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
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

AVAILABLE COLORS:

<table>
<thead>
<tr>
<th>Color Code</th>
<th>Color</th>
<th>Specific Gravity (gr/ml +/-2)</th>
<th>Solid Content (by weight +/-2)</th>
<th>Viscosity (ISO)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PC30</td>
<td>White</td>
<td>1.200</td>
<td>27%</td>
<td>70 +/-5 (ISO3)</td>
</tr>
<tr>
<td>PC31</td>
<td>Yellow</td>
<td>1.020</td>
<td>7%</td>
<td>24 +/-2 (ISO3)</td>
</tr>
<tr>
<td>PC34</td>
<td>Orange</td>
<td>1.030</td>
<td>6.5%</td>
<td>10 +/-2 (DIN 4)</td>
</tr>
<tr>
<td>PC35</td>
<td>Red</td>
<td>1.020</td>
<td>7%</td>
<td>26 +/-2 (ISO 3)</td>
</tr>
<tr>
<td>PC36</td>
<td>Brown</td>
<td>1.030</td>
<td>13%</td>
<td>26 +/-2 (ISO 3)</td>
</tr>
<tr>
<td>PC38</td>
<td>Blue</td>
<td>1.000</td>
<td>5%</td>
<td>20 +/-2 (DIN 4)</td>
</tr>
<tr>
<td>PC39</td>
<td>Black</td>
<td>1.020</td>
<td>10%</td>
<td>25 +/-2 (ISO 3)</td>
</tr>
</tbody>
</table>

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: One Year

STORAGE: Store in a tightly closed container at room temperature 18-25°C, 64-75°F and protect from moisture and foreign material.

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

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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 mm4)

DRYING: Air (min 4 hours)

SUGGESTED COATING CYCLES:
- Substrate: Different kind of wood
- Stain: PD4/90 + PC3/series + water = 100/10/50
- Drying: 4 hr
- Base coat: TT PUR WB basecoats
- Topcoat: TW PUR WB topcoats

SHELF LIFE: One Year

STORAGE: Store in a tightly closed container at room temperature 18-25°C, 64-75°F and protect from moisture and foreign material.

DATE OF ISSUANCE: 09-10
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.

CHEMICAL-PHYSICAL PROPERTIES:

<table>
<thead>
<tr>
<th>Property</th>
<th>Specific gravity(at 20°C) (+/-.05)</th>
<th>Solid content (M.U. 591) (by weight +/-1)</th>
<th>Viscosity (ISO 3 at 20°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PD601 White</td>
<td>1.15</td>
<td>24%</td>
<td>70 +/-5</td>
</tr>
<tr>
<td>PD602 Yellow vivid</td>
<td>1.1</td>
<td>24%</td>
<td>30 +/-3</td>
</tr>
<tr>
<td>PD603 Yellow Oxide</td>
<td>1.19</td>
<td>45%</td>
<td>30 +/-2</td>
</tr>
<tr>
<td>PD604 Yellow Solid</td>
<td>1.08</td>
<td>31%</td>
<td>28 +/-3</td>
</tr>
<tr>
<td>PD605 Red</td>
<td>1.08</td>
<td>29%</td>
<td>28 +/-3</td>
</tr>
<tr>
<td>PD606 Orange</td>
<td>1.60</td>
<td>23%</td>
<td>31 +/-3</td>
</tr>
<tr>
<td>PD607 Green</td>
<td>1.15</td>
<td>52%</td>
<td>27 +/-3</td>
</tr>
<tr>
<td>PD608 Blue</td>
<td>1.12</td>
<td>23%</td>
<td>31 +/-3</td>
</tr>
<tr>
<td>PD609 Black</td>
<td>1.12</td>
<td>22%</td>
<td>27 +/-3</td>
</tr>
<tr>
<td>PD611 White (dipping)</td>
<td>1.11</td>
<td>20%</td>
<td>27 +/-3</td>
</tr>
</tbody>
</table>

AVAILABLE COLORS:

APPLICATION SYSTEM: Spray or roller or dip

QUANTITY (gr/sq mt): Max total: spray & wipe: 20-40; spray manual: 10-20

DRYING TIME:
(At 20°C/68°F)
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: One Year

STORAGE:
Store in a tightly closed container at room temperatures (18-25°C/64-75°F and protect from moisture and foreign material.

DATE OF ISSUANCE: 09-10, Revised 10-10
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
PF 95 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 for better wetting and wiping.

When spraying waterbase onto maple wood, the addition of AL1000 Denatured Alcohol at 10% will help to limit blotching effect.

