

# VWS055X Series

## GRAINTONE PLUS™ HAPs Free Wiping Stains



Date: October 31, 2017 (supersedes all previous revisions)



### GENERAL INFORMATION

Axalta's GRAINTONE PLUS™ Wiping Stains are colorfast, direct-to-wood interior stains specially formulated to highlight and enhance the natural beauty of all types of wood. Select from pre-mixed colours.



### 1. PRODUCTS

- VWS0551 White
- VWS0553 Dark Cherry
- VWS0555 Maple
- VWS0557 Red Mahogany
- VWS0559 Dark Oak
- VWS0552 Antique Mahogany
- VWS0554 Dark Walnut
- VWS0556 Natural Oak
- VWS0558 Golden Oak
- VWS0560 Mission Oak



### 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)

- 12 months from date of manufacturing



### 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

- LUSTER LAC™ Professional Lacquers, ENVIRO SUPERLAC™, SUPERLAC ELITE™, SUPERLAC PLUS™ Pre-catalyzed Lacquers, SUPERGUARD™ Post-catalyzed Lacquers, ULTRAGUARD™ & PERMAFLEX Conversion Varnishes



### 8. TECH NOTES

- If reduction is needed, Max. 20% by volume 390-9102 as allowable by regulatory compliance regulations.



### 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	30 Minutes
Flash between coats	35 - 45 Minutes
To Stack	12 - 24 Hours



### 12. FORCE DRY

Flash	10 Minutes
Bake	15 Minutes @ 125°F
Cool Down	10 Minutes ambient
Stack	After cool down



### 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 %	40-50±2%
Volume Solids %	30-39±2%
Actual VOC	4.51lbs/gal of Product
VOC Ratio (lb.voc/lb.solids)	1.72lb VOC/lb solid
Regulatory VOC (less water and exempt solvents)	542g/l
Weight Per Gallon	7.17-8.28lbs/gal
Flash Point	41°C (~105°F) Closed Cup
Theoretical Coverage	N/A
VHAP (lb.HAP/lb.solids)	0.02lb VHAP/lb solid
Coating Category	Pigmented

The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Axalta assumes no obligation or liability for use of this information. **UNLESS AXALTA AGREES OTHERWISE IN WRITING, AXALTA MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. AXALTA WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option. The information in this sheet, as well as the products referenced herein, shall be considered "Confidential Information". Wet samples and uncured samples of these products shall be maintained as confidential and shall not be disclosed to any third party without the prior written permission of Axalta. IU-COR-00047

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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) Pre-Mix:** Agitate GRAINTONE PLUS™ Wiping Stains well prior to use. Adjust stains for colour by using Opticolor XP or other approved colorant system. Ready-mixed formulations will have a tint load of 5-20%. You may use Lactol Spirits or VM&P Naptha if less penetration into the pores or faster flash-off is desired. Reduction with Aromatic 150 can be used to increase dry time or to deepen penetration into the pores. Always add solvent or colorant to the base or stains while under agitation. Always make certain to pre-test color in a hidden area or on a scrap sample of the same wood to ensure desired appearance prior to use.

**2) Stain Application:** Apply an even, heavy coat of prepared stain direct to wood, using a spray, brush or lint-free cloth. While the product is wet (working time of approximately 5 minutes), wipe off in a circular motion, working the stain into the wood. Wipe clean in a final wipe, by wiping with the grain of the substrate. **DO NOT LEAVE THIS PRODUCT ON THE SUBSTRATE WITHOUT WIPING.** Leaving stain on the substrate will lead to adhesion problems and/or severe whitening in the grain. Initial sanding with coarse sandpaper will aid color development. Allow stain to dry a minimum of 30 minutes (as tested under the ideal indoor environmental conditions detailed above) before proceeding with finishing. A wash-coat may be applied prior to application of the stain to even color penetration. (Washcoats may be produced by diluting any of Axalta's sealers 50-200% with 390-7001 Lacquer Thinner.) Sand the washcoat prior to stain application. Agitate stains while in use (or stir frequently) to ensure consistent color development.

**5) Sealer / Topcoat:** Choose the desired sealer and/or self-seal topcoat (companion products) from the Axalta Industrial Wood Coatings product line. Be certain to follow all application and product instructions. Agitate all products (as directed) well before use. If additional coats are required, make certain to follow recoat instructions and allow proper time between applications. Sanding should be completed immediately prior to the applications of additional topcoats.

**IMPORTANT NOTE: System's total dry film build should not exceed 4 mils.** A higher build may result in a film breakdown or reduction in performance.

### 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.) 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.

<b>Catalyzation:</b>	n/a
<b>Pot-Life</b>	n/a
<b>Reduction:</b>	Max. 20% by volume 390-9102*
<b>Retarder:</b>	n/a

### 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.