

# SPECTRAL

COLOR TECHNOLOGY

Technical Data Sheet

## Spectral UNDER 355-00

High build filler

Spectral UNDER 355-00  
Spectral UNDER 355-00  
Spectral UNDER 355-00  
Spectral H 6525  
Spectral SOLV 855



Spectral PLAST 775  
Spectral PLAST 825









### RELATED PRODUCTS

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

### PROPERTIES

- High build acrylic filler
- Possibility of spraying very thick layers
- Original elements with cathaphoresis coating can be coated without sanding
  - Excellent dry machine sanding
    - Spectral grey system
    - Smooth surface
- Perfect for filling relatively big scratches and irregularities of the surface
  - Possibility of spraying without flash-off

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				
	UNDER 355-00 H 6525 SOLV 855	By volume	By weight	
		4	100	
		1	16	
		0÷0.4	0÷6	
VISCOSITY				
	DIN 4/20°C	30÷42 s		
VOC CONTENT				
VOC II/B/c limit*		540 g/l		
VOC actual, filling version (4:1)		420 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	Nozzle	Pressure	Distance
		1.6÷1.8mm	CAUTION: follow the equipment manufacturer's guidelines	
	No. of coats	1÷3		
	Single dry coat thickness	ca. 80 µm		
	Ready to use mixture yield for the given range of dry coat thickness	3.4 m <sup>2</sup> /l at 150 µm		
	Flash-off time between coats	0÷10 min		
	Mixture life at 20°C	45 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.				
IR DRYING				
	Distance Time, depending on lamp type and power	Follow the equipment manufacturer's guidelines 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 ÷ 1000		
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 355-00 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 355-00	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.

**Spectral UNDER 355-00 mixing ratio 4:1, hardener H6525**

**WEIGHT CONTENTS OF COMPONENTS:**

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

Ready to use mixture amount	Spectral UNDER 355-00	Spectral H 6525
0.10 l	120 g	20 g
0.20 l	240 g	40 g
0.30 l	360 g	60 g
0.40 l	480 g	80 g
0.50 l	600 g	100 g
1.00 l	1200 g	200 g
2.00 l	2400 g	400 g

**Spectral UNDER 355-00 mixing ratio 4:1:0,4, hardener H6525**

**WEIGHT CONTENTS OF COMPONENTS:**

Ready to use mixture amount	Spectral UNDER 355-00	Spectral H 6525	Spectral SOLV 855
0.10 l	111 g	18.5 g	6.5 g
0.20 l	222 g	37 g	13 g
0.30 l	334 g	55 g	20 g
0.40 l	445 g	74 g	26 g
0.50 l	557 g	92 g	33 g
1.00 l	1113 g	184 g	66 g
2.00 l	2227 g	369 g	132 g

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

**Spectral UNDER 355-00 mixing ratio 4:1, hardener H6525**

**WEIGHT CONTENTS OF COMPONENTS:**

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

Ready to use mixture amount	Spectral UNDER 355-00	Spectral H 6525	Spectral PLAST 825
0.10 l	97 g	16 g	18 g
0.20 l	194 g	32 g	36 g
0.30 l	291 g	48 g	54 g
0.40 l	388 g	64 g	72 g
0.50 l	485 g	80 g	90 g
1.00 l	967 g	161 g	179 g
2.00 l	1939 g	321 g	359 g

**Spectral UNDER 355-00 mixing ratio 4:1, hardener H6525**

**WEIGHT CONTENTS OF COMPONENTS:**

Ready to use mixture amount	Spectral UNDER 355-00	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	91 g	15 g	5 g	17 g
0.20 l	182 g	30 g	11 g	34 g
0.30 l	273 g	45 g	16 g	51 g
0.40 l	364 g	60 g	22 g	67 g
0.50 l	455 g	76 g	27 g	84 g
1.00 l	911 g	151 g	54 g	168 g
2.00 l	1822 g	302 g	108 g	337 g