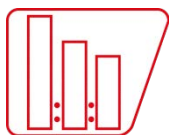


Technical Information

Wanda 860 Clear AS HS —W1.05.11



Two-component clearcoat to be applied over Wanda solventborne basecoats. 860 Clear AS HS in combination with 300 Hardener Slow can be used over both Wanda solvent and waterborne basecoats. It has very good scratch resistance with excellent gloss, appearance and flow.



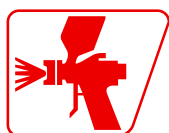
Mixing ratio

2: 860 Clear AS HS
1: 300 Hardener Slow / 310 Hardener Standard / 320 Hardener Rapid
10% 100 Thinner Slow / 110 Thinner Standard / 120 Thinner Rapid



Mixing stick

Use Wanda measuring stick
W2



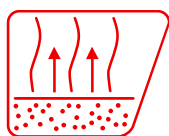
Equipment

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



Application

2 x 1 coat



Flash-off

Between coats: 8-15 minutes at 20°C
Before curing: 8-10 minutes at 20°C



Drying

Wanda Hardener 300 Slow
Wanda Hardener 310 Standard
Wanda Hardener 320 Rapid

20°C

16 hours
6 hours
4 hours

60°C

45 minutes*
30 minutes*
15 minutes*

*object temperature



Protection

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

Technical Information

Wanda 860 Clear AS HS

—W1.05.11



Product and Additives	860 Clear AS HS 300 Hardener Slow 310 Hardener Standard 320 Hardener Rapid 100 Thinner Slow 110 Thinner Standard 120 Thinner Rapid 180 Accelerator																																												
Basic Raw Materials	860 Clear AS HS: Polyol resins Hardener: Poly-isocyanate resins																																												
Suitable substrates	Original finishes Wandabase MAX																																												
Mixing Ratio	2: 860 Clear AS HS 1: 300 Hardener Slow / 310 Hardener Standard / 320 Hardener Rapid 10%: 100 Thinner Slow / 110 Thinner Standard / 120 Thinner Rapid Use measuring stick W2																																												
Viscosity	14-19 seconds DIN Cup 4 at 20°C																																												
Potlife	300 Hardener Slow 310 Hardener Standard 320 Hardener Rapid		3 hours at 20°C 2.5 hours at 20°C 1.5 hours at 20°C																																										
Spray gun set up and application pressure	Gravity feed	Fluid tip 1.2-1.4 mm	Pressure 1.7-2.2 bar* HVLP max 0.7 at air cap *See user manual spray gun used																																										
Application	Apply a flowing closed coat, allowing for a 8-15 minutes flash-off time at 20°C. Next, apply a full flowing coat allowing for a 8-10 minutes flash-off time at 20°C before bake.																																												
Cleaning of equipment	Use Wandabase Guncleaner																																												
Film thickness	Recommended application (2 coats)		45-55 µm																																										
Drying times	<table><tr><td></td><td colspan="2">20°C</td><td colspan="2">60°C</td></tr><tr><td>Standard systems</td><td>Dust dry</td><td>Dry to handle</td><td>Dust dry</td><td>Dry to handle</td></tr><tr><td>300 Hardener Slow</td><td>45 min</td><td>16 hrs</td><td>20 min</td><td>45 min</td></tr><tr><td>310 Hardener Standard</td><td>30 min</td><td>6 hrs</td><td>10 min</td><td>30 min</td></tr><tr><td>320 Hardener Rapid</td><td>15 min</td><td>4 hrs</td><td>5 min</td><td>15 min</td></tr><tr><td>Accelerated systems</td><td>Dust dry</td><td>Dry to handle</td><td>Dust dry</td><td>Dry to handle</td></tr><tr><td>310 Hardener Standard</td><td>30 min</td><td>5 hrs</td><td>12 min</td><td>20 min</td></tr><tr><td>320 Hardener Rapid</td><td>20 min</td><td>4 hrs</td><td>7 min</td><td>7 min</td></tr></table>						20°C		60°C		Standard systems	Dust dry	Dry to handle	Dust dry	Dry to handle	300 Hardener Slow	45 min	16 hrs	20 min	45 min	310 Hardener Standard	30 min	6 hrs	10 min	30 min	320 Hardener Rapid	15 min	4 hrs	5 min	15 min	Accelerated systems	Dust dry	Dry to handle	Dust dry	Dry to handle	310 Hardener Standard	30 min	5 hrs	12 min	20 min	320 Hardener Rapid	20 min	4 hrs	7 min	7 min
	20°C		60°C																																										
Standard systems	Dust dry	Dry to handle	Dust dry	Dry to handle																																									
300 Hardener Slow	45 min	16 hrs	20 min	45 min																																									
310 Hardener Standard	30 min	6 hrs	10 min	30 min																																									
320 Hardener Rapid	15 min	4 hrs	5 min	15 min																																									
Accelerated systems	Dust dry	Dry to handle	Dust dry	Dry to handle																																									
310 Hardener Standard	30 min	5 hrs	12 min	20 min																																									
320 Hardener Rapid	20 min	4 hrs	7 min	7 min																																									

Technical Information

Wanda 860 Clear AS HS

—W1.05.11



Theoretical coverage	Ready for use mixture at 1 micron layer thickness: $\pm 400 \text{ m}^2/\text{liter}$ 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 860 Clear AS HS: 4 years at 20°C
VOC	2004/42/II B(d)(420)420 The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420 g/liter VOC. The VOC content of this product in ready to use form is max. 420 g/liter.

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

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.

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