

ILVA TECHNICAL DATA SHEET

PRODUCT CODE: PI 29

DESCRIPTION: Unsaturated Polyester Black Undercoat

USES: Sanding sealer for MDF flat and shaped panels, doors etc. Can be topcoated with matte and gloss polyurethane finishes.

PRODUCT PREPARATION:	<u>Parts by weight</u>	<u>Parts by volume (ounces)</u>
PI29 Black polyester undercoat	100	128
TVS5AA1 Accelerator*	2	2
TV84 Long pot life catalyst	2	2
TZ03 Thinner	5 - 15	20
<i>*use 1 part TVS5AA1 in hot weather, 2 parts in cold weather</i>		

APPLICATION SYSTEM: Double component spray equipment is recommended.

QUANTITY(grams mt): 150 - 200 per coat (6-8 wet mils)

COATS: 2 to 3

GENERAL PROPERTIES:		
Specific Gravity, gr/cc	1.27 +/-0.05	
Viscosity*	30 +/-2 sec	
Application Viscosity**	30-35 sec	
Solids by Weight, %	92 +/-2	
Pot Life, minutes at 20°C/68°F	30-40	

*DIN 53211 Nr.4 at 20°C/68°F
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DRYING TIME: (at 20°C/68°F)	Gel time, between coats, minutes	20-30 minimum
	For sanding and topcoating, hours	24 minimum

TYPICAL SYSTEMS: Substrate MDF

Gloss Finish

TF25/TV19	1 coat	40 gr/sq.mt. (1.6 wet mils)
PI29/TVS5AA1/TV84	2 - 3 coats	150/200 gr/sq.mt. per coat (6-8 wet mils)
PM19/TX276	2 coats	150 gr/sq.mt. (6 wet mils)

Matte Finish

TF25/TV19	1 coat	40 gr/sq.mt. (1.6 wet mils)
PI29/TVS5AA1/TV84	2 - 3 coats	150/200 gr/sq.mt. per coat (6-8 wet mils)
PL59/TX50	1 coat	150 gr/sq.mt. (6 wet mils)

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.

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

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