



Axalta™ VS6001 2K Transparent Color, National Rule

<p>COMPONENTS</p>	<p>VS6001 Red 2K Transparent Color VS6002 Trans Color Activator Value Brand Reducer</p>	<p>APPLICATION</p>	<p>Prepare let-down panel to determine color match</p>
<p>MIX RATIO</p>	<p>3 : 1 : 10%</p>	<p>DRY TIME</p>	<p>Flash 8 to 15 minutes at 65-80°F (18-27°C)</p>
<p>VISCOSITY</p>	<p>N/A</p>	<p>VOC</p>	<p>339 grams / liter 2.8 lbs / gallon</p>



GENERAL

DESCRIPTION

Axalta Red 2K Transparent Color is needed to reproduce many OEM colors on passenger vehicles. They are applied in combination with Challenger, Duxone, Metalux or NasonXL basecoat colors and then clearcoated to produce a durable finish.

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.

COLOR

VS6001 Red 2K Transparent Color



MIXING

COMPONENTS

VS6001 Red 2K Transparent Color
VS6002 Transparent Color Activator
Value Brand Reducer

Challenger CH4065, CH4075, or CH4085
Duxone DX565, DX575 or DX585
Metalux 1156, 1157 or 1158
NasonXL 447-65, 447-75 or 447-85

MIX RATIO

Combine the components either by volume or weight and then mix thoroughly.

Component

VS6001 2K Transparent Color
VS6002 Transparent Color Activator
Value Brand Reducer

Volume

3
1
10%

POT LIFE

1 hour at 70°F (21°C)



APPLICATION

SUBSTRATES

Challenger National Rule Basecoat	CHN Mix Quality
Duxone National Rule Basecoat	DXN Mix Quality
Metalux National Rule Basecoat	MX Mix Quality
NasonXL National Rule Basecoat	NXN Mix Quality

GUN SETUPS*

HVLP:	1.3 mm-1.4 mm
Compliant:	1.3 mm-1.4 mm

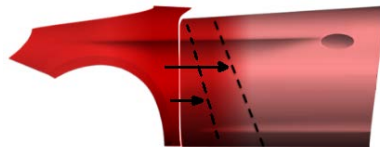
AIR PRESSURE*

HVLP:	8-9 psi at cap
Compliant:	25-30 psi

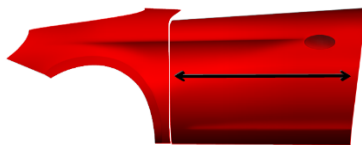
* Refer to the manufacturer's directions for gun specific recommendations

APPLICATION

- Axalta 2K Transparent Color may be flashed prior to clearcoating.
- Prepare let-down panel to verify color match and number of coats of transparent color needed.
- Mix Axalta 2K Transparent Color according to instructions.
- Apply the first coat of Axalta 2K Transparent Color over the blended basecoat. Extend each coat until color match determined by let-down panel is achieved. Flash off (no stringing) between coats. Do not extend the Axalta 2K Transparent Color to the end of the blend panel.



- Flash blended Axalta 2K Transparent Color prior to clearcoating.
- Apply 2 coats of the same basecoat brand clearcoat to complete the repair process.



DRY TIMES

FLASH 2K TRANSPARENT COLOR THEN APPLY CLEARCOAT

Flash before clearcoat:

- 8 to 15 minutes at 65-80°F (18-27°C)



- 5 to 8 minutes at 80-90°F (27-32°C)

Clearcoat Application

- Apply clearcoat according to direction for use for the clearcoat.
- Air dry or bake the clearcoat per the directions for use of the clearcoat.

Tips for Success

- For best appearance, keep flash time to clearcoat at the shorter end of the time specified for the range in booth temperatures.
- Extending flash times beyond recommendations will increase dieback and recoat lift potential.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



PHYSICAL PROPERTIES

All Values Ready To Spray

Recommendation	3:1:10%
Max. VOC (LE)	339 g/L (2.8 lbs./gal)
Max. VOC (AP)	216 g/L (1.8 lbs./gal)
Avg. Gal. Wt.	1035 g/L (8.64 lbs./gal)
Avg. Wt.% Volatiles	57.1%
Avg. Wt.% Exempt Solvent	36.2%
Avg. Wt.% Water	0.0%
Avg. Vol.% Exempt Solvent	36.3%
Avg. Vol.% Water	0.0%
Recommended Dry Film Thickness:	1.0-1.5 mils in 2 coats
Flash Point:	See SDS

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: May 2021

In the United States and Canada:
1.855.6.AXALTA
Axalta.us

