

OPTICOLOR XP™ Industrial Colorants



Date: March 19, 2019 (supersedes all previous revisions)



GENERAL INFORMATION

Opticolor XP™ Industrial Colorants are widely compatible dispersions for use in solvent based wiping stains, spray stains and glazes. They can also be used to create opaque color systems when used as directed in approved basecoats, sealers and topcoats.



1. PRODUCTS

- UXW0048 Titanium Wht
- UXB0256 Burnt Umber
- UXL0005 Phthalo Blue
- UXR0034 Red Oxide
- UXY0020 Organic Yel.
- UXB0257 Raw Umber
- UXG0010 Phthalo Green
- UXR0033 Quindo Violet
- YYY0011 Trans Yellow Ox.
- UXR0035 Quindo Red
- UXY0022 Yellow Oxide
- UXA0035 Lamp Black
- UXY0020 Med Org Yel.
- UXR0036 Napthol Red
- UXE0019 Orange
- UXR0006 Bright Red
- YYR0049 Trans Red Ox.



2. MIXING RATIO

- All products should be stirred well before use and, for best results, continuously agitated while in use.



3. SHELF LIFE @ 77°F (25°C)

- 18 months from manufacturing date



4. CLEAN UP

- Refer to regulations for specified qualities necessary in a cleaning thinner, or use recommended Axalta Lacquer Thinner to clean equipment. (Remember to verify compliance with all applicable regulations or permits before proceeding with use of any product.)



5. ADDITIVES

- N/A



6. SURFACE PREPARATION

- Surface must be clean and dust free with a moisture content of 6-8% prior to finishing. Remove all dust, dirt, wax and wood marks. Proper sanding and preparation of the wood is critical to achieving consistent results.
- On new wood, finish sand surface with 150-180 grit sandpaper
- On previously finished wood, remove all old paint or varnish and follow new wood procedure.



7. COMPANION PRODUCTS

- GRAINTONE PLUS™ Stains & Glazes, LUSTER LAC™ Professional Lacquers, Amarium™ Pre-catalyzed Lacquers and ULTRAGUARD™ Conversion Varnishes



8. TECH NOTES

- No thinning is recommended.



9. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

NOTE: Not to be used on exterior applications



10. APPLICATION

- See Application Notes for Additional Details.



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	N/A
Flash between coats	N/A
To Stack	N/A

12. FORCE DRY

Flash	N/A
Bake	N/A
Cool Down	N/A
Stack	N/A



13. GUN SET UP

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.8 mm - 2.0 mm
Airless	10 - 15 thousandths
Air-Assisted Airless	11 - 15 thousandths

AIR PRESSURES

Gravity Feed	30-35 psi (2.0-2.4 bar)
Siphon Feed	35-40 psi (2.4-2.8 bar)
Air-Assisted Airless	10-20 psi (0.7-1.4 bar)
See spray gun manufacturer data for more information	



14. PHYSICAL DATA

Viscosity	N/A
Weight Solids %	50-88±2%
Volume Solids %	43-73±2%
Actual VOC	2.22-6.13lb/gal of Product
VOC Ratio (lb.voc/lb.solids)	0.15-1.08lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	266-446g/l
Weight Per Gallon	Various
Flash Point	4°C (~40°F) Closed Cup
Theoretical Coverage	N/A
VHAP (lb.HAP/lb.solids)	0.00-0.04lb VHAP/lb solid
Coating Category	Pigmented

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Application Notes:

All products should be stirred well before use and, for best results, continuously agitated while in use. Do not mix with other finishing systems or deviate from these finishing recommendations. Axalta will not be held liable for finish failures resulting from the mixing of products or deviations from finishing recommendations. Sanding should be completed immediately prior to the application of any additional coats.

1) Stain Preparation: GRAINTONE PLUS™ Neutral Wiping Stain Base is designed to be tinted up to 20% with GRAINTONE PLUS™ Industrial Colorants. Additions of these pigments in quantities greater than 20% may directly affect the adhesion of the sealer and topcoat. Pigment concentrates tend to settle when dispersed into bases. These tints will each affect dry times differently. Wiping stains formulated at the same concentration but with different tints can vary in behavior under similar application conditions. All products and application procedures should be pre-tested (before use) fully to verify adhesion and prevent costly refinishing. If color drift, flocculation of pigment or pigment float is an issue, immediately discontinue use and contact your Axalta Industrial Wood Coatings representative for additional assistance with the desired application.

2) Glaze Preparation: Axalta's GRAINTONE PLUS™ Neutral Glaze Base (VWS0912) is designed to be tinted up to 20% Opticolor XP™ Industrial Colorants. Additions of these pigments in quantities greater than 20% may directly affect the adhesion of the sealer and topcoat. Pigment concentrates tend to settle when dispersed into bases. These tints will each affect dry times differently. Glazes formulated at the same concentration but with different tints can vary in behavior under similar application conditions. All products and application procedures should be pre-tested (before use) fully to verify adhesion and prevent costly refinishing. If color drift, flocculation of pigment or pigment float is an issue, immediately discontinue use and contact your Axalta representative for additional assistance with the desired application.

3) Incorporation with Topcoats: Axalta's Opticolor XP™ Industrial Colorants may be added to solvent-based sealers and topcoats in the Axalta Industrial Wood Coatings product line up to a maximum of 10% by volume. Additions of the pigments in quantities greater than 10% may directly affect the performance of the tinted sealer or topcoat. Pigment concentrates tend to settle when dispersed into bases. These tints will each affect dry times differently. Sealers and topcoats formulated at the same concentration but with different tints can vary in behavior under similar application conditions. All products and application procedures should be pre-tested (before use) fully to verify adhesion and prevent costly refinishing. If color drift, flocculation of pigment or pigment float is an issue, immediately

discontinue use and contact your Axalta Wood Finishes representative for additional assistance with the desired application.

Clean Up: Refer to regulations for specified quantities necessary in a cleaning thinner, or use recommended Axalta Lacquer Thinner to clean equipment. (Remember to verify compliance with all applicable regulations or permits before proceeding with use of any product.) Empty containers, application equipment and clean-up materials may contain product residue, including flammable or explosive vapors or potentially spontaneously combustible material, and must be disposed of in a safe and compliant manner. Refer to Safety Data Sheet (SDS) for further safety and handling information.

Precautions:

These products are recommended for professional application and are designed for interior use only. Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and to avoid potential need for costly refinishing. Axalta Industrial Wood Coatings are designed to protect and enhance the natural beauty of wood, but cannot eliminate natural discoloration or deterioration of wood as it ages.

Additional notes:

Do not mix with other finishing systems or deviate from these finishing recommendations. Axalta will not be held liable for finish failures resulting from the mixing of products or deviations from finishing recommendations.

Storage:

Store in a cool, dry place. DO NOT FREEZE! Product should be stored in temperatures between 50°-110°F. Close all containers after use. Do not store near heat or sparks. Spills should be cleaned up with non-sparking tools. [See the product SDS](#) for complete safety information.

Warning:

Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and avoid potential need for costly refinishing. All dry times listed are as tested under ideal indoor environmental conditions of 78°F (26°C) with relative humidity not exceeding 50%. These products are recommended for use under temperature conditions of 60-100°F (16-38°C) and when relative humidity is below 50% during application and drying time. Low temperatures, poor air circulation or high humidity will extend dry times. **Axalta strongly recommends against use of these products if temperatures of air, material, or surface to be coated are below 60°F (16°C) or below the dew point. Abnormal conditions of temperature or humidity may adversely affect product performance.** Please contact your authorized Axalta Industrial Wood Coatings distributor for additional product use recommendations and finishing guidance.