



Smart Look. Smart Choice.

North America

Technical Data Sheet  
primers/surfacers  
2.2.2011

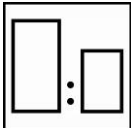
# Wanda Low VOC Primer

FOR PROFESSIONAL USE ONLY

## Description

Wanda Low VOC Primer is gray in color offering good filling and sanding properties, excellent holdout, fast dry, and good adhesion on properly prepared substrates. Wanda Low VOC Primer can be used as either a high build primer / primer surfacer or non sanding / wet on wet sealer.

## Primer / Primer Surfacer



- 4 Wanda Low VOC Primer
- 1 Wanda Low VOC Hardener



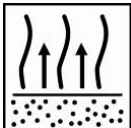
Use Wanda Universal Mixing Stick



Gravity spray gun set-up: 1.7-1.9 mm      Application pressure: HVLP Max 10 psi at air cap  
 ➤ Check gun manufacturer specification



3-4 coats



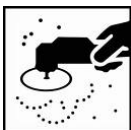
Between coats: 5 – 10 minutes at 70° F (20° C)      Before curing: 5 – 10 minutes at 70° F (20° C)



3 coat application  
 3 hours at 70° F (20° C)  
 30 minutes at 140° F (60° C)



5 minutes low power  
 5 minutes high power



Sanding for topcoat: Final sanding step: #P500 to P600 dry / #P400 to P500 wet  
 Sanding for sealer: Final sanding step: #P400 to P500 dry / #P320 to P400 wet



Recoatable with all Wanda LV sealers and topcoats



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

Read complete TDS for detailed product information





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## Description

Wanda Low VOC Primer as a wet-on-wet non-sanding sealer provides excellent leveling, opacity and topcoat appearance. Wanda Low VOC Primer is gray in color and not tintable.

## Non-sanding sealer



- 4 Wanda Low VOC Primer
- 1 Wanda Low VOC Hardener
- 1 Wanda Low VOC Reducer



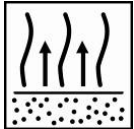
Use Wanda Universal Mixing Stick



Gravity spray gun set-up:                      Application pressure:  
 1.3-1.5 mm    HVLP Max 10 psi at air cap  
 ➤ Check gun manufacturer specification



1 full wet coat



Recoat, Wet – On – Wet time:                      Recoat within:  
 15-30 minutes at 70° F (20° C)                      8 hours at 70° F (20° C)



Recoatable with all Wanda LV topcoats



Use suitable respiratory protection  
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## Description

Wanda Low VOC Primer is gray in color offering great filling and sanding properties, excellent holdout, fast dry, and good adhesion on properly prepared substrates. Wanda Low VOC Primer can be used as either a sanding filler / surfacer or non sanding / wet on wet primer sealer.

## Suitable substrates

Existing finishes, properly sanded, in good condition  
OEM electro coat (Ecoat) properly sanded

Glass Reinforced Polyester laminates (GRP) or  
Polyester bodyfillers properly sanded

- Although Wanda Low VOC Primer will provide adequate adhesion on small bare metal areas, repairs which require extensive metal priming such as whole panel and panels that have had the existing paint system removed require Auto Prep wipe pre-treatment application prior to Wanda Low VOC Primer.

**(GRP) Under no circumstance should Wanda Low VOC Primer be applied if the gelcoat has been broken or sanded through on polyester laminates. A suitable surfacer should first be applied. Check with manufacturer for recommendation.**

## Product and additives

**Products** Wanda Low VOC Primer :

**Hardeners** Wanda Low VOC Hardener:

**Reducers** Wanda Low VOC Reducer :

**Additives** Wanda Elastic Additive: to increase flexibility of Wanda Low VOC Primer for use on very flexible parts





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## Basic raw materials

Wanda Low VOC Primer :  
Wanda Low VOC Hardener:  
Wanda Low VOC Reducer:

Acrylic and polyester resins  
Polyisocyanate resin  
VOC exempt and non exempt solvents

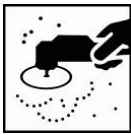
## Surface preparation



Surface Cleaners

➤ In areas where VOC emissions regulations apply, use recommended pre-cleaning product.

If necessary, pre-wash the surface with warm water and soap, rinse sufficiently with clean water and dry.



**Sanding Primer Surfacer;** final dry sanding steps; #P240 to #P320

➤ Polyester bodyfillers ; finish with;#P180 to #P220 grit paper dry.

**Wet on Wet Sealer;** final dry sanding step #P320 to #P400

➤ Feather edge sanding in case of repair area, finish with #P400

➤ Wanda Low VOC Primer can be applied to rigid OEM Ecoated parts that have been thoroughly sanded with a red Scotchbrite, cleaned and degreased.



Surface Cleaners

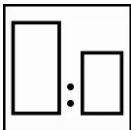
In case of polyester bodyfiller use, avoid contact with water (e.g. waterborne degreaser)

## Stir before use



After adding Wanda Low VOC Hardener, stir thoroughly prior to adding optional Wanda Low VOC Reducer.

## Mixing



**High build primer filler / Surfacer:**

4 Wanda Low VOC Primer  
1 Wanda Low VOC Hardener

**Non sanding sealer (wet-on-wet):**

4 Wanda Low VOC Primer  
1 Wanda Low VOC Hardener  
1 Wanda Low VOC Reducer

Use the Wanda Universal Mixing Stick

4:1 Primer filler

4:1:10 Primer surfacer (optional)

Use the Wanda Universal Mixing Stick

4:1:1 Small repairs & cooler temperatures

4:1:2 Large repairs & overall, higher temperatures (optional)

## Flexible car parts

Refer to Wanda Elastic Additive TDS for detailed product and application information to increase flexibility of Wanda Low VOC Primer for use on very flexible parts.





