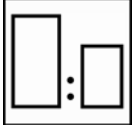


WANDABASE HS[®]

FOR PROFESSIONAL USE ONLY

Description

Wandabase HS polyester basecoat provides quick dry, good hiding and excellent color match. It can be used for small spot repairs and total resprays.



2 Parts Wandabase HS Basecoat
1 Wandabase HS Reducer 422.02999 or High Temp Reducer 422.02997



Use Wanda mixing stick



Spray gun set-up:

1.3 – 1.6 mm

HVLP max. 10 psi at air cap

Application pressure:

30-40 psi(spray gun air inlet)

o Check gun manufacturer specification



Application- metallic colors:
2 - 4 Single Coats
Or until full opacity is achieved.

Application- solid colors:
2-4 Single Coats
Or until full opacity is achieved.



Between coats:

5 -10 minutes at 70°F (20°C).

Prior to clearcoat application:

15 - 20 minutes at 70°F (20°C).



Clearcoat application

See clearcoat TDS



Use suitable respiratory protection

Akzo Nobel Car Refinishes Inc. recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Description

Wandabase HS polyester basecoat provides quick dry, good hiding and excellent color match. It can be used for small spot repairs and total resprays.

Suitable substrates

- All Existing OEM finishes, with the exception of thermoplastic acrylic finishes.
- All Wanda undercoats.

Products and additives

- Product:** - Wandabase HS Line 422, MM (Mixing Machine) colors.
- Activators / Reducers:** - Wandabase HS Reducer- 422.02999 or Wandabase HS High Temp Reducer- 422.02997
- Additives:** - None

Basic raw materials

- Wandabase HS - polyester resins, organic and inorganic pigments, solvents and additives.
- Reducer 422.02999 or 422.02997 - solvents

Surface preparation



Dry sanding with final sanding step #P500 to #P600

- o Initial sanding steps may be executed with a coarser sanding grit; for example, #P360 - #P400
- o If initially sanded with coarser paper, it must be oversanded with #P500 to #P600



Wet sanding with final sanding step #P800 to #P1000

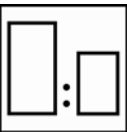
- o Initial sanding steps may be executed with a coarser sanding grit #P600
- o If initially sanded with coarser paper, it must be oversanded with #P800 to #P1000



Surface Cleaning:

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

Material preparation and mixing



2 parts by volume Wandabase HS colors.

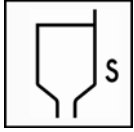
1 parts by volume Wandabase HS Reducer 422.02999 or High Temp Reducer 422.02997

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

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Spray Viscosity



18–24 seconds DIN cup #4 at 70°F (20°C).

Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure
Siphon feed	1.4-1.6 mm	30-40 psi at the spray gun air inlet
Gravity feed	1.3-1.5 mm	30-40 psi at the spray gun air inlet
Gravity feed HVLP	1.3-1.5 mm	HVLP max 10 psi at the air cap o Check gun manufacturer specification

Application process



Solid colors

Apply 2 – 4 single coats or until opacity is achieved. Flash off between coats.

Metallic colors

Apply single coats until opacity is achieved.

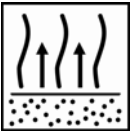
When needed, apply an orientation coat . Increase the distance to approximately 8 to 12 inches and apply a light coat .

Spot repairs

When making spot repairs apply thin coats until opacity is achieved. Flash off between each coat before fading out well beyond the edges.

In case of metallic colors air pressure adjustments may be required to achieve correct color control. Extend each coat until coverage is obtained.

Flash off time



Allow each coat to flash off for approximately 5 to 10 minutes at 70°F (20°C)

Pot-life

- All mixed solid and pearl Wandabase HS colors: Indefinite when stored in a sealed container
- Wandabase HS Metallic colors: Indefinite when stored in a sealed container



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Film thickness

Wandabase HS solid, metallic and pearl colors: Approximately 0.4-0.8 mils. (10-20 µm) per coat.

Denibbing

Allow Wandabase HS to dry sufficiently, at least 20 minutes at 70°F (20°C). Then lightly dry sand the damaged area with #P600 to #P1000 free-cut sanding paper. Thoroughly remove sanding dust residue before continuing Wandabase HS application.

Recoatable with

– Wanda 2K Clear 418.08100

Recoat time



Prior to clearcoat application:

Minimum 15 to 20 minutes at 70°F (20°C).

Maximum 24 hours at 70°F (20°C).

○ *Should this maximum time be exceeded, scuff surface and apply another coat.*

Material usage

Theoretical material usage is ± 26 sq.ft./liter (8 sq.m/liter) RTS mixture, per coat

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Cleaning of equipment

Use Wanda Reducer – 407.04001

VOC

The maximum VOC content of this product (2:1 ratio) in ready to use form is 6.8 lb. /gallon. (810gr/ltr)

Storage / shelf life

Product shelf-life is determined when products are stored unopened

Store products between 70°F and 95°F (20°C and 35°C)

Shelf life:

–Wandabase HS – minimum 3 years

–Wandabase HS Reducer 422.02999 or High Temp Reducer 422.02997 – 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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