

ILVA TECHNICAL DATA SHEET

PRODUCT CODE: PI 40

DESCRIPTION: Unsaturated Polyester White Undercoat

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

PRODUCT PREPARATION:	<u>Parts by weight</u>	<u>Parts by volume (ounces)</u>
PI40 White Polyester Undercoat	100	128
TVS5AA1* Accelerator	2	2
TV84 Long pot life catalyst	2	2
TZ03 Thinner	10-20	32
<i>* Use 1 part TVS5AA1 in hot weather, 2 parts in cold weather</i>		

APPLICATION SYSTEM: Double component spray equipment is recommended.

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

COATS: 2 to 3

GENERAL PROPERTIES:		
Specific Gravity, gr/cc		1.39 +/-0.05
Viscosity, DIN 53211 #8 at 20°C/68°F		18 +/- 2 sec
Application Viscosity*		18-30 secs
Solids by Weight, %		85 +/- 2
Pot Life, hours at 20°C/68°F		90 minutes

*ASTM D1200 (Ford) #4 at 20°C/68°F

DRYING TIME: (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: MDF

Gloss Finish

TF25/TV19	1 coat	40 gr/sq mt (1.6 wet mils)
PI40/TVS5AA1/TV84	2-3 coats	150/200 gr/sq mt (per coat) (6-8 wet mils)
PM800/TX75	1 coat	150 gr/sq mt. (6 wet mils)

Matte Finish

TF25/TV19	1 coat	40 gr/sq mt (1.6 wet mils)
PI40/TVS5AA1/TV84	2-3 coats	150/200 gr/sq mt (per coat) (6-8 wet mils)
PL50/TX75	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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