
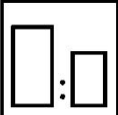





	North America	Technical Data Sheet
	Wanda 7000 Epoxy Primer	
FOR PROFESSIONAL USE ONLY		

Description

A two-component high solid epoxy primer for the vehicle refinish market. Wanda Epoxy Primer is easy to apply providing excellent hold out and a smooth appearance. The Wanda 7000 Epoxy Primer is a versatile product, good over multiple substrate types making it ideal for a wide range of vehicle repair shops.

	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.														
	 <table border="1"> <tr> <td colspan="4">High Build Primer Surfacer (Blasted Steel)</td> </tr> <tr> <td>3</td> <td colspan="3">Wanda 7000 Epoxy Primer</td> </tr> <tr> <td>1</td> <td colspan="3">Wanda 7000 Epoxy Hardener</td> </tr> </table>				High Build Primer Surfacer (Blasted Steel)				3	Wanda 7000 Epoxy Primer			1	Wanda 7000 Epoxy Hardener	
High Build Primer Surfacer (Blasted Steel)															
3	Wanda 7000 Epoxy Primer														
1	Wanda 7000 Epoxy Hardener														
	Spray gun setup:		Check gun manufacture specification												
	HVLP – Pressure (3:1)	1.3 – 1.5mm	Max 10psi (cap)	12 – 16 oz/min											
	HVLP – Gravity Feed (3:1)	1.7 – 1.9mm	Max 10psi (cap)												
	HVLP – Gravity Feed (3:1:1)	1.3 – 1.5mm	Max 10psi (cap)												
	Apply one (1) to two (2) single flowing coats														
	Between coats		Before Topcoat												
	10 minutes at 70°F (21°C)		30 – 45 minutes at 70°F (21°C)												
	Recoat within 72 hours at 70°F (21°C)														
			70°F (21°C)	140°F (60°C)											
	Dry to sand		24 hrs	1 – 1½ hrs											

Read complete TDS for detailed product information.

	North America	Technical Data Sheet
	Wanda 7000 Epoxy Primer	
FOR PROFESSIONAL USE ONLY		

Suitable Surfaces

Existing finishes	#P320 to #P400 grit dry
Fiberglass gelcoat (unbroken)	#P220 to #P320 grit dry
Polyester bodyfiller	#P180 to #P220 grit dry
Aluminum 5052	#P150 to #P180 grit dry
Cold Rolled Steel	#P80 to #P180 grit dry
Blasted Steel	Blow off dust
Galvanized steel	Red scuff pad followed by Autoprep Pretreatment Wipes

For optimal protection and performance use Autoprep Pretreatment Wipes. Other aluminum and steel grades should be tested prior to use.

Wanda 7000 Epoxy Primer can be applied over most polyester bodyfillers but should be tested prior to use. Consult AkzoNobel for approved bodyfillers. Properly degrease substrate prior to sanding with AutoPrep UltraPrep surface cleaner or WandaClean Degreaser based on local VOC requirements.

Product and Additives

Product	Wanda 7000 Epoxy Primer	Item #551751 - Grey
Hardener	Wanda 7000 Epoxy Hardener	Item #551716

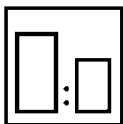
Basic Raw Material

Wanda 7000 Epoxy Primer	Epoxy resins
Wanda 7000 Epoxy Hardener	Polyamide resins

Product Characteristics

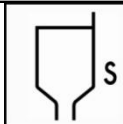
WPG (a-component)	13.1 - 13.7 lbs/gal	Gloss	Low
Volume Solids (3:1)	50% +/- 1%	Color	Grey
Volume Solids (3:1:1)	39% +/- 1%	Pot Life	4 hrs @ 70°F (21°C)
Volume Solids (3:1:0.5)	44% +/- 1%		

Mixing Ratio



High Build Primer Surfacer (Blasted Steel)	
3	Wanda 7000 Epoxy Primer
1	Wanda 7000 Epoxy Hardener

Viscosity




Wanda 7000 Epoxy Primer (3:1)	11.5 – 13.5 sec	EZ ZAHN #3 at 70°F (21°C)
Viscosities are reported as Ready to Spray		

Spray gun set-up / application pressure



Spray gun setup:	Check gun	Application Pressure
HVLP – Pressure (3:1)	1.3 – 1.5mm	Max 10 psi (cap), 12-16 oz/min
HVLP – Pressure Feed (3:1:0.5)	1.0 – 1.3mm	Max 10 psi (cap), 12-16 oz/min
HVLP – Gravity Feed (3:1)	1.7 – 1.9mm	Max 10 psi (cap)
HVLP – Gravity Feed (3:1:1)	1.3 – 1.5mm	Max 10 psi (cap)

Check gun manufacturer specification

	North America	Technical Data Sheet	
	Wanda 7000 Epoxy Primer		Primer
			05/02/2017
FOR PROFESSIONAL USE ONLY			

Application



Primer Surfacer (Sanded) – Apply two (2) single flowing coats

Flash off



10 minutes at 70°F (21°C) between coats
 30 – 45 minutes at 70°F (21°C) final flash before top coating

Dry times



Object Temp	Before Topcoat @ (1.2 – 1.5mils)	Dry to Sand
70°F (21°C)	30 – 45 min	24 hours
140°F (60°C)		1 – 1 ½ hours

Dry Film Thickness

Primer Surfacer (Sanded) – 1.5 – 1.75 mils (38-45 microns) per coat
Sandblasted surfaces – Minimum 1.5 mils over blast profile

Coverage

Coverage is calculated for the ready to spray product at 1 mil and 100% transfer efficiency
 Primer Surfacer (3:1) 780 sq ft / liter

Sanding



Primer Surfacer (Sanded) applications
 Final dry sanding step use #P400 – 500 before application of topcoats
 Initial sanding steps may be executed with a coarser sanding grit: #P320

Recoatability

Polyester Body fillers
 Wandabase HS

Wanda 7000 Epoxy Primer must be top coated within 72 hours of parts being stored indoors at 70°F (21°C). After 72 hours, Wanda 7000 Epoxy Primer must be sanded prior to topcoating or applying polyester body filler.


Wanda 7000 Epoxy Primer can be recoated with polyester body filler products after a minimum of 1 hour and a maximum of 72 hours without sanding. After the polyester body filler and the Wanda 7000 Epoxy Primer have dried, sand the polyester body filler material until satisfied with the repair.

Cleaning of equipment

Clean equipment with extra strong cleaning solvents

VOC		
Wanda 7000 Epoxy Primer (3:1)	2.1 lbs/gal	250 g/l

VOC is reported at ready to spray

	North America	Technical Data Sheet
	Wanda 7000 Epoxy Primer	
FOR PROFESSIONAL USE ONLY		

Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

Wanda 7000 Epoxy Primer Grey	2 years
Wanda 7000 Epoxy Hardener	1 year

FOR PROFESSIONAL USE ONLY

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.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.
Head Office
AkzoNobel Inc. 1845 Maxwell Street Troy Michigan 48084, USA. 1-800-618-1010