

# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TG 1323

**DESCRIPTION:** Unsaturated Polyester Clear Undercoat

**USES:** Sanding sealer for flat and shaped panels, doors, etc. Can be topcoated with matte and gloss polyurethane finishes. Excellent transparency and cold check resistance.

<b>PRODUCT PREPARATION:</b>	<u>Parts by weight</u>	<u>Parts by volume (ounces)</u>
TG1323 Clear Polyester Undercoat	100	128
TVS5AA1* Accelerator	2	2
TV84 Long Pot Life Catalyst	2	2
TZ03 Thinner	5-10	15-30

\* TVS5AA1 use 1 part in hot weather, use 2 parts in cold weather.

**APPLICATION SYSTEM:** Double component spray equipment is recommended.

**QUANTITY:** 150 - 200 per coat (gr sq mt) (6-8 wet mils)

**COATS:** Two to three

<b>GENERAL PROPERTIES:</b>	Specific Gravity, gr/cc	1.07+/-0.05
	Viscosity*	150 +/- 10 secs.
	Application Viscosity*	25-35 secs
	Solids by Weight, %	89 +/-2
	Pot Life, minutes at 20°C/68°F	30-60
	*ASTM D1200 (Ford) #4 at 20°C/68°F	

<b>DRYING TIME:</b> (at 20°C/68°F)	Between coats, minutes:	30 minimum
	Between coats, hours:	3 maximum
	For sanding and topcoating, hours:	24 minimum

**TYPICAL SYSTEMS:** Substrate: Various woods

**Gloss Finish**

TF25/TV19	1 coat	40 gr/sq mt.(1.6 wet mils)
TG1323/TVS5AA1/TV84	2-3 coats	150/200 gr/sq mt.(per coat) (6-8 wet mils)
TP60/TX75	1 coat	150 gr/sq mt. (6 wet mils)

**Matte Finish**

TF25/TV19	1 coat	40 gr/sq mt.(1.6 wet mils)
TG1323/TVS5AA1/TV84	2-3 coats	150/200 gr/sq mt.(per coat) (6-8 wet mils)
TO9 series/TX24	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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