

ILVA TECHNICAL DATA SHEET

PRODUCT CODE: PM 19

DESCRIPTION: Polyurethane gloss black topcoat

USES: Polyurethane gloss topcoat, suitable for MDF panels and assembled furniture.

PRODUCT PREPARATION:		<u>Parts by weight</u>	<u>Parts by volume (ounces)</u>
	PM19 Polyurethane gloss finish	100	128
	TX276 Hardener	100	128
	TZ13 Thinner (spray)	50	25-50

APPLICATION SYSTEM: Spray, curtain coater

QUANTITY(grsq mt): 140 - 180 per coat (5.6-7.2 wet mils)

COATS: One

GENERAL PROPERTIES:	Specific Gravity, gr/cc	1.3 +/- 0.05
	Viscosity*	25 +/- 2 sec
	Application Viscosity**(spray)	10 +/- 2 sec
	Solids by Weight, %, as supplied	68 +/- 2
	Solids by Weight, %, ready to use	49 +/- 2
	Pot Life, hours at 20°C/68°F	4

* ASTM D1200 (Ford) #6 at 20°C/68°F

** ASTM D1200 (Ford) #4 at 20°C/68°F

DRYING TIME: (at 20°C/68°F)	To handle:	2 hours
	To stack:	24 hours minimum
	Buffing	48 hours minimum

TYPICAL SYSTEMS:	Substrate	MDF
	TF25/TV19 1 coat	40 gr/sq.mt. (1.6 wet mils)
	PI29/TVS5AA1/TV84 2 - 3 coats	150/200 gr/sq.mt. (6-8 wet mils)
	PM19/TX276 1 coat	120 gr/sq.mt. (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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