



North America

Programmed System Technique (PST)

Primer

08/17/2020

Wet-On-Wet Sealer

Wanda Wet-On-Wet Sealer is a non-sanding sealer providing excellent leveling, opacity and topcoat appearance on properly prepared substrates in National Rule areas.



Safety Considerations

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.



Suitable Substrates

- Existing Finishes
- Bare Metal
 - Not recommended over bare aluminum or galvanized steel
- Autoprep Pretreatment Wipes or Wanda Pre-Treatment Cut Thru Wipe materials



Mix

4

1

By Volume

- Parts Wanda Wet-On-Wet Sealer
- Part Wanda 2K Hardener (Standard, Slow, or Extra Slow)

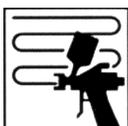


Spray-Gun Set-Up:

- 1.2 – 1.6mm HVLP Gravity
- 1.2 – 1.6mm Compliant

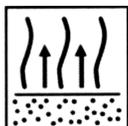
Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap maximum.
- Consult manufacturer specifications.



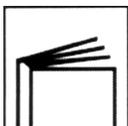
Application

- 1 x 1 Coats (One single medium wet coat)



Flash at 70°F (21°C) Before Topcoating

- 20 minutes



Recoating

- Recoatable wet-on-wet (minimum): 20 minutes
- Recoatable wet-on-wet (maximum): 8 hours
 - After 8 hours, sand surface with 800 grit and apply single coat of Wanda Sealer.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information.

**Wet-On-Wet Sealer****Description**

Wanda Wet-On-Wet Sealer is a non-sanding sealer providing excellent leveling, opacity and topcoat appearance on properly prepared substrates in National Rule areas.

Suitable Substrates

- Existing finishes
- Bare metal
 - Not recommended over bare aluminum or galvanized steel
- AutoPrep Pretreatment Wipes or Wanda Pre-Treatment Cut Thru Wipe materials

Products and Additives

Product	Wanda Wet-On-Wet Sealer	Item #396253 / 405.03100.04 (0.9 L) Item #562913 / 405.03100.01 (1 Gal)
Hardeners	Wanda 2K Hardener Standard	Item #391714 / 418.03093.03 (1 L) Item #391715 / 418.03093.30 (0.225 Lt)
	Wanda 2K Hardener Slow	Item #391712 / 418.03090.03 (1 L) Item #391713 / 418.03090.30 (0.225 L)
	Wanda 2K Hardener Extra Slow	Item #397741 / 418.03088.03 (1 L)
Additives	Wanda Flex Additive LV	Item #578979 (0.9 L)

Basic Raw Materials

- Wanda Wet-On-Wet Sealer - Acrylic resins, organic and inorganic pigments, solvents and additives.
- Wanda 2K Hardeners (Standard, Slow, Ex. Slow) - Polyisocyanate resins and solvents.

Substrate Preparation**Pre-Cleaning**

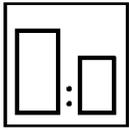
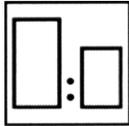
- Pre-wash the repair with warm soap and water. Rinse completely with clean water.

**Sanding Preparation**

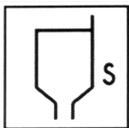
- Final sanding steps: #P320-#P400 grit dry.

**Surface Cleaning – Prior to Paint Application**

- Remove any surface contamination prior to topcoat application using WandaClean Degreaser.

**Wet-On-Wet Sealer****Mixing****Mixing**
4
1Parts by volume Wanda Wet-On-Wet Sealer
Part by volume Wanda 2K Hardener (Standard, Slow, or Extra Slow)**Mixing – Flexible Parts**If the part to be painted can be deformed by hand, increase the flexibility of Wanda Wet-On-Wet Sealer as follows:

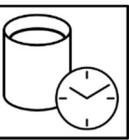
- Add 15% Flex Additive LV by volume to Wanda Wet-On-Wet Sealer prior to activating and reducing. Mix well and follow with the Wanda Wet-On-Wet Sealer activation ratio.

Viscosity When Mixed

DIN #4

18-22
seconds

Measured with a DIN #4 viscosity cup at 70°F (21°C).

Pot-Life When Mixed**Product Mix**

- Wanda 2K Hardener Standard

70°F (21°C)

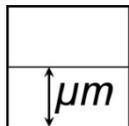
2 hours

Spray Gun Set-Up**Consult spray gun manufacturer instructions for gun pressure specifications.**

Spray Gun	Fluid Tip	Application Pressure
Siphon Feed	1.6 mm	40-45 psi at the spray gun air inlet
Gravity Feed	1.2-1.5 mm	40-45 psi at the spray gun air inlet
Gravity HVLP	1.2-1.5 mm	HVLP 10 psi (<0.7 bar) at the air cap, maximum. *Check gun manufacturer specifications.

Application

- Apply one medium wet coat.

**Wet-On-Wet Sealer****Film Thickness – Using Suitable Application**

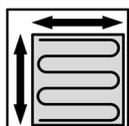
- 1 Coat will achieve a thickness of 1.0-1.5 mils (15-30 μm).

Drying / Curing Time**Dry Time at 70°F (21°C):**

- Recoatable wet-on-wet (minimum): 20 minutes
- Recoatable wet-on-wet (maximum): 8 hours
 - ✓ Drying times are stated based on the recommended application method, film thickness and object temperature.
 - ✓ After 8 hours, sand surface with 800 grit and apply single coat of Wanda Sealer before continuing.

Cleaning of Equipment

- Clean equipment following local and federal regulations using Wanda Reducer.

Theoretical Coverage

- Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others.
 - +/- 129 square feet per liter

VOC / Regulatory Information

- The maximum VOC content of this product ready to spray is 4.6 lbs/gal (550 g/liter).

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Product Storage

	Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).	
	Wanda Wet-On-Wet Sealer	2 years
	Wanda 2K Hardeners (Standard, Slow and Very Slow)	2 years

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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 Safety 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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