QUANTITY(grsq mt): 50 - 60

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

DRIING TIME:
Handling and topcoating, solvent systems 30 - 60 sec
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:
PF50* White PF51 Yellow PF54 Orange
PF55 Red PF57 Violet PF58 Blue
PF59 Black PF5V Green PF5B White for water based systems
PF5T05 Medium walnut PF5T07 Dark walnut PF5T06 Mahogany
PF5T01 Honey PF5T02 Cherry PF5T08 Rosewood
PF5K18* Wenge

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

SHELF LIFE: One year

STORAGE: Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material.

DATE OF ISSUANCE: 03 - 97 Latest Revision 5-13

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IC & S, P.O. BOX 10845, LANCASTER, PA 17605
(800) 220-4035
PRODUCT CODE: PT 200

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 200 White Aquatech Sealer 100 parts
Water Thinner 5-10 %

This product may be used without the addition of any hardener. Best chemical resistance is achieved by adding TXW08 or TXW11 Hardener at 1%-5%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

APPLICATION SYSTEM: Spray - see pg 18 for additional information

QUANTITY(grsq mt): 90-150 per coat, total maximum 250 (4-6 wet mils per coat)

COATS: Two coats maximum

GENERAL PROPERTIES: Specific Gravity, gr/cc 1.36 +/- 0.02
Viscosity - Ford Cup #4 80 +/- 5 sec
Solids by Weight, % as supplied 58 +/- 2
Pot Life with Hardener 1 to 3 hours with TXW11/TXW08

Drying Time:
(at 20°C/68°F)
- Dust Free Flash-off at 40°C (104°F) 20-40 minutes
- Dry To Touch 1-3 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 and best dry times for handling and stacking.

TYPICAL SYSTEMS:
- Substrate MDF
- Water Based 2K Topcoat
- PT200 Basecoat
- 2 coats maximum
- PW700 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: Six 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 5°C (41°F)

DATE OF ISSUANCE: 12-11, Revised 5-12, 11-12

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PRODUCT CODE: PT 410

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 0-5 %

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 TXW11 Hardener at 1%-5%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

APPLICATION SYSTEM: Spray - see pg. 18 for additional information

QUANTITY (grsq mt): 90-150 per coat, total maximum 350 (4-6 wet mils 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 TXW11 or TXW08

DUST FREE Flash-off at 40°C (104°F) 20-40 minutes

Drying Time:
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 and best dry times for handling and stacking.

TYPICAL SYSTEMS:
Substrate MDF
Water Based 2K Topcoat
PT410 Basecoat
2 or 3 coats maximum
PW700 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 prducts to verify that the results obtained meet your particular requirements.

SHELF LIFE: Six 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 5°C (41°F)

DATE OF ISSUANCE: 09-10, Revised 9-11, 5-12, 11-12
PRODUCT CODE: PW 710/series

DESCRIPTION: WB WHITE 2K POLY TOPCOAT

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.

PRODUCT PREPARATION: PW 7XX 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 TXW11 Hardener at 1%-10%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

APPLICATION SYSTEM: Spray - see pg 18 for additional information

QUANTITY(grsq mt): 120-160 per coat (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

DRIYING 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 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 component 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: Six 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 5°C (41°F)

DATE OF ISSUANCE: 09-10, Revised 2-12, 3-12, 5-12, 11-12
PRODUCT CODE: PZ5.../COLOR

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 10% maximum with no effect on film properties or gloss level. If you use with TW700 Neutral Base you can use at level of up to 30% to make deep tone colors, with no effect on gloss level. If you mix with TW34x series more than 10% to make a deep tone color, you will raise the gloss level.

These colorants may also be used with the Klima Outdoor products. If you mix with the PN6/01 Neutral base to make a solid color, the maximum you can add is up to 15%.

AVAILABLE COLORS:

- PZ520 White
- PZ531 Hi Hide Lemon Yellow
- PZ502 Solid Yellow
- PZ523 Yellow Oxide
- PZ524 Orange
- PZ510 Green
- PZ534 Brite Red
- PZ505 Carmine Red
- PZ535 Red
- PZ506 Red Oxide
- PZ527 Bordeaux
- PZ517 Violet
- PZ528 Blue
- PZ529 Black

SHELF LIFE: One Year

STORAGE: Store in a tightly closed container at room temperature 18-25°C, 64-75°F and protect from moisture and foreign material.

