



North America

Programmed System Technique (PST)

Basecoats

07/03/2024

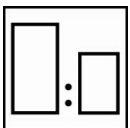
## Wandabase HS Basecoat™

Wandabase HS polyester basecoat provides quick drying, good hiding, and excellent color match. It can be used for spot repairs and complete refinishing.



### Safety Considerations

- Use suitable personal protection
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator



**Mix**  
2  
1

### By Volume

- Parts Wandabase HS Basecoat
- Part Wanda Urethane Reducer

**+10%\***

\* For optimal system performance: Before reduction, harden basecoat with Wanda 2K Hardener Standard, Slow, or Very Slow. Read the complete TDS for detailed information.

**NOTE:** 3-stage color formulas should be mixed using Wandabase MM 4000 Three Stage Binder for optimal system performance.



### Spray-Gun Set-Up:

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

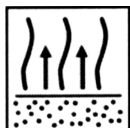
### Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap, maximum
- Consult manufacturer specifications



### Application

2 – 3 x 1 coats (2 to 3 single wet coats) or until covered

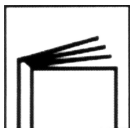


### Flash Between Coats at 70°F (21°C)

- 5 – 10 minutes

### Flash at 70°F (21°C) Before Clearcoat

- 15 – 20 minutes




### Recoating

- 2-stage color formulas: Clearcoat with any Wanda clearcoat
- 3-stage color formulas: Clearcoat with a Wanda low VOC (LV) clearcoat

- Wandabase HS Basecoat is not compliant in regulated markets. In National Rule areas, 3-stage formulas are required to be clearcoated with a Wanda low VOC (LV) clearcoat.


Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information.

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	<b>Wandabase HS Basecoat™</b>	Basecoat	
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	FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT		

## Description

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


## Suitable Substrates

	<ul style="list-style-type: none"> <li>Cleaned and properly prepared:             <ul style="list-style-type: none"> <li>Existing OEM finishes with the exception of thermoplastic acrylic finishes</li> <li>All Wanda undercoats</li> </ul> </li> </ul>
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## Products and Additives


<b>Product</b>	<ul style="list-style-type: none"> <li>Wandabase HS Basecoat</li> </ul>	<ul style="list-style-type: none"> <li>Mixed formula per OEM code</li> </ul>
<b>Reducers</b>	<ul style="list-style-type: none"> <li>Wanda Urethane Reducer Fast</li> <li>Wanda Urethane Reducer Medium</li> <li>Wanda Urethane Reducer Slow</li> <li>Wanda Urethane Reducer Extra Slow</li> </ul>	<ul style="list-style-type: none"> <li>Item #579010 (Gal)</li> <li>Item #579585 (Qt)</li> <li>Item #579591 (Gal)</li> <li>Item #579590 (Qt)</li> <li>Item #579589 (Gal)</li> <li>Item #579588 (Qt)</li> <li>Item #579586 (Gal)</li> <li>Item #579587 (Qt)</li> </ul>
<b>Hardeners</b>	<ul style="list-style-type: none"> <li>Wanda 2K Hardener Standard</li> <li>Wanda 2K Hardener Slow</li> <li>Wanda 2K Hardener Very Slow</li> </ul>	<ul style="list-style-type: none"> <li>Item # 391714 (Liter)</li> <li>Item # 391715 (0.225 L)</li> <li>Item # 391712 (Liter)</li> <li>Item # 391713(0.225 L)</li> <li>Item # 397741 (Liter)</li> </ul>



## Basic Raw Materials

	<ul style="list-style-type: none"> <li>Wandabase HS basecoat – polyester resins, organic and inorganic pigments, solvents and additives</li> <li>Wanda Urethane reducers – solvents</li> <li>Wanda 2K Hardeners – polyisocyanate resins</li> </ul>
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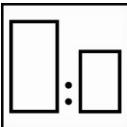
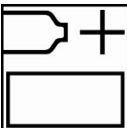

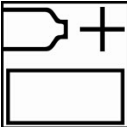

## Substrate Preparation

	<b>Pre-Cleaning</b> <ul style="list-style-type: none"> <li>The surface must be dry and free from grease, oil and other foreign matter contaminants.</li> </ul>
	<b>Surface Abrading</b> <ul style="list-style-type: none"> <li>Dry sanding with final sanding step #P500 to #P600</li> <li>Initial sanding steps may be executed with a coarser sanding.             <ul style="list-style-type: none"> <li>If initially sanded with coarser paper, it must be finish sanded with #P500 to P#600</li> </ul> </li> </ul>

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	<ul style="list-style-type: none"> <li>Wet sanding with final sanding step #P800 to #P1000</li> <li>Initial sanding steps may be performed with a coarser sanding grit #P600 <ul style="list-style-type: none"> <li>If initially sanded with coarser paper, it must be finish sanded with #P800 to P#1000</li> </ul> </li> </ul>
	<b>Final Surface Cleaning:</b> <ul style="list-style-type: none"> <li>Remove any surface contamination prior to topcoat application using WandaClean Degreaser.</li> </ul>

