



GENERAL INFORMATION

Axalta's Graintone Plus™ Wiping Stain Base is a direct to wood, interior solvent borne stain base specially formulated to highlight and enhance the natural beauty of all types of wood. It is easy to apply and when tinted with approved colorants, offers intense, rich color tones and outstanding uniformity of appearance. This product can be tinted with both dyes and pigments to achieve dark, rich color tones, and the containers are short filled for greater ease in tinting. For Wood Substrates Only.



1. PRODUCTS

- VWS0680



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)

- 4 years unopened



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
- Graintone Plus Dye Concentrates,
- Luster Lac™, Amarium™ and Ultraguard™ systems.



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 instructions



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	15-20 Minutes
Flash between coats	30 - 45 Minutes
To Stack	



12. FORCE DRY

Flash	5-8 Minutes
Bake	15 Minutes @ 125°F
Cool Down	10 Minutes ambient
Stack	



13. GUN SET UP



Gravity Feed	1.0 mm - 1.4 mm
Siphon Feed	1.0 mm - 1.4 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 %	17.11%
Volume Solids %	14.13%
Actual VOC	5.69lbs/gal
VOC Ratio (lb.voc/lb.solids)	4.85lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	679.9 g/l of material
Weight Per Gallon	6.87 lbs/gal
Flash Point	40°F Closed Cup
Theoretical Coverage	226.72 ft/gal @ 1 mil dry
VHAP (lb.HAP/lb.solids)	0.0lb VHAP/lb solid
Photochemically Reactive	No
Coating Category	Base

Application Notes:

General: Always pre-test the system on your substrate to verify suitability of the application. Tinting-The clear base is designed to be tinted with

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approved, high quality industrial colorants such as Opticolor XP and Axalta's Graintone Plus Dye Concentrates (check with your Axalta Distributor for other approved tints). Maximum tint capacity is 12 oz per gallon (9.4% by volume) in a short filled container. Maximum tint load if mixing a custom stain from scratch is 25 oz per gallon (20% by volume). If desiring to exceed 20%, make certain to pre-test (before use) adhesion and drying properties for all custom formulas not pre-approved by Axalta. Colorants must be mixed in completely with mechanical agitation before use.

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. Stir well before use and frequently during use. Apply stain by spray, brush, or lint free cloth. Apply an even, wet coat. While product is still wet (approximately 1-5 minutes) wipe off in a circular motion, working the stain into the wood. Finally, wipe clean with the grain of the substrate. **DO NOT LEAVE THIS PRODUCT ON THE SUBSTRATE WITHOUT WIPING.** Only one coat is recommended.

Drying Time:

Dry to touch: 15-20 minutes

Dry to recoat: 30-45 minutes depending on temperature, humidity and tint load.

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

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.

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.