
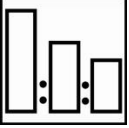


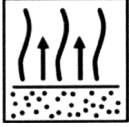


	North America	Technical Data Sheet
	Wanda 8100 2K Primer™	
	Primer 08/03/2016	
FOR PROFESSIONAL USE ONLY		

Description

Wanda 8100 2K Primer offers great filling and sanding properties, excellent hold out, fast dry and good adhesion on properly prepared substrates in National Rule areas.

	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 4 1 10-20%	Wanda 8100 2K Primer Wanda 2K Hardener Standard, Hardener Slow, or Hardener Extra Slow Wanda 2K Reducer													
	HVLP or Compliant Spray-Gun Set-Up: 1.5-2.0 mm	Application Air Pressure: HVLP – 10 psi at the air cap maximum. 30-40 psi (spray gun air inlet) Consult spray gun manufacturers' specifications.													
	Application 2-3 medium coats allowing flash time between coats.														
	Flash Between Coats at 70°F (21°C) 5-10 minutes														
	<table border="1"> <tr> <td>Hardener selection</td> <td>70°F (21°C)</td> <td>140°F (60°C)</td> </tr> <tr> <td>Wanda 2K Hardener Std</td> <td>2-3 hours</td> <td>20 minutes</td> </tr> <tr> <td>Wanda 2K Hardener Slow</td> <td>3-4 hours</td> <td>30 minutes</td> </tr> <tr> <td>Wanda 2K Hardener Extra Slow</td> <td>3-4 hours</td> <td>30 minutes</td> </tr> </table>	Hardener selection	70°F (21°C)	140°F (60°C)	Wanda 2K Hardener Std	2-3 hours	20 minutes	Wanda 2K Hardener Slow	3-4 hours	30 minutes	Wanda 2K Hardener Extra Slow	3-4 hours	30 minutes		
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Read complete TDS for detailed product information.

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Wanda 8100 2K Primer offers great filling and sanding properties, excellent hold out, fast dry and good adhesion on properly prepared substrates in National Rule areas.

Suitable Substrates

- Existing finishes
- Bare metal
 - Not recommended over bare aluminum or galvanized steel
- Polyester body fillers
- AutoPrep Pretreatment Wipes


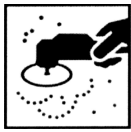
Products and Additives

Product	Wanda 8100 2K Primer	Item #391707 / 405.08980.04 (0.9 Lt) Item #391708 / 405.08980.64 (4 Lt)
Hardeners	Wanda 2K Hardener Standard	Item #391714 / 418.03093.03 (1 Lt) Item #391715 / 418.03093.30 (0.225 Lt)
	Wanda 2K Hardener Slow	Item #391712 / 418.03090.03 (1 Lt) Item #391713 / 418.03090.30 (0.225 Lt)
	Wanda 2K Hardener Very Slow	Item #397741 / 418.03088.03 (1 Lt)
Reducer	Wanda 2K Reducer	Item #391709 / 407.04001.15 (5 Lt) Item #391710 / 407.04001.96 (0.9 Lt)
Additives	Wanda Flexible Additive	Item #397881 / 408.02000.09 (0.45 Lt)

Basic Raw Materials

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

Substrate Preparation

	Pre-Cleaning Pre-wash the repair with warm soap and water. Rinse completely with clean water.
	Sanding Preparation Final sanding steps: #P240-#P320 grit dry



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Primer
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Surface Cleaning – Prior to Paint Application

Remove any surface contamination prior to topcoat application using WandaClean Degreaser.

Mixing



Reduction A – Primer Filler (higher build)

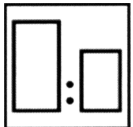
4 parts by volume Wanda 8100 2K Primer
1 part by volume Wanda 2K Hardener
10% Wanda 2K Reducer

Reduction A – Primer Surfacer

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

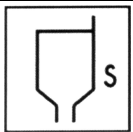
Mixing – Flexible Parts

If the part to be painted can be deformed by hand, increase the flexibility of Wanda 8100 2K Primer as follows.



Add 50% Flexible Additive for Plastics by volume to Wanda 8100 2K Primer prior to activating and reducing. Mix well and follow with the Wanda 8100 2K Primer activation ratio using only 10-15% Wanda 2K Reducer.

Viscosity When Mixed



DIN #4

20-30 seconds

Measured with a DIN #4 viscosity cup at 70°F (21°C).

Pot-Life When Mixed


Product Mix	70°F (21°C)
Wanda 2K Hardener Standard	30 minutes
Wanda 2K Hardener Slow	1 hour
Wanda 2K Hardener Very Slow	1 hour

Spray Gun Set-Up




Consult spray gun manufactures instructions for specific spray gun pressure specifications.

Spray Gun	Fluid Tip	Application Pressure
Siphon Feed	1.8 mm	30-40 psi at the spray gun air inlet
Gravity Feed	1.5-1.8 mm	30-40 psi at the spray gun air inlet

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	Gravity HVLP	1.7-2.0 mm	HVLP max 10 psi at the air cap *Check gun manufacturer specifications.
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Application


	Apply 2-3 single coats.
	Allow a flash off time between coats of 5-10 minutes. Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow. On larger areas, a minimal flash time between coats is required.

Film Thickness – Using Suitable Application

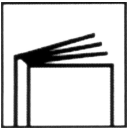
1 Coat will achieve a thickness of 0.8-2.0 mils (20-50 µm).

Drying / Curing Time


Drying times are stated based on the recommended application method, film thickness and object temperature.


		Wanda 2K Hardener Standard	Wanda 2K Hardener Slow	Wanda 2K Hardener Very Slow
	70°F (21°C)	Dust Dry	5 minutes	10 minutes
Dry to Handle		3 hours	4 hours	4-5 hours
122°F (50°C)	Dust Dry	3 minutes	8 minutes	8 minutes
	Dry to Handle	50 minutes	70 minutes	70 minutes
140°F (60°C)	Dust Dry	---	---	---
	Dry to Handle	20 minutes	30 minutes	30 minutes

Recoating

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

	Clean equipment following local and federal regulations using Wanda Reducer.
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Theoretical Coverage

	<p>Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.</p> <ul style="list-style-type: none"> • +/- 158 square feet per gallon (13 m² per liter)
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VOC / Regulatory Information

	<p>The maximum VOC content of this product (4:1:10% ratio) in ready to use form is 4.3 lbs/gal (528 g/liter).</p> <p>(4:1:20% ratio) in ready to use form is 4.8 lbs/gal (580 g/liter).</p>
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Product Storage

	<p>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).</p>	
	Wanda 8100 2K Primer	2 years
	Wanda 2K Hardeners (Standard, Slow and Very Slow)	2 years
	Wanda 2K Reducer	2 years

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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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