







Axalta® VS4510 2K Urethane Low VOC Integrated Clear

 COMPONENTS	VS4510 Low VOC Integrated Clear VS5330 Low VOC Urethane Activator VS5156, VS5157, VS5158, VS5159 Reducers	 APPLICATION	Use with final single stage coat only 2 Parts RTS (NIS) Color to 1 Part RTS VS4510 Low VOC Integrated Clear
 MIX RATIO	<h2>4 : 1 : 1</h2>	 DRY TIME	20 - 30 minutes at 120 - 140°F (49-60°C)
 VISCOSITY	Zahn #2 18 - 21 seconds	 VOC	328 grams / liter 2.7 lbs / gallon



GENERAL

DESCRIPTION

Designed to enhance the depth and color of Ful-Thane® 2K Urethane Low VOC Single Stage colors (NIS) and Ful-Thane® factory packaged colors (412-105 Black or 412-106 White).

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

- Axalta VS4510 2K Urethane Low VOC Integrated Clear
- Axalta VS5330 Low VOC Urethane Activator
- Axalta VS5156 Low VOC Low Temp Reducer (65°F-75°F)
- Axalta VS5157 Low VOC Mid Temp Reducer (75°F-85°F)
- Axalta VS5158 Low VOC High Temp Reducer (85°F-100°F)
- Axalta VS5159 Low VOC X-High Temp Reducer (Above 100°F)

MIX RATIO

Combine the components by volume (4:1:1). Mix thoroughly prior to activation.

Component	Volume
Axalta VS4510 2K Urethane Low VOC Integrated Clear	4
Axalta VS5330 Low VOC Urethane Activator	1
Axalta VS5156 / VS5157 / VS5158 / VS5159 Low VOC Reducer	1

POT LIFE

4 hours at 70°F (21°C)

SPRAY VISCOSITY

18 - 21 seconds #2 Zahn



APPLICATION

APPLICATION

Solid Colors:

Add 1 part of RTS Ful-Thane 2K Urethane Low VOC Single Stage (NIS) color to 1 part RTS VS4510 Low VOC 2K Urethane Integrated Clear during the last and final coat of the single stage color.

Effect Colors:

Add 2 parts of RTS Ful-Thane 2K Urethane Low VOC Single Stage (NIS) color to 1 part RTS VS4510 Low VOC 2K Urethane Integrated Clear during the last and final coat of the single stage color.

CLEANING OF PAINT EQUIPMENT

Clean spray equipment as soon as possible using Axalta 105 or 107 Low VOC / Low HAPS equipment cleaners.

IMPORTANT NOTES

- Do not use as a topcoat clear.
- Use as an integrated clear in final coat only.
- Be certain clear and color are properly catalyzed and reduced.



DRY TIMES

20 - 30 minutes at 120-140°F (49-60°C).



PHYSICAL PROPERTIES

All Values Ready To Spray

Max VOC (LE):	2.7 lbs./gal (328 g/L)
Max VOC (AP):	1.7 lbs./gal (204 g/L)
Avg. Gal. Wt.:	8.78 lbs./gal (1053 g/L)
Avg. Wt.% Volatiles:	58.0%
Avg. Wt.% Exempt Solvent:	38.5%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	38.0%
Avg. Vol.% Water:	0.0%
Recommended Dry Film Thickness:	1 mil in 1 coat
Flash Point:	See SDS
Theoretical Coverage:	614 ft ² (57.0m ²) at 1 mil



VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS/MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
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