

Technical Data Sheet

Spectral UNDER 365-00

Acrylic filler

Spectral UNDER 365-00
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Spectral H 6525
Spectral SOLV 855


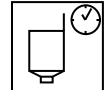
Spectral PLAST 775
Spectral PLAST 825







RELATED PRODUCTS



Acrylic filler white P1
Acrylic filler grey P3
Acrylic filler black P5
Hardener: Standard, Fast
Acrylic thinner, standard, fast, slow and
extra slow
Elasticity increasing agent
Plastic adhesion increasing agent

PROPERTIES

- Multifunctional acrylic filler
- Strong filling properties
- Original elements with cathaphoresis coating can be coated without sanding
 - Possibility of spraying without flash-off
- Can be used as a filler, primer or wet-on-wet primer
 - Excellent dry machine sanding
 - Spectral grey system
 - Smooth surface

SUBSTRATES									
Old paint coatings, including thermoplastic coats		Degrease with Spectral EXTRA 785 and dry sand with P220 ÷ P360.							
Polyester putties		Dry sand, finishing levelling with P240 ÷ P320.							
Epoxy primers		No sanding for up to 12 hours, sand with P320 afterwards.							
Steel		Degrease with Spectral EXTRA 785 and dry sand with P120.							
Original elements with cataphoretic coating.		Degrease with Spectral EXTRA 785 Degreaser, no sanding is necessary.							
Wash primers		Apply when dry.							
Plastics		See instruction EN_SI_Painting of plastics.							
Polyester laminates		Degrease with Spectral PLAST 815 and dry sand with P280.							
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: 70% P3: 30%				P3: 60% P5: 40%			
CAUTION: Mix the fillers or the additive at the recommended ratios (by weight or volume) before adding the hardener and the thinner.									
MIXING RATIO									
		Filling version		Priming version		Wet-on-wet version			
		By volume	By weight	By volume	By weight	By volume	By weight		
	UNDER 365-00	3	100	3	100	3	100		
	H 6525	1	21.5	1	21.5	1	21.5		
SOLV 855	-	-	0.6	11.5	1.2	23			
VISCOSITY									
	DIN 4/20°C		Filling version		Priming version		Wet-on-wet version		
			26÷30 s		17÷21 s		15÷17 s		
VOC CONTENT									
VOC II/B/c limit*				540 g/l					
VOC actual, filling version				430 g/l					
VOC actual, priming version				430 g/l					
VOC actual, wet-on-wet version				530 g/l					
* For ready to use mixture acc. to EU Directive 2004/42/CE									

APPLICATION CONDITIONS										
It is recommended to apply the primer over 15°C and under a humidity of 80%.										
APPLICATION										
	Traditional gravity spray gun	Filling version			Priming version			Wet-on-wet version		
		Nozzle	Pressure	Distance	Nozzle	Pressure	Distance	Nozzle	Pressure	Distance
		1.6÷1.8 mm	Follow the equipment manufacturer's guidelines		1.6÷1.8 mm	Follow the equipment manufacturer's guidelines		1.2÷1.3 mm	Follow the equipment manufacturer's guidelines	
	No. of coats	1÷3			1÷2			1		
	Single dry coat thickness	70 µm			45 µm			30 µm		
	Ready to use mixture yield for the given range of dry coat thickness	7.2 m ² /l at 70 µm			9.8 m ² /l at 45 µm			13.5 m ² /l at 30 µm		
	Flash-off time between coats	0÷10 min.			5÷10 min.			-		
	Mixture life at 20°C	60 min.								
CURING TIMES										
	20°C				60°C					
	4 h				30 min.					
CAUTION: The curing times are given for thickness 100-140 µm dry coat and apply to the temperature of specific elements.										
COATABILITY										
Coatable with Spectral Base 2.0, Spectral Wave 2.0, and Spectral 2K. Apply the topcoat in the wet on wet version after 15 min/20°C. The maximum application time for the next coat without matting is 7 days. After a minimum of 8 hours from the application, degrease the primer with the Extra 785 universal degreaser.										
IR DRYING										
	Distance	Follow the equipment manufacturer's guidelines								
	Time, depending on lamp type and power	10÷20 min.								
CAUTION: Start IR heating after at least 10 mins from applying the last coat.										

