

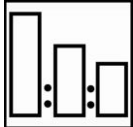


WANDA PU 2K HS

FOR PROFESSIONAL USE ONLY

Description

Wanda PU 2K HS is a single layer Polyurethane topcoat which offers good opacity, high gloss, quick dry and good weather resistance. It is suitable for repair or overall re-sprays.



- 4 Wanda PU 2K HS – Line 429
- 1 Wanda 2K Hardener Std – 418.03093 or Hardener Slow – 418.03090 or Hardener Extra Slow – 418.03088
- 10% Wanda 2K Reducer – 407.04001



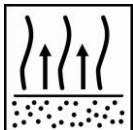
Use Wanda mixing stick



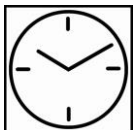
Spray gun set-up: 1.4-1.6 mm HVLP max. 10 psi at air cap	Application pressure: 40-50 psi (spray gun air inlet) o Check gun manufacturer specification
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Application:
2 – 3 Single Coats or until full opacity is achieved



Between coats: 5-10 minutes at 70°F (20°C)	Before curing: 0-5 minutes at 70°F (20°C)
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Hardener selection	70°F (20°C)	140°F (60°C)
Wanda 2K Hardener Std 418.03093	8-18 hours	25 minutes
Wanda 2K Hardener Slow 418.3090	12-24 hours	30 minutes
Wanda 2K Hardener Extra Slow 418.3088	12-24 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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Products and additives

- | | |
|------------------|--|
| Product | - Wanda PU 2K HS – 429 Line |
| | - Wanda 2K Hardener Std – 418.03093 - a faster hardener for small repair areas and the sides of vehicles. |
| Hardener | - 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 PU 2K HS for use on flexible parts. |

Basic raw materials

- Wanda PU 2K HS – line 429 - Acrylic resins 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

- Existing finishes
- All Wanda primers

Surface preparation



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

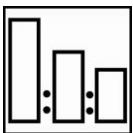


Final sanding steps; #P500 - #P600 grit dry or #P800 - #P1000 grit wet.



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

Material preparation and mixing



4 parts by volume of Wanda PU 2K HS
1 parts by volume of Wanda 2K Hardener
10% 2K Reducer

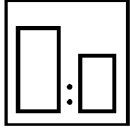
- o For easy and accurate mixing, use the Wanda mixing stick



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Flexible car parts

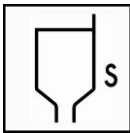


To increase flexibility of Wanda PU 2K HS for use on flexible parts.

Add 30% of Elastic Additive (volume) to Wanda PU 2K HS prior to activating and reducing. Follow with the Wanda PU 2K HS mixing ratio.

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

Spray viscosity



18-20 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

1.5-1.6 mm
1.5-1.6 mm
1.4-1.6 mm

Application pressure

40 to 50 psi at the spray gun air inlet
40 to 50 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 on larger areas a minimal flash off time between coats is required.

Pot-life

(The ready to spray mixture 4:1:10%)

Wanda 2K Hardener Std;	1.5 hours	At 70°F (20°C)
Wanda 2K Hardener Slow;	3 hours	At 70°F (20°C)
Wanda 2K Hardener Extra Slow;	3 hours	At 70°F (20°C)



Film thickness

Approximately 0.8-1.2 mils. (20-30 µm) per coat.



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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	20 minutes	30 minutes	35 minutes
	Dry to handle	8-18 hours	12-24 hours	12-24 hours
122°F (50°C)	Dust dry	10 minutes	12 minutes	12 minutes
	Dry to handle	45 minutes	50 minutes	50 minutes
140°F (60°C)	Dust dry	10 minutes	10 minutes	10 minutes
	Dry to handle	25 minutes	30 minutes	30 minutes
Through-hardening:				
Following the drying cycle at 140°F (60°C) surface temperature, allow the Wanda PU 2K HS to cool fully to ambient temperature to complete the through-hardening process.				
Recoatability				
Recoatable with itself after full drying cycle, sanding becomes necessary if there are defects or after 24 hours.				
Polishability				
	Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 140°F (60°C) object temperature, followed by a cool down of the object to ambient temperature. Carefully sand out dust particles and restore the surface according to the polishing recommendations. <ul style="list-style-type: none"> ○ Ready to polish approximately 30 minutes after cool down to ambient temperature. ○ Carefully sand out dust particles with #1500 then #2000 grit paper wet paper then polish with appropriate compound. 			
Material usage				
With recommended application, the theoretical material usage is ± 26 sq.ft./liter (8 m ² /liter) per coat. <ul style="list-style-type: none"> ○ 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. 				



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Cleaning of equipment

Use Wanda Reducer – 407.04001

VOC

The maximum VOC content of this product (4:1:10% ratio) in ready to use form is 5.0 lb/gal (600g/liter).

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 PU HS 4:1 – minimum 3 years
- Wanda 2K Hardener Std - 2 years
- Wanda 2K Hardener Slow - 2 years
- Wanda 2K Hardener Extra Slow - 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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Head Office

Akzo Nobel Car Refinishes Inc. 5555 Spalding Drive Norcross, GA 30092, USA.