## Mixing

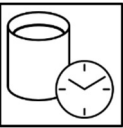
	<b>Mix</b> <b>2</b> <b>1</b>	<b>Standard Mix</b> Parts by volume Wandabase HS Basecoat Color Part by volume Wanda Urethane Reducer
	<b>NOTE:</b>	3-stage color formulas should be mixed using Wandabase MM 4000 Three Stage Binder for optimal system performance.
 	<b>Mix</b> <b>100</b> <b>10%</b>	<b>Hardened Basecoat Mix</b> Parts by volume Wandabase HS Basecoat Color Wanda 2K Hardener (Standard, Slow, or Very Slow)
	<b>50</b>	- Stir together, THEN -  Parts by volume Wanda Urethane Reducer
 	<b>Mix</b> <b>100</b> <b>10%</b>	<b>Pre-coat / Wet-bed Blender Mix</b> Parts Wandabase MM 4000 Binder Wanda 2K Hardener (Standard, Slow, or Very Slow)
	<b>50</b>	- Stir together, THEN -  Parts by volume Wanda Urethane Reducer

## Viscosity When Mixed


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

	<b>Product Mix</b>	<b>70°F (21°C)</b>
	Wandabase HS Colors, reduced	– Indefinite when stored in a sealed container
	Wandabase HS Colors, hardened and reduced	– 4 hours


## Spray Gun Setup


	<b>Consult spray gun manufacturer instructions for detailed pressure specifications.</b>		
	<b>Spray Gun</b>	<b>Fluid Tip</b>	<b>Application Pressure</b>
	HVLP Gravity Feed	1.3-1.5 mm	HVLP – 10 psi (<0.7 bar) at cap, maximum
	Compliant Gravity Feed	1.3-1.5 mm	Consult manufacturer specifications
	Siphon Feed	1.4-1.6 mm	Consult manufacturer specifications

## Application

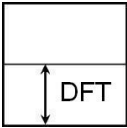
	<b>Solid Colors:</b> <ul style="list-style-type: none"> <li>Apply 2-3 single coats or until covered. Flash-off between coats.</li> </ul>
	<b>Metallic Colors:</b> <ul style="list-style-type: none"> <li>Apply single coats until coverage is achieved. When needed, apply an orientation coat. Increase the distance to approximately 8-12 inches and apply a light coat.</li> </ul>
	<b>Spot Repairs:</b> <ul style="list-style-type: none"> <li>The pre-coat/wet-bed blender mix may be used as a clear foundation coat for a metallic spot repair. <ul style="list-style-type: none"> <li>After preparing the blender mixture, apply one thin, single flowing coat to assist with metallic orientation and the blend transition. Flash until dry.</li> </ul> </li> <li>Apply thin coats until coverage is achieved. Flash-off and tack between each coat. <ul style="list-style-type: none"> <li>Extend each coat until coverage is obtained.</li> <li>Metallic colors may require air pressure adjustments and an orientation coat for the best color match.</li> </ul> </li> <li>After coverage is achieved fade color into existing finish.</li> </ul>

## Drying / Curing Time

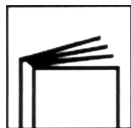
	<b>Flash Drying Between Coats</b> <ul style="list-style-type: none"> <li>5 – 10 minutes</li> </ul>	<b>Flash Drying Before Clearcoat</b> <ul style="list-style-type: none"> <li>15 – 20 minutes</li> </ul>
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### Film Thickness – Using Suitable Application

	<ul style="list-style-type: none"> <li>1 coat will achieve a thickness of 0.4-0.8 mils (10-20 µm).</li> </ul>
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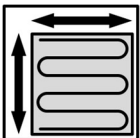
### Recoating

	<ul style="list-style-type: none"> <li>2-stage color formulas: Clearcoat with any Wanda clearcoat</li> <li>3-stage color formulas: Clearcoat with a Wanda low VOC (LV) clearcoat</li> <li>Maximum recoat window 24 hours at 70°F (21°C) <ul style="list-style-type: none"> <li>After 24 hours, scuff the dried color and apply Wandabase HS color before clearcoating</li> </ul> </li> </ul>
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### De-Nibbing

	<ul style="list-style-type: none"> <li>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.</li> </ul>
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### Material Usage


	<ul style="list-style-type: none"> <li>Theoretical coverage is ± 326 ft<sup>2</sup>/gallon (8 m<sup>2</sup>/liter) ready-to-spray per coat at 100% transfer efficiency</li> <li>Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique and other application variables.</li> </ul>
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### Cleaning of Equipment

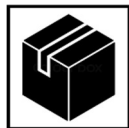
	<ul style="list-style-type: none"> <li>Clean equipment and dispose of waste following local and federal regulations. Use a quality approved cleaning solvent to clean spray gun after use.</li> <li>For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.</li> </ul>
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### VOC / Regulatory Information

	Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.	
	Wandabase HS ready to spray	– VOC: ≤6.58 lb./gal. (≤790 g/L)
	Wandabase HS 3-stage colors ready to spray and using a Wanda Low VOC (LV) Clearcoat	– VOC: <5.2 lb./gal. (<630 g/L)

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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).
- Refer to the Wanda Product Shelf-Life Overview TDS or the current price list for the most up-to-date shelf-life information.

### FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

**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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