



**HIGH PERFORMANCE  
INDUSTRIAL  
WATER BASE  
WOOD COATINGS**

**IC&S  
P.O. BOX 10845  
LANCASTER, PA 17605  
800-220-4035**

**ILVA  
IVM CHEMICALS, srl  
INTERNATIONAL WOOD COATINGS DIV  
PARONA, ITALY**

## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** HMM5A Series

**DESCRIPTION:** WB CLEAR SELF-SEALER VARIOUS SHEENS

**USES:** Furniture, architectural millwork, store fixtures. Offers the best in dry times and leveling, with very good sanding properties and filling power.

**PRODUCT PREPARATION:** HMM5A Series      WB Clear Self-Sealer      100 parts by weight      128 parts by volume  
Water      Thinner      0-5 parts by weight      0-6 parts by volume

**APPLICATION SYSTEM:** Spray

**FILM THICKNESS:** 4.4-5.6 mils wet

**COATS:** Two

**GENERAL PROPERTIES:** Specific Gravity, gr/cc      1.040 +/- 0.02  
Viscosity -- Iso 6 cup      85+/- 5 secs  
Solids by Weight, %, as supplied      33 +/- 2 sec  
Thinner      Water  
Dilution      0-5%

**DRYING TIME:** All dry times are dependent upon air flow, ambient temperatures, and humidity  
(at 20°C/68°F) Drying time at room temperature      2-3 hr  
Drying time with warm air tunnel      20-30 mins  
Dust Free/time gel      30-60 mins  
Dry to Touch      2-3 hr  
Dry hard      6-8 hr  
Stackable      overnight  
Sandable      after 2-3 hrs, before applying topcoat

**GLOSS LEVELS:** HMM5A036      10 SHEEN  
HMM5A054      20 SHEEN  
HMM5A053      30 SHEEN  
HMM5A032      50 SHEEN  
HMM5A03D      60 SHEEN

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18-25°C/64-75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 1-15, 3-17, 11-18

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** HMM5A457

**DESCRIPTION:** WB CLEAR NATURAL EFFECT PARQUET SELF-SEALER

**USES:** Designed to be used as a 2-component self-sealer urethane ultra matte finish for flooring. May be applied by spray/roller/brush. Fast drying with soft natural effect feel. Very good wear resistance. May also be used as a 2-component system for table and desk tops.

**PRODUCT PREPARATION:** HMM5A457 W/B Clear Natural Effect Self-Sealer 100 parts by weight  
TXW08 or HXS5A16 Hardener 5 parts by weight (mechanical mixing required)  
Water Thinner as needed (if necessary for application)

**APPLICATION SYSTEM:** Airmix spray: 3.4-4.2 wet mills min-max  
Hand spray: 3.4-4.6 wet mills min-max  
Brush: 2.3-3.0 wet mills min-max  
Manual roller 2.3-3.0 wet mills min-max  
Spray - see pg 26 for additional information

**COATS:** Two

**GENERAL PROPERTIES:** Specific Gravity, gr/ml 1.032 +/- 0.030  
Viscosity\* (ISO 6) 24 sec +/- 2  
Solids Content (% by weight) 21.1 +/- 2  
Pot Life using PU Hardener 2 hours

**DRYING TIME:** (at 20°C/68°F) Drying schedule at room temperature (64-72°F, 65-70% relative humidity), completely drying: 96 hours  
Dust Free 50 minutes  
Dry to Touch 75 minutes  
Hard dry 5 hours  
Sandable after 4 hours  
Maximum time between layers without sanding 2-3 hours  
Overcoatability time 8 hours  
Overcoatability time between layers 4-8 hours  
Jet hot air drying Temp: 35°C, 95°F  
Stackable after jet hot air drying 4 hours with spacers  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**TYPICAL SYSTEMS:** Substrate: Walnut/oak/beech/maple  
Stain: PF5 Series  
Sealer HMM5A457 (80 g/m2)  
Topcoat: HMM5A457 - topcoat 5 sheen (80g/m2)  
TXW08 or HXS5A16 must use 5% in both sealer and topcoat

**RECOMMENDATIONS:** Sand using 280-320 grit stearate paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the waterbased product and loading up sandpaper.  
We recommend using stainless steel for all water-based products. If using both solvent and water-based products we suggest the following:  
---from water to solvent: wash with water, then wash with solvent  
from solvent to water, reverse the cycle. If you find it necessary to dilute the material we suggest using de-ionized water in order to avoid problems which may arise from a high concentration of salts.  
Keep cans closed when not in use and wash all equipment well. Keep from freezing. Do not thin more than 5%.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 06-16, Revised 9-16, 4-17, 3-18

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## ILVA TECHNICAL DATA SHEET

<b>PRODUCT CODE:</b>	<b>HMMB05x Series</b>		
<b>DESCRIPTION:</b>	<b>Waterbase Multilayer Floor Finish</b>		
<b>USES:</b>	Multilayer for parquets and stairs, open and close pore.		
<b>FEATURES:</b>	Excellent elasticity and floor surface resistance.		
<b>PRODUCT PREPARATION:</b>	HMMB05x	Waterbase Multilayer Floor Finish	100 parts
<b>APPLICATION SYSTEM:</b>	Brush or roller		
<b>FILM THICKNESS:</b>	2.8 - 4.58 mils wet		
<b>COATS:</b>	Two		
<b>GENERAL PROPERTIES:</b>	Specific Gravity, gr/cc	1.045 +/- 0.01	
	Viscosity*	18 +/- 2 sec	
	Solids by Weight, % as supplied	30 +/- 2	
	*Ford Cup #4		
<b>GLOSS AVAILABLE:</b>	HMMB052 50 Gloss (Old Code TW632) HMMB054 20 Gloss (Old Code TW634)		
<b>DRYING TIME:</b> (at 20°C/68°F)	Dry to touch	1 hour	
	Dry hard	12 hours	
	Drying schedule by oven 25-60°C	1 hour	
	Walking on (minimum)	5 days	
<b>TYPICAL SYSTEMS:</b>	Various woods		
	Stain		
	Basecoat	HMMB05X	1 coat (interval between coats without sanding: 1-3 h)
	Topcoat	HMMB05X	1 coat
<b>RECOMMENDATIONS:</b>	We recommend using this product at temperatures above 15°C (60°F) and <70% humidity. Do not exceed 180 gr/cc per coat. When dilution is necessary we recommend using de-ionized water in order to avoid problems associated with a high concentration of salts. Do not exceed 10% dilution. Wash all equipemnt thoroughly before and after use.		
<b>SHELF LIFE:</b>	12 Months		
<b>STORAGE:</b>	Store in a tightly closed container at room temperatures (18-25°C/64-75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)		
<b>DATE OF ISSUANCE:</b>	12-16, 4-17		

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** HNS7A04

**DESCRIPTION:** Interior WB Gel Stain Base

**USES:** To be tinted with PZ5xx at 2-5%. Apply to achieve a consistent uniform color of the wood, especially recommended when harmonizing of the wood is necessary, such as finger joint wood. May be used on hard or soft woods. Good vertical hang.