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				
In order to increase the elasticity of the paint coat on plastic elements or to increase gravel resistance of the coat (i.e. front fascia, hood), add 10 ÷ 30% of Spectral PLAST 775 on the ready mixture of Spectral UNDER 365-00 and Spectral H 6525 to adequately correct the amount of the thinner.				
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 365-00		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 the 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.				

WEIGHT CONTENTS OF COMPONENTS:

CAUTION! In order to obtain a primer with suitable parameters, it is very important to precisely dose the specific components.

Spectral UNDER 365-00 FILLING VERSION - 3:1

Ready to use mixture amount	Spectral UNDER 365-00	Spectral H 6525	Spectral SOLV 855
0.10 l	115 g	25 g	-
0.20 l	229 g	50 g	-
0.30 l	344 g	75 g	-
0.40 l	458 g	100 g	-
0.50 l	573 g	125 g	-
1.00 l	1145 g	249 g	-
2.00 l	2290 g	498 g	-

Spectral UNDER 365-00 PRIMING VERSION - 3:1:0,6

Ready to use mixture amount	Spectral UNDER 365-00	Spectral H 6525	Spectral SOLV 855
0.10 l	99.5 g	21.5 g	11.5 g
0.20 l	199 g	43 g	23 g
0.30 l	299 g	65 g	35 g
0.40 l	398 g	87 g	46 g
0.50 l	498 g	108 g	58 g
1.00 l	996 g	216 g	116 g
2.00 l	1992 g	433 g	232 g

Spectral UNDER 365-00 WET-ON-WET VERSION - 3:1:1,2

Ready to use mixture amount	Spectral UNDER 365-00	Spectral H 6525	Spectral SOLV 855
0.10 l	88 g	19 g	21 g
0.20 l	176 g	38 g	41 g
0.30 l	264 g	56 g	62 g
0.40 l	352 g	77 g	82 g
0.50 l	441 g	96 g	103 g
1.00 l	881 g	192 g	205 g
2.00 l	1762 g	383 g	410 g

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

Spectral UNDER 365-00 FILLING VERSION - 3:1

Ready to use mixture amount	Spectral UNDER 365-00	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	94 g	20 g	-	17 g
0.20 l	187 g	41 g	-	34 g
0.30 l	281 g	61 g	-	51 g
0.40 l	347 g	81 g	-	68 g
0.50 l	467 g	102 g	-	85 g
1.00 l	935 g	203 g	-	170 g
2.00 l	1870 g	406 g	-	340 g

Spectral UNDER 365-00 PRIMING VERSION - 3:1:0,6

Ready to use mixture amount	Spectral UNDER 365-00	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	83.5 g	18 g	9.5 g	15 g
0.20 l	167 g	36 g	19 g	30 g
0.30 l	250 g	54 g	29 g	45 g
0.40 l	333 g	72 g	39 g	61 g
0.50 l	417 g	90 g	48 g	76 g
1.00 l	833 g	181 g	97 g	151 g
2.00 l	1666 g	362 g	194 g	303 g

Spectral UNDER 365-00 WET-ON-WET VERSION - 3:1:1,2

Ready to use mixture amount	Spectral UNDER 365-00	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	72 g	16 g	21 g	13 g
0.20 l	143 g	31 g	42 g	26 g
0.30 l	215 g	47 g	63 g	39 g
0.40 l	286 g	62 g	83 g	52 g
0.50 l	358 g	78 g	104 g	65 g
1.00 l	716 g	156 g	208 g	130 g
2.00 l	1432 g	311 g	417 g	260 g