

## Technical Information

### Wanda 650 Filler HB 5:1 —W2.02.04

Two-pack high quality, quick through-hardening filler. Wanda 650 Filler HB 5:1 has very good sanding as well as high filling and application properties. Wanda 650 Filler HB 5:1 comes in black, white and grey versions which are intermixable.



**Degreaser**



**P280-P320**



**P400-P600**



**Mixing ratio**

5: 5 parts by volume of Wanda 65 Filler HB 5:1

1: 1 part of volume of Wanda 350 Hardener HB 5:1

0-20%: parts of thinner (optional) 100 Slow / 110 Standard / 120 Rapid



**Mixing stick**

Use Wanda measuring stick

**W9**



**Equipment**

Spray gun set up: 1.6-2.0mm

Application pressure: 1.6-2.0 bar

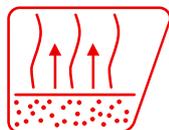


**Application**

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 minutes

## Technical Information

### Wanda 650 Filler HB 5:1 —W2.02.04



**Flash-off**  
5-10 minutes



**Drying:**

**20°C**  
3 hours

**60°C**  
60 minutes



**Protection**

Use suitable respiratory protection.

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

# Technical Information

## Wanda 650 Filler HB 5:1

### —W2.02.04



#### Products and Additives

Wanda 650 Filler HB 45:1  
Wanda 350 Hardener HB 5:1  
Wanda thinner 100 Slow / 110 Standard / 120 Rapid

#### Basic Raw Materials

Filler: acrylic resin  
Hardener: poly-isocyanate resin

#### Suitable substrates

Existing Finishes, including;  
Thermoplastic acrylic finishes,  
660 1K Etch Primer,  
610 1K Plastic Primer  
Wash primers\Polyester Putties,  
Bare steel surfaces, 2K Epoxy Primer  
Bare steel surfaces, Zinc coated steel,  
Aluminium (first apply 660 1K Etch or 630 2K Epoxy Primer)

#### Mixing

5: 5 parts by volume of Wanda 65 Filler HB 5:1  
1: 1 part of volume of Wanda 350 Hardener HB 5:1  
0-20%: parts of thinner 100 Slow / 110 Standard / 120 Rapid (optional)

#### Spraying Viscosity

20-24 seconds at 20°C

#### Surface preparation

Existing Finishes: Degrease and sand with P220-P320 grit dry or P400-P600 grit wet  
Polyester Putties: Sand with P220-P320 grit dry  
Bare steel surfaces: Degrease and sand with P80-P180 grit

#### 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

#### Pot-life

45 minutes at 20°C

#### Drying times

<b>Drying:</b>	<b>20°C</b>	<b>60°C</b>
	3 hours	40 minutes

#### Cleaning of the equipment

Use Guncleaner or a nitrocellulose thinner

#### Film thickness

80-100 pm per coat

# Technical Information

## Wanda 650 Filler HB 5:1 —W2.02.04



**Theoretical cover rate** 5.5 m<sup>2</sup> / liter per coat.

**Note:** The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application

**Recommended sanding Paper**  
Dry sanding:  
Initial sanding: P280-P320 grit  
Final sanding: P400-P500 grit

Wet sanding:  
Initial sanding: P600 grit  
Final sanding: P800-P1000 grit

**Recoatability** All Wanda topcoats

**Shelf life** Wanda 650 Filler HB 5:1: 12 months at temperatures between 5°C and 40°C  
350 Hardener HB 5:1: 12 months at temperatures between 5°C and 40°C

**Color** 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. 500 g/liter.

# Technical Information

## Wanda 650 Filler HB 5:1

### —W2.02.04

---



---

Akzo Nobel Car Refinishes B.V.  
Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim  
Tel: +31(0)71308-6944

#### **FOR PROFESSIONAL USE ONLY**

**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.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.  
Head Office  
Akzo Nobel Car Refinishes B.V., PO Box 3, 2170 BA Sassenheim, The Netherlands. [www.Wandarefinish.com](http://www.Wandarefinish.com)