

Technical data sheet

## **Spectral UNDER 335**

Two-component acrylic filler

Spectral UNDER 335  
Spectral UNDER 335  
Spectral UNDER 335  
Spectral H 6525  
Spectral SOLV 855

Spectral PLAST 775  
Spectral PLAST 825  
Spectral EXTRA 755  
Spectral EXTRA 745

### **RELATED PRODUCTS**







P1 white acrylic filler  
P3 grey acrylic filler  
P5 black acrylic filler  
Hardener  
Standard, fast, slow and extra slow  
acrylic thinners  
Elasticity increasing agent  
Plastic adhesion increasing agent  
Acrylic filler accelerating agent  
Filler Dye

### **PROPERTIES**


- Universal acrylic filler
- Can be used as filler or insulator
  - Special anticorrosive additives
- Spectral shades of grey system
  - Smooth surface

SUBSTRATES				
Old paint coatings, including thermoplastic paints		Degrease, dry sand P220 ÷ P360.		
Polyester putties		Dry sand, for final sanding P240 ÷ P320.		
Epoxy primers		Till 12 hours without sanding, after 12 hours sand dry P320.		
Steel		Degrease, dry sand P120.		
Stainless steel		Degrease.		
Wash primers		Apply after drying.		
Plastics Polypropylene PP and its mixtures (e.g. PP/EPDM)		Degrease with Spectral PLAST 815 degreaser, mat with a needled cloth, degrease again.  Apply the Spectral PLAST 825 or apply the Spectral PLAST 705 adhesion increasing agent.  If necessary, apply the Spectral PLAST 775 elasticity increasing agent.		
Plastics ABS, PC, PA, PPO, PVC, PBT.		Degrease with Spectral PLAST 815 degreaser, mat with a needled cloth, degrease again.  If necessary, apply the Spectral PLAST 775 elasticity increasing agent.		
Polyester laminates		Degrease, dry sand 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%	P1: 99% EXTRA 745: 1%	P3: 50% P5: 50%	Max. 3% of EXTRA 745 to improve the coverage strength.
	P1: 99,7 % EXTRA 745: 0,3 %		P1: 97% EXTRA 745: 3 %	
			P3: 98 % EXTRA 745: 2 %	
CAUTION: Mix the fillers or the additive at the recommended ratios (by weight or volume) before adding the hardener and the thinner.				
Spectral EXTRA 745 FILLER DYE				
A special additive to increase the hiding power in black acrylic fillers; when used at specific mixing ratios, the product gives grades of grey. Maximum quantity: 3% by weight. Overdosing the EXTRA 745 additive may reduce sandability of the filler and result in loss of adhesion.				

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MIXING RATIO					
	UNDER 335 H 6525 SOLV 855	Filling version		Priming version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		5	100	5	100
		1	13	1	13
		1	12	2	24
VISCOSITY					
	DIN 4/20 °C	Filling version		Priming version	
		40 ÷ 60 s		25 ÷ 35 s	
CONTENT OF VOLATILE ORGANIC COMPOUNDS					
VOC II/B/c limit *			540 g/l		
Actual VOC content, filling version			500 g/l		
Actual VOC content, priming version			530 g/l		
* For ready to apply mixture compliant with Directive UE 2004/42/CE					
APPLICATION CONDITIONS					
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	
		1.6 ÷ 1.8mm	CAUTION: Instructions of the equipment manufacturer must be followed.		
	Number of layers	1÷3			
	Single dry layer thickness	Filling version		Priming version	
		40 ÷ 60 µm		30 ÷ 50 µm	
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	4.3 m <sup>2</sup> /l at 100 µm		7.9 m <sup>2</sup> /l at 50 µm	
	Trwałość mieszanki w 20°C	1 hour			
	Flash off between layers	5 ÷ 10 min			

**DRYING TIMES**

	20 °C	60 °C
	3 hours	30 min.



CAUTION: Drying times apply to the temperatures of the individual elements.

**DRYING WITH AN INFRARED RADIATOR**

	Distance	Follow the recommendations of the equipment manufacturer.
	Time depending on the type and power of the lamp	10 ÷ 20 min.