DATE OF ISSUANCE: 4-12, Revised 6-12, 11-12, 4-13
**PRODUCT CODE:** TT 06

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

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

**PRODUCT PREPARATION:**

<table>
<thead>
<tr>
<th>Component</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>TT06 W/B Clear 2K P/U Sealer</td>
<td>100 parts by weight</td>
</tr>
<tr>
<td>TXW08 or TXW11 Hardener</td>
<td>5-10%</td>
</tr>
<tr>
<td>Water Thinner</td>
<td>0-5 parts by weight (if necessary for application)</td>
</tr>
</tbody>
</table>

**APPLICATION SYSTEM:** Spray - see pg 18 for additional information

**QUANTITY(gr sq mt):**

90-150 per coat, 300 maximum (4-6 wet mils 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
- **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 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.

Preperation note: to have a good mix between 1st and 2nd component you must follow this procedure: weigh and prepare separately the quantity of 2nd componentet 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:** Six 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 5°C (41°F)

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

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PRODUCT CODE: TT 276

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 TXW11 Hardener at 1%-10%. The more Hardener you add, the shorter the pot life, but better the chemical resistance.

APPLICATION SYSTEM: Spray - see pg 18 for additional information

QUANTITY(grsq mt): 90-150 per coat, 250 maximum (4-6 wet mils 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
- 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 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: Six 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 5°C (41°F)

DATE OF ISSUANCE: 09-10, Revised 9-11, 5-12, 11-12

EVERY REASONABLE PRECAUTION IS TAKEN IN THE MANUFACTURE OF OUR PRODUCTS TO INSURE THAT THEY COMPLY WITH OUR STANDARDS. INFORMATION GIVEN IS CORRECT TO THE BEST OF OUR KNOWLEDGE. ANY SUGGESTIONS MADE BY US COVERING THE USE OF OUR PRODUCTS ARE BASED ON EXPERIENCE AND/OR TESTS BELIEVED TO BE RELIABLE. HOWEVER, BECAUSE THE USE OF ANY PRODUCT OF OUR MANUFACTURE IS COMPLETELY BEYOND OUR CONTROL, INCLUDING FOR EXAMPLE, THE METHOD AND CONDITIONS OF APPLICATION, NO GUARANTEE OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE. MANUFACTURER'S MAXIMUM LIABILITY SHALL BE TO REPLACE SUCH QUANTITY OF PRODUCT DETERMINED BY OUR LABORATORY TO BE DEFECTIVE. USER SHALL DETERMINE THE SUITABILITY OF THE PRODUCT FOR HIS INTENDED USE AND ASSUME ALL RISK AND LIABILITY IN CONNECTION THEREWITH.
**PRODUCT CODE:** TW 2/60X Series

**DESCRIPTION:** WB CLEAR SELF-SEALER

**USES:** General purpose finish. Flat and shapped panels, indoor furniture. Self-sealer with good transparency, leveling and pore design.

**PRODUCT PREPARATION:**

| TW 2/60X Series | WB Clear Self-Sealer | 100 parts | Water | 0-10 parts |

This product is designed for use as a one component product. You may add 0.5% - 1.0% TXW02 Cross-linker to slightly improve chemical resistance if desired.

**APPLICATION SYSTEM:** Spray - see pg 18 for additional information

**QUANTITY (grsq mt):**

80-1st coat (3 wet mils) 100 -2nd coat (4 wet mils) (maximum total film approx 150) (6-7 wet mils)

**COATS:** Two

**GENERAL PROPERTIES:**

- Specific Gravity, gr/cc: 1.020 +/- 0.01
- Viscosity with Ford Cup #6: 40 +/- 2 sec
- Solids by Weight, %, as supplied: 28 +/- 2

**DRYING TIME:**

- Dust Free Flash-off at 40°C (104°F): 20-40 minutes
- Dry To Touch: 90 minutes
- Dry To Cure: 10-12 hours

Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and and best dry times for handling and stacking. Sandable depending upon drying conditions in 3 hours. Sand with 280-320 grit paper.

**GLOSS AVAILABLE:**

- TW 2/601: 60 sheen
- TW 2/603: 25 sheen
- TW 2/605: 15 sheen
- TW 2/606: 10 sheen

**TYPICAL SYSTEMS:**

- Substrate: Various woods
- TW 2/60x Self-Sealer: One Coat
  - Dry for 12 hr at 20° - 70% RH
  - Sand with 280-320
- TW 2/60x Self-Sealer: One Coat
  - 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.