**APPLICATION SYSTEM:** Brush, Spray, or Lambs wool pad, then wipe

**FILM THICKNESS:** 300-400 Sq feet per gallon @1.6-2.3 mils wet

**COATS:** One

**GENERAL PROPERTIES:**

Specific Gravity, gr/cc	1.010+/-0.03
Viscosity as supplied Brookfield	1300+/-500 cps, spindle 2, speed 5
Solids, % by weight:	10+/-2
Thinner:	Water
% of dilution:	0-5%

**DRYING TIME:** At 20°C with ventilation, dry to handle:  
**(at 20°C/68°F)** Dust Free: 20 minutes  
Dry to touch: 2 hours  
Full dried: 4 hours

(Drying times may vary according to temperature, ventilation and relative humidity)

**WARNINGS:** KEEP FROM FREEZING

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 2-18

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** IWS1303

**DESCRIPTION:** Waterbase Spray Stain Binder

**USES:** Use for doors, furniture and manufactured goods. Fast drying.

**APPLICATION SYSTEM:** Spray

**PRODUCT PREPARATION:** Spray application  
IWS1303 Binder 90+ parts  
PF5, PC3, PZ5 Colors 0-10 parts

**FILM THICKNESS:** 1.2-1.6 mils wet

**COATS:** One

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.00 +/- 0.01  
Viscosity\* 12 sec +/-1

\* CF4 at 20°C/68°F

**DRYING TIME:** Handling: 30-40 minutes  
(at 20°C/68°F)

**TYPICAL SYSTEMS:** Substrate: Various woods  
Stain vehicle: IWS1303  
Drying: 30-40 minutes  
TTx series P/U WB Basecoats or TA series P/U Solvent Basecoats  
TW34 series P/U WB Topcoats or TO9 series P/U Solvent Topcoats

**NOTES:** We advise removal of excess stain so adhesion of the next coat will not be effected. The vehicle provides excellent workability to stain color bases.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 03-17

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# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PC 3/Series

**DESCRIPTION:** Water Based Dye Stain for Spray or Dip

**USES:** Staining of furniture, frames, panels.

**PRODUCT PREPARATION:** Spray application

PC 3/ series	Stain	7-10 parts by weight
Water		80-90 parts by weight
PD4/90	Vehicle	5 parts by weight

Dipping application

PC 3/ series	Stain	7-10 parts by weight
Water		40-50 parts by weight
PF95	Vehicle	40-50 parts by weight

Spray and Wipe application

PC 3/ series	Stain	7-10 parts by weight
Water		60-80 parts by weight
PD4/90	Vehicle	15-30 parts by weight

**GENERAL PROPERTIES:** Dry content and Specific Gravity, gr/cc see below  
 Viscosity DIN 53211 NR4 at 20°C/68°F 10+/-2 sec  
 Dry time at 20°C/68°F 4-24 h

<b>AVAILABLE COLORS:</b>	<u>Specific gravity</u> (gr/ml +/-2)	<u>Solid content</u> (by weight +/-2)	<u>Viscosity</u>
<b>PC30</b> White	1.200	27%	70 +/-5 (ISO3)
<b>PC31</b> Yellow	1.020	7%	24 +/-2 (ISO3)
<b>PC34</b> Orange	1.030	6.5%	10 +/-2 (DIN 4)
<b>PC37</b> Red	1.020	7%	26 +/-2 (ISO 3)
<b>PC36</b> Brown	1.030	13%	26 +/-2 (ISO 3)
<b>PC38</b> Blue	1.000	5%	20 +/-2 (DIN 4)
<b>PC39</b> Black	1.020	10%	25 +/-2 (ISO 3)

**TYPICAL SYSTEMS:** SYSTEM NR 1

Barrier Coat:	PC3/Series Stain
Sealer:	TT06 Aquatech Sealer or TA48 Solvent Polyurethane Sealer
Finish:	TW3/xxSeries - Waterbase PU Topcoat or TO9/series Solvent PU Topcoat

**REMARKS:** Increasing the vehicle percentage will improve uniformity, less penetration so consequently greater covering power, and the grain is more enhanced. A wide variety of colors can be achieved by mixing the base colors.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10, Revised 10-10, 2-18

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PD4/90

**DESCRIPTION:** WB GLAZE & STAIN VEHICLE

**USES:** Vehicle for glazes by spray and wipe. Suitable for chestnut, oak, etc. woods. Excellent smoothing action. Can be used on various types of furniture.

**APPLICATION SYSTEM:** By spray and wipe

**GENERAL PROPERTIES:**

Specific gravity:	1.05 +/-0.02 gr/m;
Solid content:	25% +/- 1% by weight
Viscosity (at 20°C):	55 +/-5 (DIN 53211 CUP 0 mm.4)

**DRYING TIME:** Air (minnum 4 hours)  
(at 20°C/68°F)

**SUGGESTED COATING CYCLES:**

Substrate:	Different kinds of wood
Stain:	PD4/90 + PC3/series + water = 100/10/50
Drying:	4 hr
Base coat:	TT PUR WB base coats
Topcoat:	TW PUR WB topcoats

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18-25°C/64-75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10

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# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PD 6xx/Series

**DESCRIPTION:** Pigmented Water Stains

**USES:** Staining of furniture, frames, panels. Can be used by spray, dip and roller. Excellent balance between uniformity and transparency making it possible to obtain different colors, hiding power and nuances. Excellent resistance to daylight.