CAUTION: Use the radiator no sooner than 10 min. 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 SOLV 855	Fast	Standard	Slow	Extra Slow

**Spectral PLAST 775 ELASTICITY INCREASING AGENT**

To increase the paint coating's elasticity on plastic elements or to increase the coating's resistance to stone chipping (e.g. front strip, bonnet), add 10 + 30 % of Spectral PLAST 775 per ready to apply mixture (Spectral UNDER 335 with Spectral H 6525), correcting the amount of the thinner accordingly.

**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.

**Spectral EXTRA 755 Acrylic filler accelerating agent**

Add Spectral EXTRA 755 at 10% per Component A to reduce the curing time and adjust the thinner volume accordingly. The time to sand can even be reduced to 2 hours only, depending on the volume of additive used. The additive greatly reduces the application life. Do not use with the wet on wet version or at temperatures above 30°C.



**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.

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SHELF LIFE			
Spectral UNDER 335		24 months/20 °C	
Spectral H 6525		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	
Spectral EXTRA 745		12 months/20 °C	
Spectral EXTRA 755		24 months/20 °C	
SAFETY			
See Safety Data Sheet.			
OTHER INFORMATIONS			
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.			
ADDITIONAL INFORMATION			
<b>Spectral UNDER 335, WET ON WET VERSION</b>			
The wet on wet version is intended for use in industrial installations and in countries where regulations of Directive 2004/42/EC of the European Parliament and of the Council of April 21, 2004 on the limitation of emissions of volatile organic compounds due to the use of organic solvents in certain paints and varnishes and vehicle refinishing products do not apply.			
MIXING RATIO			
	Spectral UNDER 335 Spectral H 6525 Spectral SOLV 855 (slow)	Volume ratio	Weight ratio
		5	100
		1	13
		3	36
VISCOSITY			
	DIN 4/20 °C	16÷20 s	
CONTENT OF VOLATILE ORGANIC COMPOUNDS*			
Actual VOC content*		570 g/l	
* For ready to apply mixture			
APPLICATION CONDITIONS			
The primer should be applied at a temperature above 15 °C.			

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APPLICATION				
	Conventional gravity fed spray gun	Nozzle	Pressure	Distance
		1.2 ÷1.4mm	CAUTION: Instructions of the equipment manufacturer must be followed.	
	Number of layers	1 ÷ 2		
	Single dry layer thickness	20 ÷ 30 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	11.7 m <sup>2</sup> /l at 30 µm		
	Mixture life at 20 °C	2 hours		
	Flash off between layers	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 335, FILLING VERSION**
**COMPONENT QUANTITY BY WEIGHT:**

**CAUTION!** In order to obtain a primer with appropriate parameters it is very important do exactly dose the individual components.

Mixture quantity	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855
0.10 l	111 g	14 g	13 g
0.20 l	222 g	28 g	25 g
0.30 l	334 g	43 g	38 g
0.40 l	445 g	57 g	51 g
0.50 l	556 g	71 g	64 g
1.00 l	1112 g	142 g	127 g
2.00 l	2224 g	285 g	254 g

**Spectral UNDER 335, PRIMING VERSION**
**COMPONENT QUANTITY BY WEIGHT:**

Mixture quantity	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855
0.10 l	97 g	13 g	22 g
0.20 l	195 g	25 g	44 g
0.30 l	292 g	37 g	67 g
0.40 l	389 g	50 g	89 g
0.50 l	487 g	62 g	111 g
1.00 l	973 g	124 g	222 g
2.00 l	1946 g	249 g	444 g

**Spectral UNDER 335, WET ON WET VERSION**
**COMPONENT QUANTITY BY WEIGHT:**

Mixture quantity	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855
0.10 l	87 g	11 g	30 g
0.20 l	173 g	22 g	59 g
0.30 l	260 g	33 g	89 g
0.40 l	346 g	44 g	119 g
0.50 l	433 g	55 g	148 g
1.00 l	865 g	111 g	296 g
2.00 l	1730 g	221 g	593 g

Example amounts of ingredients to achieve grey scale levels with the use of the EXTRA 745 filler dye.

