# ILVA PRODUCT MIXING RATIOS QUICK REFERENCE

**BELOW IS A QUICK REFERENCE OF THE ILVA PRODUCTS TO USE AS A GUIDE WHEN MIXING.**
**THINNER RATIO IS A GUIDE ONLY. ADD OR REDUCE THE SOLVENT TO MEET YOUR REQUIREMENTS.**
**UNDER EXTREME CONDITIONS (HOT / COLD / HUMID) USE TZ14S RETARDER TO HELP KEEP A WET EDGE.**

| PRODUCT CODE | | PRODUCT DESCRIPTION | HARDENER | MIX RATIO | SOLVENT | HOT CONDITION | THINNER RATIO | POT LIFE |
|---|---|---|---|---|---|---|---|---|
| **"Interthane" (PU) Polyurethane – Clear Sealer & Clear Topcoats** | | | | | | | | |
| **TA48** | | Polyurethane Clear Sealer | TX11 / TX24 | 2:1 | TZ35 | – | 20–30% | 4hrs |
| **TO97**<br>**TO96**<br>**TO93**<br>**TO91** | | PU – Extra Matt Clear Lacquer 5%<br>PU – Matt Clear Lacquer 10%<br>PU – Satin Clear Lacquer 30%<br>PU – Semi-Gloss Clear Lacquer 60% | TX24 | 2:1 | TZ35 | TZ13 | 20–30% | 4hrs |
| **"Technofinish" Acrylic Urethane Clear System (AU = Acrylic Urethane)** | | | | | | | | |
| **TA15** | | Acrylic Urethane Clear Sealer | TX90 | 5:1 | TZ35 | – | 20–35% | 4hrs |
| **TS18**<br>**TS537**<br>**TS536**<br>**TS534**<br>**TS531** | | AU – Flat Clear Lacquer 0%<br>AU – Extra Matt Clear Lacquer 5%<br>AU – Matt Clear Lacquer 10%<br>AU – Satin Clear Lacquer 25%<br>AU – Semi Gloss Clear Lacquer 60% | TX90 | 5:1 | TZ35 | TZ13 | 25–35% | 4hrs |
| **PX1705** | | UV Additive (Add 2–3% Max.) | | | | | | |
| **"Diamante Finish" Premium High Build / Scratch Resistance Polyurethane Clear System** | | | | | | | | |
| **TA48** | | Polyurethane Clear Sealer | TX11 / TX24 | 2:1 | TZ35 | – | 20–30% | 4hrs |
| **TO9757**<br>**TO9756**<br>**TO9754**<br>**TO9751** | | PU – Premium Extra Matt Clear Lac. 5%<br>PU – Premium Matt Clear Lac. 10%<br>PU – Premium Satin Clear Lac. 30%<br>PU – Premium Semi-Gloss Clear Lac. 60% | TX70 | 2:1 | TZ35 | TZ13 | 20–30% | 4hrs |
| **TP60** | | PU – Premium Full Gloss Clear Lac. 100% | TX76 | 2:1 | TZ13 | TZ13 | 30–40% | 4hrs |
| **Polyurethane – White Primer** | | | | | | | | |
| **PAS5AB3** | | PU – White Primer Undercoat | TX19 / TX24 | 2:1 | TZ35 | | 25–35% | 3hrs |
| **Polyester – White Primer** | | | | | | | | |
| **Pi30** | | PE – Economy White Primer Undercoat | | | TZ2003 | – | 20–30% | 1hr |
| **TVSAA1**<br>**TV84** | | PE – Accelerator – Add 2% to Primer<br>PE – Hardener – Add 2% to Primer | | | | | | |
| **Polyurethane – Light / Medium Colours** | | | | | | | | |
| | | PU White Light / Medium Matt Colours<br>PU White Light / Medium Satin Colours | TX24 / TX72 | 2:1 | TZ35 | TZ13 | 20–35% | 4hrs |
| | | PU White Light / Medium Semi-Gloss Colours<br>PU White Light / Medium Full Gloss Colours | TX76 / TX110 | 2:1 | TZ13 | TZ13 | 20–35% | 4hrs |
| **Polyurethane – Dark / Bright Colours** | | | | | | | | |
| | | PU Dark / Bright Matt Colours<br>PU Dark / Bright Satin Colours | TX24 / TX72 | 2:1 | TZ35 | TZ13 | 25–40% | 4hrs |
| | | PU Dark / Bright Semi-Gloss Colours<br>PU Dark / Bright Full Gloss Colours | TX76 / TX110 | 2:1 | TZ13 | TZ13 | 25–40% | 4hrs |

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