<b>CHEMICAL/PHYSICAL PROPERTIES:</b>	<u>Specific gravity(at 20°C)</u> ( +/- .05)	<u>Solid content (M.U. 591)</u> (by weight +/-1)	<u>Viscosity (ISO 3 at 20°C)</u>
<b>AVAILABLE COLORS:</b>			
PD601	White	1.15	24%
PD602	Yellow vivid	1.1	24%
PD603	Yellow Oxide	1.19	45%
PD604	Yellow Solid	1.08	31%
PD605	Red	1.08	29%
PD606	Orange	1.60	23%
PD607	Green	1.15	52%
PD608	Blue	1.12	23%
PD609	Black	1.12	22%
PD611	White (dipping)	1.11	20%

**APPLICATION SYSTEM:** Spray, roller, or dip

**FILM THICKNESS:** Max total: spray & wipe: 0.8-1.6 mils wet; spray manual: 0.4-0.8 mils wet

**DRYING TIME:** Drying schedule at room temperature: 4 - 24 hr  
Drying time hot air tunnel (25 - 60°C): 1 hr.  
Drying time IR/percussion: 3 min

**RECOMMENDED COATING SCHEDULES:**

Substrate:	Ash, maple, pine
Stain:	PD6xx/series
Basecoat: TTxx	Water Base Sealer
Topcoat:	TW34xx Water Base Finishes

**PRODUCT PREPARATION:** Dipping application

PD 6/ series	Stain	1-5 parts by weight
Water		40-50 parts by weight
PF95	Vehicle	40-50 parts by weight

Spray and Wipe application

PD 6/ series	Stain	1-5 parts by weight
Water		70-80 parts by weight
PD4/90	Vehicle	20-25 parts by weight

**REMARKS:** It is best to use waterbase sealer to limit the possibility of color bleed. For dipping application of white use special product code PD611. It is formulated ready to use by dipping.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18-25°C/64-75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10, Revised 10-10

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# ILVA TECHNICAL DATA SHEET

**PRODUCT SERIES:** ILVATINT

**PRODUCT CODE:** PF 5/Series

**DESCRIPTION:** Universal Stains

**USES:** Staining of furniture, frames, panels. Can be used by spray and roller, and diluted with solvent or water. Product should not be used without dilution.

**PRODUCT PREPARATION:** Spray application (water system)

Water		50-100 parts by weight
PF95	Vehicle	Add 10% - 40% to above mixture
PF 5/ series	Stain	10 parts by weight

Wipe Application (water system)

Water		50-100 parts by weight
PD4/90	Vehicle	Add 10% - 40% to above mixture
PF 5/ series	Stain	10 parts by weight

If you are using the Vehicles, you must add them to the water and stir before adding the PF5 stains. Addition of TZ08 will slow down the dry time for better wetting and wiping.

When spraying waterbase onto maple wood, the addition of AL 1000 Denatured Alcohol at 10% will help to limit blotching effect.

**FILM THICKNESS:** 2-2.4 wet mils

**COATS:** One

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 0.97 +/- 0.05  
Viscosity\* 10 +/- 2 sec

\*ASTM D1200 (Ford) #4 at 20°C/68°F

**DRYING TIME:** Handling and topcoating, solvent systems 30 - 60 sec  
(at 20°C/68°F) Handling and topcoating, water systems 8 hours minimum

**(tunnel 60°C or IR oven):** Handling and topcoating, solvent systems 10 sec  
Handling and topcoating, water systems 20 minutes minimum

**AVAILABLE COLORS:**

<b>PF50*</b> White	<b>PF51</b> Yellow	<b>PF54</b> Orange
<b>PF55</b> Red	<b>PF57</b> Violet	<b>PF58</b> Blue
<b>PF59</b> Black	<b>PF 5V</b> Green	<b>PF5B</b> White for water-based systems
<b>PF5T05</b> Medium walnut	<b>PF5T07</b> Dark walnut	<b>PF5T06</b> Mahogany
<b>PF5T01</b> Honey	<b>PF5T02</b> Cherry	<b>PF5T08</b> Rosewood
<b>PF5K18*</b> Wenge	<b>PF5WB18</b> Water Reducible Wenge	

**\*PF50 & PF5K18 can be used only in solvent, not in water**

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 03 - 97 Latest Revision 5-13, 9-16

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PF95

**DESCRIPTION:** Vehicle for Waterbase Stain

**USES:** Use as a vehicle for water base stain on cabinets, furniture, and chairs. Fast drying.

**APPLICATION SYSTEM:** Dip and spray

**PRODUCT PREPARATION:** Spray application

Water		100 parts by weight
PF95	Vehicle	10%-50% to water
PF5	Stain	1%-10%

Dip Application

Water		100 parts by weight
PF95	Vehicle	50%-100% to water
PC3 series*	Stain/colorant	7%-10%

\*PF5 and PZ5 colors can be used in very small amounts

If using the PF95 vehicle you must add it to the water first and then stir in the PF5 stains. Addition of TZ88 or PX0/03 will slow down the dry time for better wetting and wiping.

Increasing the vehicle percentage, in both cases, can cause both positive and negative effects:

- more uniform penetration
- less sagging
- greater coverage
- the grain is more enhanced

A wide variety of colors can be achieved by mixing the base colors in any of the three systems: PC3, or PF5, PZ5 series colorants (see note above for the PF5 and PZ5 colorants in dip applications)

**FILM THICKNESS:** 2-2.4 wet mils

**COATS:** One

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.02 +/- 0.03  
Viscosity\* 12 sec +/-1

\* DIN53211 #4 at 20°C/68°F

**DRYING TIME:** Handling: 2 - 4 hours  
(at 20°C/68°F)

**TYPICAL SYSTEMS:** Substrate: Various woods  
Stain vehicle: PF95  
Drying: 2 - 4 hours  
TTx series P/U WB Basecoats or TA series P/U Solvent Basecoats  
TW34 series P/U WB Topcoats or TO9 series P/U Solvent Topcoats

**NOTES:** We advise removal of excess stain so adhesion of the next coat will not be effected. The vehicle provides excellent workability to stain color bases.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

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# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PT410

**DESCRIPTION:** WHITE AQUATECH SEALER

**USES:** Horizontal and vertical surfaces, such as furniture, kitchen cabinets, interior doors. Excellent hiding power, sandability, and leveling.

**PRODUCT PREPARATION:** PT 410 White Aquatech Sealer 100 parts  
Water Thinner 0-10 %  
This product may be used without the addition of any crosslinker or hardener. The addition of TXW02 Crosslinker at 1% will slightly improve resistance properties. Best chemical resistance is achieved by adding TXW08 or HXS5A16 Hardener at 0%-10%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

**APPLICATION SYSTEM:** Spray - see pg. 26 for additional information

**FILM THICKNESS:** 4-6 mils wet per coat

**COATS:** Two Or Three coats maximum

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.36 +/- 0.02  
Viscosity - Ford Cup #8 71 +/- 5 sec  
Solids by Weight, % as supplied 57 +/- 2  
Pot Life with Hardener 1 to 3 hours with HXS5A16 or TXW08

**DRYING TIME:** Dust Free Flash-off at 40°C (104°F) 20-40 minutes  
(at 20°C/68°F) Dry To Touch 1-3 hours  
Dry To Cure 8-12 hours  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**TYPICAL SYSTEMS:** Substrate MDF  
Water-Based 2K Topcoat  
PT410 Basecoat  
2 or 3 coats maximum  
PW710 White 2K Poly Water 1 or 2 coats maximum  
Sand using 280-320 grit stearate paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the waterbased product and loading up sandpaper.

