



Wanda 8100 2K Clear 418.08100

FOR PROFESSIONAL USE ONLY

Description

Wanda 2K polyurethane clearcoat is used as a topcoat over Wandabase HS basecoat. Wanda 2K Clear offers excellent application, fast dry, great gloss and good durability. It can be used for small spot repairs and total respray's.



- 4 Wanda 2K Clear 418.01800
- 1 Wanda 2K Hardener Std -418.03093 or
Wanda 2K Hardener Slow -418.03090



Use Wanda measuring stick



Spray gun set-up: 1.3-1.5 mm HVLP max. 10 psi at air cap	Application pressure: 40-50 psi (spray gun air inlet) o Check gun manufacturer specification
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2 Single Coats
 Apply 2 medium coats, allowing flash off time between coats



Between coats 5-10 minutes at 70°F (20°C)	Before curing 0-5 minutes at 70°F (20°C)
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Hardener selection Wanda 2K Hardener Slow -418.3090 Wanda 2K Hardener Std -418.3093	<table border="0"> <tr> <td style="text-align: center;">70°F (20°C)</td> <td style="text-align: center;">140°F (60°C)</td> </tr> <tr> <td style="text-align: center;">10-18 hours</td> <td style="text-align: center;">30 minutes</td> </tr> <tr> <td style="text-align: center;">8-16 hours</td> <td style="text-align: center;">25 minutes</td> </tr> </table>	70°F (20°C)	140°F (60°C)	10-18 hours	30 minutes	8-16 hours	25 minutes
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10-18 hours	30 minutes						
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Use suitable respiratory protection
 Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Product and additives

Product	Wanda 8100 2K Clear – 418.08100
Hardener	Wanda 2K Hardener Slow – 418.03090; a general purpose hardener for all repair sizes. Wanda 2K Hardener Std – 418.03093; a faster hardener for small repair areas and the sides of vehicles.
Reducers	None
Additives	Wanda Flexible Additive; to increase flexibility of High Speed Clear for use on flexible parts.

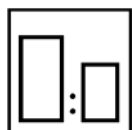
Basic raw materials

Wanda 8100 2K Clear;	Acrylic resins solvents and additives
Wanda 2K Hardener Slow ;	Poly-isocyanate resins and solvents
Wanda 2K Hardener Std;	Poly-isocyanate resins and solvents

Suitable substrates

- Wandabase HS basecoat; after a minimum flash off time of 15 to 20 minutes at 70°F (20°C).
 - o Wandabase HS basecoat should not be sanded before the clear coat application.
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

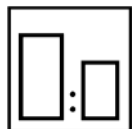
Mixing Ratio



4 parts by volume of Wanda 8100 2K Clear
1 parts by volume of Wanda 2K Hardener Std or Wanda 2K Hardener Slow .

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

Flexible car parts



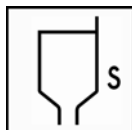
To increase flexibility of Wanda 8100 2K Clear for use on flexible parts.

Before adding hardener, prepare the Wanda 2K Clear as follows:

100 parts by volume Wanda 2K Clear.
30 parts by volume Wanda Flexible additive

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

Viscosity



18-20 seconds – DIN Cup #4 at 70°F (20°C)



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Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure
Gravity HVLP	1.3–1.5 mm	HVLP max 10 psi at the air cap
Gravity	1.3–1.5 mm	40 to 50 psi
Siphon Feed	1.6–1.8 mm	40 to 50 psi
HVLP Pressure Feed	0.8–1.0 mm	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.
 - On horizontal surfaces (hoods) it is recommended to apply 3 coats. this provides improved durability and gloss retention

Pot-life

(The ready to spray mixture 4:1)

Wanda 2K Hardener Slow ;	3 hours	At 70°F (20°C)
Wanda 2K Hardener Std;	2 hours	At 70°F (20°C)

Film thickness

Approximately 0.8-1.0 mils. (20-25 µm) per coat.

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
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70°F (20°C)	Dust dry	20 minutes	15 minutes
	Dry to handle	10-18 hours	8-16 hours

122°F (50°C)	Dust dry	12 minutes	10 minutes
	Dry to handle	50 minutes	45 minutes

140°F (60°C)	Dust dry	10 minutes	10 minutes
	Dry to handle	30 minutes	25 minutes



Smart Look. Smart Choice.

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Through-hardening:

Following the drying cycle at 140°F (60°C) object temperature, allow the High Speed Clear to cool fully to ambient temperature to complete the through-hardening process.

Recoatability

Recoat with itself after full drying cycle, sanding becomes necessary if there are defects or after 24 hours

Polishability



Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 140°F (60°C) object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according to the polishing recommendations.

- o Ready to polish approximately 30 minutes after cool down to ambient temperature.
- o Carefully sand out dust particles with #1500 then #2000 grit paper wet paper, then polish with appropriate compound.

Material usage

With recommended application, the theoretical material usage is ± 29 sq.ft./liter (9 m²/liter) per coat.

- o 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 Ready to spray mixture) High Speed Clear: 4.1 lb/gal 495 g/liter

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 2K Clear; 3 years

Wanda 2K Hardener Slow; 1 year

Wanda 2K Hardener Std; 1 year



Technical Data Sheet 01 - 08
Top coats

7.30.2007

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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.

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