**SHELF LIFE:** Six 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 5°C (41°F)

**DATE OF ISSUANCE:** 09-10, Revised 10-10, 11-12
PRODUCT CODE: TW 32842 and TW49152

DESCRIPTION: WB CLEAR CROSSLINK 30 GLOSS SELF-SEALER AND WB CLEAR CROSSLINK 10 GLOSS SELF-SEALER (TW49152)

USES: Furniture, architectural millwork, kitchen cabinets (must use crosslinker). Offers the best transparency, touch or feel, physical and chemical resistance of our products designed as a crosslink self-sealer.

PRODUCT PREPARATION: TW 32482/49152 WB Clear Crosslink 100 parts by weight Water Thinner 20-30 parts by weight

This product is designed for use as a crosslink type product. It is necessary to add 1.0% TXW02 Crosslinker to slightly improve chemical resistance. It may be used as a one component product.

APPLICATION SYSTEM: Spray - see pg 18 for additional information

QUANTITY(grsq mt): 150 per coat (5-6 wet mils per coat)

COATS: Two

GENERAL PROPERTIES:

- Specific Gravity, gr/cc: 1.000 +/- 0.02
- Viscosity - Ford Cup #8: 100 +/- 2 sec
- Solids by Weight, %, as supplied: 39 +/- 2 sec
- Thinner: Water
- Dilution: 5%

DRYING TIME:

- Drying time at room temperature: 6 h
- Drying time with warm air tunnel: 2 h
- Dust Free/time gel: 20 minutes
- Dry to Touch: 1h
- Dry to Cure: 6 h
- Sandable: After 4 h
- Time between coats: 1 hr
- Time before application of topcoat: 12 hr

GLOSS AVAILABLE: 30 Sheen +/- 2, 10 Sheen +/-2

RECOMMENDATIONS: We suggest washing the machinery before and after every application. Drying time depends on temperature, relative humidity and ventilation conditions. When dilution is necessary, we advise using de-ionized water in order to avoid problems coming from a high concentration of salts. We recommend using this product at temperatures above 15°C and humidity below 70%.

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.

SHELF LIFE: Six 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 5°C (41°F)

DATE OF ISSUANCE: 09-10, Revised 12-10, 11-12
**PRODUCT CODE:** TW 34 Series

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

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

**PRODUCT PREPARATION:**
- TW 34 series: 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 TXW11 Hardener at 1% - 10%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

**APPLICATION SYSTEM:** Spray - see pg 18 for additional information

**QUANTITY (gr sq mt):** 120-160 per coat (4-6 wet mils per coat)

**COATS:** One

**GENERAL PROPERTIES:**
- Specific Gravity, gr/cc: 1.000 +/- 0.02
- Viscosity - Ford Cup #6 TW341-342-344-347: 40 +/- 2 sec
- TW343: 30 +/- 2 sec
- Solids by Weight, % as supplied (I component): 36 +/- 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
- 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 and best dry times for handling and stacking.

**GLOSS AVAILABLE:**
- TW341: 64-66 sheen
- TW342: 48-52 sheen
- TW343: 28-32 sheen
- TW344: 19-21 sheen
- TW346: 9-12 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:** Six 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 5°C (41° F)

**DATE OF ISSUANCE:** 9-10, Revised 9-11, 5-12, 11-12

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PRODUCT CODE: TW 63X

DESCRIPTION: Waterbase Multilayer Floor Finish

USES: Multilayer for parquets and stairs, open and close pore.

FEATURES: Excellent elasticity and floor surface resistance.

PRODUCT PREPARATION: TW 63X Waterbase Multilayer Floor Finish 100 parts

APPLICATION SYSTEM: Brush or roller

QUANTITY (grsq mt): 70-120 per coat, total maximum 200

COATS: Two

GENERAL PROPERTIES:
- Specific Gravity, gr/cc: 1.045 +/- 0.01
- Viscosity*: 18 +/- 2 sec
- Solids by Weight, %, as supplied: 30 +/- 2
- *Ford Cup #4

GLOSS AVAILABLE:
- TW632 Semi-Gloss
- TW634 Satin

DRYING TIME: (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

TYPICAL SYSTEMS:
- Various woods
  - Stain
  - Basecoat TW63X 1 coat (interval between coats without sanding: 1-3 h)
  - Topcoat TW63X 1 coat

RECOMMENDATIONS:
- 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 equipment thoroughly before and after use.

SHELF LIFE: Six 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 5°C (41°F)

DATE OF ISSUANCE: 09-10, Revised 9-12
ILVA TECHNICAL DATA SHEET

PRODUCT CODE: TW 88X
DESCRIPTION: WB Multilayer 2K For Floor
USES: For parquet and stairs (open and closed pores).

