

# Technical Information

## Wanda 850 Clear Easy

### —W1.05.07



Two-component clearcoat to be applied over Wanda solvent borne basecoats.  
It has very good scratch resistance with excellent gloss, appearance and flow.



#### Mixing ratio

2: 850 Clear Easy  
1: 370 Hardener Easy Fast / 380 Hard. Easy Medium / 390 Hard. Easy Slow  
10-20%: 100 Thinner Slow / 110 Thinner Standard / 120 Thinner Rapid



#### Mixing stick

Use Wanda measuring stick  
**W3**



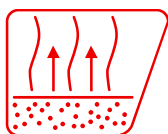
#### Equipment

Spray gun set-up: 1.2-1.4 mm  
Application pressure: 1.7-2.2 bar  
\*See user manual spray gun used



#### Application

2 x 1 coat



#### Flash-off

Between coats: 5-10 minutes  
Before curing: 10-15 minutes



#### Drying

**20°C**  
10 – 12 hours

**60°C**  
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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<b>Product and Additives</b>	850 Clear Easy 300 Hardener Slow 310 Hardener Standard 320 Hardener Rapid 370 Hardener Easy Fast 380 Hardener Easy Medium 390 Hardener Easy Slow 100 Thinner Slow 110 Thinner Standard 120 Thinner Rapid		
<b>Basic Raw Materials</b>	850 Clear Easy: Polyol resins Hardener: Poly-isocyanate resins		
<b>Suitable substrates</b>	Original finishes Wandabase MAX		
<b>Mixing Ratio</b>	2: 850 Clear Easy 1: 370 Hardener Easy Fast / 380 Hardener Easy Medium / 390 Hardener Easy Slow 10-20%: 100 Thinner Slow / 110 Thinner Standard / 120 Thinner Rapid  Use measuring stick <b>W3</b>  2: 850 Clear Easy 1: 300 Hardener Slow / 310 Hardener Standard / 320 Hardener Rapid 10-20%: 100 Thinner Slow / 110 Thinner Standard / 120 Thinner Rapid  Use measuring stick <b>W3</b>		
<b>Viscosity</b>	15-18 seconds DIN Cup 4 at 20°C		
<b>Potlife</b>	300 Hardener Slow 3 hours at 20°C 310 Hardener Standard 2 hours at 20°C 320 Hardener Rapid 1 hour at 20°C 370 Hardener Easy Fast 1.5 hours at 20°C 380 Hardener Easy Medium 2.5 hours at 20°C 390 Hardener Easy Slow 3.5 hours at 20°C		
<b>Spray gun set up and application pressure</b>	Gravity feed	<b>Fluid tip</b> 1.2-1.4 mm	<b>Pressure</b> 1.7-2.2 bar* HVLP max 0.7 at air cap  *See user manual spray gun
<b>Application</b>	Apply a flowing closed coat, allowing for a 5-10 minutes flash-off time at 20°C. Next, apply a full flowing coat allowing for a 10-15 minutes flash-off time at 20°C before bake.		

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**Cleaning of equipment** Use Wandabase Guncleaner

**Film thickness** Recommended application (2 coats) 45-60 µm

<b>Drying times</b>	<b>Easy Hardeners</b>	<b>20°C</b>	<b>60°C</b>
	Dust dry	15-30 minutes	3 minutes
	Dry to handle	10-12 hours	30-45 minutes
	<b>Hardeners</b>	<b>20°C</b>	<b>60°C</b>
Dust dry	20-40 minutes	5-15 minutes	
Dry to handle	10-12 hours	30-45 minutes	

**Theoretical coverage** Ready for use mixture at 1 micron layer thickness: ± 330 m<sup>2</sup>/liter  
The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

**Polishability** Ready to polish minimum 1 hour after cooling down.

**Product storage** Avoid extreme temperature fluctuations.

**Shelf life** Product shelf life is determined when products are stored unopened

850 Clear Easy:	4 years
300 Hardener Slow	1 year
310 Hardener Standard	1 year
320 Hardener Rapid	6 months
370 Hardener Easy Fast	1 year
380 Hardener Easy Medium	1 year
390 Hardener Easy Slow	1 year
100 Thinner Slow	4 years
110 Thinner Standard	4 years
120 Thinner Rapid	4 years

**VOC** The VOC content of this product in ready to use form is max. 600 g/liter.

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#### **FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT**

**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 fulfil 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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