
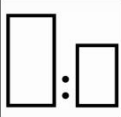


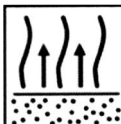
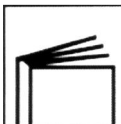

	North America	Technical Data Sheet
	Wandabase HS Basecoat™	
	Basecoat 03/20/2017	
FOR PROFESSIONAL USE ONLY		

Description

Wandabase HS polyester basecoat provides quick dry, good hiding and excellent color match. It can be used for spot repairs and total respray.

	Safety Considerations Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
	Mixing 2 1	Parts by volume Wandabase HS Basecoat Parts by volume Wandabase HS Reducer or High Temperature Reducer
	HVLP or Compliant Spray-Gun Set-Up: 1.3-1.6 mm	Application Air Pressure: 30-40 psi (spray gun air inlet) HVLP – 10 psi at the air cap maximum. Consult spray gun manufacturers' specifications.
	Application – Metallic Colors 2-4 single coats or until opacity is achieved	Application – Solid Colors 2-4 single coats or until opacity is achieved.
	Flash Between Coats at 70°F (21°C) 5-10 minutes	Flash Before Clearcoat at 70°F (21°C) 15-20 minutes
	Re-Coatable With: · Wanda Clearcoats	

Read complete TDS for detailed product information.

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Wandabase HS polyester basecoat provides quick dry, good hiding and excellent color match. It can be used for spot repairs and total respray

Suitable Substrates

- Existing OEM finishes with the exception of thermoplastic acrylic finishes
- All Wanda undercoats




Products and Additives

Product	Wandabase HS Basecoat Line	Item # are available on the price list
Reducer	Wandabase HS Reducer	Item #517026 (5 L)
	Wandabase HS High Temperature Reducer	Item #395957 (3.6 L)

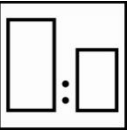
Basic Raw Materials


- Wandabase HS basecoat – polyester resins, organic and inorganic pigments, solvents and additives
- Wandabase HS reducers – solvents

Substrate Preparation

	<p>Dry sanding with final sanding step #P500 to #P600</p> <ul style="list-style-type: none"> · Initial sanding steps may be executed with a coarser sanding · If initially sanded with coarser paper, it must be over sanded with #P500 to P#600
	<p>Wet sanding with final sanding step #P800 to #P1000</p> <ul style="list-style-type: none"> · Initial sanding steps may be executed with a coarser sanding grit #P600 · If initially sanded with coarser paper, it must be over sanded with #P800 to P#1000
	<p>Surface cleaning: Remove any surface contamination prior to topcoat application using WandaClean Degreaser.</p>

Mixing

	<p>2 1</p>	<p>Parts by volume Wandabase HS Basecoat Color Parts by volume Wandabase HS Reducer or High Temperature Reducer</p>
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Viscosity When Mixed

	18-24 seconds	Measured with a DIN #4 viscosity cup at 70°F (21°C).
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Pot-Life When Mixed

Product Mix	70°F (21°C)
All mixed solid, metallic and pearl Wandabase HS Colors	Indefinite when stored in a sealed container

Spray Gun Set-Up


	Consult spray gun manufactures instructions for specific spray gun pressure specifications.		
	Spray Gun	Fluid Tip	Application Pressure
	HVLP Gravity Fed	1.3-1.5 mm	30-40 psi at the spray gun inlet (<10 psi at cap).
	Compliant Gravity Fed	1.3-1.5 mm	HVLP max 10 psi at the air cap
	Siphon Fed	1.4-1.6 mm	30-40 psi at the spray gun inlet (<10 psi at cap).

Application

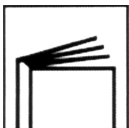
	<p>Solid Colors: Apply 2-4 single coats or until opacity is achieved. Flash off between coats.</p> <p>Metallic Colors: Apply single coats until opacity is achieved. When needed, apply an orientation coat. Increase the distance to approximately 8-12 inches and apply a light coat.</p> <p>Spot Repairs: When making spot repairs apply thin coats until opacity is achieved. Flash off between each coat before fading out well beyond the edges.</p> <p>In the case of metallic colors, air pressure adjustments may be required to achieve correct color control. Extend each coat until coverage is obtained.</p>
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Film Thickness – Using Suitable Application

1 Coat will achieve a thickness of 0.4-0.8 mils (10-20 µm).

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Recoating

	Recoatable with Wanda 2K Clearcoats.
	Allow a minimum of 15-20 minutes prior to clearcoat application and a maximum of 24 hours at 70°F (21°C). After 24 hours scuff the surface and apply another coat.


De-Nibbing

	Allow Wandabase HS to dry sufficiently, at least 20 minutes at 70°F (21°C). Then lightly dry sand the damaged area with #P600 to #P1000 free-cut sanding paper. Thoroughly remove sanding dust residue before continuing Wandabase HS application.
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Material Usage

	Theoretical material usage is ± 26 sq.ft./liter (8 sq.m/liter) RTS mixture, per coat <i>The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.</i>
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Cleaning of Equipment

	Clean equipment with Wanda Reducer.
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VOC / Regulatory Information

	The maximum VOC content of this product (2:1 ratio) in ready to use form is 6.58 lb. /gallon. (790gr/lit)
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Product Storage

	Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).	
	Wandabase HS Basecoat toners	3 years
	Wandabase HS Reducer and High Temp Reducer	3 years

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.

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AkzoNobel 1845 Maxwell Street Troy, MI 48084 USA 1-800-618-1010