

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



GENERAL INFORMATION

Axalta's Graintone Plus™ Glaze Base is a neutral base that is used to formulate custom color glazes using our Color Choice™ system. It is designed for application over an approved Axalta washcoat, sealer, or self-seal topcoat to add depth, color, and character to a finish. Formulated for use in all interior wood finishing including: furniture, molding, doors and cabinetry. For Wood Substrates Only.



1. PRODUCTS

- VWS0912



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,
- 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 detailed information



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Dry to touch	30-60 Minutes
Flash between coats	1-8 Hours
To Stack	



12. FORCE DRY

Flash	10 Minutes
Bake	15-30 Minutes @ 125°F
Cool Down	10-20 Minutes ambient
Stack	



13. GUN SET UP

Gravity Feed	1.2 mm - 1.4 mm
Siphon Feed	1.2 mm - 1.4 mm
Airless	9 - 11 thousandths
Air-Assisted Airless	9 - 11 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 %	52.18%
Volume Solids %	37.92%
Actual VOC	4.02lbs/gal of Product
VOC Ratio (lb.voc/lb.solids)	0.90lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	485.83 g/l
Weight Per Gallon	8.64
Flash Point	90°F Closed Cup
Theoretical Coverage	608.28 ft/gal @ 1 mil dry
VHAP (lb.HAP/lb.solids)	0.00lb VHAP/lb solid HAPs
Photochemically Reactive	No
Coating Category	Pigmented

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**Application Notes:**

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

Tinting: This product is designed to be tinted with approved, high quality industrial colorants such as Opticolor XP (see 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 glaze 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 glaze 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.

Seal the surface: When using this glaze, the substrate should first be sealed using a washcoat, sealer, or self seal topcoat as the sealer. Let dry and sand the sealed surface with 280-320 grit no fill sandpaper before applying the glaze.

Apply the glaze: Apply the glaze by spray, brush, or lint free cloth. Apply an even, wet coat. Remove most of the glaze immediately with a clean cloth, leaving only enough to highlight cracks, crevasses, panel details, wormholes etc. Let dry completely before topcoating. Glaze may also be worked with a brush to smooth and blend the effect. Do not rush dry times. Inadequate drying time or excessive application will affect adhesion. As with all glazing, Axalta recommends that sealing, sanding, glazing, and topcoating all be completed the same day.

Drying Time:

Dry times will vary depending on application, temperature, humidity, and tint load. Generally, light applications will be dry in 1-2 hours, medium application 2-4 hours, and heavy applications from 4-8 hours.

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. **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 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.