

Technical data sheet

## Spectral UNDER 385-00

Two-component epoxy primer

### RELATED PRODUCTS

Spectral UNDER 385-00	Epoxy primer
Spectral H6385	Hardener
Spectral PLAST 825	Plastic adhesion increasing agent

### PROPERTIES

- Fast-drying epoxy primer
- Superb anticorrosive resistance
- Good insulating performance – developed within a short time
- Perfect flow – can be applied wet-on-wet under decorative coatings

<b>SUBSTRATES</b>			
Old paint coatings	Degrease, dry sand P220 ÷ P360, degrease.		
Polyester putties	Dry sand, for final sanding P240 ÷ P320, degrease.		
Steel	Degrease, dry sand P120, degrease.		
Aluminium	Degrease, dry sand P280 ÷ P360 or mat with an abrasive finishing pad, degrease.		
Original elements with cataphoretic coating.	Degrease with Spectral EXTRA 785 Degreaser, no sanding is necessary.		
Galvanised steel	Degrease, mat with a fine abrasive finishing pad, degrease.		
Polyester laminates	Degrease, dry sand P280, degrease.		
Plastics, except for PP, PE, PTFE and mixtures thereof	Degrease with Spectral PLAST 815 degreaser, mat with an abrasive finishing pad, degrease.		
PP plastic and mixtures thereof	Degrease with Spectral PLAST 815 degreaser, mat with an abrasive finishing pad, degrease again. Apply the Spectral PLAST 825 or apply the Spectral PLAST 705 adhesion increasing agent.		
<b>MIXING RATIO</b>			
	Spectral UNDER 385-00 Spectral H6385	Volume ratio	Weight ratio
		1	100
		1	56
<b>VISCOSITY</b>			
	DIN 4/20°C	13 ÷ 14 s	
<b>CONTENT OF VOLATILE ORGANIC COMPOUNDS</b>			
VOC II/B/ c limit*	540 g/l		
Actual VOC content	539 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 %.			

APPLICATION				
	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 ÷ 3		
	Dry coating thickness - 1 layer	20 ÷ 25 µm		
	CAUTION: If the epoxy primer is the only anti-corrosion primer in the paint coating, its minimum thickness must be 70 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	2 hours		
	Flash off between layers at 20 °C	2 ÷ 10 min		
APPLYING THE FILLER to Spectral UNDER 385-00				
	Number of UNDER 385-00 layers	1		
	UNDER 385-00 drying time to apply the polyester filler	30 min /20°C		
NOTE: 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 385-00.				
RECOATING Spectral UNDER 385-00				
	Number of UNDER 385-00 layers	1		
	UNDER 385-00 drying time to recoat (with an acrylic primer or a decorative coating)	15-20 min /20°C		
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 385-00.				
DRYING TIME				
	Time to sand	20°C	60°C	
	1 layer of UNDER 385-00	1 hour	20 min	
	2 layer of UNDER 385-00	2.5 hours	30 min	
	3 layer of UNDER 385-00	4 hours	45 min	
CAUTION: Drying times apply to the temperatures of the individual elements.				

<b>DRYING WITH AN INFRARED RADIATOR</b>		
	Distance  Time depending on the type and power of the lamp	Follow the recommendations of the equipment manufacturer  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 385-00	24 months/20 °C	
Spectral H6385	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.		

<b>Spectral UNDER 385-00</b>		
<b>COMPONENT QUANTITY BY WEIGHT:</b>		
<b>CAUTION!</b> 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 385-00	Spectral H6385
0.10 l	77 g	43 g
0.20 l	154 g	86 g
0.30 l	231 g	130 g
0.40 l	308 g	173 g
0.50 l	385 g	216 g
0.75 l	578 g	324 g
1.00 l	770 g	432 g

<b>Example amounts of ingredients when using the Spectral PLAST 825 plastic adhesion increasing agent at 30% by volume per Component A.</b>			
<b>Spectral UNDER 385-00</b>			
Ready to use mixture amount	Spectral UNDER 385-00	Spectral H6385	Spectral PLAST 825
0.10 l	67 g	38 g	12 g
0.20 l	134 g	75 g	24 g
0.30 l	201 g	113 g	36 g
0.40 l	268 g	150 g	48 g
0.50 l	335 g	188 g	60 g
1.00 l	670 g	375 g	121 g