



## GENERAL INFORMATION

Axalta's GRAINTONE Plus™ Spray Stain Base is a spray-no wipe-base formulated for industrial applications. It is fast drying and is not designed to be wiped. This stain base allows the finisher to achieve a consistent, even color on hard to stain woods such as maple, pine, and cherry, without a blotchy appearance. For Wood Substrates Only.



## 1. PRODUCTS

- VSS0194



## 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



## 4. CLEAN UP

- Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer soaked rags should be stored in water-filled, closed containers prior to disposal.



## 5. ADDITIVES



## 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

- Opticolor XP colorants
- VDS102X Series Dye Concentrates
- VDS107X Series Universal Dye Concentrates



## 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

- Only one box coat is recommended. Apply stain by spray only. Apply an even, medium-wet coat against the grain followed immediately by another medium wet coat with the grain (box coat). If the stain is applied too dry it will have a blotchy, cloudy appearance. Make sure each coat "wets" the grain. Do not wipe. Let dry completely before applying topcoat.



## 11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	5-10 Minutes
Flash between coats	10-20 Minutes
To Stack	

## 12. FORCE DRY

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

## 13. GUN SET UP

Gravity Feed	1.0 mm - 1.2 mm
Siphon Feed	1.0 mm - 1.2 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	5-10 psi (0.3-0.7 bar)
See spray gun manufacturer data for more information	



## 14. PHYSICAL DATA

Viscosity	N/A
Weight Solids %	0.12%
Volume Solids %	0.06%
Actual VOC	3.87lbs/gal of Product
VOC Ratio (lb.voc/lb.solids)	443.66lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	463.7 g/l of Material
Weight Per Gallon	7.18 lbs/gal
Flash Point	70°F Closed Cup
Theoretical Coverage	0.98 ft/gal @ 1 mil dry
VHAP (lb.HAP/lb.solids)	0.0lb VHAP/lb solid
Photochemically Reactive	No
Coating Category	Base



Refer to your local regulations for compliance requirements for cleaning solvents. Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer soaked rags should be stored in water-filled, closed containers prior to disposal.

### Application Notes:

**General:** Always pre-test the system on your substrate to verify suitability of the application.

**Tinting:** This product may be tinted with Opticolor XP colorants, VDS102X series Dye Concentrates, and VDS105X series Universal Dye Concentrates. Maximum tint load is 9 oz per gallon (7% by volume).

Always test the stain for appearance in an inconspicuous area (or scrap sample of the same type of wood) before using. Intermix containers of the same color. Mix well before use and frequently during use. Only one box coat is recommended. Apply stain by spray only. Apply an even, medium-wet coat against the grain followed immediately by another medium wet coat with the grain (box coat). If the stain is applied too dry it will have a blotchy, cloudy appearance. Make sure each coat "wets" the grain. Do not wipe. Let dry completely before applying topcoat.

### Drying Time:

Dry to touch: 5-10 minutes

Dry to recoat: 10-20 minutes

Do not apply if the material or substrate temperature is below 55°F.

This product is best applied when surface and air temperatures are between 55°-90° F (~12-32°C) and when relative humidity is below 50% during application and drying time.

### Clean Up:

# VSS0194

## Graintone Plus™ Spray Stain

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



### 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. Close all containers after use. Do not store near heat or sparks. Spills should be cleaned up with non-sparking tools. See the product MSDS 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.