**Spectral UNDER 335, FILLING VERSION**

Mixture quantity	Target grey scale level	Spectral Under 335 P1	Spectral Under 335 P3	Spectral Extra 745	Spectral H 6525	Spectral SOLV 855
1.0 l	P2	1152 g	-	3.5 g	138 g	126 g
	P3	1144 g	-	11.5 g	138 g	126 g
	P4	1121 g	-	34.5 g	138 g	126 g
	P4	-	1132 g	23.0 g	138 g	126 g

**Spectral UNDER 335, PRIMING VERSION**

Mixture quantity	Target grey scale level	Spectral Under 335 P1	Spectral Under 335 P3	Spectral Extra 745	Spectral H 6525	Spectral SOLV 855
1.0 l	P2	1007 g	-	3.0 g	121 g	220 g
	P3	1000 g	-	10.0 g	121 g	220 g
	P4	980 g	-	30.0 g	121 g	220 g
	P4	-	990 g	20.0 g	121 g	220 g

**Spectral UNDER 335, WET ON WET VERSION**

Mixture quantity	Target grey scale level	Spectral Under 335 P1	Spectral Under 335 P3	Spectral Extra 745	Spectral H 6525	Spectral SOLV 855
1.0 l	P2	897 g	-	2.5 g	107 g	293 g
	P3	890 g	-	9.0 g	107 g	293 g
	P4	872 g	-	27.0 g	107 g	293 g
	P4	-	881 g	18.0 g	107 g	293 g



Example amounts of ingredients when using the Spectral EXTRA 755 acrylic filler accelerating agent at 10% by volume per Component A.

**Spectral UNDER 335, FILLING VERSION**

Mixture quantity	Spectral UNDER 335	Spectral EXTRA 755	Spectral H 6525	Spectral SOLV 855
0.10 l	111 g	6.5 g	14 g	6.5 g
0.20 l	222 g	13 g	29 g	13 g
0.30 l	334 g	19 g	43 g	19 g
0.40 l	445 g	26 g	56 g	25 g
0.50 l	556 g	32 g	71 g	32 g
1.00 l	1112 g	64 g	142 g	64 g

**Spectral UNDER 335, PRIMING VERSION**

Mixture quantity	Spectral UNDER 335	Spectral EXTRA 755	Spectral H 6525	Spectral SOLV 855
0.10 l	97 g	5.5 g	12.5 g	16.5 g
0.20 l	195 g	11.2 g	25 g	33 g
0.30 l	292 g	17 g	37 g	50 g
0.40 l	389 g	22 g	50 g	67 g
0.50 l	486 g	28 g	62 g	83 g
1.00 l	973 g	56 g	125 g	167 g

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

**Spectral UNDER 335, FILLING VERSION**

Mixture quantity	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	92 g	12 g	10 g	16 g
0.20 l	183 g	23 g	21 g	33 g
0.30 l	275 g	35 g	31 g	49 g
0.40 l	366 g	47 g	42 g	65 g
0.50 l	458 g	59 g	52 g	82 g
1.00 l	916 g	117 g	105 g	163 g

**Spectral UNDER 335, PRIMING VERSION**

Mixture quantity	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	82 g	10 g	19 g	14 g
0.20 l	164 g	21 g	37 g	29 g
0.30 l	246 g	31 g	56 g	44 g
0.40 l	328 g	42 g	75 g	58 g
0.50 l	410 g	52 g	94 g	73 g
1.00 l	820 g	105 g	187 g	146 g

**Spectral UNDER 335, WET ON WET VERSION**

Mixture quantity	Spectral UNDER 335	Spectral H 6525	Spectral SOLV 855	Spectral PLAST 825
0.10 l	74 g	10 g	25 g	13 g
0.20 l	148 g	19 g	51 g	27 g
0.30 l	222 g	26 g	76 g	40 g
0.40 l	297 g	38 g	102 g	53 g
0.50 l	371 g	47 g	127 g	66 g
1.00 l	741 g	95 g	254 g	132 g