

Technical Information

Wanda 850 Clear Easy —W1.05.07

An easy to apply multi-purpose 2K clearcoat system that delivers a satisfactory finish. It is suitable for all types of repairs and application conditions. Wanda 850 Clear Easy is very easy to apply and polish. Different Wanda hardeners and thinners are available to adjust the clear to different application conditions.



Mixing ratio

2: parts 850 Clear Easy
1: part Hardener 370 / 380 / 390 Easy:
10-20%: Wanda Thinners 100 Slow / 110 Standard / 120 Rapid



Mixing stick

Use Wanda measuring stick
W3



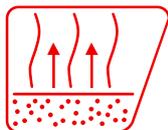
Equipment

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



Application

2 x 1 coat
First, apply a flowing closed coat, after indicated flash off time; apply a second full flowing coat.



Flash-off

Between coats: 5-10 minutes at 20°C
Before curing: 10-15 minutes at 20°C



Drying

Hardeners:	20°C	60°C
	10-12 hours	30-45 minutes*

**Object temperature*



Protection

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

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Product and Additives	Wanda 850 Clear Easy Hardener 370 Easy / Hardener 380 Easy / Hardener 390 Easy Wanda Thinners: 100 Slow-110 Standard-120 Rapid		
Suitable substrates	Solventborne Basecoats and hard dry finishes		
Mixing	2:	Parts 850 Clear Easy	
	1:	Part of Hardener 370 Easy Fast / 380 Easy Medium / 390 Easy Slow	
	10-20%	Wanda Thinners 100 Slow / 110 Standard / 120 Rapid	
Spray gun set up and application pressure	Gravity feed	1.2-1.4 mm	1.7-2.2 bar at the spray gun inlet HVLP max 0.6-0.7 bar at the air cap
Application	Apply a flowing closed layer, allowing for a 5-10* minutes flash-off time at 20°C. (depends on hardener / thinner combination used) Next, apply a full flowing layer allowing for a 10-15* minutes flash-off time at 20°C before bake.		
	* This time can be influenced by the conditions at the time of application.		
Pot-life	All hardeners 2-3 hours at 20°C		
Drying times	Dry to handle	20°C	60°C
		10-12 hours	30-45 minutes

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Infra-Red	Dry to handle after 4 minutes low power and 8 minutes high power	
Polishability	Ready to polish minimum 1 hour after cooling down.	
Film thickness	Per coat	25-30 μm
	Recommended application (2 coats)	45-60 μm
Theoretical coverage	Ready for use mixture at 50 micron dry film thickness: $\pm 6.5 \text{ m}^2/\text{liter}$	
	<i>The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.</i>	
Cleaning of equipment	Use Guncleaner, or nitrocellulose thinner	
Product storage	Product shelf- life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation. Shelf life; 4 year at 20°C.	
VOC	The VOC content of this product in ready to use form is 560 g/liter RTS mixture	

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