

Technical Information

Wanda 640 Filler Multi —W2.02.05

Two-component VOC compliant filler with sanding and non-sanding properties. Available in white, black, and grey for optimal coverage of the topcoat.

Sanding



Degreaser



P280-P320



P400-P600



Mixing ratio Sanding version

- 5: 5 parts by volume of Wanda 640 Filler Multi Grey
 - 1: 1 part of volume of Wanda Flexi Hardener (any)
 - 1: 1 part of volume of Wanda Thinner
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Mixing stick

Use Wanda measuring stick
W9



Equipment

Spray gun set up: 1.6-2.0mm
Application pressure: 1.6-2.0 bar

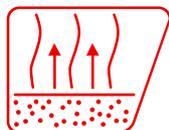


Application

1-3 coats

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Flash-off

Between coats and before bake 5-10 minutes



Drying:

Dry to sand*:

20°C

3-5 hours

60°C

30-40 minutes

**Depending on environmental circumstances*



Protection

Use suitable respiratory protection.

AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

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Products and Additives Wanda 640 Filler Multi Grey
Wanda 320 Hardener Rapid / 310 Hardener Standard / 300 Hardener Slow
Wanda Thinners 100 Slow / 110 Standard / 120 Rapid

Basic Raw Materials Filler: acrylic resin
Hardener: poly-isocyanate resin

Suitable substrates Existing Finishes, including;
Thermoplastic acrylic finishes,
Wash primers\Polyester Putties,
Bare steel surfaces,
660 1K Etch Primer
610 1K Plastic Primer
630 2K Epoxy Primer
Thoroughly cleaned un-sanded OEM Electrocoat
If application on aluminium and galvanized is required first apply Wanda 660 1K Etch Primer

Surface preparation **Existing Finishes:** Degrease and sand with P220-P320 dry or P400-P600 wet
Polyester Putties: Sand with P220-P320 dry
Bare Steel Surfaces: Degrease and sand with P220-P320 dry

GreyBase Please use the WANDA GreyBase poster to decide which grey shade should be used for the car under repair or use the recommendation in the MIXIT link:

Wanda GreyBase	Code
GreyBase 30	GB-30
GreyBase 25	GB-25
GreyBase 20	GB-20
GreyBase 15	GB-15
GreyBase 10	GB-10

Mixing 5: 5 parts by volume of Wanda 640 Filler Multi Grey
Sanding version 1: 1 part of volume :320 Hardener Rapid / 310 Hardener Standard / 300 Hardener Slow
1: 1 part of volume of Wanda Thinners 100 Slow / 110 Standard / 120 Rapid

Spraying Viscosity 23-25 seconds at 20°C

Pot-life 60 minutes at 20°C

Spray gun fluid tip and working pressure Spray gun: Fluid tip: Pressure:
Gravity feed: 1.6 – 2.0 mm 1.7-2.0 bar

Application process Apply 1-3 single coats, allowing for 5 to 10 minutes flash off time between coats. If force dried, allow for a minimum flash-off time of 5-10 minutes before bake.

Film thickness 50-60 pm per coat

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Color Available in white, grey, and black

VOC The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC. The VOC content of this product in ready to use form is max. 540 g/liter.

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Wanda 640 Filler Multi Grey is a two pack white, black and grey colored, VOC compliant medium build fast drying sanding filler with very good sanding and filling properties

Non-Sanding



Degreaser



P280-P320



P400-P600



Mixing ratio Sanding version

- 6: 6 parts by volume of Wanda 640 Filler Multi Grey
- 1: 1 part of volume of Wanda 330 Hardener HS
- 3: 3 part of volume of Wanda 160 Thinner Non-Sanding



Mixing stick

Use Wanda measuring stick
W10



Equipment

Spray gun set up: 1.2-1.4mm
Application pressure: 1.7-2.2 bar

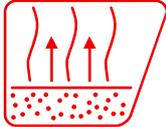


Application

1-2 coats

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Flash-off

Between coats 10-15 minutes

Before topcoat 15-20 minutes



Drying:

Dry to sand*:

20°C

6 hours

60°C

30 minutes

**Depending on environmental circumstances*



Protection

Use suitable respiratory protection.

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Products and Additives Wanda 640 Filler Multi Grey
Wanda 330 Hardener HS
Wanda Thinner 160 Thinner Non Sanding

Basic Raw Materials Filler: acrylic resin
Hardener: poly-isocyanate resin

Suitable substrates Existing Finishes, including;
Thermoplastic acrylic finishes, Wash primers

Surface preparation **Existing Finishes:** Degrease and sand with P320 dry or P600 wet

GreyBase Please use the WANDA GreyBase poster to decide which grey shade should be used for the car under repair or use the recommendation in the MIXIT link:

Wanda GreyBase	Code
GreyBase 30	GB-30
GreyBase 25	GB-25
GreyBase 20	GB-20
GreyBase 15	GB-15
GreyBase 10	GB-10

Mixing 6: 6 parts by volume of Wanda 640 Filler Multi
Non-Sanding version 1: 1 part of volume of Wanda 330 Hardener HS
3: 3 parts of volume of Wanda Thinner 160 Thinner Non Sanding

Pot-life 90 minutes at 20°C

Spray gun fluid tip and working pressure Spray gun: Fluid tip: Pressure :
Gravity feed: 1.2 – 1.4 mm 1.7-2.2 bar

Application process Apply 1 or 2 single flowing coats, allow 10-15 minutes flash off between coats and 15 to 20 minutes at 20°C before application of Basecoat/topcoats. (*Re-coatable with Wanda topcoats within 6 hrs @20°C*)

Film thickness 15-20 pm per coat

Color Available in white, grey, and black

VOC The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC. The VOC content of this product in ready to use form is max. 540 g/liter.

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