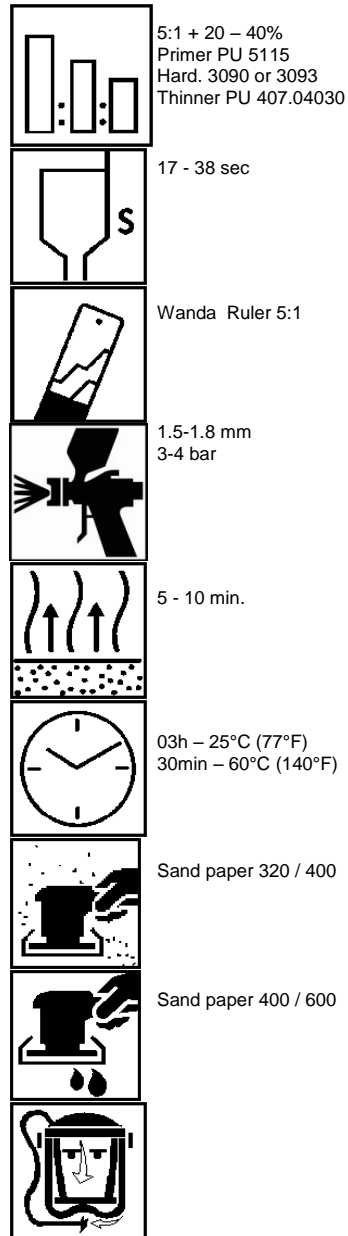




WANDAPRIMER PU 5100 HS DARK GREY

Quick Reference



Description: Polyurethane Primer indicated to promote filling and adhesion on metallic substrates. It has a good filling power, fast drying time, sanding properties and excellent durability.

Products and additives: Wandaprimer PU 5100 HS Grey Dark – (SBC32875)
 Hardener PU 3093 – (SBC31202)
 Hardener PU 3090 Slow – (SBC31203)
 Thinner for Polyester / PU 4030 – (SBC33340)
 RRA (Rapid Repair Agent)

Basic raw materials: Wandaprimer PU 5100 HS Grey Dark – acrylic resin, organic and inorganic pigments, solvents and additives.
 Hardener 3090/3093 – Poly isocyanate and solvents
 Thinner for Polyester / PU 4030 (SBC33340) – solvents
 RRA (Rapid Repair Agent) - Various solvents

Suitable Substrates: Bare metals
 Washprimers
 Existing finishes

Surface Preparation: Sand with P220 or P320 grit. Degrease with Desengraxe Wanda

Mixing ratio:

| Reduction A - Primer Filler | Reduction B – Primer surfacer |
|-----------------------------|-------------------------------|
| 5 parts of Primer | 5 parts of Primer |
| 1 part of hardener | 1 part of hardener |
| 20% of thinner 4030 | 40% of thinner 4030 |

Mixing ratio accelerated system for spot repair:

| |
|--------------------|
| 5 parts of Primer |
| 1 part of hardener |
| 20% of thinner PU |
| 10% of RRA |

Observations:

These products are intended for professional use only. Please, refer to can, Technical Data Sheet and Safety Data Sheet form more specific information. These products are thoroughly controlled and their quality will be kept as long as they are used according to the manufacturer recommendations. The final result depending upon factors of use which are outside our control.





Spray Viscosity: 17 – 38" seconds FC4 / 25°C (77°F)

Pot life: 1 hour at 20°C (68°F) in the mixing ratio 5:1 + 30% to 40%
1 hour at 20°C in the mixing ratio 5:1 + 20% 4030 + 10% RRA
30 minutes at 20°C (68°F) in the mixing ratio 5:1 + 20%

| Spray gun fluid tip and working pressure: | Spray Gun: | Fluid tip: | Pressure : |
|--|-------------------|-------------------|--------------------------------------|
| | Suction Feed: | 1.8 mm | 3-4 bar (40-50 lb/pol ²) |
| | Gravity Feed: | 1.5 – 1.8 mm | 3-4 bar (40-50 lb/pol ²) |
| | HVLP: | 1.7 – 2.0 mm | 3-4 bar (40-50 lb/pol ²) |

Process: Apply 2 - 3 single coats, allowing for 5 to 10 minutes flash off time between coats.

For accelerated drying system with RRA, apply 2 simple coats, respecting the flash off interval 5-10 minutes between coats.

The use of RRA should be restricted to small areas and the layer of primer will not exceed 50 microns indicating that it is for retouching spot repairs.

Film Thickness: 20-50 microns per coat, depending on the added thinner amount.

Theoretical cover rate : 13 m²/ liter per coat
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 Cleaning Solvent Wanda 4120

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| Drying times: | 3093- 25°C (77°F) | 3090– 25°C (77°F) | 60°C (140°F) |
|---------------|-------------------|-------------------|--------------|
| | Dust | 5 min | 10 min |
| Touch | 20 min | 30 min | ----- |
| Handle | 1,5 h | 2 h | 30 min |
| Total | 3 h | 4 h | |

| Drynd times accelerated system for spot repair: | 3093 + RRA a 25°C | 60°C |
|---|-------------------|--------|
| | Dust | 5 min |
| Touch | 15 min | ----- |
| Handle | 1 h | 15 min |

Sanding: dry: sand paper 320, ending with 400
wet: sand paper 400, ending with 600

Shelf life: 2 years at temperatures between 15°C (59°F) and 35°C (95°F), no humidity.

Health and Safety data: Please refer to MSDS

Notes: **Mixing ratio, in volume, between the Primer 5100 and 5115 Dark Grey, to get different gray shades.**

| Light Grey : Dark Grey | | Shade |
|------------------------|-------------------|-------|
| 100 : 0 | Light Grey | |
| 75 : 25 | Medium Light Grey | |
| 50 : 50 | Medium Grey | |
| 25 : 75 | Medium Dark Grey | |
| 0 : 100 | Dark Grey | |

- If necessary, correct the primer with fast putty and respray it.
- Always use the indicated thinner to the product.
- Use the indicated sand paper for dry and wet sanding.
- Before sanding, allowing the specified flash of time in order to avoid mapping defect.

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