

Technical Information

Wanda 610 1K Plastic Primer —W2.01.02



Quick drying, one-pack adhesion primer for plastic parts in vehicle refinishes.



Mixing ratio

Ready for use



Equipment

Spray gun set-up: 1.2-1.4 mm

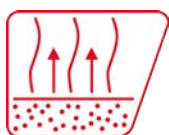
Application pressure: 1.7-2.2 bar

*See user manual spray gun



Application

1 coat



Flash-off

20 minutes



Recoatability

All Wanda primers, basecoats and topcoats (*within 24 hours*)



Protection

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

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Product and Additives	610 1K Plastic Primer		
Basic Raw Materials	610 1K Plastic Primer: Polyester resins		
Suitable substrates	All plastic car body parts currently available in the automotive industry with the exception of those made of pure PE (polyethylene)		
	<i>Note: Do not apply 1K Plastics Primer to plastic parts that are already pre-treated with OEM primer</i>		
Surface preparation	Pre-clean the surface with warm water and detergent and rinse sufficiently with clean water. Remove surface contamination with Wandabase SB Degreaser		
Mixing Ratio	610 1K Plastics Primer is ready for use (shake 5 seconds before use)		
Viscosity	15-17 seconds DIN Cup 4 at 20°C		
Spray gun set up and application pressure	Gravity feed	Fluid tip 1.2-1.4 mm	Pressure 1.7-2.2 bar* HVLP max 0.7 at air cap
	*See user manual spray gun used		
Application	Apply 1 even coat		
Cleaning of equipment	Use Wandabase Guncleaner		
Film thickness	1-4 µm		
Recoat time	Allow for a minimum of 20 minutes flash-off time at 20°C before recoating. Apply the fillers or topcoats within 24 hours at 20°C		
Recoatable with	Wanda fillers, basecoats and topcoats		
Theoretical coverage	Ready for use mixture at 1 micron layer thickness: ± 11 m ² /liter The practical coverage depends on several factors i.e. shape of the object, roughness of surface, application method and application circumstances.		
Product storage	Avoid extreme temperature fluctuations.		
Shelf life	Product shelf-life is determined when products are stored unopened 1K Plastics Primer: 2 years at 20°C		
VOC	2004/42/IIb(e)(840)780 The EU limit value for this product (product category: IIb(e)) in ready to use form is 840 gram/liter of VOC. The VOC content of this product in ready to use form is max. 780 gram/liter.		

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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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