

Technical Information

Wanda 630 2K Epoxy Primer —W2.05.03

Two-pack Epoxy based primer with perfect corrosion protection for use in car refinishing and light commercial vehicles. It is for medium build sanding or lower build non-sanding purposes.

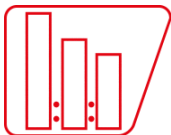
Sanding



Degreaser



P280-P320



Mixing ratio

100: Wanda 630 2K Epoxy Primer

50: Wanda 360 Hardener 2K Epoxy Primer

40: Wanda Thinners: 100 Slow / 110 Standard / 120 Rapid



Mixing stick

Use Wanda measuring stick

W7



Equipment

Spray gun set up: 1.6-2.0mm

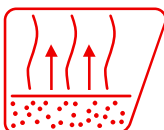
Application pressure: 1.6-2.0 bar

*See user manual spraygun used



Application

Recoatable with all topcoats, primers/fillers, putties.



Flash-off

5-10 minutes

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Drying:

Dry to sand*:

20°C

8 hours *

60°C

45 minutes *

**object temperature*



Protection

Use suitable respiratory protection.

AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

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Products and Additives	Wanda 630 2K Epoxy Primer		
	Hardeners: Wanda 360 Hardener 2K Epoxy Primer		
	Thinners: Wanda Thinners 100 Slow / 110 Standard / 120 Rapid		
Basic Raw Materials	Epoxy Primer : Epoxy resins Epoxy Primer Hardener : Amine resins		
Suitable substrates	Wanda thinners : A blend of organic solvents Existing Finishes Polyester Putties, Polyester Spraying Filler, Steel, Zinc coated Steel, Aluminium Polyester Laminates Wood, Ply wood OEM E-coated primers * *Sanding is not necessary, thoroughly cleaning and degreasing is sufficient		
Spraying Viscosity	25 - 30 seconds. DC 4 at 20°C		
Surface preparation	Existing Finishes	P280-P320	
	Polyester Putties, Polyester Spraying Filler	P280-P320	
	Steel, Zinc coated Steel	P280-P320	
	Aluminium	Scotch brite red	
	Polyester Laminates	P280-P320	
	Wood, Ply wood	P180-P220	
Spray gun set up and application pressure	Gravity feed	1.6-2.0 mm	1.6-2.0 bar*
	*See user manual spraygun used		
Application	Apply 1-3 single coats, allowing for 5 to 10 minutes flash off time between coats. If force dried, allow for a minimum flash-off time of 5-10 minutes. If applied by brush, do not add thinner. Apply only one coat of 630 2K Epoxy Primer if a Polyester Body Filler or Polyester Spraying Filler will be applied		
Film thickness	40-50 pm per coat		

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Mixing by weight sanding

	630 2K Epoxy Primer	360 Hardener Epoxy Primer	Wanda thinner Thinners 100 Slow / 110 Standard / 120 Rapid
Sanding	100gr	28gr	22gr

Theoretical use per ltr/m²: At a layer thickness of 1 micron 405 m² /liter ready for use mixture

Note: The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application

Cleaning of equipment Use Guncleaner or a nitrocellulose thinner

Drying	Drying	20°C	60°C
	Hard dry	8 hrs	45 mins
	Polyester Putties after	45 mins	15 mins
	Polyester Spraying filler after	45 mins	15 mins
	Fillers/Topcoats after	30 mins	10 mins

Recommended sanding paper before topcoat P400-P500 for dry sanding
P800-P1000 for wet sanding

Recoatibility Wanda topcoats
Wanda Primers and Filler
Wanda Putties and Polyester Spraying Filler

Note: Do **not** apply on etch primers

Tinting If required, Wanda 630 2K Epoxy Primer can be tinted up to 5% by volume with Wanda Topcoat 2K MAX or Wanda Topcoat 2k 420

Wanda 630 2K Epoxy Primer mixed with any of the topcoat colours must be stirred thoroughly before adding the 360 Epoxy Primer Hardener and Thinners

Brushing If Wanda 630 2K Epoxy Primer will be applied by brush, mix the 630 2K Epoxy Primer only with Hardener, do not add any thinner

