

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.

Technical Information

VE Wanda Metallic

28-05-2018

FOR PROFESSIONAL USE ONLY



Suitable substrates All the 2 K PU primer surfacers.
All the NC surfacers and 1 K primer surfacers

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 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.

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
--------------	--------	---

Technical Information

VE Wanda Metallic

28-05-2018

FOR PROFESSIONAL USE ONLY



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 microns

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.

Technical Information

VE Wanda Metallic

28-05-2018

FOR PROFESSIONAL USE ONLY



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

Technical Information

VE Wanda Metallic

28-05-2018

FOR PROFESSIONAL USE ONLY



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.

Coating brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel India Limited

Plot 62 P, Hoskote Industrial Area, Hoskote, Bangalore- 562114

Tel: +91 80 22047000

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

Akzo Nobel India Limited
Plot 62 P, Hoskote Industrial Area, Hoskote, Bangalore- 562114
Tel: +91 80 22047000

Technical Information

Wanda Easy Solids

24-04-2018

FOR PROFESSIONAL USE ONLY



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.

Technical Information

Wanda Easy Solids

24-04-2018

FOR PROFESSIONAL USE ONLY



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
--------------	------------	---

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

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.

Application

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 microns

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 schedule - 55 - 65 minutes at 60°C to 80°C

Technical Information

Wanda Easy Solids

24-04-2018

FOR PROFESSIONAL USE ONLY



Theoretical coverage	By using the recommended application the theoretical material usage is 125 -130 ft ² /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

Technical Information

Wanda Easy Solids

24-04-2018

FOR PROFESSIONAL USE ONLY



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.

Coating brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel India Limited

Plot 62 P, Hoskote Industrial Area, Hoskote, Bangalore- 562114

Tel: +91 80 22047000