



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

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## Polyurethane White 2-Pack System

- Primer (Part A): ILVA PAS5AB3
- Primer Hardener (Part B): TX19
- Topcoat (Gloss Pack Part A): ILVA PM800 or TP800 Series
- Topcoat Hardener (Part B): TX76

### PAS5AB3 Primer – Features & Benefits

#### Features:

- High-build Italian-made two-pack
- True white base for clean, accurate topcoat colour
- Reduces grain raise on MDF
- Excellent filling and hiding power
- Helps prevent topcoat shrink-back
- Fast drying, 5-hour pot life
- Compatible with pot, gravity, Airmix and airless spray systems
- Suitable for robotic spray lines

#### Benefits:

- Bright, consistent base supports topcoat clarity
- Easier sanding, even on detailed edges
- Smoother surface finish
- Strong foundation reduces risk of topcoat defects
- Streamlines production with longer working time
- Adapts to both manual and automated spray setups

### PM800 / TP800 Topcoat – Features & Benefits

#### Features:

- Excellent surface hardness and chemical resistance
- Long-term clarity and gloss retention
- Tintometric colour system
- Suitable for MDF, paint coat board, melamine, and solid timber

#### Benefits:

- Durable, protective finish for high-use areas
- Withstands daily wear and cleaning
- Maintains visual appeal over time
- Consistent colour matching across jobs
- Versatile for a wide range of interior joinery

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

Mix 500 mL of PAS5AB3 Primer with 250 mL of TX19 Hardener and 100-200 mls of TZ13 or TZ35 Thinner. Apply two coats wet-on-wet, allowing the first coat to flash off for approximately 15–20 minutes before applying the second. Coverage is approximately 6 m<sup>2</sup> per litre. Allow a minimum of 4 hours before sanding. Recommended spray setup includes a gravity or suction-fed gun with a 1.8–2.0 mm tip, an Airmix gun with a 09.094 tip, or an airless system with a 4/11 tip.

### Step 3

#### Sanding of PAS5AB3 Primer :

Sand the primer using 400–500 grit paper. For face panels, mechanical sanding is best performed with a 150 mm disc sander or suitable wide belt machine. Smaller surfaces and edges can be sanded by hand using 400 grit sheet paper or fine sponge blocks. Sanding should only be undertaken after a minimum of 4 hours. After sanding, blow off and wipe down all panels thoroughly to remove dust. For best results, apply the topcoat as soon as possible, ideally within 3 hours of sanding.



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#### Step 4

Application Ilva Gloss PM800 / TP800 series topcoat :

Apply 2 coats wet on wet. Coverage: 1litre/6m<sup>2</sup> of PM800 / TP800 series clear topcoat as follows: 500 mls of PM800/TP800 Gloss topcoat, 350 mls of TX76 hardener, 200 to 250mls 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 (TDS).

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 your local technical sales representative prior to commencing product application. The steps outlined herein are intended as a general guide only and are given without prejudice.