

ILVA TECHNICAL DATA SHEET

PRODUCT SERIES: **ACRIPOL**

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.

PRODUCT PREPARATION:

TG1323 Clear Polyester Undercoat	100 parts by weight
TV72* Accelerator	2 parts by weight
TV84 Long Pot Life Catalyst	2 parts by weight
TZ03 Thinner (for <i>horizontal</i> applications)	15-20 parts by weight
TZ03 Thinner (For <i>vertical</i> applications)	5-10 parts by weight

* TV72 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)

COATS: 2 to 3

GENERAL PROPERTIES:

Specific Gravity, gr/cc	1.07 +/- 0.05
Viscosity*	150 +/- 10 sec
Application Viscosity*	25-35 sec
Solids by Weight, %	89 +/- 2
Pot Life, minutes at 20°C/68°F	30 - 60

* ASTM D1200 (Ford) #4 at 20°C/68°F

DRYING TIME: Between coats, minutes: 30 minimum
(at 20°C/68°F) 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.
TG1323/TV72/TV84	2-3 coats	150/200 gr/sq mt.(per coat)
TP60/TX75	1 coat	150 gr/sq mt.

Matte Finish

TF25/TV19	1 coat	40 gr/sq mt.
TG1323/TV72/TV84	2-3 coats	150/200 gr/sq mt.(per coat)
TO9 series/TX24	1 coat	150 gr/sq mt.

SHELF LIFE: One Year

STORAGE: Store in a tightly closed container at room temperatures (18 -25 °C/64 -75 °F) and protect from moisture and foreign material.

DATE OF ISSUANCE: 02 - 98 Revised 4-05

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Clear Polyurethane Table Top System

Step 1: Barrier coat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TF25	Polyurethane Barrier Coat	100	128
TV19	Accelerator	5	8
TZ35	Thinner	25	32

Pot life: 3-4 hours

Dry to handle: 20 minutes

Application: A thin wash coat must be applied, allowed to dry for at least 2 hours, and then apply the polyester undercoat. If undercoat is not applied within 4 hours, the barrier coat must be allowed to cure 8 hours, then sanded to insure adhesion.

Tip size: 1.8

Air pressure: 35 lbs

Step 2: Polyester Undercoat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TG1323	Clear polyester undercoat	100	128
TV72*	Accelerator	2	2
TZ03	Thinner	10	15-30

Note: Mix extremely well before adding catalyst

TV84	Catalyst	2	2
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* Use 1 part TV72 in hot weather, it slows the cure, but always use 2 parts TV84.

Pot life: 30 - 60 minutes

Dry to handle: 1.5 - 2 hours

Application: Spray one very heavy coat (cross-hatch), let the undercoat dry for one hour and then spray an additional heavy coat (cross-hatch). If more than three hours dry, wait 12 hours and sand before recoating. Allow this wet-on-wet stage to dry 12 hours (at ambient temperature) before sanding. Note: Never mix the accelerator and catalyst together.

Dry to recoat: 12 hours

Tip size: 2.5

Air pressure: 35 lbs

Step 3: Polyurethane Finish

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
T0975/series	Polyurethane Finish	100	128
TX70	Hardener	50	64
TZ425	Thinner Blend	10-30	10-30

Pot life: 3-4 hours

Dry to handle: 30-40 minutes

Application: After 12 hours sand sealer with 320 sand paper. Blow the residue from the panel and then spray a normal 3-5 mil wet coat. Additional coats are not recommended. If necessary spray the additional coat wet on wet in the time window of 90 minutes to 3 hours after the original coat. If recoating is necessary after 3 hours, sand extremely well with 320 paper first.

Tip size: 1.8

Air pressure: 35 lbs

Clear Polyurethane - Wet Look System

Step 1: Pf 5/series Stains for Color

Step 2: Barrier coat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TF25	Polyurethane Barrier Coat	100	128
TV19	Accelerator	5	8
TZ35	Thinner	25	32

Pot life: 3-4 hours

Dry to handle: 20 minutes

Application: A thin wash coat must be applied, allowed to dry for at least 2 hours, and then apply the polyester undercoat. If undercoat is not applied within 4 hours, the barrier coat must be allowed to cure 8 hours, then sanded to insure adhesion.

Tip size: 1.8 **Air pressure:** 35 lbs

Step 3: Polyester Undercoat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TG1323	Clear polyester undercoat	100	128
TV72*	Accelerator	2	2
TZ03	Thinner	10	15-30

Note: Mix extremely well before adding catalyst

TV84	Catalyst	2	2
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* Use 1 part TV72 in hot weather, it slows the cure, but always use 2 parts TV84.

Pot life: 30 - 60 minutes

Dry to handle: 1.5 - 2 hours

Application: Spray one very heavy coat (cross-hatch), let the undercoat dry for one hour and then spray an additional heavy coat (cross-hatch). If more than three hours dry, wait 12 hours and sand before recoating. Allow this wet-on-wet stage to dry 12 hours (at ambient temperature) before sanding. Note: Never mix the accelerator and catalyst together.

