

# SPECTRAL

COLOR TECHNOLOGY

Technical Data Sheet

## Spectral UNDER 365-00

Acrylic filler

Spectral UNDER 365-00  
Spectral UNDER 365-00  
Spectral UNDER 365-00  
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.
PP plastic and mixtures thereof (i.e. PP/EPDM)	Degrease with Spectral PLAST 815 Degreaser for Plastics, mat with an abrasive finishing pad and degrease again. Apply Spectral PLAST 825 or apply Spectral PLAST 705 Adhesion Increasing Agent. If necessary, use Spectral PLAST 775 Elasticity Increasing Agent.
Plastics ABS, PC, PA, PPO, PVC, PBT.	Degrease with Spectral PLAST 815 Degreaser for Plastics, mat with an abrasive finishing pad and degrease again. If necessary, use Spectral PLAST 775 Elasticity Increasing Agent.
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
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										
<b>APPLICATION CONDITIONS</b>										
It is recommended to apply the primer over 15°C and under a humidity of 80%.										
<b>APPLICATION</b>										
	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 <sup>2</sup> /l at 70 µm			9,8 m <sup>2</sup> /l at 45 µm			13,5 m <sup>2</sup> /l at 30 µm		
	Flash-off time between coats	0 ÷ 10 min			5 ÷ 10 min			-		
	Mixture life at 20°C	60 min.								
<b>CURING TIMES</b>										
	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.										
<b>COATABILITY</b>										
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.										
<b>IR DRYING</b>										
	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.										

<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>				
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.				
<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 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		
<b>SAFETY</b>				
See the 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.				

**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