**RECOMMENDATIONS:** We recommend using this product at temperatures above 15°C (60°F) and <70% humidity. Do not use steel wool for sanding the raw wood since residual metal dust can cause rust spots. Wood can vary in color and absorption qualities, thereby producing different results in color of stain and finish coat. For touch-up and re-coating, it is advisable to use the same type of coatings as used on the first application. Drying times on all water-based coatings are increased by wood that has poor absorption characteristics and by cold, wet weather. It is always advisable to effect short tests with these products to verify that the results obtained meet your particular requirements.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PW710/Series

**DESCRIPTION:** WBWHITE 2K POLY TOPOAT

**USES:** Kitchen Cabinets (must use PU Hardener), Panels, Furniture. If used as a base for making pastel colors use PZ5xx series colorants and do not exceed 30% of pigmented paste.

**PRODUCTION PREPARATION:** PW710 W/B White 2K Polyurethane 100 parts by weight  
TXW08 Waterbase Hardener for PU 0-10 parts by weight  
Water Thinner 5-10 parts by weight (if necessary for application)  
This product may be used without the addition of any crosslinker or hardener. The addition of TXW02 Crosslinker at 1% will slightly improve resistance properties. Best chemical resistance is achieved by adding TXW08 or HXS5A16 Hardener at 0%-10%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

**APPLICATION SYSTEM:** Spray - see pg 26 for additional information

**FILM THICKNESS:** 4-6 wet mils per coat

**COATS:** One or Two Maximum

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.20 +/-0.02  
Viscosity using Ford Cup #6 40 +/- 5 sec  
Solids by Weight, % as supplied (I component) 44 +/- 2  
Solids by Weight, % as supplied (II component) 70%  
Pot Life using PU Hardener 1-3 hours

**DRYING TIME:** Dust Free Flash-off at 40°C (104°F) 20-40 minutes  
(at 20°C/68°F) Dry To Touch 1-3 hours  
Dry To Cure 8-12 hours  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**GLOSS AVAILABLE:** PW710/20 20 sheen  
PW710/10 10 sheen  
PW710/30 30 sheen  
PW710/60 60 sheen

**TYPICAL SYSTEMS:** Substrate: Various woods  
PT410 White Aquatech Sealer  
Sand using 280-320 grit stearate paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the waterbased product and loading up sandpaper.

**RECOMMENDATIONS:** We recommend using stainless steel for all water-based products. If using both solvent and water-based products we suggest the following:  
---from water to solvent: wash with water, then wash with solvent  
from solvent to water, reverse the cyle.  
Keep cans closed when not in use and wash all equipment well. Keep from freezing.  
Preparation note: to have a good mix between 1st and 2nd component you must follow this procedure: weigh and prepare separately the quantity of 2nd componenet necessary to mix; pour out slowly 2nd component into 1st component as 1st component is be continually mixed; add water only when 2nd component is completely mixed.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10, Revised 2-12, 3-12, 5-12, 11-12, 8-14, 3-15, 9-16, 4-17

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** PZ5.../COLOR SERIES

**DESCRIPTION:** WATER BASE PIGMENTED TINT PASTE

**USES:** Tinting colors for Water-Based Products. In general they may be used in all waterbase systems at a level of 15% maximum with no effect on film properties, only gloss levels at the maximum level of tint paste. If you mix with TW34x series more than 15% to make a deep tone color, you will raise the gloss level.

**AVAILABLE COLORS:** These colorants may also be used with the Klima Outdoor products. If you mix with the TN931/00 Clear or TN931 Wood Tone to make a solid color, the maximum you can add is up to 10%.

PZ520	White
PZ521	Vivid Yellow
PZ531	Lemon Yellow
PZ522	Gold Yellow
PZ523	Yellow Oxide
PZ561	Yellow
PZ564	Orange
PZ537	Green
PZ534	Vivid Red
PZ525	Wisteria Red
PZ535	Red
PZ526	Red Oxide
PZ534/C	Concentrate Red
PZ527	Bordeaux
PZ547	Violet
PZ528	Blue
PZ529	Deep Black
PZ539	Black

**CHEMICAL/PHYSICAL PROPERTIES:**

CODE	Density (Kg/l)	Density (lb/US gal)	Solid content %
PZ520	2.100 +/- 0.030	17.5 +/- 0.3	77.7 +/- 2
PZ521	1.126 +/- 0.030	9.4 +/- 0.3	47.6 +/- 2
PZ531	1.857 +/- 0.030	15.5 +/- 0.3	68.6 +/- 2
PZ522	1.181 +/- 0.030	9.9 +/- 0.3	49.3 +/- 2
PZ523	1.611 +/- 0.030	13.4 +/- 0.3	54.6 +/- 2
PZ561	1.134 +/- 0.030	9.5 +/- 0.3	48.4 +/- 2
PZ564	1.165 +/- 0.030	9.7 +/- 0.3	43.2 +/- 2
PZ537	1.221 +/- 0.030	10.2 +/- 0.3	46.4 +/- 2
PZ534	1.119 +/- 0.030	9.3 +/- 0.3	39.2 +/- 2
PZ525	1.085 +/- 0.030	9.1 +/- 0.3	35.0 +/- 2
PZ535	1.111 +/- 0.030	9.3 +/- 0.3	39.4 +/- 2
PZ526	1.673 +/- 0.030	14.0 +/- 0.3	56.2 +/- 2
PZ534/C	1.180 +/- 0.030	9.8 +/- 0.3	54.0 +/- 2
PZ527	1.174 +/- 0.030	9.8 +/- 0.3	54.0 +/- 2
PZ547	1.100 +/- 0.030	9.2 +/- 0.3	38.3 +/- 2
PZ528	1.071 +/- 0.030	8.9 +/- 0.3	32.3 +/- 2
PZ529	1.133 +/- 0.030	9.5 +/- 0.3	44.5 +/- 2
PZ539	1.100 +/- 0.030	9.2 +/- 0.3	39.0 +/- 2

**USAGE INDICATIONS:** Mechanically shake every single paste before use. It is advisable to add pastes under mechanical mixing. Quantities must be weighed with high precision balances.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F).