Shelf life Wanda 630 2K Epoxy Primer: 18 months
Wanda 360 Hardener Epoxy Primer: 1 Year

VOC **2004/42/IIB(c)(540)540**
The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC. The VOC content of the sanding version of this product in ready to use form is max:540 g/liter

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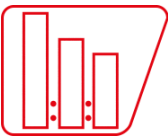
Non-Sanding



Degreaser



P280-P320



Mixing ratio

100: Wanda 630 2K Epoxy Primer

50: Wanda 360 Hardener 2K Epoxy Primer

40: Wanda Thinners: 100 Slow / 110 Standard / 120 Rapid



Mixing stick

Use Wanda measuring stick

W8



Equipment

Spray gun set-up: 1.3-1.6 mm

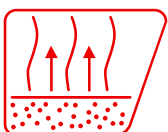
Application pressure: 1.7-2.2 bar

*See user manual spraygun used



Application

Recoatable with all topcoats, primers/fillers, putties.



Flash-off

Before topcoat 45 minutes

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Drying:

Dry to sand*:

**object temperature*

20°C

8 hours *

60°C

45 minutes *



Protection

Use suitable respiratory protection.

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Products and Additives	Wanda 630 2K Epoxy Primer		
	Hardeners: Wanda 360 Hardener 2K Epoxy Primer		
	Thinners: Wanda Thinners 100 Slow / 110 Standard / 120 Rapid		
Basic Raw Materials	Epoxy Primer : Epoxy resins		
	Epoxy Primer Hardener : Amine resins		
Suitable substrates	Wanda thinners : A blend of organic solvents		
	Existing Finishes		
	Polyester Putties, Polyester Spraying Filler,		
	Steel, Zinc coated Steel, Aluminium		
	Polyester Laminates		
	Wood, Ply wood		
	OEM E-coated primers *		
	*Sanding is not necessary, thoroughly cleaning and degreasing is sufficient		
Spraying Viscosity	23 - 27 seconds. DC 4 at 20°C		
Surface preparation	Existing Finishes	P280-P320	
	Polyester Putties, Polyester Spraying Filler	P280-P320	
	Steel, Zinc coated Steel	P280-P320	
	Aluminium	Scotch brite red	
	Polyester Laminates	P280-P320	
	Wood, Ply wood	P180-P220	
Pot-life	6 hours at 20°C		
Spray gun set up and application pressure	Gravity feed	1.3-1.6 mm	1.7-2.2 bar*
	*See user manual spraygun used		
Application	Apply 1 single coat, allowing for 20 minutes flash off time before the application of the topcoat.		
Film thickness	20-25 µm per coat.		

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Mixing by weight sanding

	630 2K Epoxy Primer	360 Hardener Epoxy Primer	Wanda thinner Thinners 100 Slow / 110 Standard / 120 Rapid
Non sanding	100gr	28gr	26gr

Theoretical use per ltr/m²: Non sanding version:
At a layer thickness of 1 micron 398 m² /liter ready for use mixture

Note: The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application

Cleaning of equipment Use Guncleaner or a nitrocellulose thinner

Drying	Drying	20°C	60°C
	Hard dry	8 hrs	45 mins
	Polyester Putties after	45 mins	15 mins
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Recommended sanding paper before topcoat P400-P500 for dry sanding
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Wanda 630 2K Epoxy Primer mixed with any of the topcoat colours must be stirred thoroughly before adding the 360 Epoxy Primer Hardener and Thinners

Brushing If Wanda 630 2K Epoxy Primer will be applied by brush, mix the 630 2K Epoxy Primer only with Hardener, do not add any thinner

Shelf life Wanda 630 2K Epoxy Primer: 18 months
Wanda 360 Hardener Epoxy Primer: 1 Year

VOC **2004/42/IIB(c)(540)540**
The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC. The content of the sanding version of this product in ready to use form is 550 g/liter (**not VOC compliant**)

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Akzo Nobel Car Refinishes B.V.
Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim
Tel: +31(0)71308-6944

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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

Akzo Nobel Car Refinishes B.V., PO Box 3, 2170 BA Sassenheim, The Netherlands. www.Wandarefinish.com