**Wanda Low VOC Clear**

FOR PROFESSIONAL USE ONLY

**Description**

The Wanda Low VOC Clear is an acrylic urethane clearcoat for use over Wanda Waterbase. Intended for ambient cure or low bake conditions, this clear offers excellent resistance to surface contamination with excellent gloss, making it an ideal choice for air dry environments. It also meets the regulatory requirements for clearcoats at 250 g/liter VOC.

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wanda Low VOC Standard Clear or Wanda Low VOC Slow Clear</td>
<td>2</td>
</tr>
<tr>
<td>Wanda Low VOC Hardener</td>
<td>1</td>
</tr>
<tr>
<td>Wanda Low VOC Reducer (optional- high temp / large areas)</td>
<td>0-10%</td>
</tr>
</tbody>
</table>

Use Wanda Universal Mixing Stick

Gravity spray gun set-up:
- 1.3 - 1.4 mm

Application pressure:
- HVLP Max 10 psi at air cap
- Check gun manufacturer specification

2 coats

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

Air Drying:
- Dust free:
  - 15 minutes at 70°F (20°C)
- Dry to handle:
  - 1 to 1½ hours at 70°F (20°C)

Force drying:
- Dry to handle:
  - 30 minutes at 120° F (49° C)

Polishing:
- (Color-sand and compound):
  - 2 to 3 hours at 70°F (20°C)
  - 30 minutes at 120° F (49°C)

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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Suitable substrates

- Wanda Waterbase
- Allow the base coat color a minimum flash off time of 20 minutes at 77°F (25°C) or until matte
- Existing finish that is thoroughly prepared, in the case of spot repairs and blending.

Product and additives

<table>
<thead>
<tr>
<th>Products</th>
<th>Wanda Low VOC Standard Clear or Wanda Low VOC Slow Clear</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardeners</td>
<td>Wanda Low VOC Hardener</td>
</tr>
<tr>
<td>Reducers</td>
<td>Wanda Low VOC Reducer (optional- high temp / large areas)</td>
</tr>
<tr>
<td>Additives</td>
<td>Wanda Elastic Additive – to increase flexibility of Wanda Low VOC Clear for use on very flexible parts</td>
</tr>
</tbody>
</table>

Basic raw materials

- Wanda Low VOC Clear: Acrylic Polyol resins
- Wanda Low VOC Hardener: Polyisocyanate resins
- Wanda Low VOC Reducer: ~VOC exempt and non exempt solvents

Mixing

2 Parts by volume Wanda Low VOC Standard or Slow Clear *
1 Part by volume Wanda Low VOC Hardener.

0-10% Parts by volume Wanda Low VOC Reducer (optional- high temp / large areas)

* For facilities located within the Bay Area Air Quality Management District of California: in order to comply with VOC regulations, we recommend the following mix when using Wanda Low VOC Standard Clear:

1 Part by volume Wanda Low VOC Standard Clear
1 Part by volume Wanda Low VOC Slow Clear
1 Part by volume Wanda Low VOC Hardener

Use the Wanda Universal Mixing Stick

Flexible car parts

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

Viscosity

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

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Spray gun set-up / application pressure

<table>
<thead>
<tr>
<th>Spray gun:</th>
<th>Fluid tip-set-up:</th>
<th>Application pressure:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Siphon feed</td>
<td>1.4-1.5 mm</td>
<td>40 to 50 psi at the spray gun air inlet</td>
</tr>
<tr>
<td>HP Gravity</td>
<td>1.3-1.4 mm</td>
<td>40 to 50 psi at the spray gun air inlet</td>
</tr>
<tr>
<td>RP Gravity</td>
<td>1.3-1.4 mm</td>
<td>35 psi at the spray gun air inlet</td>
</tr>
<tr>
<td>HVLP Gravity</td>
<td>1.3-1.4 mm</td>
<td>29 psi at the spray gun air inlet</td>
</tr>
<tr>
<td></td>
<td></td>
<td>~HVLP max 10 psi at the air cap.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>~Check gun manufacturer specification</td>
</tr>
</tbody>
</table>

Pot-life

<table>
<thead>
<tr>
<th>With:</th>
<th>At 70°F (20°C)</th>
<th>At 95°F (35°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wanda Low VOC Standard or Slow Clear</td>
<td>45 minutes</td>
<td>30 minutes</td>
</tr>
</tbody>
</table>

Application

Apply 2 single full wet coats.

Allow a flash off time of 5 to 10 minutes between the coats, this will depend on ambient temperature, applied layer thickness and airflow.