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TT06

**DESCRIPTION:** WB CLEAR 2K POLY SEALER

**USES:** Horizontal and vertical surfaces, furniture, kitchen cabinets, panels. This product provides maximum chemical resistance.

**PRODUCT PREPARATION:** TT06 W/B Clear 2K P/U Sealer 100 parts by weight  
TXW08 or HXS5A16 Hardener 5-10%  
Water Thinner 0-5 parts by weight (if necessary for application)

**APPLICATION SYSTEM:** Spray - see pg 26 for additional information

**FILM THICKNESS:** 4-6 mils wet per coat)

**COATS:** One or Two maximum

**GENERAL PROPERTIES:** Specific Gravity, gr/cc, part A 1.030 +/- 0.01  
Specific Gravity, gr/cc, part B 1.170 +/- 0.01  
Viscosity - Part A - Ford Cup #6 46 +/- 2 sec  
Solids by Weight, %, as supplied (I component) 34 +/- 2  
Solids by Weight, % as supplied (II component) 80%  
Solids by Weight, % Catalyzed Product 38 +/- 2  
Pot Life 1 - 3 hours

**DRYING TIME:** Dust Free Flash-off at 40°C (104°F) 20-40 minutes  
(at 20°C/68°F) Dry To Touch 1-2 hours  
Dry To Cure 6-8 hours  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**TYPICAL SYSTEMS:** Substrate: Various woods  
PD6xx Waterbase Stain or PF5x Series Stains  
TT06 W/B Clear 2K P/U Sealer  
TW34/series W/B Clear 2K P/U Topcoat  
Sand using 280-320 grit stearate paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the waterbased product and loading up sandpaper.

**RECOMMENDATIONS:** We recommend using stainless steel for all water-based products. If using both solvent and water-based products we suggest the following:  
---from water to solvent: wash with water, then wash with solvent  
from solvent to water, reverse the cycle.  
Keep cans closed when not in use and wash all equipment well. Keep from freezing.  
Preparation note: to have a good mix between 1st and 2nd component you must follow this procedure: weigh and prepare separately the quantity of 2nd component necessary to mix; pour out slowly 2nd component into 1st component as 1st component is continually mixed; add water only when 2nd component is completely mixed.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F).

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TT276

**DESCRIPTION:** WB CLEAR SANDING SEALER

**USES:** General Purpose Wood Sealer for horizontal and vertical surfaces. Fast dry & good sanding.

**PRODUCT PREPARATION:** TT276 W/B Clear Sanding Sealer 100 parts by weight  
Water Thinner 5-10 parts by weight (if necessary for application)  
This product may be used without the addition of any crosslinker or hardener. The addition of TXW02 Crosslinker at 1% will slightly improve resistance properties. Best chemical resistance is achieved by adding TXW08 or HXS5A16 Hardener at 1%-10%. The more Hardener you add, the shorter the pot life, but better the chemical resistance.

**APPLICATION SYSTEM:** Spray - see pg 26 for additional information

**FILM THICKNESS:** 4-6 mills wet per coat

**COATS:** One or two

**GENERAL PROPERTIES:**

Specific Gravity, gr/cc, part A	1.030 +/- 0.01
Specific Gravity, gr/cc, part B	1.075 +/- 0.01
Viscosity* Part A - Ford Cup #6	40 +/- 2 sec
Solids by Weight, %, as supplied (Part A)	33 +/- 2
Solids by Weight, % as supplied (Part B)	70 +/- 2
Pot Life using PU Hardener	1 - 3 hours

**DRYING TIME:** Dust Free Flash-off 20-40 minutes  
(at 20°C/68°F) Dry To Cure 6-8 hours  
Dry To Cure by warm air tunnel (25-40C) 2 hours  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**TYPICAL SYSTEMS:** Substrate: Various woods  
PD6 W/B Stain  
TT276 W/B Clear Sanding Sealer One or two coats  
TW34/series W/B Clear 2K P/U Topcoat  
Sand using 280-320 grit stearate paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the waterbased product and loading up sandpaper.

**RECOMMENDATIONS:** We recommend using stainless steel for all water-based products. If using both solvent and water-based products we suggest the following:  
---from water to solvent: wash with water, then wash with solvent  
from solvent to water, reverse the cycle. If you find it necessary to dilute the material we suggest using de-ionized water in order to avoid problems which may arise from a high concentration of salts.  
Keep cans closed when not in use and wash all equipment well. Keep from freezing. Do not thin more than 10%.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18-25°C/64-75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10, Revised 9-11, 5-12, 11-12, 3-15, 9-16, 4-17

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# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TW18

**DESCRIPTION:** WB CLEAR NATURAL EFFECT SELF SEAL

**USES:** Flat panels and kitchen doors. Fast drying, very good pore design, transparency and soft natural feel. To be used as a self-sealer with or without hardener. Hardener increases the chemical resistance properties.

**PRODUCT PREPARATION:** TW18 W/B Clear Natural Effect Self-Sealer 100 parts by weight  
TXW08 Hardener 5 parts by weight  
Water Thinner as needed (if necessary for application)

**APPLICATION SYSTEM:** Spray - see pg 26 for additional information

**FILM THICKNESS:** 2.5 - 4 wet mils

**COATS:** One or two

**GENERAL PROPERTIES:** Specific Gravity, gr/ml 1.011 +/- 0.02  
Viscosity\* (ISO 6) 70 - 75 sec  
Solids by Weight, %, as supplied (Part A) 17 +/- 2  
Solids by Weight, % as supplied (Part B) 80 +/- 2  
Pot Life using PU Hardener 5 - 6 hours

**DRYING TIME:** (at 20°C/68°F) Drying schedule at room temperature 1 - 3 hours  
Dry To Cure by warm air tunnel (25-40C) 90 minutes  
Sandable after 4 hours  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**TYPICAL SYSTEMS:** Substrate: Walnut/oak/multi-laminar woods  
Stain: PF5 Series  
Sealer TW18 (3-4 wet mils)  
Topcoat: TW18 - topcoat 5 sheen (3-4 wet mils)  
TXW08 - 5%

**RECOMMENDATIONS:** Sand using 280-320 grit stearate paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the waterbased product and loading up sandpaper.

