drying
- Perfect adhesion to numerous substrates
 - Spectral shades of grey system

SUBSTRATES					
Old paint coatings, including thermoplastic paints	Degrease, dry sand P220 ÷ P360.				
Polyester putties	Dry sand, for final sanding P240 ÷ P320.				
Epoxy primers	Till 12 hours without sanding, after 12 hours sand dry P320.				
Steel	Degrease, dry sand P120.				
Wash primers	Apply after drying.				
Plastics	See instruction EN_SI_Painting of plastics.				
Polyester laminates	Degrease, dry sand P280.				
SHADES OF GREY					
P1	P2	P3	P4	P5	
P1: 100% P5: 0%	P1: 90% P5: 10%	P1: 70% P5: 30%	P1: 30% P5: 70%	P1: 0% P5: 100%	
	P1: 70% P3: 30%		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 325 H 6525 SOLV 855	Priming version		Wet on wet version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		3	100	3	100
		1	20	1	20
		0.9	15	1.2	21
VISCOSITY					
	DIN 4/20 °C	Priming version		Wet on wet version	
		24÷28 s		19÷23 s	
CONTENT OF VOLATILE ORGANIC COMPOUNDS					
VOC II/B/c limit *		540 g/l			
Actual VOC content, priming version		516 g/l			
Actual VOC content, wet on wet version		539 g/l			
* For ready to apply mixture compliant with Directive UE 2004/42/CE					
APPLICATION CONDITIONS					
The primer should be applied at a temperature above 15 °C and a humidity of no more than 80 %.					

APPLICATION							
		Priming version			Wet on wet version		
		Nozzle	Pressure	Distance	Nozzle	Pressure	Distance
	Conventional gravity fed spray gun	1.6 ÷ 1.8 mm	CAUTION: Instructions of the equipment manufacturer must be followed.		1.3 ÷ 1.4 mm	CAUTION: Instructions of the equipment manufacturer must be followed.	
	Number of layers	1÷2			1÷2 CAUTION: Apply the following system layers after no more than 3 hours. After 3 hours, Spectral UNDER 325 should be sanded.		
	Single dry layer thickness	Priming version			Wet on wet version		
		40÷60 µm			25÷35 µm		
Yield of the ready to apply mixture for a dry layer thickness in the provided range	8.2 m ² /l at 50 µm			13.0 m ² /l at 30 µm			
	Mixture life at 20 °C	60 min			90 min		
	Flash off between layers	10÷15 min			5÷10 min		
DRYING TIMES							
	20 °C			60 °C			
	3 hours			30 min			
CAUTION: Drying times apply to the temperatures of the individual elements.							
DRYING WITH AN INFRARED RADIATOR							
	Distance	Follow the recommendations of the equipment manufacturer.					
	Time depending on the type and power of the lamp	10 ÷ 20 min					
CAUTION: Use the radiator no sooner than 10 min. after applying the last layer.							
SANDING							
	Dry sanding	P360 ÷ P500					
	Wet sanding	P600 ÷ P1000					

RELATED PRODUCTS DEPENDING ON THE PROCESSING TEMPERATURE				
	15+18°C	18+25°C	25+35°C	+35°C
Spectral SOLV 855	Fast	Standard	Slow	Extra Slow
Spectral PLAST 775 ELASTICITY INCREASING AGENT				
To increase the paint coating's elasticity on plastic elements or to increase the coating's resistance to stone chipping (e.g. front strip, bonnet), add 10 – 30 % of Spectral PLAST 775 per ready to apply mixture (Spectral UNDER 325 with Spectral H 6525), correcting the amount of the thinner accordingly.				
Spectral PLAST 825 PLASTIC ADHESION INCREASING AGENT				
In order to increase the adhesion of the paint to plastic elements (especially made of PP and its mixtures), add Spectral PLAST 825 at 30% (by volume) of Component A.				
EQUIPMENT CLEANING				
Spectral SOLV 855 acrylic 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 325	24 months/20 °C			
Spectral H 6525 Standard	18 months/20 °C			
Spectral H 6525 Fast	12 months/20 °C			
Spectral SOLV 855	24 months/20 °C			
Spectral PLAST 775	24 months/20 °C			
Spectral PLAST 825	24 months/20 °C			
SAFETY				
See Safety Data Sheet.				
OTHER INFORMATIONS				
Registration number: 000024104.				
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.				

Spectral UNDER 325, PRIMING VERSION

COMPONENT QUANTITY BY WEIGHT:

CAUTION!

In order to obtain a primer with appropriate parameters it is very important do exactly dose the individual components.

Ready to use mixture amount	Spectral UNDER 325	Spectral H 6525	Spectral SOLV 855
0.10 l	104 g	20 g	16 g
0.20 l	208 g	40 g	32 g
0.30 l	311 g	61 g	49 g
0.40 l	415 g	81 g	65 g
0.50 l	519 g	101 g	81 g
0.75 l	779 g	152 g	122 g
1.00 l	1038 g	202 g	162 g
2.00 l	2076 g	404 g	324 g

Spectral UNDER 325, WET ON WET VERSION

COMPONENT QUANTITY BY WEIGHT:

Ready to use mixture amount	Spectral UNDER 325	Spectral H 6525	Spectral SOLV 855
0.10 l	98 g	19 g	20 g
0.20 l	196 g	38 g	41 g
0.30 l	293 g	57 g	61 g
0.40 l	391 g	76 g	81 g
0.50 l	489 g	95 g	102 g
0.75 l	734 g	143 g	152 g
1.00 l	978 g	190 g	203 g
2.00 l	1956 g	380 g	406 g

Example amounts of ingredients when using the Spectral PLAST 825 plastic adhesion increasing agent at 30% by volume per Component A.

Spectral UNDER 325, PRIMING VERSION

Ready to use mixture amount	Spectral UNDER 325	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	85 g	17 g	14 g	14 g
0.20 l	170 g	34 g	28 g	28 g
0.30 l	256 g	51 g	41 g	43 g
0.40 l	341 g	69 g	55 g	57 g
0.50 l	427 g	86 g	69 g	72 g
1.00 l	853 g	172 g	138 g	144 g

Spectral UNDER 325, WET ON WET VERSION

Ready to use mixture amount	Spectral UNDER 325	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	81 g	16 g	17 g	14 g
0.20 l	162 g	33 g	35 g	27 g
0.30 l	243 g	49 g	52 g	41 g
0.40 l	325 g	65 g	70 g	55 g
0.50 l	406 g	82 g	87 g	68 g
1.00 l	812 g	163 g	175 g	137 g