

Technical Data Sheet

## Spectral PLAST 825

Plastic adhesion increasing agent




### RELATED PRODUCTS

Spectral PLAST 825  
Spectral SOLV 855

Plastic adhesion increasing agent  
Acrylic thinner, standard

### PROPERTIES

- Additive for two-component fillers, can also be used as one-component filler
  - Excellent adhesion to plastics
- ESSENTIAL for coating polypropylene and its mixtures
  - RECOMMENDED for coating other plastics

SUBSTRATES						
Plastics, especially PP and its mixtures		Hold the detail at +50°C for at least 30 minutes. Degrease with Spectral PLAST 815, mat down with an abrasive finishing pad, and degrease again with Spectral PLAST 815.				
Caution: Spectral PLAST 825 does not improve adhesion to PE (polyethylene) or PTFE (Teflon).						
Use of Spectral PLAST 825						
ADDITIVE FOR TWO-COMPONENT FILLERS		ONE-COMPONENT FILLER				
<p>In order to increase the paint coating adhesion to plastic details (especially made of PP and its mixtures), add at:</p> <p style="text-align: center;"><b>30%</b></p> <p style="text-align: center;"><b>(v/v) to Component A</b></p>			Volume ratio		Weight ratio	
			Spectral PLAST 825		1	100
<p>See the TDS of specific fillers for examples of mixing ratios.</p> <p>Apply as instructed in the filler's TDS.</p>			Conventional gravity fed spray gun		Distance	
			Spectral SOLV 855		1	96
<p><b>Fillers compatible with Spectral PLAST 825:</b></p> <p>Spectral UNDER 325 acrylic filler Spectral UNDER 325-00 acrylic filler Spectral UNDER 335 acrylic filler Spectral UNDER 355 acrylic filler Spectral UNDER 355-00 acrylic filler Spectral UNDER 365 acrylic filler Spectral UNDER 365-00 acrylic filler Spectral UNDER 385 epoxy filler Spectral UNDER 00-RACE aspartic filler</p> <p>Do not use with waterborne products.</p>			Nozzle	Pressure	Distance	
			Low-pressure spray gun Gravity fed HVLP gun		1.2 - 1.3 mm	3 - 4 bar
		NOTE: Follow the equipment manufacturer's guidelines		1.2 - 1.3 mm	2 bar	10 - 15 cm
		Number of layers		1 - 2		
Single dry layer thickness		5 - 10 µm				
Flash-off time between layers		2 - 5 min				
Drying time		5 - 10 min / 20°C				
EQUIPMENT CLEANING						
Spectral SOLV 855 acrylic thinner or NC solvent						

<b>STORAGE CONDITIONS</b>	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
<b>SHELF LIFE</b>	
Spectral PLAST 825	24 months/20°C
<b>SAFETY</b>	
See the Safety Data Sheet.	
<b>OTHER INFORMATION</b>	
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 perform 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.	