

ILVA TECHNICAL DATA SHEET

PRODUCT CODE: PM 80

DESCRIPTION: Acrylic-urethane gloss finish, pigmented white

USES: Acrylic-urethane white gloss top coats, suitable for closed grain systems, for flat panels and assembled furniture. Maximum yellowing resistance.

PRODUCT PREPARATION:		<u>Partys by weieght</u>	<u>Parts by volume (ounces)</u>
	PM80 Acrylic-urethane gloss finish white	100	128
	TX90 Non-yellowing curing agent	50	84
	TZ13 Thinner	20 - 40	64

APPLICATION SYSTEM: Spray

QUANTITY(grsq mt): 120 - 140 per coat (4.8-5.6 wet mils)

COATS: One or two

GENERAL PROPERTIES:	Specific Gravity, gr/cc	1.23 +/- 0.05
	Viscosity*	85 +/- 2 sec
	Application Viscosity*(spray)	15 +/- 2 sec
	Solids by Weight, %, as supplied	57 +/- 2
	Solids by Weight, %, ready to use	49 +/- 2
	Pot Life, hours at 20°C/68°F	3

*ASTM D1200 Ford #4 Cup at 20°C/68°F

DRYING TIME: (at 20°C/68°F)	To handle:	1 hour
	Top coating with itself without sanding:	3 hours minimum
	5 hours maximum	
	To stack:	24 hours minimum
	To buff:	72 hours minimum

TYPICAL SYSTEMS:	Substrate	MDF
	TF25/TV19	One coat 40 gr/sq.mt.(1.6 wet mils)
	PI40/TVS5AA1/TV80	Two/sealer 150/200 gr/sq.mt. per coat (6-8 wet mils)
	PM80/TX90	One or two coats 120 gr/sq.mt. per coat (4.8 wet mils)

SHELF LIFE: 18 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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