

SPECTRAL UNDER 325

Characteristics:

SPECTRAL UNDER 325 is acrylic primer with low contents of solvents. It is design for wet on wet application. This primer is complined with Directive UE 2004/42/CE of 21 April 2004. Under 325 thanks to applying high quality resins and special additives provides good anti-corrosion protection and insulation between polyester materials (putties) and acrylic paints. Protect 325 has very good adhesion to various substrates. Primer is in three colours; black, white and grey. By mixing these three colours in proper ratio, it is obtained primer providing the best hide power for enamel.

Substrates:


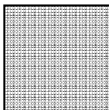
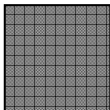
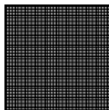
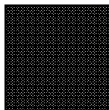
- old paint coatings (including thermoplastic paints),
- Novol polyester putties,
- steel,
- aluminium,
- galvanized steel,
- stainless steel,
- wash primers,
- plastics
- polyester laminates.

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

Mixing primers – shades of gray

To achieve optimum hiding power in Spectral computer software are given mixing ratios for black and white primers. There are five shades of gray in range of P1 –P5:

P1	P2	P3	P4	P5
				
P1: 100%	P1: 90%	P1: 70%	P1: 30%	P1: 0%
P5: 0%	P5: 10%	P5: 30%	P5: 70%	P5: 100%
	or		or	
	P1: 70%		P3: 50%	
	P3: 30%		P5: 50%	

Primers should be mixing in proper ratio (by volume or by weight) before hardener and thinner. Spectral UNDER 325 is found in gray colour which is equivalent P3 shade of gray.

Mixing ratio:

as primer surfacer:

	By volume	By weight
Spectral UNDER 325	3	100
Hardener H 6525	1	20
Acryl Thinner SOLV 855	30%	15

Wet on wet:

	By volume	By weight
Spectral UNDER 325	3	100
Hardener H 6525	1	20
Acryl Thinner SOLV 855	40%	21

Amount of solvent calculate on primer.

Complementary articles:

Accelerating Agent PLUS 750.
Acryl Thinner SOLV 855 Fast, Normal, Slow.
Elasticity Increasing Agent PLAST 775.
Adhesion Increasing Agent PLAST 705

Potlife:

App. 1 hour at the temperature of 20°C.

Spray viscosity, nozzle, pressure:

as primer surfacer:
DIN 4/20°C 24÷28 s, Ø1.6÷1.8mm, 3÷4 bar
wet on wet:
DIN 4/20°C 19÷23 s, Ø1.2÷1.4mm, 3÷4 bar

Contents of volatile organic compounds:

VOC limit (cat. B/3) = 540g/L (ready to apply mixture)
as primer surfacer:
VOC = 516g/L
Wet on wet:
VOC = 539g/L

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

Procedure:

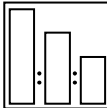
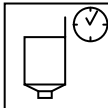
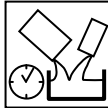
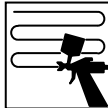
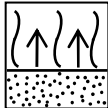
Primer surfacer:

Apply two single wet layers leaving 5 ÷ 10 min time for evaporation after each one. Evaporation time depends on the temperature and the thickness of the layer.

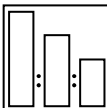
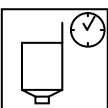

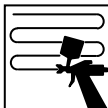
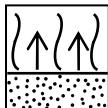
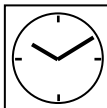


Wet on wet:

Apply one single wet layers leaving 10 ÷ 15 min time for evaporation after each one. Evaporation time depends on the temperature and the thickness of the layer. If time after applying the last layer is longer then 3 hours, sanding is needed.

WET ON WET:

				
3+1+40%	DIN 4/20°C 19÷23 s	1 h./20°C Ø 1.2÷1.4 mm	1X, 3 ÷4bar	10÷15 min

PRIMER SURFACER:

							
3+1+30%	DIN 4/20°C 24÷28s	1 h./20°C	2X, 3 ÷4bar Ø 1.6÷1.8 mm	5÷10 min	3 hours/20°C 30 min./60°C	P360 – P500	P600-P100 0

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Layer thickness:

Primer Surfacer: 50÷60 µm for each layer.

Wet on wet: 40÷50 µm for each layer.

Drying time:

Primer Surfacer: 3 h at 20°C or 30 min at 60°C for maximum two layers.

Yield:

Primer Surfacer:

Complete mixture (1.0L of UNDER 325 + hardener in recommended ratio) is enough to get ca. 15 m² of 50 µm thick dry coat.

Wet on wet:

Complete mixture (1.0L of UNDER 335 + hardener in recommended ratio) is enough to get ca. 18m² of 40 µm thick dry coat.

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:

White, black, grey.

Tools cleaning:

NC solvent or Acryl Thinner 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 Spectral UNDER 325: 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.