We recommend using stainless steel for all water-based products. If using both solvent and water-based products we suggest the following:

---from water to solvent: wash with water, then wash with solvent  
from solvent to water, reverse the cycle. If you find it necessary to dilute the material we suggest using de-ionized water in order to avoid problems which may arise from a high concentration of salts. Keep cans closed when not in use and wash all equipment well. Keep from freezing. Do not thin more than 10%.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10, Revised 9-11, 5-12, 11-12, 4-17, 6-17

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TW34 Series

**DESCRIPTION:** WB CLEAR 2K POLY TOPCOAT

**USES:** Kitchen Cabinets (must use PU Hardener). Manufactured indoor products, including panels and furniture.

**PRODUCT PREPARATION:** TW 34series WB Clear 2K Poly Topcoat 100 parts by weight  
TXW08 Waterbase Hardener for PU 0-10 parts by weight  
Water Thinner 0-10 parts by weight (if necessary for application)  
This product may be used without the addition of any crosslinker or hardener. The addition of TXW02 Crosslinker at 1% will slightly improve resistance properties. Best chemical resistance is achieved by adding TXW08 or HXS5A16 Hardener at 0%-10%. The more Hardener you add, the shorter the pot life, longer the dry time, but improved chemical resistance.

**APPLICATION SYSTEM:** Spray - see pg 26 for additional information

**FILM THICKNESS:** 4-6 wet mils per coat

**COATS:** One

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.03 +/- 0.02  
Viscosity - Ford Cup #6  
TW340-TW341-342-343-344-346-347 40 +/- 2 sec  
Solids by Weight, % as supplied (I component) 33 +/- 2  
Solids by Weight, % as supplied (II component) 70%  
Pot Life using PU Hardener 2 - 3 hours

**DRYING TIME:** Dust Free 50 minutes  
(at 20°C/68°F) Dry To Touch 60-90 minutes  
Dry To Handle (with forced air dry can be reduced to 2 hrs) 5 hours  
Dry To Cure to achieve ultimate resistance properties 96 hours  
Please note that drying times may change with varying temperatures, ventilation, relative humidity, and type and quantity of hardener. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**GLOSS AVAILABLE:** TW340 80-85 sheen  
TW341 64-66 sheen TW344 19-21 sheen  
TW342 48-52 sheen TW346 9-12 sheen  
TW343 28-32 sheen TW347 4-6 sheen

**RECOMMENDATIONS:** Sand with 280- 320 paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the water based product and loading up sandpaper.  
To guarantee an adequate incorporation of the second component please use the following procedure: weigh out the appropriate amount of the second component; add the second component to the TW34 series slowly, while using the automatic agitator; add water only when the second component has been incorporated completely. Drying times can vary with differing temperatures, ventilation and relative humidity. We recommend using stainless steel for all water-based products.  
Keep cans closed when not in use and wash all equipment well. Keep from freezing.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 9-10, Revised 9-11, 5-12, 11-12, 9-16, 1-17, 4-17

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# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TW88X

**DESCRIPTION:** WB SELF SEALER 2K FLOOR FINISH

**USES:** For parquet and stairs (open and closed pores)

**PRODUCT PREPARATION:**

TW 88X	WB Self Sealer 2K	100 parts by weight
TXW08	Waterbase Hardener	10 parts by weight
Water	Thinner	0-10 parts by weight (if necessary for application)

\*Pot life with TXW08: from 1-3 hours depending on dilution percentage and room temperature. For improved hardness and wear resistance use HXS5A16 (must be mechanically mixed)

**APPLICATION SYSTEM:** Brush or roller

**FILM THICKNESS:** 3-5 wet mils per coat, maximum 12 wet mils total

**COATS:** Three

**GENERAL PROPERTIES:**

Specific Gravity, gr/cc	1.000 +/- 0.02
Viscosity (Ford Cup #4)	13 +/- 2 sec
Solids by Weight, %, as supplied (I component)	28 +/- 2
Thinner	Water
Dilution	0-10%, if necessary

**DRYING TIME:** Drying schedule at room temperature:

Dust Free	45 minutes
Dry to touch	2 hours 30 minutes
Hard Dry	12 hours
Drying time in tunnel 25-60°C	1 h
Walk on	with care, in 24 hours
Time between coats without sanding	2-4 hours

Please note that drying times may change with varying temperatures, ventilation and relative humidity.

**GLOSS AVAILABLE:**

TW882	50 sheen +/- 3
TW884	20 sheen +/- 2

**TYPICAL SYSTEMS:**

(a) Substrate: Various woods (sand with 150 paper) Base Coat: TW88x with 10% TXW08 Dry for 12 hours - sand with 280-320 Base Coat: TW88x with 10% TXW08 Dry for 12 hours - sand with 280-320 Topcoat: TW88x with 10% TXW08	(b) Substrate: Various woods (sand w/150) Primer Dry for 6 hours - sand with 280-320 Basecoat: TW88x with 10% TXW08 Dry for 8 hours sand with 280-320 Basecoat: TW88x with 10% TXW08 Dry 12 hours - sand with 280-320 Topcoat: TW88x with 10% TXW08
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**RECOMMENDATIONS:** To guarantee an adequate incorporation of the second component please use the following procedure: weigh out the appropriate amount of the second component; add the second component to the TW88 series slowly, while using the automatic agitator; add water only when the second component has been incorporated completely. Drying times can vary with differing temperatures, ventilation and relative humidity. We recommend using stainless steel for all water-based products. Keep cans closed when not in use and wash all equipment well. Keep from freezing.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 09-10, Revised 1-11, 9-16, 4-17, 2-18

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** WB1343

**DESCRIPTION:** WB GLAZE & WIPE STAIN LOW SOLIDS BASE

**USES:** Vehicle for staining & glazing by spray and wipe. Suitable for all types of wood. Very little grain raising when used as a stain. It may be used as a glaze in both waterbase and solvent based polyurethane cycles.

**APPLICATION SYSTEM:** Spray and wipe

**FILM THICKNESS:** 1.6 - 2.4 wet mils

**GENERAL PROPERTIES:**

Specific Gravity, gr/cc	1.10 +/- 0.02
Viscosity (DIN 53211 Cup 0 - 4mm)	30 +/- 2 sec
Solids by Weight, %, as supplied	27 +/- 1%

**DRYING TIME:** Air Dry 2-4 hours. Moving ambient air for the best drying conditions.  
(at 20°C/68°F) Please note that drying times may change with varying temperatures, ventilation and relative humidity.

