

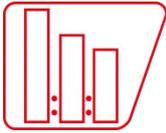
# Technical Information

## 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**



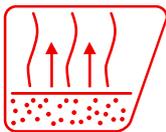
#### Equipment

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

	20°C	60°C
Wanda Hardener 300 Slow	16 hours	45 minutes*
Wanda Hardener 310 Standard	6 hours	30 minutes*
Wanda Hardener 320 Rapid	4 hours	15 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>	860 Clear AS HS 300 Hardener Slow 310 Hardener Standard 320 Hardener Rapid 100 Thinner Slow 110 Thinner Standard 120 Thinner Rapid 180 Accelerator
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<b>Basic Raw Materials</b>	860 Clear AS HS: Polyol resins Hardener: Poly-isocyanate resins
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<b>Suitable substrates</b>	Original finishes Wandabase MAX
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<b>Mixing Ratio</b>	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 <b>W2</b>

<b>Viscosity</b>	14-19 seconds DIN Cup 4 at 20°C
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<b>Potlife</b>	300 Hardener Slow	3 hours at 20°C
	310 Hardener Standard	2.5 hours at 20°C
	320 Hardener Rapid	1.5 hours at 20°C

<b>Spray gun set up and application pressure</b>	<b>Fluid tip</b>	<b>Pressure</b>
	Gravity feed	1.2-1.4 mm
		1.7-2.2 bar* HVLP max 0.7 at air cap
	*See user manual spray gun used	

<b>Application</b>	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.
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<b>Cleaning of equipment</b>	Use Wandabase Guncleaner
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<b>Film thickness</b>	Recommended application (2 coats)	45-55 µm
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<b>Drying times</b>	<b>Standard systems</b>	<b>20°C</b>		<b>60°C</b>	
		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
	<b>Accelerated systems</b>	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

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<b>Theoretical coverage</b>	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.
<b>Polishability</b>	Ready to polish minimum 1 hour after cooling down.
<b>Product storage</b>	Avoid extreme temperature fluctuations.
<b>Shelf life</b>	Product shelf-life is determined when products are stored unopened 860 Clear AS HS: 4 years at 20°C
<b>VOC</b>	<b>2004/42/II B(d)(420)420</b> 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.

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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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