



North America

Programmed System Technique (PST)
Primer

05/24/2021

7100 Primer Surfacer/Sealer – as a surfacer

Wanda 7100 Primer Surfacer/Sealer is a high-solids urethane surfacer and sealer. Depending on the mixing ratio used, it can be either used as a high build sanding surfacer or wet-on-wet primer sealer. 7100 Primer Surfacer/Sealer is available in white and black which may be intermixed for fast topcoat coverage and versatility. It provides a smooth and stable substrate, with exceptional coverage and holdout, for a top-rate final appearance.



Safety Considerations

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



Surface Preparation

- Existing Finishes
 - #P220 to #P360 sandpaper, dry.
- Body Filler
 - #P180 to #P220 sandpaper, dry.
- Bare Steel
 - #P80 then #P120 sandpaper, dry.

✓ Optimal adhesion to bare metal is achieved through pretreatment. See the Surface Preparation section of the TDS for details.



Surface Cleaning

- Use suitable surface cleaners and technique to ensure a clean surface.



BY VOLUME

Mix	Standard Mix
4	Parts 7100 Primer Surfacer/Sealer
1	Part 7100 Primer Surfacer Hardener
1	Part 7100 Activator (Medium or Fast)



HVLP or Compliant Spray-Gun Set-Up:

- 1.7 – 2.0 mm HVLP Gravity
- 1.7 – 2.0 mm Compliant Gravity

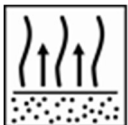
Application Air Pressure:

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



Application

- Apply 2 to 3 single (medium wet) coats
 - Flash dry between coats



Flash Between Coats at 70°F (21°C)

- 5-10 minutes

Flash at 70°F (21°C) Before Force Dry

- 5-10 minutes

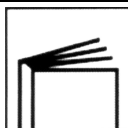


Drying at 70°F (21°C)

- 3 hours (3 coats)

Force Dry Curing

- 30 minutes at 140°F (60°C)
- Shortwave infrared: 5 minutes low power then 5 minutes high power.



Recoatability

- As a sanded primer surfacer, 7100 Primer Surfacer/Sealer may be recoated with Wanda surfacers, sealers, and basecoats
 - ✓ For sanding instructions, refer to the technical data sheet of the product to be applied.

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



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Safety Considerations

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



Surface Preparation

- Existing Finishes
 - #P320 to #P400 sandpaper dry
- Bare Steel
 - #P80 then #P120 sandpaper dry

✓ Optimal adhesion to bare metal is achieved through pretreatment. See the Surface Preparation section of the TDS for details.



Surface Cleaning

- Use suitable surface cleaners and technique to ensure a clean surface.



BY VOLUME

Mix	Standard Mix	Mix	High Temperature Mix
3 Parts	7100 Primer Surfacer/Sealer	100 Parts	7100 Primer Surfacer/Sealer
1 Part	7100 Primer Surfacer Hardener	25 Parts	7100 Primer Sealer Hardener Slow
1 Part	7100 Primer Sealer Reducer	35 Parts	7100 Primer Sealer Reducer



HVLP or Compliant Spray-Gun Set-Up:

- 1.4 – 1.5 mm HVLP Gravity
- 1.4 – 1.5 mm Compliant Gravity

Application Air Pressure:

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



Application

- Apply 1 to 2 thin but flowing coats over the desired area.

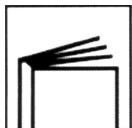


Flash Between Coats at 70°F (21°C)

- 5 minutes

Flash at 70°F (21°C) Before Topcoating

- 15 minutes.
 - Maximum of 4 hours.



Recoating

- After flash drying, 7100 Primer Surfacer/Sealer may be recoated with Wanda basecoats.

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

**7100 Primer Surfacer/Sealer**

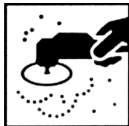
FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

Description

Wanda 7100 Primer Surfacer/Sealer is a high-solids urethane surfacer and sealer. Depending on the mixing ratio used, 7100 Primer Surfacer/Sealer can be either used as a high build sanding surfacer or wet-on-wet primer sealer. 7100 Primer Surfacer/Sealer is available in white and black which may be intermixed for fast topcoat coverage and versatility. 7100 Primer Surfacer/Sealer provides a smooth and stable substrate, with exceptional coverage and holdout, for a top-rate final appearance.

