

ILVA TECHNICAL DATA SHEET

PRODUCT CODE: TW34 Series

DESCRIPTION: WB CLEAR 2K POLY TOPCOAT

USES: Kitchen Cabinets (must use PU Hardener). Manufactured indoor products, including panels and furniture.

PRODUCT PREPARATION: TW 34series WB Clear 2K Poly Topcoat 100 parts by weight
TXW08/TXW13 Waterbase Hardener for PU 0-10 parts by weight
Water Thinner 0-10 parts by weight (if necessary for application)
This product may be used without the addition of any crosslinker or hardener. The addition of TXW02 Crosslinker at 1% will slightly improve resistance properties. Best chemical resistance is achieved by adding TXW08/TXW13 or HXS5A16 Hardener at 0%-10%. The more Hardener you add, the shorter the pot life, longer the dry time, but improved chemical resistance.

APPLICATION SYSTEM: Spray - see pg 29 for additional information

FILM THICKNESS: 4-6 wet mils per coat

COATS: One

GENERAL PROPERTIES: Specific Gravity, gr/cc 1.03 +/- 0.02
Viscosity - Ford Cup #6
TW340-TW341-342-343-344-346-347 40 +/- 2 sec
Solids by Weight, % as supplied (I component) 33 +/- 2
Solids by Weight, % as supplied (II component) 70%
Pot Life using PU Hardener 2 - 3 hours

DRYING TIME: Dust Free 50 minutes
(at 20°C/68°F) Dry To Touch 60-90 minutes
Dry to Handle (with forced air dry can be reduced to 2 hrs) 5 hours
Dry To Cure to achieve ultimate resistance properties 96 hours
Please note that drying times may change with varying temperatures, ventilation, relative humidity, and type and quantity of hardener. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

GLOSS AVAILABLE: TW340 80-85 sheen
TW341 64-66 sheen TW344 19-21 sheen
TW342 48-52 sheen TW346 9-12 sheen
TW343 28-32 sheen TW347 4-6 sheen

RECOMMENDATIONS: Sand with 280- 320 paper or superfine sponges or maroon Scotchbrite between coats. May be recoated within one hour of drying without sanding. Avoid high pressure or reduce speed on powered sanding equipment to avoid overheating of the water based product and loading up sandpaper.
To guarantee an adequate incorporation of the second component please use the following procedure: weigh out the appropriate amount of the second component; add the second component to the TW34 series slowly, while using the automatic agitator; add water only when the second component has been incorporated completely. Drying times can vary with differing temperatures, ventilation and relative humidity. We recommend using stainless steel for all water-based products.
Keep cans closed when not in use and wash all equipment well. Keep from freezing.

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. Do not store at temperatures below 7°C (45°F)

DATE OF ISSUANCE: 9-10, Revised 9-11, 5-12, 11-12, 9-16,1-17, 4-17, 11-21, 2-23

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

EVERY REASONABLE PRECAUTION IS TAKEN IN THE MANUFACTURE OF OUR PRODUCTS TO INSURE THAT THEY COMPLY WITH OUR STANDARDS. INFORMATION GIVEN IS CORRECT TO THE BEST OF OUR KNOWLEDGE. ANY SUGGESTIONS MADE BY US COVERING THE USE OF OUR PRODUCTS ARE BASED ON EXPERIENCE AND/OR TESTS BELIEVED TO BE RELIABLE. HOWEVER, BECAUSE THE USE OF ANY PRODUCT OF OUR MANUFACTURE IS COMPLETELY BEYOND OUR CONTROL, INCLUDING FOR EXAMPLE, THE METHOD AND CONDITIONS OF APPLICATION, NO GUARANTEE OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE. MANUFACTURER'S MAXIMUM LIABILITY SHALL BE TO REPLACE SUCH QUANTITY OF PRODUCT DETERMINED BY OUR LABORATORY TO BE DEFECTIVE. USER SHALL DETERMINE THE SUITABILITY OF THE PRODUCT FOR HIS INTENDED USE AND ASSUME ALL RISK AND LIABILITY IN CONNECTION THEREWITH.