

SPECTRAL

COLOR TECHNOLOGY

Technical Data Sheet

Spectral UNDER 375-00

High build Air Dry filler

RELATED PRODUCTS

Spectral UNDER 375-00
Spectral UNDER 375-00
Spectral UNDER 375-00
Spectral H 6525
Spectral SOLV 855

Spectral PLAST 775
Spectral PLAST 825



High build Air Dry filler white P1
High build Air Dry filler grey P3
High build Air Dry filler black P5
Hardener: Standard









Acrylic thinner, standard, fast, slow and
extra slow

Elasticity increasing agent
Plastic adhesion increasing agent

PROPERTIES

- Saves energy used to accelerate the drying of traditional primers
 - Short time to sand (60-90min/20°C)
depending on the number of layers (1÷3)
 - Suitable for drying at low temperatures (from 5°C)
 - High build acrylic filler
 - Possibility of spraying very thick layers
- Original elements with cathaphoresis coating can be coated without sanding
 - Excellent dry machine sanding
- Perfect for filling relatively big scratches and irregularities of the surface
 - Spectral grey system

SUBSTRATES				
Old paint coatings	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.			
Plastics	See instruction EN_SI_Painting of plastics.			
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				
	UNDER 375-00 H 6525 SOLV 855	By volume		By weight
		4	1	100
		0+0.4		0+5.5
VISCOSITY				
	DIN 4/20°C	28+52 s		
VOC CONTENT				
VOC II/B/c limit*		540 g/l		
VOC actual		445 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	ca. 70 µm					
	Ready to use mixture yield for the given range of dry coat thickness	3.2 m ² /l at 150 µm					
	Flash-off time between coats	After 1st layer 3 ÷ 5 min After 2nd layer 0 ÷ 3 min					
	Mixture life at 20°C	20 min					
CURING TIMES							
	5°C	10°C	15°C	20°C	30°C	40°C	60°C
	7 h	5 h	3 h	1.5 h	55 min	40 min	20 min
CAUTION: The curing times are given for thickness 120 µm dry coat and apply to the temperature of specific elements. With lower application thickness, curing times are considerably shorter.							
COATABILITY							
Coatable with all NOVOL topcoats.							
IR DRYING							
	Distance Time, depending on lamp type and power	Follow the equipment manufacturer's guidelines 5 ÷ 15 min					
CAUTION: Start IR heating after at least 10 mins from applying the last coat.							
SANDING							
	Dry sanding	P360 ÷ P500					
	Wet sanding	P600 ÷ 1000					
RELATED PRODUCTS DEPENDING ON THE PROCESSING TEMPERATURE							
	5 ÷ 18°C	18 ÷ 25°C	25 ÷ 35°C	+35°C			
Spectral SOLV 855	fast	standard	slow	extra slow			

Spectral PLAST 775 ELASTICITY INCREASING AGENT

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 375-00 and Spectral H 6525 to adequately correct the amount of the thinner.

Spectral PLAST 825 PLASTIC ADHESION INCREASING AGENT

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.

EQUIPMENT CLEANING

Spectral SOLV 855 acrylic thinner or NC solvent

STORAGE CONDITIONS

Store in a dry and cool room, away from sources of fire and heat.
Avoid direct exposure to sunlight.

SHELF LIFE

Spectral UNDER 375-00	24 months/20°C
Spectral H 6525 Standard	18 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 INFORMATIONS

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 375-00 mixing ratio 4:1, hardener H6525

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 375-00	Spectral H 6525
0.10 l	129 g	20 g
0.20 l	257 g	40 g
0.30 l	386 g	60 g
0.40 l	514 g	80 g
0.50 l	643 g	100 g
1.00 l	1286 g	199 g
2.00 l	2571 g	398 g

Spectral UNDER 375-00 mixing ratio 4:1:0,4, hardener H6525

WEIGHT CONTENTS OF COMPONENTS:

Ready to use mixture amount	Spectral Under 375-00	Spectral H 6525	Spectral SOLV 855
0.10 l	119 g	18.5 g	6.5 g
0.20 l	238 g	37 g	13 g
0.30 l	357 g	55 g	20 g
0.40 l	476 g	74 g	26 g
0.50 l	595 g	92 g	33 g
1.00 l	1190 g	184 g	66 g
2.00 l	2380 g	369 g	132 g

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

Spectral UNDER 375-00 mixing ratio 4:1, hardener H6525

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 375-00	Spectral H 6525	Spectral PLAST 825
0.10 l	104 g	16 g	18 g
0.20 l	207 g	32 g	36 g
0.30 l	311 g	48 g	54 g
0.40 l	415 g	64 g	72 g
0.50 l	518 g	80 g	90 g
1.00 l	1037 g	161 g	179 g
2.00 l	2073 g	321 g	359 g

Spectral Under 375-00 mixing ratio 4:1:0,4, hardener H6525

Ready to use mixture amount	Spectral Under 375-00	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	97 g	15 g	5 g	17 g
0.20 l	195 g	30 g	11 g	34 g
0.30 l	292 g	45 g	16 g	51 g
0.40 l	390 g	60 g	22 g	67 g
0.50 l	487 g	76 g	27 g	84 g
1.00 l	974 g	151 g	54 g	168 g
2.00 l	1948 g	302 g	108 g	337 g