

## Technical Information

# Wanda 670 Filler HB 4:1 Grey —W2.02.06

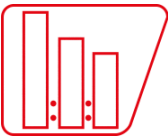
Two pack, grey colored high quality, quick through-hardening filler. 670 Filler HB 4:1 Grey is easy to apply with fast drying good sanding properties, can be applied as a high build filler without a thinner or as a lower build filler by adding one of the Wanda thinners.



### Degreaser



### P280-P320



### Mixing ratio

4: 4 parts by volume of Wanda 670 Filler 4:1 Grey

1: 1 part of volume of Wanda 400 Hardener HB 4:1 Grey

0-10%: 100 Thinner Slow/110 Thinner Standard /120 thinner Rapid (optional)



### Mixing stick

Use Wanda measuring stick

**W5**



### Equipment

Spray gun set up: 1.6-2.0mm

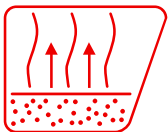
Application pressure: 1.6-2.0 bar



### Application

1-3 x 1 coat

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.



### Flash-off

5-10 minutes

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#### Drying:

Dry to sand\*:

**20°C**

3 hours

**60°C**

30 minutes

*\*Depending on environmental circumstances*



#### Protection

Use suitable respiratory protection.

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

# Basic Raw Materials

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<b>Products and Additives</b>	Wanda 670 Filler HB 4:1 Grey Wanda 400 Hardener HB 4:1 Wanda Thinners 120 Rapid/110 Standard/100 Slow
<b>Basic Raw Materials</b>	Filler: acrylic resin Hardener: poly-isocyanate resin
<b>Suitable substrates</b>	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)
<b>Mixing</b>	4: 4 parts by volume of Wanda 600 Filler 4:1 1: 1 part of volume of Wanda 340 Hardener Filler 4:1 10%: 10% by volume of Wanda Thinners (Optional)
<b>Spraying Viscosity</b>	20-24 seconds at 20°C
<b>Surface preparation</b>	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
<b>Pot-life</b>	40 minutes at 20°C
<b>Drying times</b>	<b>Dry to sand</b> At 20°C takes 3 hours and 60°C takes 30 minutes
<b>Cleaning of the equipment</b>	Use Guncleaner or a nitrocellulose thinner
<b>Film thickness</b>	70-90 µm per coat
<b>Theoretical cover rate</b>	10 m <sup>2</sup> / liter of unthinned paint if applied at 50 µm.  <b>Note:</b> The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application

# Note:

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<b>Recommended sanding Paper</b>	<b>Dry sanding:</b> Initial sanding: P280-P320 grit Final sanding: P400-P500 grit
	<b>Wet sanding:</b> Initial sanding: P600 grit Final sanding: P800-P1000 grit
<b>Recoatibility</b>	All Wanda topcoats
<b>Shelf life</b>	Wanda 670 Filler HB 4:1: Grey 12 months at temperatures between 5°C and 40°C 400 Hardener HB 4:1: 12 months at temperatures between 5°C and 40°C
<b>Color</b>	Grey
<b>VOC</b>	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.

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### 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.

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