

# SPECTRAL

COLOR TECHNOLOGY

Technical data sheet

## Spectral UNDER 335

Two-component acrylic filler

Spectral UNDER 335  
Spectral UNDER 335  
Spectral UNDER 335  
Spectral H 6525  
Spectral SOLV 855

Spectral PLAST 775  
Spectral PLAST 825

### RELATED PRODUCTS

P1 white acrylic filler

P3 grey acrylic filler

P5 black acrylic filler

Hardener



Standard, fast, slow and extra slow  
acrylic thinners







Elasticity increasing agent



Plastic adhesion increasing agent







### PROPERTIES

- Universal acrylic filler
- Can be used as filler or insulator
  - Special anticorrosive additives
  - Spectral shades of grey system
    - Smooth surface

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 Polypropylene PP and its mixtures (e.g. PP/EPDM)	Degrease with Spectral PLAST 815 degreaser, mat with a needled cloth, degrease again. Apply the Spectral PLAST 825 or apply the Spectral PLAST 705 adhesion increasing agent. If necessary, apply the Spectral PLAST 775 elasticity increasing agent.				
Plastics ABS, PC, PA, PPO, PVC, PBT.	Degrease with Spectral PLAST 815 degreaser, mat with a needled cloth, degrease again. If necessary, apply the Spectral PLAST 775 elasticity increasing agent.				
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 335 H 6525 SOLV 855	Filling version		Priming version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		5	100	5	100
		1	13	1	13
1	12	2	24		
VISCOSITY					
	DIN 4/20 °C	Filling version		Priming version	
		40 ÷ 60 s		25 ÷ 35 s	

CONTENT OF VOLATILE ORGANIC COMPOUNDS				
VOC II/B/c limit *		540 g/l		
Actual VOC content, filling version		500 g/l		
Actual VOC content, priming version		530 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				
	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
		1.6 ÷ 1.8mm	CAUTION: Instructions of the equipment manufacturer must be followed.	
	Number of layers	1÷3		
	Single dry layer thickness	Filling version	Priming version	
		40 ÷ 60 µm	30 ÷ 50 µm	
Yield of the ready to apply mixture for a dry layer thickness in the provided range	4.3 m <sup>2</sup> /l at 100 µm	7.9 m <sup>2</sup> /l at 50 µm		
	Mixture life at 20° C	1 hour		
	Flash off between layers	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.				

<b>SANDING</b>				
	Dry sanding	P360 ÷ P500		
	Wet sanding	P600 ÷ 1000		
<b>RELATED PRODUCTS DEPENDING ON THE PROCESSING TEMPERATURE</b>				
	15 - 18°C	18 - 25°C	25 - 35°C	+35°C
Spectral SOLV 855	Fast	Standard	Slow	Extra Slow
<b>Spectral PLAST 775 ELASTICITY INCREASING AGENT</b>				
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 335 with Spectral H 6525), correcting the amount of the thinner accordingly.				
<b>Spectral PLAST 825 PLASTIC ADHESION INCREASING AGENT</b>				
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.				
<b>EQUIPMENT CLEANING</b>				
Spectral SOLV 855 acrylic thinner or NC solvent.				
<b>STORAGE CONDITIONS</b>				
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight.				
<b>SHELF LIFE</b>				
Spectral UNDER 335		24 months/20 °C		
Spectral H 6525		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		
<b>SAFETY</b>				
See Safety Data Sheet.				
<b>OTHER INFORMATIONS</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 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.				

ADDITIONAL INFORMATION				
<b>Spectral UNDER 335, WET ON WET VERSION</b>				
The wet on wet version is intended for use in industrial installations and in countries where regulations of Directive 2004/42/EC of the European Parliament and of the Council of April 21, 2004 on the limitation of emissions of volatile organic compounds due to the use of organic solvents in certain paints and varnishes and vehicle refinishing products do not apply.				
MIXING RATIO				
		Volume ratio	Weight ratio	
	Spectral UNDER 335	5	100	
	Spectral H 6525	1	13	
	Spectral SOLV 855 (slow)	3	36	
VISCOSITY				
	DIN 4/20 °C	16÷20 s		
CONTENT OF VOLATILE ORGANIC COMPOUNDS*				
Actual VOC content*		570 g/l		
* For ready to apply mixture				
APPLICATION CONDITIONS				
The primer should be applied at a temperature above 15 °C.				
APPLICATION				
		Nozzle	Pressure	Distance
	Conventional gravity fed spray gun	1.2 ÷1.4mm	CAUTION: Instructions of the equipment manufacturer must be followed.	
	Number of layers	1 ÷ 2		
	Single dry layer thickness	20 ÷ 30 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	11.7 m <sup>2</sup> /l at 30 µm		
	Mixture life at 20 °C	2 hours		
	Flash off between layers	5 ÷10 min		
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 UNDER 335, FILLING 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 335	Spectral H 6525	Spectral SOLV 855
0.10 l	111 g	14 g	13 g
0.20 l	222 g	28 g	25 g
0.30 l	334 g	43 g	38 g
0.40 l	445 g	57 g	51 g
0.50 l	556 g	71 g	64 g
1.00 l	1112 g	142 g	127 g
2.00 l	2224 g	285 g	254 g

**Spectral UNDER 335, PRIMING VERSION**

**COMPONENT QUANTITY BY WEIGHT:**

Ready to use mixture amount	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855
0.10 l	97 g	13 g	22 g
0.20 l	195 g	25 g	44 g
0.30 l	292 g	37 g	67 g
0.40 l	389 g	50 g	89 g
0.50 l	487 g	62 g	111 g
1.00 l	973 g	124 g	222 g
2.00 l	1946 g	249 g	444 g

**Spectral UNDER 335, WET ON WET VERSION**

**COMPONENT QUANTITY BY WEIGHT:**

Ready to use mixture amount	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855
0.10 l	87 g	11 g	30 g
0.20 l	173 g	22 g	59 g
0.30 l	260 g	33 g	89 g
0.40 l	346 g	44 g	119 g
0.50 l	433 g	55 g	148 g
1.00 l	865 g	111 g	296 g
2.00 l	1730 g	221 g	593 g

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

**Spectral UNDER 335, FILLING VERSION**

Ready to use mixture amount	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	92 g	12 g	10 g	16 g
0.20 l	183 g	23 g	21 g	33 g
0.30 l	275 g	35 g	31 g	49 g
0.40 l	366 g	47 g	42 g	65 g
0.50 l	458 g	59 g	52 g	82 g
1.00 l	916 g	117 g	105 g	163 g

**Spectral UNDER 335, PRIMING VERSION**

Ready to use mixture amount	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	82 g	10 g	19 g	14 g
0.20 l	164 g	21 g	37 g	29 g
0.30 l	246 g	31 g	56 g	44 g
0.40 l	328 g	42 g	75 g	58 g
0.50 l	410 g	52 g	94 g	73 g
1.00 l	820 g	105 g	187 g	146 g

**Spectral UNDER 335, WET ON WET VERSION**

Ready to use mixture amount	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	74 g	10 g	25 g	13 g
0.20 l	148 g	19 g	51 g	27 g
0.30 l	222 g	26 g	76 g	40 g
0.40 l	297 g	38 g	102 g	53 g
0.50 l	371 g	47 g	127 g	66 g
1.00 l	741 g	95 g	254 g	132 g