Product Assortment**Product**

- Wanda 7100 Primer Surfacer/Sealer White – Item# 583083 (gallon)
 - Wanda 7100 Primer Surfacer/Sealer White – Item# 583139 (quart)
 - Wanda 7100 Primer Surfacer/Sealer Black – Item# 583138 (gallon)
 - Wanda 7100 Primer Surfacer/Sealer Black – Item# 583137 (quart)
 - Wanda 7100 Activator Fast – Item# 583180 (quart)
 - Wanda 7100 Activator Medium – Item# 583181 (quart)
 - Wanda 7100 Primer Surfacer Hardener – Item# 583135 (quart)
 - Wanda 7100 Primer Sealer Hardener Slow – Item# 583136 (quart)
 - Wanda 7100 Primer Sealer Reducer – Item# 583179 (quart)
 - Wanda Flex Additive LV – Item# 578979 (quart)
- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures. Optimum storage temperature is approximately 70°F (21°C). Avoid too much temperature fluctuation. The maximum temperature range for storage is 40°F - 95°F (5°C - 35°C).
 - Refer to price sheet for product shelf life.

Surface Preparation

Substrate Type	For Surfacer	For Sealer	
	Dry Sanding	Dry Sanding	Wet Sanding
Existing Finishes	#P220 – #P360	#P320 – #P400	#P500 – #P600
OEM E-Coat	Not Required	Not Required	Not Required
Steel	#P80 then #P120	#P80 then #P120	N / A
Galvanized Steel	#P120 – #P180	#P120 – #P180	N / A
Aluminum	#P180 or Red Pad	#P180 or Red Pad	N / A
Polyester Bodyfiller	#P180 – #P220	N / A	N / A
Gel-Coat	#P220 – #P360	#P320 – #P400	#P500 – #P600
Polyolefin Plastic	#P320 – #P400	#P400	#P500 – #P600
Non-Polyolefin Plastic	#P320 – #P400	#P320 – #P400	#P500 – #P600

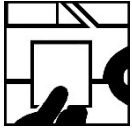
**Surface Cleaning**

- Use suitable surface cleaners and technique to ensure a clean surface.
- Wanda 7100 Surfacer and Sealer will provide adequate adhesion on small bare metal areas. Repairs that require extensive metal priming such as panels that have had the existing paint system removed require Wanda Pre-Treatment Cut Thru Wipe application prior to coating with 7100.
- Polyolefin plastics require a pre-treatment adhesion promoter. Prime polyolefin plastics with Wanda Plastic Primer LV prior to the application of flexed 7100. For more information, refer to the Wanda Plastic Primer Technical Data Sheet.



**7100 Primer Surfacer/Sealer**

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Mixing Color Formulas and Products

Shade	Ratio	Gray shade
White	White (100%)	AN1
Light Gray	White 75% / Black 25%	AN2
Gray	White 50% / Black 50%	AN3
Dark Grey	White 25% / Black 75%	AN4
Black	Black (100%)	AN5

- ✓ 7100 White and 7100 Black can be intermixed in any ratio necessary to create the desired shade of gray.
- ✓ If white is desired, add a small amount of black to 100% white for increased hiding.

Mixing - Surfacer

Mix	Surfacer Mix
4	Parts 7100 Primer Surfacer/Sealer
1	Parts 7100 Primer Surfacer Hardener
1	Parts 7100 Activator (Fast or Medium)

BY VOLUME

Mixing - Sealer

Mix	Standard Mix	Mix	High Temp. Mix: 85° - 110°F (29° - 43° C)
3	Parts 7100 Primer Surfacer/Sealer	100	7100 Primer Surfacer/Sealer
1	Parts 7100 Primer Surfacer Hardener	25	7100 Primer Sealer Hardener Slow
1	Parts 7100 Primer Sealer Reducer	35	7100 Primer Sealer Reducer

BY VOLUME

Mixing - Flexible Parts

Mix	Step #1 - Mix
4	Parts 7100 Primer Surfacer/Sealer
1	Parts Wanda Flex Additive LV

BY VOLUME

- ✓ A mixture of 3:1 should be used for soft parts.

