

Technical data sheet

## Spectral UNDER 385

Two-component epoxy primer




### RELATED PRODUCTS



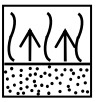




Spectral UNDER 385  
Spectral H 6985  
Spectral PLAST 825



Epoxy primer  
Hardener  
Plastic adhesion increasing agent

### PROPERTIES

- Very good adhesion to metal elements and most plastics, except for PP, PE, PTFE (Teflon) and mixtures thereof
  - Fast-drying epoxy primer
  - Superb anticorrosive resistance
    - Good insulating properties
    - Can be applied wet on wet

<b>SUBSTRATES</b>				
Old paint coatings, including thermoplastic paints	Degrease, dry sand P220 ÷ P360.			
Polyester putties	Dry sand, for final sanding P240 ÷ P320.			
Steel	Clean steel surfaces until reaching Sa 21/2 (wet blasting) or St3 (manual cleaning or using a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free from oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.			
Aluminium	Degrease, dry sand P280 ÷ P360 or mat with an abrasive needled cloth, degrease again.			
Galvanised steel	Degrease, mat with a fine abrasive needled cloth, degrease again.			
Stainless steel	Degrease.			
Polyester laminates	Degrease, dry sand P280.			
Plastics, except for PP, PE, PTFE and mixtures thereof	Degrease with Spectral PLAST 815 degreaser, mat with a needled cloth, degrease again.			
PP plastic and mixtures thereof	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.			
<b>MIXING RATIO</b>				
	Spectral UNDER 385 Spectral H 6985	Volume ratio	Weight ratio	
		1	100	
		1	52	
<b>VISCOSITY</b>				
	DIN 4/20 °C	14 ÷ 15 s		
<b>CONTENT OF VOLATILE ORGANIC COMPOUNDS</b>				
VOC II/B/ c limit*		540 g/l		
Actual VOC content		537 g/l		
* For ready to apply mixture compliant with Directive UE 2004/42/CE				
<b>APPLICATION CONDITIONS</b>				
The primer should be applied at a temperature above 15 °C and a humidity of no more than 80 %.				
<b>APPLICATION</b>				
	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
		1.2 ÷ 1.4 mm	CAUTION: Instructions of the equipment manufacturer must be followed.	

	Number of layers	1 ÷ 2 Do not apply in thick layers	
	Dry coating thickness:		
	1 layer	20 ÷ 30 µm	
2 layers	40 ÷ 60 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	13.0 m <sup>2</sup> /l at 30 µm	
	Mixture life at 20 °C	6 hours	
	Flash off between layers	5 ÷ 10 min	
<b>APPLYING THE FILLER to Spectral UNDER 385</b>			
	Number of SPECTRAL UNDER 385 layers	1	
	Drying time for SPECTRAL UNDER 385	30 min / 20°C	
<p>NOTE:</p> <p>The fillers can be applied during the first 12 hours without sanding. If the filler is to be applied after 12 hours, first sand the layer of Spectral UNDER 385. Apply the Spectral Glaze or Soft Light filler at least 1.5 h after applying SPECTRAL UNDER 385 (in 1 layer / 20°C).</p>			
<b>RECOATING Spectral UNDER 385</b>			
	Number of UNDER 385 layers	1	
	Drying time for UNDER 385	15-20 min / 20°C	
<p>NOTE: The next system layers can be applied in 12 hours without sanding. If the next coat is to be applied after 12 hours, first sand the layer of Spectral UNDER 385.</p>			
<b>DRYING TIME</b>			
	Time to sand	20 °C	60 °C
		3 hours	45 min.
CAUTION: Drying times apply to the temperatures of the individual elements.			
<b>DRYING WITH AN INFRARED RADIATOR</b>			
	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 ÷ P1000
<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>		
Epoxy thinner.		
<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 385	24 months/20 °C	
Spectral H 6985	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.		

**Spectral UNDER 385**

**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 385	Spectral H 6985
0.10 l	79 g	44 g
0.20 l	158 g	87 g
0.30 l	237 g	131 g
0.40 l	316 g	174 g
0.50 l	395 g	218 g
0.75 l	593 g	326 g
1.00 l	790 g	435 g
2.00 l	1580 g	870 g

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

**Spectral UNDER 385**

Ready to use mixture amount	Spectral UNDER 385	Spectral H 6985	Spectral PLAST 825
0.10 l	69 g	38 g	12 g
0.20 l	137 g	76 g	24 g
0.30 l	206 g	114 g	36 g
0.40 l	275 g	151 g	48 g
0.50 l	344 g	189 g	60 g
1.00 l	687 g	378 g	121 g