

Technical Information

VE Wanda Metallic

28-05-2018

FOR PROFESSIONAL USE ONLY



VE Wanda Metallics is an acrylic metallic basecoat and is to be used as a basecoat/clear coat system with Wanda PU clear. It has excellent coverage, has a wide range of colors having metallic and pearlescent effects. It is suitable for all types of Automobiles and two wheelers.



Ready for Use



Equipment

Spray gun: Gravity Feed

Fluid Tip: 1.4 mm

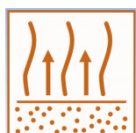
1.7-2.2 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Application of VE WE Metallic Shades

Full coat – intermediate coat – drop coat

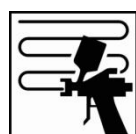


Between coats

5-10 minutes at 30°C

Before clearcoat application

15- 20 minutes at 30°C



Clearcoat application

See clearcoat T.D.S



Protection

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

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Suitable substrates	All the 2 K PU primer surfacers. All the NC surfacers and 1 K primer surfacers
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Surface preparation	Final sanding step P500
	<ul style="list-style-type: none">○ Initial sanding steps may be executed with a coarser sanding grit; P360 - P400○ Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.○
	Final sanding step P1000

	<ul style="list-style-type: none">○ Initial sanding steps may be executed with a coarser sanding grit P600 - P800○ Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
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Surface cleaning; remove any surface contamination prior to the application of any Wanda Easy Metallics using an appropriate surface cleaner.

Mixing Ratio	Stir the Wanda PU Metallic shades thoroughly prior to use.
	Stir VE WE Metallic thoroughly and wanda easy tinters for formula reproducibility as per standard shade
	100 VE Wanda Metallics 100 PU Thinners

Viscosity	14-15 seconds Bs-B4 at 30°C.
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Spray gun set-up and application pressure	Gravity feed	1.4 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

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Apply 1 full wet coat allowing for a 3 - 5 minutes flash-off time at 20°C until the basecoat dries completely to a matt /semi gloss finish. Next apply an intermediate coat until achieving opacity and allow again a 3-5 minutes flash-off time at 20°C until the basecoat dries completely to a matt /semi gloss finish.

When needed, apply a drop coat (metallic orientation coat) by reducing the pressure to 1-1 ½ bar at the gun inlet and apply the drop coat with full trigger, increase the distance to approximately 30 cm.

*Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.

Application

Spot repairs:

When making spot repairs use lower application pressure and apply thin coats until reaching opacity.

Allow for a 3-5 minutes flash-off time at 20°C between coats. Next, fade out, by extending beyond the edges, using similar application pressure. In case of metallic colors apply a drop coat (metallic orientation coat)

when needed by increasing the spray gun distance.

*Allow for a minimum of 15 minutes final flash-off time at 20°C before clearcoat application.

Film thickness	By using the recommended application; VE Wanda Metallics , 2 coat	15 – 20 micons
Masking	VE Wanda Metallic shades can be taped after 20 minutes flash-off at 20°C. Temperature increase in combination with air movement increase the ability for masking. Let the object cool down to ambient temperature before masking.	
Denibbing	Allow VE Wanda Metallic shades to flash off sufficiently, at least 20 minutes at 20°C. Then lightly sand the damaged area with P500 free-cut dry or P1000grit wet sanding paper sanding paper.	
Recoatable with	All PU Clears	
Drying time	Flash off: 5-10 Min at 30 deg Surface Dry / Handleable time: 15-20 Min at 30 deg metallic shades must be recoated within: 90 minutes max.	

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Theoretical coverage	By using the recommended application the theoretical material usage is $\pm 160 \text{ ft}^2/\text{l RTS}$ mixture. 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 2K PU Thinner (any)
Shelf life	24 months at 20°C

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Head Office

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Technical Information

Wanda Easy Solids

24-04-2018

FOR PROFESSIONAL USE ONLY



Wanda easy solid Shades is a two-pack oil polyester modified Polyurethane (PU) Finish Coat. It has very good coverage, high gloss and is suitable for all types of vehicles. It has good polishing properties.



Ready for Use



Equipment

Spray gun: Gravity Feed

Fluid Tip: 1.2-1.4 mm

1.7-2.2 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



Application

2 Coat application



Drying times

20 mins at 20°C



Protection

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

Read complete TDS for detailed product information

Technical Information

Wanda Easy Solids

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All the 2 K primer surfacers.
All the NC surfacers and 1 K primer surfacers.

For the betterment of corrosion resistance it is advisable to apply Etch primer followed by PUPS and Oil Primer followed by NC surfacers.

Suitable substrates

For absorptive substrates: Wood, MDF, Gypsum board etc.

Sand the substrate with suitable emery paper to remove loose particles and dust off.
Apply two – three coats of primer to get sheen on the cured substrate.
Apply PU surfacer and then finish off with Wanda PU topcoat

This product is not recommended for application on alkaline substrates

Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure

Surface preparation

Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.

Surface cleaning; remove any surface contamination prior to the application of any Wanda easy PU Solids using an appropriate surface cleaner.

Shake well before use.

Mixing Ratio

Stir the Wanda easy PU Neutral base , Adjustor clear and Wanda easy range of tinters thoroughly for reproducibility of color formula as standard.
5:1:25 -35 % by Vol.
5 parts Wanda Easy Solids : 1 part HS Hardener : 25-35 % Slow/ extra slow thinner.

Viscosity

18-24 seconds Bs-B4 at 30°C.

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Spray gun set-up and application pressure

Gravity feed	1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap
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Spray 2 single wet coats, allowing for a flash-off time of 8-12 minutes between coats

Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow.

For better life and aesthetic appearance of Solid shades, one full single coat of any PU clear will suffice.

Overall repair

Application

Pay attention to the application method. Spray procedure has to ensure proper overspray melting which is achieved within 2 min. of the clear application. Plan the process to avoid dry overspray.

Spot repair (Fade Out Thinner method)

When spot repairing , the following solid coat method can be used. If blending out the solid coat in original areas is unavoidable, the melt-in of the solid shade can be achieved as follows:

- Apply PU Fade Out Thinner over the spot after surface preparation. Allow to dry for 10 – 15 minutes in ambient conditions.
- Apply 1 coat of above solid shade over the sanded ground, extending into the area surrounding the spot.
- Apply a 2nd coat of the Wanda easy PU Solid shade, extending further into the area surrounding the spot.

Film thickness

40 – 45 micons

Drying time

At 30°C & 60-65 % RH

Dust free time - 45 to 55 minutes
Dry to handle - 5 to 6 hours
Hard dry time - Overnight

Baking shedule - 55 - 65 minutes at 60°C to 80°C

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24-04-2018

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Theoretical coverage	<p>By using the recommended application the theoretical material usage is 125 -130 ft²/l RTS mixture.</p> <p>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.</p>
Cleaning of equipment	<p>Use 2K PU Thinner (any)</p>
Shelf life	<p>24 months at 20°C</p>

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