**SUGGESTED COATING CYCLES:**

Substrate:	Different kinds of wood
Stain:	WB1343 & colors
Drying:	2 - 4 hours
Base Coat:	TTx Series P/U WB Basecoats or TA Series P/U Solvent Basecoats
Topcoat:	TW34 Series P/U WB Topcoats or TO9 Series P/U Solvent Topcoats

**TYPICAL STAIN COLOR FORMULATION:**

WB1343	80 parts
PD6 colors*	10 parts
Water	10 parts

\*You may also use PC3 colors to obtain bright and very clear stains. PZ5xx Series Aquatech pastes may also be used at maximum 10% level.

**TYPICAL GLAZE COLOR FORMULATION:**

WB1343	80 parts
PZ5xx colors*	10 parts
Water	10 parts

\*You may also use PD6xx stain colorants

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** WBS5A15

**DESCRIPTION:** WHITE INTERIOR WB STAIN BLOCK SEALER

**USES:** Recommended for use as a tannin stain blocker. Seals tannins, knots and wood sap areas. May be used on new construction or remodeling work.

**PRODUCT PREPARATION:** WBS5A15 White Interior WB Stain Block Sealer 100 parts  
Water Thinner 0-5%

**APPLICATION SYSTEM:** Airmix Spray or Hand Spray

**FILM THICKNESS:** 2.4 - 3.6 wet mils

**COATS:** Two coats maximum

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.15+/- 0.03  
Viscosity (Ford Cup #6) 65 +/- 5 sec  
Solids by Weight, %, as supplied 50 +/- 2

**DRYING TIME:** Dust Free 40 minutes  
Dry to touch 60 minutes  
Dry to Cure 3 hours  
Stackable after room temperature drying 4 hours  
Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**TYPICAL SYSTEMS:**

Substrate	Pine, Poplar, MDF, Oak	
WBS5A15	White Stain Block	1 coat - no sanding
PT410	White Sealer	1 coat - apply same day as stain block
PW710 series/TXW08	White 2K Topcoat	1 coat
Substrate	Pine, Poplar, MDF, Oak	
WBS5A15	White Stain Block	1 coat, dry overnight or longer, sand
PT410	White Sealer	1 coat
PW710 series/TXW08	White 2K Topcoat	1 coat

**RECOMMENDATIONS:** We recommend using this product at temperatures above 15°C (60°F) and <70% humidity. Do not use steel wool for sanding the raw wood since residual metal dust can cause rust spots. Wood can vary in color and absorption qualities, thereby producing different results in color of stain and finish coat. For touch-up and re-coating, it is advisable to use the same type of coatings as used on the first application. Drying times on all water-based coatings are increased by wood that has poor absorption characteristics and by cold, wet weather. It is always advisable to effect short tests with these products to verify that the results obtained meet your particular requirements.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** WBS503

**DESCRIPTION:** WHITE AQUATECH SEALER

**USES:** Furniture, doors and profiles for solid wood and MDF. Very fast dry with excellent sanding properties.

**PRODUCT PREPARATION:** WBS503 White Aquatech Sealer 100 parts  
Water Thinner 0-5 %

**APPLICATION SYSTEM:** Airmix Spray or Hand Spray

**FILM THICKNESS:** 4.8 - 6.4 wet mils

**COATS:** Two coats maximum

**GENERAL PROPERTIES:** Specific Gravity, gr/cc 1.38 +/- 0.05  
Viscosity - CF4@20°C 85 +/- 8 sec  
Solids by Weight, % as supplied 59 +/- 2

**DRYING TIME:** Drying schedule at room temperature 2-4 hours  
**(at 20°C/68°F)** Drying time with hot air tunnel 45 minutes  
Dust Free 30 minutes  
Dry To Touch 60 minutes  
Dry To Cure 2-4 hours  
Sandable after Minimum 2 hours  
Time between layers 1-4 hours

Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**RECOMMENDATIONS:** We recommend using this product at temperatures above 15°C (60°F) and <70% humidity. Do not use steel wool for sanding the raw wood since residual metal dust can cause rust spots. Wood can vary in color and absorption qualities, thereby producing different results in color of stain and finish coat. For touch-up and re-coating, it is advisable to use the same type of coatings as used on the first application. Drying times on all water-based coatings are increased by wood that has poor absorption characteristics and by cold, wet weather. It is always advisable to effect short tests with these products to verify that the results obtained meet your particular requirements.

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** WES5A01

**DESCRIPTION:** WB GLAZE & WIPE STAIN HIGH SOLIDS BASE

**USES:** Vehicle for staining and glazing by spray and wipe. Suitable for all types of wood. Very little grain raising when used as a stain. It may be used as a glaze in both waterbase and solvent based polyurethane cycles.

**APPLICATION SYSTEM:** Spray and wipe

**FILM THICKNESS:** 1.6 - 2.4 wet mils

**GENERAL PROPERTIES:**

Specific Gravity, gr/cc	1.12 +/- 0.02
Viscosity (DIN 53211 Cup 0 - 4mm)	33 +/- 2 sec
Solids by Weight, %, as supplied	33 +/- 1%

**DRYING TIME:** Air Dry 2-4 hours. Moving ambient air for the best drying conditions.  
(at 20°C/68°F) Please note that drying times may change with varying temperatures, ventilation and relative humidity.

**SUGGESTED COATING CYCLES:**

Substrate:	Different kinds of wood
Stain:	WES5A01 & colors
Drying:	2 - 4 hours
Base Coat:	TTx Series P/U WB Basecoats or TA Series P/U Solvent Basecoats
Topcoat:	TW34 Series P/U WB Topcoats or TO9 Series P/U Solvent Topcoats

**TYPICAL STAIN COLOR FORMULATION:**

WES5A01	80 parts
PD6 colors*	10 parts
Water	10 parts

\*You may also use PC3 colors to obtain bright and very clear stains. PZ5xx Series Aquatech pastes may also be used at maximum 10% level.

**TYPICAL GLAZE COLOR FORMULATION:**

WES5A01	80 parts
PZ5xx colors*	10 parts
Water	10 parts

\*You may also use PD6xx stain colorants

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 08-11, 6-12, 3-17

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** WES5A07

**DESCRIPTION:** DRY WATER GLAZE

**USES:** Antiquing and Decape effect on mobile in style, doors and frames for painting

**PRODUCT PREPARATION:** WES5A07 Dry Glaze 100 parts by weight 128 parts by volume  
May be tinted to color using ILVA PZ5xx series water-base pigmented pastes.  
May be diluted with water if needed.

**APPLICATION SYSTEM:** By spray and wipe. Allow to air dry 15-45 minutes. Moving ambient air is best for drying conditions.  
After drying, remove the antiquing glaze with scotch brite or cloth to desired effect.