Stir the paint and Flex Additive mixture together. Then, Step #2 mix:



Mix	For Surfacer:
4	Parts 7100 Primer Surfacer/Sealer / Flex Additive mixture (from step #1)
1	Parts 7100 Primer Surfacer Hardener
1	Parts 7100 Activator

BY VOLUME



Mix	For Sealer Standard:
3	Parts 7100 Primer Surfacer/Sealer / Flex Additive mixture (from step #1)
1	Parts 7100 Primer Surfacer Hardener
1	Parts 7100 Primer Sealer Reducer

BY VOLUME

**7100 Primer Surfacer/Sealer**

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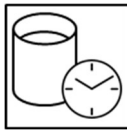
BY VOLUME

- Mix**
- 100** For Sealer High Temperature:
Parts 7100 Primer Surfacer/Sealer / Flex Additive mixture (from step #1)
- 25** Parts 7100 Primer Sealer Hardener Slow
- 35** Parts 7100 Primer Sealer Reducer

✓ Flexed sealer mixtures are recommended when painting aftermarket plastic bumpers.

Viscosity – DIN #4**Product Mix****70°F (21°C)**

- 7100 Primer Surfacer/Sealer Surfacer – Sanding mix – 18 – 22 seconds
- 7100 Primer Surfacer/Sealer Sealer – Non-sanding mix – 13 to 16 seconds

Pot-Life When Mixed**Product Mix****70°F (21°C)**

- 7100 Primer Surfacer/Sealer Primer Surfacer – 50 to 60 minutes
- 7100 Primer Surfacer/Sealer (Sealer mixed 3:1:1) – 60 to 90 minutes
- 7100 Primer Surfacer/Sealer (Sealer mixed 100:25:35 using 7100 Primer Sealer Hardener Slow) – 120 to 180 minutes

Spray-Gun Set-Up**HVLP or Compliant Spray-Gun Set-Up:**

- Surfacer: 1.7 – 2.0 mm
- Sealer: 1.4 – 1.5 mm

Application Air Pressure:

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

Application**Primer Surfacer**

- Apply 2-3 single wet coats. For use on repair (polyester bodyfiller) or sanded areas apply one coat over the repair, and then after a flash dry apply the second and third coats.
 - Flash off between the coats until the surface becomes totally matt (about 5-10 minutes), this will depend on ambient temperature, applied thickness/wetness and airflow.

Primer Sealer

- Apply 1 to 2 thin but flowing coats over the desired area. Flash 5 minutes between coats.
 - Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with a normal coat.

Drying / Curing Time – Primer Surfacer

- **Primer Surfacer Air Dry**
 - 3 hours at 70°F (21°C)
- **Primer Surfacer Force Dry**
 - 30 Minutes at 140°F (60°C)



North America

Technical Data Sheet

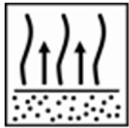
7100 Primer Surfacer/Sealer

Primer

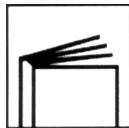
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Flash Time – Primer Sealer

- Prior to topcoating 7100 Primer Surfacer/Sealer, allow a minimum flash off time of 15 minutes at 70°F (21°C).
 - Maximum recoat time is 4 hours 70°F (21°C).
 - If the maximum flash time is exceeded, 7100 Primer Surfacer/Sealer must be sanded prior to topcoat application. Sand by following the sanding instructions for the product to be applied.

Recoating

- 7100 Primer Surfacer/Sealer can be recoated with Wanda topcoats.
 - Refer to the technical data sheet for the product to be applied for information.

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.

7100 Primer Surfacer/Sealer Ready to spray VOC:

- Wanda 7100 Primer Surfacer/Sealer – Primer Surfacer (4:1:1) – ≤4.8 lbs./gal (575 g/L)
- Wanda 7100 Primer Surfacer/Sealer – Sealer (3:1:1) – ≤4.6 lbs./gal (550 g/Liter)
- Wanda 7100 Primer Surfacer/Sealer – Sealer with Slow Hardener (100:25:35) – ≤4.51 lbs./gal (540 g/L)

AkzoNobel Inc., North America**Address: 1845 Maxwell Street – Troy, MI USA****Telephone: 800.618.1010****FOR PROFESSIONAL USE WITH SUITABLE HSE 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 Safety 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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