PRODUCT PREPARATION:
- TW 88X: WB Multilayer 2K
- TXW08: Waterbase Hardener
- Water: Thinner
100 parts by weight
10 parts by weight
0 - 10 parts by weight (if necessary for application)
*Pot life with TXW08: from 1 - 3 hours depending on dilution percentage and room temperature.

APPLICATION SYSTEM: Brush or roller
QUANTITY (grsq mt): 70 - 120 per coat, maximum 300 total
COATS: Three

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

DRYING TIME:
- Drying schedule at room temperature:
  - Dust Free: 45 minutes
  - Dry to touch: 2 h 30 minutes
  - Hard Dry: 12 h
  - Drying time in tunnel 25 - 60°C: 1 h
  - Walk on: 7 days
  - Time between coats without sanding: 2 - 4 h
- 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  
  Basecoat: TW88x with 10% TXW08  
  Dry 12 hours - sand with 280 - 320  
  Topcoat: TW88x with 10% TXW08  
(b) Substrate: Various woods (sand w/150)  
  Base Coat: TW88x with 10% TXW08  
  Dry for 6 hours - sand with 280 - 320  
  Basecoat: TW88x with 10% TXW08  
  Dry for 8 hours sand with 280 - 320  
  Topcoat: TW88x with 10% TXW08

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 compent 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: Six 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 5°C (41°F)
DATE OF ISSUANCE: 09-10, Revised 1-11

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PRODUCT CODE: WES5A01

DESCRIPTION: WB GLAZE & STAIN VEHICLE

USES: Vehicle for staining and glazing by spray and wipe. Suitable for all types of woods. 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: By spray and wipe. Ready to use 40/60 gr/m

GENERAL PROPERTIES:
Specific gravity: 1.12 +/-0.02 gr/m;
Solid content: 33% +/- 1% by weight;
Viscosity (at 20°C): 33 +/-2 (DIN 53211 CUP 0 mm.4)

DRYING:
Air 2-4 hours. Moving ambient air for the best drying conditions.

SUGGESTED COATING CYCLES:
Substrate: Different kind of wood
Stain: WESSA01 & colors
Drying: 2-4 hrs
Base coat: TT PUR WB Basecoats or TA PUR Solvent Basecoats
Topcoat: TW PUR WB Topcoats or TO PUR Solvent Topcoats

TYPICAL STAIN COLOR FORMULATION:
- WESSA01 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 max 10% level.

TYPICAL GLAZE COLOR FORMULATION:
- WESSA01 80 parts
- PZ5xx colors* 10 parts
- Water 10 parts
*You may also use PD6xx Stain colorants.

SHELF LIFE: One Year

STORAGE: Store in a tightly closed container at room temperature 18-25°C, 64-75°F and protect from moisture and foreign material.

DATE OF ISSUANCE: 08-11, Revised 6-12
PRODUCT CODE:  WES5A07
DESCRIPTION:  DRY WATER GLAZE
USES:  Antiquing and Decape effect on mobile in style, doors and frames for painting

PRODUCT PREPARATION:  WESSA07 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;
Solid 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
WESSA07 tinted with PZ5xxseries apply by cloth
allow to dry 45 minutes
remove with scotch brite or cloth
TW34/series final clear coat

SHELF LIFE:  One Year

STORAGE:  Store in a tightly closed container at room temperature 18-25°C, 64-75°F and protect from moisture and foreign material.

DATE OF ISSUANCE:  4-13
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%. We also have a special Waterbase Reducer, code TZ-77. It will reduce the viscosity much faster than adding plain water.

ADDING THE PU HARDENER
PU Hardener TXW11 and TXW08 are used to increase the resistance properties. The end result will be our most resistant waterbase products. Please note that both TXW11 and TXW08 are not flammable.

TXW11 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. Then mix this reducer 1/1 with the TXW11. This premixed reducer and hardener can then be added to the paint. If you are adding TXW11 under mechanical agitation, you may add it directly to the paint while stirring. TXW11 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 TXW11.

Many of our water based products may be used without the addition of hardener, or by using TXW02 Crosslinker or by adding polyurethane hardeners TXW11 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 proucts than solvent based products. When sanding water based finishes 280-320-400 stearated 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 air.

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

Date of Issuance: 09-10, Revised 11-12
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 affect 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.

Furthermore, we underline the fact that in unindustrial 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%.