

Technical data sheet

Spectral UNDER 345

Two-component wash primer







Spectral UNDER 345
Spectral H 6915


RELATED PRODUCTS

Wash primer
Hardener

PROPERTIES

- Very good anticorrosive protection
 - Superb adhesion
 - High yield
 - Quick application

| SUBSTRATES | | | | |
|--|---|-----------------------------------|---|--------------|
| Steel | Degrease, dry sand P120 ÷ P240. | | | |
| Aluminium | Degrease, mat with an abrasive finishing pad, degrease again. | | | |
| Galvanised steel | Degrease, mat with an abrasive finishing pad, degrease again. | | | |
| MIXING RATIO | | | | |
|  | UNDER 345 H 6915 | Volume ratio | | Weight ratio |
| | | 1 | 1 | 100 80 |
| VISCOSITY | | | | |
|  | DIN 4/20 °C | 18 ÷ 20 s | | |
| CONTENT OF VOLATILE ORGANIC COMPOUNDS | | | | |
| VOC II/B/c limit * | 780 g/l | | | |
| Actual VOC content | 780 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 |
| | | 1.2 ÷ 1.5mm | CAUTION: Instructions of the equipment manufacturer must be followed. | |
|  | Number of layers | 1 ÷ 2 | | |
| | Single dry layer thickness | 5 ÷ 10 µm | | |
| | Yield of the ready to apply mixture for a dry layer thickness in the provided range | 7.0 m ² /l at 15 µm | | |
|  | Mixture life at 20 °C | 2 days | | |
|  | Flash off between layers | 3 ÷ 5 min | | |
| Polyester putties and epoxy primers cannot be applied directly to UNDER 345. | | | | |

| DRYING TIME | |
|---|-----------------|
|  | 7 min./20 °C |
| 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 345 | 24 months/20 °C |
| Spectral H 6915 | 24 months/20 °C |
| SAFETY | |
| See Safety Data Sheet. | |
| OTHER INFORMATIONS | |
| <p>Registration number: 000024104.</p> <p>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.</p> | |

Spectral UNDER 345**COMPONENT QUANTITY BY WEIGHT:**

CAUTION! In order to obtain a primer with appropriate parameters it is very important do exactly dose the individual components.

| Ready to use mixture amount | Spectral UNDER 345 | Spectral H 6915 |
|-----------------------------|--------------------|-----------------|
| 0.10 l | 53 g | 45 g |
| 0.20 l | 107 g | 89 g |
| 0.30 l | 160 g | 134 g |
| 0.40 l | 213 g | 178 g |
| 0.50 l | 267 g | 223 g |
| 0.75 l | 400 g | 334 g |
| 1.00 l | 533 g | 445 g |
| 2.00 l | 1066 g | 890 g |