

# ILVA TECHNICAL DATA SHEET

**PRODUCT CODE:** TW 34 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	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 or TXW11 Hardener at 1%-10%. The more Hardener you add, the shorter the pot life, but the better the chemical resistance.

**APPLICATION SYSTEM:** Spray - see pg 18 for additional information

**QUANTITY(grsq mt):** 120-160 per coat (4-6 wet mils per coat)

**COATS:** One

**GENERAL PROPERTIES:**

Specific Gravity, gr/cc	1.000 +/- 0.02
Viscosity - Ford Cup #6	
TW341-342-344-347	40 +/- 2 sec
TW343	30 +/- 2 sec
Solids by Weight, % as supplied (I component)	36 +/- 2
Solids by Weight, % as supplied (II component)	70%
Pot Life using PU Hardener	1 - 3 hours

**DRYING TIME:** (at 20°C/68°F)

Dust Free Flash-off at 40°C (104°F)	20-40 minutes
Dry To Touch	1-3 hours
Dry To Cure	8-12 hours

Please note that drying times may change with varying temperatures, ventilation and relative humidity. In particular, good ventilation promotes hard dry and best dry times for handling and stacking.

**GLOSS AVAILABLE:**

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:** Six 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 5°C (41°F)

**DATE OF ISSUANCE:** 9-10, Revised 9-11, 5-12, 11-12

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