



**Polyurethane white 2 pack primer- ILVA
PA30 (Part A)**

Gloss pack topcoat - ILVA PM800 or TP800

Series (Part A)

Hardener - TX50 (Part B)

**ILVA Gloss
Solvent Solid
Colour
Specification:
PM800 /
TP800**

FEATURES and BENEFITS :

- This high-quality high build Italian made two pack coating has excellent filling power, high surface hardness and excellent chemical resistance.
- Fast drying for quick turn around and production cycles, eliminates dust settle
- Tintometric system for consistent colour replication. Wide range of colours available.
- Ideally suited to MDF, paint coat board and melamine.
- Available in Full Gloss 100%
- Excellent resistance to yellowing
- Beautiful aesthetic feel and egg shell lustre.
- Moisture resistant for a wider range of applications.
- Spray applications : pot gun, gravity gun, airless systems.
- Suitable for: internal doors, skirts & architraves, cupboards, furniture, bookshelves, kitchen panels.

Gloss levels available: 100% gloss

This guideline must be read in its entirety and be fully understood prior to commencing product application.

Step 1

Surface Preparation : Sand surface using 120 -180 grit sandpaper, MDF panel edges may need to be sanded to 240 grit to remove machine marks. Ensure that the surface is free of dust and contaminants.

Step 2

Application of Ilva PA30 white P.U Primer : Apply 2 coats of primer wet on wet. 1 coat let flash off approx 15 - 20min Coverage 1litre/6m². Apply second coat of PA30 primer as follows:500 mls of PA30 Primer, 250mls TX50 or TX19 Hardener, 20-25 mls of TZ13 or TZ35 Thinner. Minimum 4 hours before any sanding can be undertaken. Gravity or suction fed gun 1.8 to 2.0mm set up. Airmix gun tip 09.094 airless 4/11.

Step 3

Sanding of PA30 Primer : Sand primer with 400-500 grit paper. Mechanical sanding of face panels is best done with 150mm disc sander or suitable wide belt units. Small surfaces and edges can be sanded by hand with sheet paper 400grit or fine sponge blocks. Sanding after minimum 4 hours. Blow off and wipe down panels to remove dust. It is best practice to topcoat as soon as possible with maximum of 3 hours after sanding.



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Step 4

Application Ilva Gloss PM800 or TP800 series topcoat :
Apply 2 coats wet on wet. Coverage: 1litre/6m² of PM800 / TP800 series clear topcoat as follows: 250 mls of PM800/TP800 Gloss topcoat, 175 mls of TX76 hardener, 100 to 125mls of TZ13 thinner. Apply 1 coat then let flash off for 20-30 minutes, apply a second coat. Touch dry in 40 minutes. Hard dry in 24 hours. Gravity gun 1.4 suction gun 1.8mm set up. Airmix gun tip 06.094 airless 4/10

The PM800 and TP800 systems are for the protection of furniture and panels in normal day to day use where some indoor filtered sunlight exposure is expected but not direct sunlight exposure for any extended period.

Substrate: The PM800 and TP800 specified systems are suitable for most timbers and MDF panels (please check with your timber merchant or your paint supplier if the coating system will be suitable for the substrate you choose).

Gun Cleaning: Please make sure you clean your spray gun in the correct manner to ensure no damage occurs to your equipment.

Force Dry: If force drying coating, do not exceed 30C

IMPORTANT INFORMATION

Do not exceed maximum thickness per coat of product. All mixing ratios are according to Volume and weight. Thinning is a guide and is variable depending on application type and desired effect.

- All sanding uses sheet paper or 150mm sanding discs
- All drying, sanding and recoating schedules are based on 20 degrees Celsius and 50% humidity and must be performed in a well-ventilated area.
- Ensure that your surface is free of dust and contaminants prior to coating.
- All safety measures should be taken in accordance with Technical Data Sheets (TDI), Material Safety Data Sheets (MSDS) and local laws.
- Other products should not be interchanged with those outlined in this specification.
- This specification sheet is a general guide for application only and does not replace the Technical Data Sheets (TDI).

Many factors can influence the coating process (e.g. mixing ratios of products, allowable film thickness per coat and drying times, etc.) These factors include but are not limited to environmental variables, timber species, substrate quality, and quality of surface preparation and product application. If you are in doubt regarding how variables can affect the application process, then please contact us prior to commencing product application. The steps outlined herein are intended as a general guide only and are given without prejudice.