

Technical Information

Wanda 820 Clear AS Express —W1.05.01



For a faster clearcoat process, Wanda 820 Clear AS Express is the answer. This flexible anti-scratch clearcoat is ideal for fast spot repairs in all conditions. It produces a consistent, fast drying, easy to polish and durable finish.



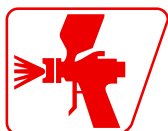
Mixing ratio

2: 820 Clear AS Express
1: 310 Hardener Standard / 320 Hardener Rapid
10-20%: 110 Thinner Standard / 120 Thinner Rapid / 180 Accelerator



Mixing stick

Use Wanda measuring stick
W3



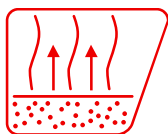
Equipment

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



Application

2 x 1 coat



Flash-off

Between coats: 3-5 minutes
Before curing: 5-7 minutes



Drying

Wanda Hardener:
+180 Accelerator

20°C

2-4 hours
1 ¾ hours

60°C

7-15 minutes*
12-15 minutes*
*object temperature



Protection

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

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Product and additives	820 Clear AS Express 310 Hardener Standard 320 Hardener Rapid 110 Thinner Standard 120 Thinner Rapid 180 Accelerator																																												
Basic Raw Materials	820 Clear AS Express: Hardener:	Polyol resins Poly-isocyanate resins																																											
Suitable substrates	Original finishes waterborne basecoats solventborne basecoats																																												
Mixing Ratio	2: 820 Clear AS Express 1: 310 Hardener Standard / 320 Hardener Rapid 10-20%: 110 Thinner Standard / 120 Thinner Rapid / 180 Accelerator Use measuring stick W3																																												
Viscosity	14-17 seconds DIN Cup 4 at 20°C																																												
Potlife	3 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 3-5 minutes flash-off time at 20°C. Next, apply a full flowing coat allowing for a 5-7 minutes flash-off time at 20°C before bake.																																												
Cleaning of equipment	Use Wandabase Guncleaner																																												
Film thickness	Recommended application (2 coats)		40-50 µm																																										
Drying times	<table><thead><tr><th></th><th colspan="2">20°C</th><th colspan="2">60°C</th></tr></thead><tbody><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>310 Hardener Standard</td><td>15 min</td><td>> 4 hrs</td><td>4 min</td><td>15 min</td></tr><tr><td>320 Hardener Rapid</td><td>9 min</td><td>> 4 hrs</td><td>4 min</td><td>7 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>15 min</td><td>1 hr 55 min</td><td>7 min</td><td>15 min</td></tr><tr><td>320 Hardener Rapid</td><td>10 min</td><td>1 hr 45 min</td><td>5 min</td><td>12 min</td></tr><tr><td>Infra-Red:</td><td colspan="2">4 minutes low power</td><td colspan="2">8 minutes high power</td></tr></tbody></table>						20°C		60°C		Standard systems	Dust dry	Dry to handle	Dust dry	Dry to handle	310 Hardener Standard	15 min	> 4 hrs	4 min	15 min	320 Hardener Rapid	9 min	> 4 hrs	4 min	7 min	Accelerated systems	Dust dry	Dry to handle	Dust dry	Dry to handle	310 Hardener Standard	15 min	1 hr 55 min	7 min	15 min	320 Hardener Rapid	10 min	1 hr 45 min	5 min	12 min	Infra-Red:	4 minutes low power		8 minutes high power	
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Theoretical coverage	Ready for use mixture at 1 micron layer thickness: $\pm 321 \text{ m}^2/\text{liter}$ 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 820 Clear AS Express: 2 years at 20°C
VOC	2004/42/II B(e)(840)580 The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840 g/liter VOC. The VOC content of this product in ready to use form is max. 580 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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