Dry to recoat: 12 hours

Tip size: 2.5 **Air pressure:** 35 lbs

Step 4: Polyurethane Finish

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TP60	Clear polyurethane finish	100	128
TX75	Hardener	100	128
TZ13**	Thinner	40	40

**Use TZ13/TZ35 blend at 30/10 in cooler weather for faster dry.

Pot life: 2 hours

Dry to handle: 2 hours

Buffing: 24 hours

Topcoating with itself without sanding: 30 minutes minimum - 3 hours maximum

Application: First sand the sealer with a series of sand papers - 320 then 400. Spray one coat. This finish may be buffed if desired, but two coats may be necessary to avoid rubbing through to undercoat.

Tip size: 1.8 **Air pressure:** 35 lbs

Clear Polyester - Gloss Wet Look System

Step 1: *Barrier coat*

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TF1525	Lo-Haps Barrier Coat	100	128
TV19	Accelerator	5	8
TZ35NH	Thinner	25	32

Pot life: 3-4 hours

Dry to handle: 20 minutes

Application: A thin wash coat must be applied, allowed to dry for at least 2 hours, and then apply the polyester undercoat. If undercoat is not applied within 4 hours, the barrier coat must be allowed to cure 8 hours, then sanded to insure adhesion.

Tip size: 1.8

Air pressure: 35 lbs

Step 2: *Polyester Undercoat*

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TG1323	Clear polyester undercoat	100	128
TV72*	Accelerator	2	2
TZ03	Thinner	10	15-30
Note: Mix extremely well before adding catalyst			
TV84	Catalyst	2	2

* Use 1 part TV72 in hot weather, it slows the cure, but always use 2 parts TV84.

Pot life: 30 - 60 minutes

Dry to handle: 1.5 - 2 hours

Application: Spray one very heavy coat (cross-hatch), let the undercoat dry for one hour and then spray an additional heavy coat (cross-hatch). If more than three hours dry, wait 12 hours and sand before recoating. Allow this wet-on-wet stage to dry 12 hours (at ambient temperature) before sanding. Note: Never mix the accelerator and catalyst together.

Dry to recoat: 12 hours

Tip size: 2.5

Air pressure: 35 lbs

Step 3: *Polyester Clear Gloss Finish Coat*

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TR9982	Clear Polyester Finish	100	128
TV72	Accelerator	2	2
TZ86	Thinner	20	32
Note: Mix extremely well before adding catalyst			
TV84	Catalyst	2	2

Pot life: 30 - 60 minutes

Dry to handle: 1 - 2 hours

Application: First sand the sealer with a series of sand papers - 320 then 400. Spray one coat (cross-hatch). This finish may be buffed if desired, but 2 coats may be necessary to avoid rubbing through to undercoat. Note: Never mix the accelerator and catalyst together.

Tip size: 1.8

Air pressure: 35 lbs

Clear Polyester - Gloss Wet Look System

Step 1: PF 5/series Stains for Color

Step 2: Barrier Coat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TF25	Polyurethane Barrier Coat	100	128
TV19	Hardener	10	13
TZ50	Thinner	50	64

Pot life: 2 hours **Dry to handle:** 20 minutes

Application: A thin wash coat must be applied, allowed to dry for at least 35 minutes, and then apply the polyester undercoat. If undercoat is not applied within 90 minutes, the barrier coat must be allowed to cure 4 hours, then sanded to insure adhesion.

Tip size: 1.8 **Air pressure:** 35 lbs

Step 3: Polyester Undercoat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TG1323	Clear polyester undercoat	100	128
TV72	Accelerator	2	2
TZ03	Thinner	10	15-30
Note: Mix extremely well before adding catalyst			
TV84	Catalyst	2	2

Pot life: 30 - 60 minutes

Application: Spray one very heavy coat (cross-hatch), let the undercoat dry for one hour and then spray an additional heavy coat (cross-hatch). If more than three hours dry, wait 12 hours and sand before topcoating. Allow this wet-on-wet stage to dry 12 hours (at ambient temperature) before sanding. Note: Never mix the accelerator and catalyst together.

Tip size: 2.5 **Air pressure:** 35 lbs.

Step 4: Polyester Clear Gloss Finish Coat

<u>Product #</u>	<u>Component Description</u>	<u>Parts/Wt</u>	<u>Parts/Vol</u>
TR1688	Clear Polyester Finish	100	128
TV72	Accelerator	2	2
TZ86	Thinner	10	12-16
Note: Mix extremely well before adding catalyst			
TV84	Catalyst	2	2

Pot life: 30 - 60 minutes

Dry to handle: 1 - 2 hours

Application: First sand the sealer with a series of sand papers - 320 then 400. Spray one coat (cross-hatch). This finish may be buffed if desired, but 2 coats may be necessary to avoid rubbing through to undercoat. Note: Never mix the accelerator and catalyst together.

Tip size: 1.8 **Air pressure:** 35 lbs