



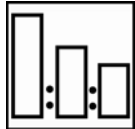
WANDA 8100 2K PRIMER

405.08980

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.



4	Wanda 8100 2K Primer – 405.08980
1	Wanda 2K Hardener Std – 418.03093 or Hardener Slow – 418.03090 or Hardener Extra Slow – 418.03088
10-20%	Wanda 2K Reducer – 407.04001



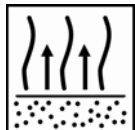
Use Wanda mixing stick



Spray gun set-up: 1.5-2.0 mm HVLP max. 10 psi at air cap	Application pressure: 30-40 psi (spray gun air inlet) o Check gun manufacturer specification
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Application:
2 – 3 Coats
Apply 2 to 3 medium coats, allowing flash off time between coats



Between coats:
5-10 minutes at 70°F (20°C)



Hardener selection	70°F (20°C)	140°F (60°C)
Wanda 2K Hardener Std - 418.3093	2-3 hours	20 minutes
Wanda 2K Hardener Slow - 418.3090	3-4 hours	30 minutes
Wanda 2K Hardener Extra Slow – 418.3088	3-4 hours	30 minutes



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

Products and additives

Product	- Wanda 8100 2K Primer -405.08980
Hardener	- Wanda 2K Hardener Std – 418.03093 - a faster hardener for small repair areas. - Wanda 2K Hardener Slow – 418.03090 - a general purpose hardener for all repair sizes and higher temperatures. - Wanda 2K Hardener Extra Slow – 418.03088 - an extra slow hardener for large repair sizes and very high temperatures.
Reducers	- Wanda 2K Reducer – 407.04001
Additives	- Wanda Flexible Additive - to increase flexibility of Wanda 8100 2K Primer for use on flexible parts.

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

Suitable substrates – Properly prepared

- Bare metal
- Polyester body fillers
- Washprimers
- Existing finishes
 - o *Not recommended over bare aluminum or galvanized steel*

Surface preparation



Surface Cleaning:
Pre-wash the surface with warm water and soap, rinse sufficiently with clean water.

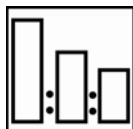


Final sanding steps; #P240 - #P320 grit dry paper



Surface Cleaning:
Remove any surface contamination prior to topcoat application using Wanda Degreaser 408.10400.

Material preparation and mixing



Reduction A - Primer Filler (higher build)	Reduction A - Primer Surfacer
4 parts by volume Wanda 8100 2K Primer 1 part by volume Wanda 2K Hardener 10% Wanda 2K Reducer	4 parts by volume Wanda 8100 2K Primer 1 part by volume Wanda 2K Hardener 20% Wanda 2K Reducer

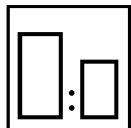
- o *For easy and accurate mixing, use the Wanda mixing stick*

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Flexible car parts

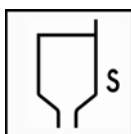


To increase flexibility of Wanda 8100 2K Primer for use on flexible parts.

Add 50% of Elastic Additive (volume) to Wanda 8100 2K Primer prior to activating and reducing. Follow with the primer mixing instructions **using only 10-15% Wanda 2K Reducer**.

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

Spray viscosity



20-30 seconds – DIN Cup #4 at 70°F (20°C)

Spray gun set-up / application pressure



Spray gun

Siphon Feed
Gravity Feed
Gravity HVLP

Fluid tip – set-up

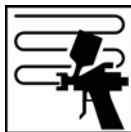
1.8 mm
1.5–1.8 mm
1.7–2.0 mm

Application pressure

30 to 40 psi at the spray gun air inlet
30 to 40 psi at the spray gun air inlet
HVLP max 10 psi at the air cap

- 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.

Pot-life

(The ready to spray mixture)

Wanda 2K Hardener Std	30 minutes	At 70°F (20°C)
Wanda 2K Hardener Slow	1 hour	At 70°F (20°C)
Wanda 2K Hardener Extra Slow	1 hour	At 70°F (20°C)

Film thickness

Approximately 0.8-2.0 mils. (20-50 µm) per coat, depending on the amount of thinner added.



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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 Std	Wanda 2K Hardener Slow	Wanda 2K Hardener Extra Slow
70°F (20°C)	Dust dry	5 minutes	10 minutes	15 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

Recoatability

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

Material usage

With recommended application, the theoretical material usage is ± 42 sq.ft./liter (13 m²/liter) per coat.

- *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

Use Wanda Reducer – 407.04001

VOC

The VOC content of this product (4:1:10% ratio) in ready to use form is 4.3 lb/gal (528gr/lit).
The VOC content of this product (4:1:20% ratio) in ready to use form is 4.8 lb/gal (580gr/lit).



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Storage / shelf life

Store products unopened, and used products with closed lids preferably between 70°F-95°F (20°C-35°C)
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

Shelf life:

- Wanda 8100 2K Primer - 2 years
- Wanda 2K Hardener Std - 1 year
- Wanda 2K Hardener Slow - 1 year
- Wanda 2K Hardener Extra Slow - 1 year

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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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