Film thickness when using the recommended application

2 coats 2.4 — 3.0 mils (60 - 75µm)

Drying time

<table>
<thead>
<tr>
<th>Standard Clear</th>
<th>at 70°F (20°C)</th>
<th>at 95°F (35°C)</th>
<th>At 120°F (49°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust free</td>
<td>15 minutes</td>
<td>10 minutes</td>
<td>5 minutes</td>
</tr>
<tr>
<td>Dry to handle</td>
<td>1 to 1½ hours</td>
<td>30 minutes</td>
<td>25 minutes</td>
</tr>
<tr>
<td>Dry to polish</td>
<td>2 to 3 hours</td>
<td>1½ to 2½ hours</td>
<td>30 minutes</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Slow Clear</th>
<th>at 70°F (20°C)</th>
<th>at 95°F (35°C)</th>
<th>At 120°F (49°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust free</td>
<td>20 minutes</td>
<td>30 minutes</td>
<td>10 minutes</td>
</tr>
<tr>
<td>Dry to handle</td>
<td>2.5 hours</td>
<td>1.5 hours</td>
<td>30 minutes</td>
</tr>
<tr>
<td>Dry to polish</td>
<td>3-4 hours</td>
<td>3 hours</td>
<td>30 minutes</td>
</tr>
</tbody>
</table>

Drying times relate to recommended application (film thickness) and object temperature

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

Allow 3 to 5 minutes flash off before Infra red curing

Cure 5 minutes low power setting followed by 10 minutes high power setting.

~ The panel must not reach a temperature above 100°C while curing.
Recoatable and blending

Recoatable with itself after full drying cycle. Sanding becomes necessary if there are defects or after 24 hours.

For blending (spot repairs and panel blends), Please see Spot Repairs TDS with Wanda Waterbase data sheet.

Theoretical coverage

per coat of unmixed paint; 743 sq.ft/liter (18.2 sq. m/liter)

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

Polishability

Dust and minor damage can be polished out after the stated air-dry times have been reached, or after a full bake at 120°F (49°C) object temperature, followed by approximately 1 hour cool down of the object to ambient temperature.

Carefully sand out dust particles and restore the surface according to the polishing recommendations. Sand out dust particles with #1500 then #2000 grit paper wet or finish with the 3M Perfect-It™ Paint Finishing System.

1. Trizact foam disc P3000 followed with Perfect-It™ Rubbing Compound (PN 06085/06086) using the Superbuff™ Ill Wool Pad (PN 05703).

2. Remove compounding swirls by using Perfect-It™ Machine Polish (PN 06064 / 06065) using Perfect-It™ Plus Foam Polish Pad (PN 05738).

3. Complete the system, if necessary with:

   a. Perfect-It™ Ultrafine Machine Polish (PN 06068 / 06069) using the Ultrafine Foam Polishing Pad (PN 05733).

Cleaning of equipment

Gun cleaner

VOC

<table>
<thead>
<tr>
<th>Ratio</th>
<th>Product Description</th>
<th>VOC (2:1:10%-optional; ready to spray)</th>
<th>VOC (2:1:10%-optional; ready to spray)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wanda Low VOC Standard Clear</td>
<td>2.1 lb/gal (250 g/Liter) max, not to exceed.</td>
<td>2.1 lb/gal (250 g/Liter) max, not to exceed.</td>
<td></td>
</tr>
<tr>
<td>Wanda Low VOC Slow Clear</td>
<td>2.1 lb/gal (250 g/Liter) max, not to exceed.</td>
<td>2.1 lb/gal (250 g/Liter) max, not to exceed.</td>
<td></td>
</tr>
<tr>
<td>Blend of Wanda Low VOC Standard Clear and Wanda Low VOC Slow Clear</td>
<td>2.1 lb/gal (250 g/Liter) max, not to exceed.</td>
<td>2.1 lb/gal (250 g/Liter) max, not to exceed.</td>
<td></td>
</tr>
</tbody>
</table>

Product storage

Store products unopened, and used products with closed lids preferably between 40°F-95°F (5°C-35°C). Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C); wait.

<table>
<thead>
<tr>
<th>Product Description</th>
<th>Shelf Life</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wanda Low VOC Standard &amp; Slow Clear</td>
<td>1 year  6 Months</td>
</tr>
<tr>
<td>Wanda Hardener</td>
<td>6 Months</td>
</tr>
</tbody>
</table>

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.
Wanda Low VOC Clear

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