

SPECTRAL UNDER 355 (FLEX)

Characteristics:

SPECTRAL UNDER 355 (FLEX) is a filling primer based on acrylic resin. It is mainly design for dry sanding. Work with this primer allows to save up more abrasive materials. It is easy to use, guarantees good spreading and precise covering of the grounded surface with filling even large scratches or surface irregularities. Thanks to high quality resins and special additives it provides anti-corrosion protection and insulation between polyester materials (putties) and acrylic paints.

Substrates:

- old paint coatings (including thermoplastic paints),
- Novol polyester putties,
- steel,
- aluminium,
- galvanized steel,
- stainless steel,
- wash primers,
- plastics
- polyester laminates.

Substrates preparation:

- old paint coatings: degrease and sand dry P220 - P360
- polyester putties: finish sand dry P240 – P320
- steel surfaces: degrease, sand dry P120 - P240
- aluminium surfaces: degrease, matt using abrasive needled cloth. Degrease again,
- galvanized surfaces: degrease, matt using very fine-grained, abrasive needled cloth. Degrease again,
- stainless steel: degrease,
- plastics: clean with a Silicone Remover EXTRA 785 and matt using abrasive needled cloth. Again degrease, apply Adhesion Increasing Agent PLAST 705 and Elasticity Increasing Agent PLAST 775.
- polyester laminates: degrease and sand dry P280

Colour matching:

Various colour acrylic topcoat can be used. Do not exceed 15 % by volume. Hardener should be calculated on the whole amount colored primer.

Mixing ratio:

	volume	weight
Spectral UNDER 355	4	100
Hardener H 6525	1	15
Acryl thinner SOLV 855	10%	5.6

Amount of solvent calculate on primer.

Complementary articles:

Accelerating agent PLUS 750.
Acryl Thinner Spectral SOLV 855. Fast, Normal, Slow.
Elasticity Increasing Spectral PLAST 775.

Potlife:

Ca. 1 h at the temperature of 20°C

Spray viscosity, nozzle, pressure:

DIN 4/20°C app. 32s, Ø 1.6÷1.8 mm, 3÷4 bar

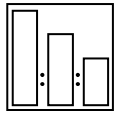
Contents of volatile organic compounds:

VOC limit (cat. B/3) = 540g/L (ready to apply mixture)
VOC = 510g/L

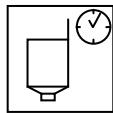
Volatile organic compound (VOC) compliant with Directive UE 2004/42/CE of 21 April 2004.

Procedure:

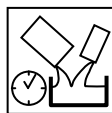
Apply two or three single wet layers leaving 5 ÷ 10 min time for evaporation after each one. Evaporation time depends on temperature and layer thickness. 10 min after the last layer was applied the coat can be forced-dried.



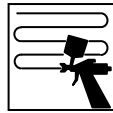
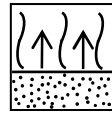
4+1+10%



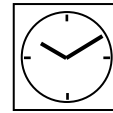
DIN 4/20°C ca.32s



1 h / 20°C

2÷3 X3÷4 bar
Ø 1.6÷1.8 mm

5÷10 min

3 h / 20°C
30 min / 60°C

P360 - P500



P600-1000

Layer thickness:

30÷40 µm for each layer.

Drying time:

3 h at 20°C; 30 min at 60°C for 15-180µm thickness.

Yield:

A set (1.0L of primer + hardener in recommended ratio) is enough to get ca. 5.0 m² of 100 µm thick dry layer.

Recommended abrasive paper:

Dry sand by machine: P360 ÷ P500
Dry sand by hand: P400 ÷ P500
Wet sand by machine: P600 ÷ P1000
Wet sand by hand: P800 ÷ P1000

Colour:

Grey.

Tools cleaning:

NC solvent or Acryl Thinner Spectral SOLV 855.

Storage time and condition:

Store in a dry, cool place, away from sources of fire and heat. Direct sunlight should be avoided.
Acryl Filler UNDER 355: 24 months at a temperature of 20°C.
Hardener H 6525: 9 months at a temperature of 20°C.

Industrial safety:

See Safety Data Sheet of this article.