

Technical data sheet

Spectral UNDER 385

Two-component epoxy primer




RELATED PRODUCTS








Spectral UNDER 385
Spectral H 6985
Spectral PLAST 825
Spectral EXTRA 745



Epoxy primer
Hardener
Plastic adhesion increasing agent
Filler Dye

PROPERTIES

- Quick-drying epoxy primer
- Very good adhesion to metal elements and most plastics, except for PP, PE, PTFE (Teflon) and mixtures thereof
 - Superb anticorrosive resistance
 - Good insulating properties
 - Can be applied wet on wet

SUBSTRATES				
Old paint coatings, including thermoplastic paints	Degrease, dry sand P220 ÷ P360.			
Polyester putties	Dry sand, for final sanding P240 ÷ P320.			
Steel	Clean steel surfaces until reaching Sa 21/2 (wet blasting) or St3 (manual cleaning or using a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free from oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.			
Aluminium	Degrease, dry sand P280 ÷ P360 or mat with an abrasive needled cloth, degrease again.			
Galvanised steel	Degrease, mat with a fine abrasive needled cloth, degrease again.			
Stainless steel	Degrease.			
Polyester laminates	Degrease, dry sand P280.			
Plastics, except for PP, PE, PTFE and mixtures thereof	Degrease with Spectral PLAST 815 degreaser, mat with a needled cloth, degrease again.			
PP plastic and mixtures thereof	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.			
MIXING RATIO				
	Spectral UNDER 385 Spectral H 6985	Volume ratio	Weight ratio	
		1	100	
		1	52	
VISCOSITY				
	DIN 4/20 °C	14 ÷ 15 s		
CONTENT OF VOLATILE ORGANIC COMPOUNDS				
VOC II/B/ c limit*		540 g/l		
Actual VOC content		537 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
		1.3 ÷ 1.4 mm	2 bar	15 ÷ 20 cm
	Low-pressure gravity fed HVLP spray gun	1.2 ÷ 1.3 mm	2 bar	10 ÷ 15 cm
CAUTION: Instructions of the equipment manufacturer must be followed.				

	Number of layers	1 ÷ 3	
	CAUTION: In case of application directly on steel for obtaining the best anticorrosion properties minimum thickness of primer must be 80 µm.		
	Dry coating thickness:		
	1 layer	20 ÷ 30 µm	
2 layers	40 ÷ 60 µm		
3 layers	60 ÷ 90 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	13.0 m ² /l at 30 µm	
	Mixture life at 20 °C	6 hours	
	Flash off between layers	5 ÷ 10 min	
APPLYING THE FILLER to Spectral UNDER 385			
	Number of UNDER 385 layers	1	
	UNDER 385 drying time	30 min.	
CAUTION: Apply the following system layers after no more than 12 hours. After 12 hours, Spectral UNDER 385 should be sanded.			
APPLYING THE PRIMER or COLOUR COATING to Spectral UNDER 385			
	Number of UNDER 385 layers	1 ÷ 2	
	UNDER 385 drying time	15 min.	
CAUTION: Apply the following system layers after no more than 12 hours. After 12 hours, Spectral UNDER 385 should be sanded.			
DRYING TIME			
	Time to sand	20 °C	60 °C
		3 hours	45 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 ÷ P1000
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 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.		
EQUIPMENT CLEANING		
Epoxy thinner.		
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 385	24 months/20 °C	
Spectral H 6985	24 months/20 °C	
Spectral PLAST 825	24 months/20 °C	
Spectral EXTRA 745	12 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.		

Spectral UNDER 385
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 385	Spectral H 6985
0.10 l	79 g	44 g
0.20 l	158 g	87 g
0.30 l	237 g	131 g
0.40 l	316 g	174 g
0.50 l	395 g	218 g
0.75 l	593 g	326 g
1.00 l	790 g	435 g
2.00 l	1580 g	870 g

Ingredients proportioned by weight with the use of the EXTRA 745 filler dye.

Mixture quantity	quantity Extra 745 [%]	Spectral Under 385	Spectral Extra 745	Spectral H 6985
1.0 l	1	782 g	8 g	435 g
	2	774 g	16 g	435 g
	3	766 g	24 g	435 g

Example amounts of ingredients when using the Spectral PLAST 825 plastic adhesion increasing agent at 30% by volume per Component A.
Spectral UNDER 385

Mixture quantity	Spectral UNDER 385	Spectral H 6985	Spectral PLAST 825
0.10 l	69 g	38 g	12 g
0.20 l	137 g	76 g	24 g
0.30 l	206 g	114 g	36 g
0.40 l	275 g	151 g	48 g
0.50 l	344 g	189 g	60 g
1.00 l	687 g	378 g	121 g