

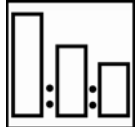
# WANDA 8100 2K Primer

## 405.08980

FOR PROFESSIONAL USE ONLY

**Description**

Wanda 8100 2K Primer offers great filling and sanding properties, excellent holdout, fast dry, and good adhesion on properly prepared substrates.



4	Wand 8100 2K Primer - 405.08980
1	Wanda 2K Hardener Std -418.03093 or Wanda 2K Hardener Slow -418.03090
10-20%	Wanda 2K Reducer - 407.04001



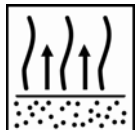
Use Wanda measuring stick



<p>Spray gun set-up: 1.7-2.0 mm HVLP max. 10 psi at air cap</p>	<p>Application pressure: 30 psi ( spray gun air inlet) o Check gun manufacturer specification</p>
---	---



**2 - 3 Coats**  
Apply 2 to 3 medium coats, allowing flash off time between coats



**Between coats**  
5-10 minutes at 70°F (20°C)



<b>Hardener selection</b>	<b>70°F (20°C)</b>	<b>140°F (60°C)</b>
Wanda 2K Hardener Slow -418-3090	3-4 hours	30 minutes
Wanda 2K Hardener Std -418-3093	2-3 hours	20 minutes



**Use suitable respiratory protection**  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

# WANDA 8100 2K Primer

## 405.08980

FOR PROFESSIONAL USE ONLY

### Description

Wanda 8100 2K Primer offers great filling and sanding properties, excellent holdout, fast dry, and good adhesion on properly prepared substrates.

### Product and additives

<b>Product</b>	Wanda 8100 2K Primer -405.08980
<b>Hardener</b>	Wanda 2K Hardener Slow – 418.03090; a general purpose hardener for all repair sizes and higher temperatures. Wanda 2K Hardener Std – 418.03093; a faster hardener for small repair areas.
<b>Reducers</b>	Wanda 2K Reducer – 407.04001
<b>Additives</b>	Wanda Flexible Additive; to increase flexibility of Wanda 8100 2K Primer for use on flexible parts.

### Basic raw materials

Wanda 8100 2K Primer;	Acrylic resins, organic and inorganic pigments, solvents and additives
Wanda 2K Hardener Slow ;	Poly-isocyanate resins and solvents
Wanda 2K Hardener Std;	Poly-isocyanate resins and solvents
Wanda 2K Reducer;	Esters and aromatic solvents

### Suitable substrates – Properly prepared

- Bare metals
- Polyester body fillers
- Washprimers
- Existing finishes

### Surface preparation



Surface Cleaning

*If necessary, pre-wash the surface with warm water and soap, rinse sufficiently with clean water.*



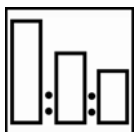
Final sanding steps; #P240 - #P320 grit dry paper



Surface Cleaning:

Remove any surface contamination prior to topcoat application using;  
**Wanda Degreaser 408.10400.**

### Mixing Ratio



#### Reduction A - Primer Filler (higher build)

4 parts by volume Wanda 8100 2K Primer  
1 part by volume Wanda 2K hardener  
10% Wanda 2K Reducer

#### Reduction A - Primer Surfacer

4 parts by volume Wanda 8100 2K Primer  
1 part by volume Wanda 2K Hardener  
20% Wanda 2K Reducer

- o For easy and accurate mixing, use the Wanda measuring stick

# WANDA 8100 2K Primer

## 405.08980

FOR PROFESSIONAL USE ONLY

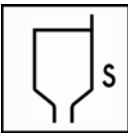
### Flexible car parts



To increase flexibility of Wanda 8100 2K Primer for use on flexible parts. Before adding hardener, prepare the Wanda 8100 2K Primer as follows:  
100 parts by volume Wanda 8100 2K Primer.  
50 parts by volume Wanda Flexible Additive

- For easy and accurate mixing, use the Wanda measuring stick
- Stir thoroughly and finish the mixing as stated under mixing ratio.

### Viscosity



20-30 seconds – DIN Cup #4 at 70°F (20°C)

### Spray gun set-up / application pressure



**Spray gun**  
Gravity HVLP  
Gravity  
Siphon Feed

**Fluid tip – set-up**  
1.7–2.0 mm  
1.5–1.8 mm  
1.8 mm

**Application pressure**  
HVLP max 10 psi at the air cap  
40 to 50 psi  
40 to 50 psi

Check gun manufacturer specification.

### Application process



Apply 2 to 3 single coats, allowing for a 5-10 minutes flash off time.

- Flash off between coats; in case of application to larger areas a minimal flash off time between coats is required.

### Pot-life

(The ready to spray mixture)

Wanda 2K Hardener Slow;

1 hour At 70°F (20°C)

Wanda 2K Hardener Std;

30 minutes At 70°F (20°C)

### Film thickness

Approximately 0.8-2.0 mils. (20-50 µm) per coat. Depending on the amount of thinner added

# WANDA 8100 2K Primer

## 405.08980

FOR PROFESSIONAL USE ONLY

### Drying times

Allow a 5 minute flash-off time before moving the car into a pre-heated drying oven (booth).  
All drying times relate to application and object temperature.



	Wanda 2K Hardener Slow	Wanda 2K Hardener Std
--	------------------------	-----------------------

70°F (20°C)	Dust dry	10 minutes	5 minutes
	Dry to handle	4 hours	3 hours
122°F (50°C)	Dust dry	8 minutes	3 minutes
	Dry to handle	70 minutes	50 minutes
140°F (60°C)	Dust dry	-----	-----
	Dry to handle	30 minutes	20 minutes

### Recoatibility

After sanding, Wanda 8100 2K Primer can be recoated with all Wanda topcoats.

### Material usage

With recommended application, the theoretical material usage is ± 42 sq.ft./liter (13 m<sup>2</sup>/liter) per coat.

- *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

### Cleaning of equipment

Clean equipment thoroughly with lacquer thinner

### VOC

(4:1:10% Ready to spray mixture) Wanda 8100 2K Primer: 4.3 lb/gal 528 g/liter  
(4:1:20% Ready to spray mixture) Wanda 8100 2K Primer: 4.8 lb/gal 580 g/liter



# WANDA 8100 2K Primer

## 405.08980

FOR PROFESSIONAL USE ONLY

### Product storage

Store products unopened, and used products with closed lids preferably between 70°F-95°F (10°C-35°C)  
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

*shelf life*

Wanda 8100 2K Primer; 2 years  
Wanda 2K Hardener Slow; 1 year  
Wanda 2K Hardener Std; 1 year

### FOR PROFESSIONAL USE ONLY

**IMPORTANT NOTE:** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coating brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

**Head Office**

Akzo Nobel Car Refinishes Inc. 5555 Spalding Drive Norcross, GA 30092, USA.