**GENERAL PROPERTIES:** Specific gravity: 1.02 +/-0.02 gr/m;  
Solids content: 8.45% +/- 1% by weight  
Viscosity (at 20°C): 50+/-3 (iso 6)

**TYPICAL SYSTEM:** PT410 1 coat-dry 2-3 hours and sand  
PW710/10 with 5% TXW08 1 coat-dry 2- 3 hours and then very lightly sand with scotch brite  
WES5A07 tinted with PZ5xxseries apply by cloth-allow to dry 45 minutes  
remove with scotch brite or cloth  
TW34/series final clear coat

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

**DATE OF ISSUANCE:** 4-13

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## ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** WMM5A/SERIES

**DESCRIPTION:** WB WHITE SELF-SEALER

**USES:** Furniture, architectural millwork, store fixtures. Offers the best in dry times and leveling, with very good sanding properties and filling power.

**PRODUCT PREPARATION:** WMM5A series      White Self-Sealer      100 parts by weight      128 parts by volume  
Water      0-5 parts      1-6 parts by volume

**APPLICATION SYSTEM:** Spray

**FILM THICKNESS:** 4.4 - 5.2 wet mils

**GENERAL PROPERTIES:** Specific gravity: 1.28+/-5 gr/l  
Solid content (% by weight) 55 +/- 2 by weight  
Viscosity (at 20°C): 95+/-15 (iso 6)

**DRYING TIME:** All dry times are dependent upon air flow, ambient temperatures, and humidity  
(at 20°C/68°F) Drying schedule at room temperature 2-3 hours  
Drying time with hot air tunnel 20-30 mins  
Dust free/time gel 30-60 mins  
Dry to touch 2-3 hours  
Dry Hard 6-8 hours  
Stackable overnight  
Sandable after 2-3 hours before applying 2nd coat as topcoat

**GLOSS LEVELS:** WMM5A03D 60 sheen  
WMM5A032 50 sheen  
WMM5A033 30 sheen  
WMM5A034 20 sheen  
WMM5A036 10 sheen

**SHELF LIFE:** 12 Months

**STORAGE:** Store in a tightly closed container at room temperatures (18 -25°C/64 -75°F) and protect from moisture and foreign material. Do not store at temperatures below 7°C (45°F)

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## HELPFUL HANDLING & MIXING INSTRUCTIONS

### VISCOSITY AND REDUCTION

Our waterbase products are generally formulated at a high thixotropy level. This is done to ensure good vertical spray properties. Water can be used as a thinning agent generally at 5-10%. Our recommended thinner or retarder is PX0/03, at a level of 1-5%. We also have a special Waterbase Reducer, code TZ-88, used at 1-5%. It will reduce the viscosity much faster than adding water, but will retard the dry.

### ADDING THE PU HARDENER

PU Hardener HXS5A16 and TXW08 are used to increase the resistance properties. The end result will be our most resistant waterbase products. Please note that both HXS5A16 and TXW08 are not flammable.

HXS5A16 is difficult to add by hand stirring. If you attempt to do this, you must make a pre-mix of the reducer and hardener. First make a mixture of 80% water and 20% TZ08, (our code TZ88). Then mix this reducer 1/1 with the HXS5A16. This premixed reducer and hardener can then be added to the paint. If you are adding HXS5A16 under mechanical agitation, you may add it directly to the paint while stirring. HXS5A16 is a non-yellowing hardener and gives the best chemical resistance properties.

TXW08 may be added directly to the paint whether stirring by hand or using mechanical agitation. The higher the level of TXW08, the slower the dry time will be. TXW08 is a non-yellowing hardener and gives a slightly lower result in chemical resistance properties versus HXS5A16.

Many of our water-based products may be used without the addition of hardener, or by using TXW02 Crosslinker or by adding polyurethane hardeners HXS5A16 or TXW08. Please refer to the individual product technical data sheet. The more hardener you add, the better the chemical resistance properties. A general rule of thumb is that higher levels of hardener will slow down the dry time and may effect the gloss level.

### ADDING THE CROSSLINKER

TXW02 Crosslinker is used to increase the resistance properties over using waterbase as a one component product. These properties will not be as high as using a Polyurethane Hardener.

TXW02 may be added directly to the paint whether stirring by hand or using mechanical agitation. The recommended level of TXW02 is 1.0%. Adding the crosslinker will improve the chemical resistance properties versus using the material as a one component product. The crosslinker remains effective for approx 8 hours. At the end of this time, the unused product is not lost, but may be rejuvenated by adding an equal volume or more of fresh material to the product that was not used, and then you must re-crosslink at 1% the entire new quantity.

### SANDING

It is recommended that you use a finer grit paper for sanding raw wood when finishing with water-based products than solvent based products. When sanding water based finishes 280-320-400 steartated paper is recommended.

### SPRAY APPLICATION

You may use air-assisted airless, conventional, pressure pot, or cup gun for spraying. Best results are obtained using air-assisted airless with 600 fluid lbs and 35-40 static atomizing pressure and small tips, such as 06134/06154.

### DRYING

Best drying method for water-based products is warm moving fresh air. Fresh air is necessary to keep the drying room humidity level under control.

### RECOMMENDED STORAGE

All water-based products should be stored in tightly closed containers at temperatures above 5°C (41°F)

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## CONCERNS

Since every single panel or any other substrate, even if of the same chemical nature, can be theoretically different than the previous one and possess chemical and physical properties which can greatly influence the end-results of the applied coating, and considering that the mixing, catalysis and diluting operations are not under our strict control, nor are temperatures, air humidity and technical features of the various installations, which can also effect the end results, subject to our personal decision at the time of application, it is impossible for our company to assume any responsibility whatsoever in regard to the results obtained with the use of our products.

Futhermore, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is definitely not caused by the quality of the products employed.

The technological information contained in the present technical data sheets are based on the average results obtained with the test effects in our laboratories, and as such represents the most complete information and technological experience available in the wood coating field.

Our company gives the maximum assurance as to the constancy of the chemical and physical properties of our products within the tolerance limits indicated on our technical data sheets. Our company is also always ready to substitute any of our products, whenever the properties do not correspond to the information given in our technical bulletins.

Nevertheless, the end results obtained are under the complete responsibility of the end user, who has the obligation to verify if the properties of the specific products in use correspond to his particular requirements, and if the ambient conditions, application, installation and substrates might eventually indicate substantial modifications of the products involved.

All the information in our technical data sheets have been obtained at a temperature of 20°C and at a relative humidity of 70%.

11-12-18

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