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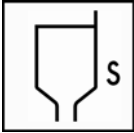
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## Viscosity



### High build primer / Surfacers:

18 – 22 seconds DIN cup #4 at 70°F (20°C)

### Non sanding sealer:

14 – 16 seconds DIN cup #4 at 70°F (20°C)

## Spray gun set-up / application pressure



### Spray gun

Gravity feed

### Fluid tip-set-up Sanding

1.7-2.0 mm

### Application pressure

29 psi at the spray gun air inlet  
HVLP max 10 psi at the air cap

### Wet on wet

Gravity feed

1.3-1.5 mm

29 psi at the spray gun air inlet  
HVLP max 10 psi at the air cap

➤ Check gun manufacturer specification

## Pot-life

### At 70°F (20°C)

Wanda Low VOC Hardener

### Sanding Surfacers:

50 min.at 70°F (20°C)

### Non sanding sealer:

50 min. at 70°F (20°C)

## Application



**Sanding surfacer;** For use on repair (polyester bodyfiller) or sanded areas apply one coat over the repair, and then apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat.

Where a full panel application is required, apply 2-3 coats over the total panel

- Flash off between the coats until the surface becomes totally matt, this will depend on ambient temperature, applied layer thickness and airflow.

### Wet on wet (non sanding sealer)

Apply 1 thin but flowing coat over the desired area.

- Over any sand through areas, first apply a thin coat to make all the substrate layers uniform before continuing with the normal coat.
- **Alternate application;** Wanda Low VOC Primer mixed as a surfacer (4:1:20%) may be used wet-on-wet when edging in parts. In this case, apply one coat of Wanda Low VOC Primer . Apply topcoat after 15 minutes to a maximum of 45 minutes at 70°F (20°C).  
After a drying time of longer than 1.5 hours, thorough sanding is necessary for adhesion of top coat

## Film thickness when using the recommended application

### Sanding Surfacers: (mixing ratio 4:1)

1 coat

1.5 – 1.8 mils (37 - 45µm)

3 coats

4.0 – 5.0 mils (100 -125µm)

### Non sanding sealer: (mixing ratio 4:1:1)

1 coat

1.0 – 1.2 mils (25 - 30µm)





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### Drying time; sanding filler / surfacer:



3 hours at 70°F (20°C)

30 minutes at 140°F (60°C)

Drying times relate to recommended application (3-4 coats) and object temperature



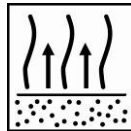
Distance between short wave IR unit and object. 20- 27inches (50-70 cm)

Allow 3 to 5 minutes flash off before Infra red curing

Cure 5 minutes low power setting followed by 5 minutes high power setting.

- The panel must not reach a temperature above 100°C while curing.

### Flash-off time wet-on-wet Non sanding sealer:



Prior to the topcoat application allow a minimum of 15-30 minutes flash off time up to a maximum of 8 hours at 70°F (20°C).

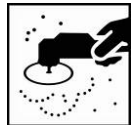
Should this maximum time be exceeded, Wanda Low VOC Primer wet on wet should be sanded prior to topcoat application, either with #P500 to #P600 dry or #P800 wet sanding paper.

### Denibbing wet-on-wet:

For minor defects (e.g. dust) Wanda Low VOC Primer can be denibbed with #P500 dry or #P800 wet after 15-20 minutes at 70°F (20°C)

After a drying time of longer than 8 hours thorough sanding is necessary! If sanding is necessary, this may be done after 12 hours at 70°F (20°C) or 30 minutes at 140°F (60°C)

### Final sanding; sanding surfacer



Final dry sanding step #P400 to #P500 before application of Wanda LV topcoats

- Initial sanding steps may be executed with a coarser sanding grit; #P320 to #P400



Final wet sanding step #P500 to #P600 before application of Wanda LV topcoats.



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

- In areas where VOC emissions regulations apply, use recommended pre-cleaning product.

### Recoatable with

All Wanda top coats that are VOC compliant for the area.

### Theoretical coverage

**High Build Primer** per coat of unmixed paint; 96 sq.ft/liter (9 m<sup>2</sup>/liter)

**Filler / Surfacer:**

**Wet-on-wet Sealer:** per coat of unmixed paint; 150 sq.ft/liter (14 m<sup>2</sup>/liter)

- *The practical coverage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*





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## Cleaning of equipment

Waterborne gun cleaner

## VOC

System	Mix Ratio	VOC not to exceed
Filler / Surfacers	4:1:20%	2.1 lb/gal (250 g/Liter)
Sealer	4:1:1-2	2.1 lb/gal (250 g/Liter)

## Product storage

Store products unopened, and used products with closed lids preferably between 50°F-95°F (10°C-35°C)  
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

Wanda Low VOC Primer : 1 year  
Wanda Low VOC Hardener : 6 months  
Wanda Low VOC Reducer : 1 year

**AkzoNobel Car Refinishes Inc. North America**  
**Address: 5555 Spalding Drive, Norcross. GA 30092 USA**  
**Tel: 770-662-8464**

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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 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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### Head Office

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