

# SPECTRAL

COLOR TECHNOLOGY

Technical Data Sheet

## Spectral UNDER 365

Two-component acrylic filler

Spectral UNDER 365  
Spectral UNDER 365  
Spectral UNDER 365  
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  
Acrylic thinner, standard, fast, slow and  
extra slow  
Elasticity increasing agent  
Plastic adhesion increasing agent







### PROPERTIES

- Application without a necessity of sanding on original elements with cataphoretic coating
  - Universal acrylic filler
  - Can be used as a filler or insulator
    - Excellent dry machine sanding
      - Spectral grey system
        - Smooth surface

SUBSTRATES					
Old paint coatings, including thermoplastic coats	Degrease 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 and dry sand with P120.				
Original elements with cathaporetic 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 and dry sand with P280.				
GRADES 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 365 H 6525 SOLV 855	Filling version		Priming version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		4	100	4	100
		1	17	1	17
0.5	7.5	1	15		
VISCOSITY					
	DIN 4/20°C	Filling version		Priming version	
		35 ÷ 45 s		25 ÷ 35 s	

VOC CONTENT				
VOC II/B/c limit*		540 g/l		
VOC actual, filling version		515 g/l		
VOC actual, priming version		539 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	Filling version	Priming version	
		55 µm	40 µm	
Ready to use mixture yield for the given range of dry coat thickness	4.1 m <sup>2</sup> /l at 100 µm	7.8 m <sup>2</sup> /l at 50 µm		
	Mixture life at 20°C	1 h		
	Flash-off time between coats	1 ÷ 3 min	5 ÷ 10 min	
CURING TIMES				
	20°C	60°C		
	3 h	30 min.		
CAUTION: The curing times apply to the temperature of specific elements.				
COATABILITY				
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.				
IR DRYING				
	Distance	Follow the equipment manufacturer's guidelines		
	Time, depending on lamp type and power	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 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		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.				

OTHER INFORMATION				
<b>Spectral UNDER 365 WET ON WET VERSION</b>				
The wet on wet version is intended for application in industrial plants and in the states where the regulations do not apply as of the Directive 2004/42/EC of the European Parliament and of the Council of 21 April 2004 on the limitation of emissions of volatile organic compounds due to the use of organic solvents incertain paints and varnishes and vehicle refinishing products.				
MIXING RATIO				
		Volume ratio	Weight ratio	
	Spectral UNDER 365	4	100	
	Spectral H 6525	1	17	
	Spectral SOLV 855 slow	1.5	22	
VISCOSITY				
	DIN 4/20°C	18÷21 s		
VOC CONTENT*				
VOC actual*		590 g/l		
* For ready to use mixture				
APPLICATION CONDITIONS				
It is recommended to apply the primer at over 15°C.				
APPLICATION				
		Nozzle	Pressure	Distance
	Traditional gravity spray gun	1.2 ÷1.4mm	CAUTION: follow the equipment manufacturer's guidelines	
	No. of coats	1 ÷ 2		
	Single dry coat thickness	20 ÷ 30 µm		
	The yield of the ready to use mixture for the given range of dry coat thickness	11.2 m <sup>2</sup> /l at 30 µm		
	Mixture life at 20°C	1.5 h		
	Flash-off time between coats	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 365 FILLING VERSION**

**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 365	Spectral H 6525	Spectral SOLV 855
0.10 l	107 g	18 g	8 g
0.20 l	214 g	36 g	16 g
0.30 l	320 g	54 g	24 g
0.40 l	427 g	72 g	32 g
0.50 l	534 g	90 g	40 g
1.00 l	1067 g	179 g	80 g
2.00 l	2135 g	357 g	160 g

**Spectral UNDER 365 PRIMING VERSION**

**WEIGHT CONTENTS OF COMPONENTS:**

Ready to use mixture amount	Spectral UNDER 365	Spectral H 6525	Spectral SOLV 855
0.10 l	98 g	17 g	15 g
0.20 l	196 g	33 g	29 g
0.30 l	294 g	49 g	40 g
0.40 l	392 g	66 g	59 g
0.50 l	489 g	82 g	73 g
1.00 l	979 g	164 g	147 g
2.00 l	1957 g	328 g	293 g

**Spectral UNDER 365 WET ON WET VERSION**

**WEIGHT CONTENTS OF COMPONENTS:**

Ready to use mixture amount	Spectral UNDER 365	Spectral H 6525	Spectral SOLV 855
0.10 l	91 g	15 g	20 g
0.20 l	182 g	30 g	40 g
0.30 l	273 g	45 g	61 g
0.40 l	364 g	60 g	80 g
0.50 l	455 g	74 g	102 g
1.00 l	910 g	150 g	200 g
2.00 l	1820 g	300 g	400 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 FILLING VERSION**

Ready to use mixture amount	Spectral UNDER 365	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	88 g	15 g	6.5 g	16.5 g
0.20 l	177 g	30 g	13 g	33 g
0.30 l	265 g	45 g	20 g	50 g
0.40 l	353 g	60 g	26 g	66 g
0.50 l	441 g	74 g	33 g	83 g
1.00 l	882 g	149 g	66 g	166 g

**Spectral UNDER 365 PRIMING VERSION**

Ready to use mixture amount	Spectral UNDER 365	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	82 g	14 g	12 g	15 g
0.20 l	164 g	28 g	25 g	31 g
0.30 l	246 g	42 g	37 g	46 g
0.40 l	328 g	55 g	49 g	62 g
0.50 l	411 g	69 g	62 g	77 g
1.00 l	821 g	138 g	124 g	154 g

**Spectral UNDER 365 WET ON WET VERSION**

Ready to use mixture amount	Spectral UNDER 365	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	77 g	13 g	17 g	14 g
0.20 l	154 g	26 g	35 g	29 g
0.30 l	230 g	39 g	52 g	43 g
0.40 l	307 g	52 g	69 g	58 g
0.50 l	384 g	65 g	87 g	72 g
1.00 l	768 g	129 g	173 g	144 g