SPECTRAL
COLOR TECHNOLOGY

Technical Data Sheet

# Spectral UNDER 00-RACE

Aspartic filler

	RELATED PRODUCTS
Spectral UNDER 00-RACE	Aspartic filler white P1
Spectral UNDER 00-RACE	Aspartic filler grey P3
Spectral UNDER 00-RACE	Aspartic filler black P5
Spectral H 6525	Hardener
Spectral PLAST 775	Elasticity increasing agent
Spectral PLAST 825	Plastic adhesion increasing agent

PROPERTIES

- Very fast two component filler
- Sanding after 20 min without heating
- Possibility of application from 10°C
- Good filling properties
- Smooth surface
- Easy to sand

SUBSTRATES	
Old paint coatings, including thermoplastic coats	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.
Wash primers	Apply when dry.
PP plastic and mixtures thereof (i.e. PP/EPDM)	Degrease with Spectral PLAST 815 Degreaser for Plastics, mat with an abrasive cloth and degrease again. Apply Spectral PLAST 825 or apply Spectral PLAST 705 Adhesion Increasing Agent. If necessary, use Spectral PLAST 775 Elasticity Increasing Agent.
Plastics ABS, PC, PA, PPO, PVC, PBT.	Degrease with Spectral PLAST 815 Degreaser for Plastics, mat with an abrasive cloth and degrease again. If necessary, use Spectral PLAST 775 Elasticity Increasing Agent.
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.

MIXING RATIO

		Volume ratio	Weight ratio
	UNDER 00-RACE	1	100
	H 6525	1	61

VISCOSITY

	DIN 4/20°C	14 ÷ 25 s

VOC CONTENT

VOC II/B/c limit*	540 g/l
VOC actual, filling version	490g/l

* For ready to use mixture acc. to EU Directive 2004/42/CE

APPLICATION CONDITIONS

It is recommended to apply the primer over 10°C and under a humidity of 80%.

APPLICATION

		Nozzle	Pressure	Distance
	Traditional gravity spray gun	1.4 ÷ 1.6mm	CAUTION: follow the equipment manufacturer's guidelines	
	No. of coats	2 ÷ 4		
	Single dry coat thickness	ca. 40 µm		
	Ready to use mixture yield for the given range of dry coat thickness	4.1 m²/l at 100 µm		
	Mixture life at 20°C	15 min		
	Flash-off time between coats	After first layer 3 ÷ 5 min After next layers 0 ÷ 3 min		

CURING TIMES

	2 layers		3 layers		4 layers	
	20°C	60°C	20°C	60°C	20°C	60°C
	20 min	5 min	45 min	7 min	60 min	15 min

CAUTION: The curing times are given for 20°C and 50% humidity.

COATABILITY

Coatable with Spectral Base 2.0, Spectral Wave 2.0, and Spectral 2K. Apply within 32 hours after coating with the primer.

IR DRYING

	Distance	Follow the equipment manufacturer's guidelines
	Time, depending on lamp type and power	5 ÷ 10 min.

CAUTION: Start IR heating after at least 10 mins from applying the last coat.

SANDING		
	Dry sanding	P360 ÷ P600
	Wet sanding	P600 ÷ 1000

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 00-RACE and Spectral H 6525.

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 00-RACE	12 months/20°C
Spectral H 6525	12 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 00-RACE mixing ratio 1:1

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 00-RACE	Spectral H 6525
0.10 l	81 g	50 g
0.20 l	163 g	100 g
0.30 l	244 g	149 g
0.40 l	326 g	199 g
0.50 l	407 g	249 g
1.00 l	814 g	498 g
2.00 l	1629 g	996 g

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

Spectral UNDER 00-RACE mixing ratio 1:1

Ready to use mixture amount	Spectral UNDER 00-RACE	Spectral H 6525	Spectral PLAST 825
0.10 l	71 g	43 g	12 g
0.20 l	142 g	87 g	24 g
0.30 l	212 g	130 g	36 g
0.40 l	283 g	173 g	48 g
0.50 l	354 g	216 g	60 g
1.00 l	708 g	433 g	121 g
2.00 l	1416 g	866 g	242 g