

# Spectral Under 325-00

Plastic adhesion increasing agent

Two-component acrylic filler, wet on wet, VHS

	RELATED PRODUCTS
Spectral Under 325-00	P1 white acrylic filler
Spectral Under 325-00	P3 grey acrylic filler
Spectral Under 325-00	P5 black acrylic filler
Spectral H 6115	Hardener: Standard, Fast, Slow, Extra Slow
Spectral SOLV 855	Acrylic thinner: Standard, Fast, Slow, Extra Slow
Spectral PLAST 775	Elasticity increasing agent

Spectral PLAST 825

#### **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



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SUBSTRATES							11.02.2019	
Old paint coatings, thermoplastic coats		Degrease a	and dry sa	and with P220 -	P360.			
Polyester putties		Dry sand, fi	inish leve	lling with P240	- P320.			
Epoxy primers		No sanding	for up to	12 hours, sand	d with P	320 afterwards.		
Steel		Degrease a	and dry sa	and with P120.				
Original elements v		Degrease v	with Spect	tral EXTRA 785	5 Degre	aser, no sanding nec	essary.	
Wash primers		Apply when	n dry.					
Plastics: Polypropylene (PP) the same (e.g. PP/EPDM)	) and mixtures of	cloth, and o	degrease ne Spectra	again. Apply th	ne Spec Adhesi	stral PLAST 825 Plassion increasing agent	matt down with needle stic adhesion increasing . If necessary, use the	
Plastics: ABS, PC, PA, PPC	), PVC, PBT	Degrease v cloth, and increasing a	degrease	pectral PLAST e again. If ne	815 decessary	egreaser for plastics, , use the Spectral	matt down with needle PLAST 775 elasticity	
Polyester laminates	S	Degrease a	and dry sa	and with P280.				
SHADES OF GRE	Υ							
P1	P2	P3		P4	P5			
P1: 100% P5: 0%	P1: 90 P5: 10				P1: 30% P5: 70%	P1: 0% P5: 100%		
	P1: 70 P3: 30					P3: 50% P5: 50%		
CAUTION: Mix the thinner.	fillers or the additive	at the recom	nmended	ratios (by weigh	nt or vol	ume) before adding t	the hardener and the	
MIXING RATIO								
			Priming	version		Wet-on-	-wet version	
		Volume ra	atio	Weight ratio	)	Volume ratio	Weight ratio	
Пп	Under 325-00	4		100		4	100	
	H 6115	1		16		1	16	
	SOLV 855	1 15		2	30			
VISCOSITY								
	DIN 4/0000		Priming v	ersion		Wet-on-w	et version	
	DIN 4/20°C		26 - 30	0s		16 - 21s		



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VOC CONTENT				
VOC II/B/c limit*	540 g/l			
VOC actual, wet on wet version	530 g/l			
VOC actual, priming version	480 g/l			

<sup>\*</sup> 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**

		Р	riming versior	า	Wet	-on-wet versi	on
<b>7</b> *	Conventional gravity fed spray	Nozzle	Pressure	Distance	Nozzle	Pressure	Distance
	gun	1.6 - 1.8 mm	manufa	equipment acturer's elines	1.3 - 1.4 mm	manufa	equipment acturer's elines
	Number of lovers	Pr	iming version		Wet-	on-wet version	on
	Number of layers	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 m²/l at 50 μm		13.0 m²/l at 30 μm			
	Mixture life at 20° C	60 min		90 min			
(1/1/	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**

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.

#### **IR DRYING**

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

CAUTION: Start IR heating no sooner than 10 minutes after applying the last layer.



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SANDING							
		Dry sanding		P360 - P500			
	Wet sanding P600 - 1000						
RELATED PR	RELATED PRODUCTS, DEPENDING ON THE PROCESSING TEMPERATURE						
	15 - 18°C 18 - 25°C 25 - 35°C +35°C						
Spectral H 6	6115	Standard		Standard	Slow	Extra Slow	
Spectral SOL Priming ver		Fast		Standard	Slow	Extra Slow	
Spectral SOL Wet on wet vo		Standard		Slow	Extra Slow	Extra Slow	
Spectral PLA	ST 775	ELASTICITY INCREASIN	NG AGE	NT			
damage (e.g.	to the fro	the paint coating elastici ont fascia or hood), add S ectral H 6115, and adjust	pectral I	PLAST 775 at 10-3	increase the resistance of 0% (by volume) of the ready	the coating to mechanical r-to-use mixture of Spectral	
Spectral EXT	RA 825	PLASTIC ADHESION IN	CREAS	ING AGENT			
		ne paint coating adhesion e) of Component A.	to plast	ic details (especiall	y made of PP and its mixtu	res), add Spectral EXTRA	
EQUIPMENT	CLEAN	ING					
Spectral SOL	√ 855 ac	crylic thinner or NC solver	nt				
STORAGE CO	ONDITIO	ONS					
Store in a cool	l dry roo xposure	m, away from sources of to sunlight.	flame or	heat.			
SHELF LIFE							
Spectral Unde	er 325-00	)		24 months / 20°C			
Spectral H 61	15			12 months / 20°C			
Spectral SOLV 855 24 months / 20°C							
Spectral PLAS	Spectral PLAST 775 24 months / 20°C						
Spectral PLAST 825 24 months / 20°C							
SAFETY							
See the Safet	y Data S	sheet.					



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#### **OTHER INFORMATION**

SPECTRAL

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	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	100 g	16 g	15 g				
0.20	201 g	33 g	30 g				
0.30 I	302 g	50 g	45 g				
0.40 I	403 g	66 g	59 g				
0.50 l	503 g	82 g	74 g				
1.00 l	1007 g	165 g	148 g				
2.00 l	2013 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	86 g	14 g	25 g			
0.20	173 g	28 g	51 g			
0.30 I	259 g	42 g	76 g			
0.40 l	345 g	57 g	102 g			
0.50 l	431 g	71 g	127 g			
1.00	863 g	141 g	254 g			
2.00 l	1726 g	283 g	508 g			



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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 PRI	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	84 g	14 g	12 g	15 g			
0.20	167 g	28 g	25 g	31 g			
0.30 I	252 g	41 g	37 g	46 g			
0.40 I	336 g	55 g	49 g	62 g			
0.50	419 g	69 g	62 g	77 g			
1.00 l	839 g	137 g	124 g	154 g			

pectral 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 I	74 g	12 g	22 g	14 g		
0.20	147 g	24 g	43 g	27 g		
0.30	221 g	36 g	65 g	41 g		
0.40 l	295 g	48 g	87 g	54 g		
0.50	368 g	60 g	108 g	68 g		
1.00 l	737 g	121 g	217 g	136 g		