

Technical Data Sheet

Spectral Under 325-00

Two-component acrylic filler, wet on wet, VHS

RELATED PRODUCTS

Spectral Under 325-00
Spectral Under 325-00
Spectral Under 325-00
Spectral H 6115

Spectral SOLV 855

Spectral PLAST 775
Spectral PLAST 825

P1 white acrylic filler
P3 grey acrylic filler
P5 black acrylic filler
Hardener: Standard, Fast, Slow, Extra Slow
Acrylic thinner: Standard, Fast, Slow, Extra Slow
Elasticity increasing agent
Plastic adhesion increasing agent

PROPERTIES

- Wet-on-wet acrylic filler with a reduced volatile organic compound (VOC) content
- Application without the necessity of sanding on original elements with a cataphoretic coating
 - Can be applied at high temperatures
 - Perfect flowability
 - Smooth surface
 - Fast drying
- Excellent adhesion to different substrates

SUBSTRATES					
Old paint coatings, including thermoplastic coats	Degrease and dry sand with P220 - P360.				
Polyester putties	Dry sand, finish 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 a cataphoretic coating	Degrease with Spectral EXTRA 785 Degreaser, no sanding necessary.				
Wash primers	Apply when dry.				
Plastics	See instruction EN_SI_Painting of plastics.				
Polyester laminates	Degrease and dry sand with 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 325-00 H 6115 SOLV 855	Priming version		Wet-on-wet version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		4	100	4	100
		1	16	1	16
		1	15	2.4	35
VISCOSITY					
	DIN 4/20°C	Priming version		Wet-on-wet version	
		26÷30s		16÷21s	
VOC CONTENT					
VOC II/B/c limit*		540 g/l			
VOC actual, wet on wet version		540 g/l			
VOC actual, priming version		480 g/l			
* For ready to apply mixture acc. to EU Directive 2004/42/EC					

APPLICATION CONDITIONS							
It is recommended to apply the filler at over 15°C and at a humidity of 80% or lower.							
APPLICATION							
	Conventional gravity fed spray gun	Priming version			Wet-on-wet version		
		Nozzle	Pressure	Distance	Nozzle	Pressure	Distance
		1.6÷1.8 mm	Follow the equipment manufacturer's guidelines		1.3÷1.4 mm	Follow the equipment manufacturer's guidelines	
	Number of layers	Priming version			Wet-on-wet version		
		1÷2			1÷2		
	Single dry layer thickness	40÷60 µm			20÷30 µm		
	The yield of the ready to use mixture for the given range of dry layer thicknesses	8.2 m ² /l at 50 µm			13.0 m ² /l at 30 µm		
	Mixture life at 20° C	60 min			90 min		
	Flash-off time between layers	10÷15 min			5÷10 min		
CURING TIMES							
	20°C			60°C			
	2 h			20 min			
CAUTION: The curing times apply to the temperatures of the individual elements.							
COATABILITY							
<p>Can be coated with Spectral Base 2.0, Spectral Wave 2.0, or Spectral 2K. The wet on wet version is coatable with a top coat after 15 min / 20°C. The maximum time to recoat is 7 days. If more than 8 hours have passed since applying the product, degrease the filler thoroughly with Extra 785.</p>							
IR DRYING							
	Distance Time depending on the type and power rating of the lamp			Follow the recommendations of the equipment manufacturer 10÷20 min			
CAUTION: Start IR heating no sooner than 10 minutes after applying the last layer.							

SANDING				
	Dry sanding	P360 + P500		
	Wet sanding	P600 + 1000		
RELATED PRODUCTS, DEPENDING ON THE PROCESSING TEMPERATURE				
	15+18°C	18+25°C	25+35°C	+35°C
Spectral H 6115	Standard	Standard	Slow	Extra Slow
Spectral SOLV 855 Priming version	Fast	Standard	Slow	Extra Slow
Spectral SOLV 855 Wet on wet version	Standard	Slow	Extra Slow	Extra Slow
Spectral PLAST 775 ELASTICITY INCREASING AGENT				
<p>In order to increase the paint coating elasticity on plastic details or to increase the resistance of the coating to mechanical damage (e.g. to the front fascia or hood), add Spectral PLAST 775 at 10-30% (by volume) of the ready-to-use mixture of Spectral Under 325-00 and Spectral H 6115, and adjust the thinner volume.</p>				
Spectral EXTRA 825 PLASTIC ADHESION INCREASING AGENT				
<p>In order to increase the paint coating adhesion to plastic details (especially made of PP and its mixtures), add Spectral EXTRA 825 at 30% (by volume) of Component A.</p>				
EQUIPMENT CLEANING				
Spectral SOLV 855 acrylic thinner or NC solvent				
STORAGE CONDITIONS				
<p>Store in a cool dry room, away from sources of flame or heat. Avoid direct exposure to sunlight.</p>				
SHELF LIFE				
Spectral Under 325-00	24 months / 20°C			
Spectral H 6115 Standard, Slow, Extra Slow	18 months / 20°C			
Spectral H 6115 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			
SAFETY				
See the Safety Data Sheet.				

OTHER INFORMATION

Registration number 000024104

The effectiveness of our systems results from laboratory research and many years of experience. The data contained here meets the current knowledge about our products and their application potential. We ensure high quality, if 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 reactions with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.

Spectral Under 325-00 priming version component weight amounts

Ready to use mixture amount	Spectral Under 325-00	Spectral H 6115	Spectral SOLV 855
0.10 l	102 g	16,5 g	15 g
0.20 l	204 g	33 g	30 g
0.30 l	306 g	50 g	45 g
0.40 l	408 g	66 g	59 g
0.50 l	510 g	82 g	74 g
1.00 l	1020 g	165 g	148 g
2.00 l	2040 g	330 g	296 g

Spectral Under 325-00 wet on wet version component weight amounts

Ready to use mixture amount	Spectral Under 325-00	Spectral H 6115	Spectral SOLV 855
0.10 l	83 g	13 g	29 g
0.20 l	165 g	27 g	58 g
0.30 l	248 g	40 g	86 g
0.40 l	331 g	54 g	115 g
0.50 l	413 g	67 g	144 g
1.00 l	827 g	133 g	288 g
2.00 l	1654 g	267 g	576 g

Example component amounts for the application of the Spectral PLAST 825 Plastic adhesion increasing agent. The agent is applied at 30% (by volume) of Component A.

Spectral UNDER 325-00 PRIMING VERSION

Ready to use mixture amount	Spectral Under 325-00	Spectral H 6115	Spectral SOLV 855	Spectral PLAST 825
0.10 l	85 g	14 g	12 g	15 g
0.20 l	170 g	28 g	25 g	31 g
0.30 l	255 g	41 g	37 g	46 g
0.40 l	340 g	55 g	49 g	62 g
0.50 l	425 g	69 g	62 g	77 g
1.00 l	850 g	137 g	124 g	154 g

Spectral UNDER 325-00 WET ON WET VERSION

Ready to use mixture amount	Spectral Under 325-00	Spectral H 6115	Spectral SOLV 855	Spectral PLAST 825
0.10 l	71 g	12 g	25 g	13 g
0.20 l	142 g	23 g	50 g	26 g
0.30 l	214 g	34 g	75 g	39 g
0.40 l	285 g	46 g	99 g	52 g
0.50 l	356 g	58 g	124 g	65 g
1.00 l	711 g	115 g	248 g	129 g