

Technical Information

Wanda 860 Clear AS HS

—W1.05.11



Two-component clearcoat to be applied over Wanda solventborne Basecoats. It can be used from small spots up till total resprays. It has very good scratch resistance with excellent gloss, appearance and flow.



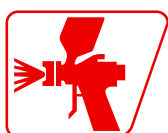
Mixing ratio

2: Wanda 860 Clear AS HS
 1: 320 Hardener Rapid / 310 Hardener Standard / 300 Hardener Slow
 10% 120 Thinner Rapid / 110 Thinner Standard / 100 Thinner Slow



Mixing stick

Use Wanda measuring stick
W1



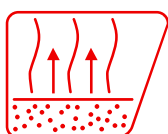
Equipment

Spray gun set-up: 1.2-1.4 mm
 Application pressure: 1.7-2.2 bar
 *See user manual spraygun used



Application

2 x 1 coat
 First, apply a flowing closed coat, followed by a full flowing coat after indicated flash off time.



Flash-off

Between coats: 8-15 minutes at 20°C
 Before curing: 8-10 minutes at 20°C



Drying

| | 20°C | 60°C |
|-----------------------------|----------|--------------|
| Wanda Hardener 320 Rapid | 4 hours | 15 minutes* |
| Wanda Hardener 310 Standard | 6 hours | 30 minutes * |
| Wanda Hardener 300 Slow | 16 hours | 45 minutes * |

*object temperature



Protection

Use suitable respiratory protection.
 AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

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Product and Additives

Wanda 860 Clear AS HS

320 Hardener Rapid / 310 Hardener Standard / 300 Hardener Slow
120 Thinner Rapid / 110 Thinner Standard / 100 Thinner Slow

Suitable substrates

Original finishes
Wandabase MAX

Mixing

2: Parts Wanda 860 Clear AS HS
1: Part 320 Hardener Rapid / 310 Hardener Standard / 300 Hardener Slow
10%: Parts 120 Thinner Rapid / 110 Thinner Standard / 100 Thinner Slow

Use a measuring stick **W1**

Spray gun set up and application pressure

Gravity feed 1.2-1.4 mm 1.7-2.2 bar*
*See user manual spraygun used

Application

Apply a flowing closed coat, allowing for a 8-15 minutes flash-off time at 20°C. (depends on thinner combination used) Next, apply a full flowing coat allowing for a 8-10 minutes flash-off time at 20°C before bake. This time can be greatly influenced by the conditions at the time of application

Pot-life

| | 20°C. |
|--------------------------------|-----------|
| Wanda 860 Clear AS HS Hardener | 3 hours |
| 320 Hardener Rapid | 1.5 hours |
| 310 Hardener Standard | 2.5 hours |
| 300 Hardener Slow | 3 hours |

Drying times

| | 20°C | 60°C* |
|-----------------------|------------|------------|
| Dry to handle: | | |
| 320 Hardener Rapid | 4 hours | 15 minutes |
| 310 Hardener Standard | 6 hours | 30 minutes |
| 300 Hardener Slow | 16 hours | 45 minutes |
| Dust dry | | |
| 320 Hardener Rapid | 15 minutes | 5 minutes |
| 310 Hardener Standard | 30 minutes | 10 minutes |
| 300 Hardener Slow | 45 minutes | 20 minutes |

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| | | |
|------------------------------|--|----------|
| Polishability | Ready to polish minimum 1 hour after cooling down. | |
| Film thickness | Recommended application (2 coats) | 45-55 µm |
| Theoretical coverage | Ready for use mixture at 1 micron layer thickness: ± 400 m ² /liter The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances. | |
| Cleaning of equipment | Use Guncleaner, or nitrocellulose thinner | |
| Product storage | Product shelf-life is determined when product are stored unopened at 20°C Avoid extreme temperature fluctuations. Shelf life: 4 year at 20°C. | |
| VOC | The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/liter VOC. The VOC content of this product in ready to use form is max. 560 g/liter. | |

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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 fulfil 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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