

Technical Data*

Mixing Ratio

4:1

Color* 4 parts color
Reducer 1 part LR10, 11, 12, 13, or 15

* 2 Parts Base + 1 Part LMC1 Mixing Clear

Mixing Ratio

with LH130 Hardener 4:1

Color* 4 parts color
Hardener 1 part LH130

* 2 parts Base + 1 Part LMC1 Mixing Clear

VOC

As packaged lbs/gl (gms/ltr) 4.1-4.7 (491-563)
As applied lbs/gl (gms/ltr) 4.6-5.0 (551-599)

Technical Data

Viscosity Ford #4 68°F/20°C 18-20 sec.

Fluid Tip (Gravity) 1.4-1.6 mm or .055"-.063"
Fluid Tip (Suction) 1.6-1.8 mm or .063"-.071"
Fluid Tip (Gravity HVLP) 1.3-1.5 mm or .051"-.059"
Fluid Tip (Suction HVLP) 2.2 mm or .087"
Air Pressure 40-55 psi (10 psi HVLP)

Number of Coats 2 or 3
Film thickness 2.0 to 2.5 mils.
Coverage 235 sq. ft. @ 2.0 mils

Flash off 5-10 mins. between coats
Pot Life @ 68°F/20°C infinite

Dry Times

68°F/20°C 30 mins. dust free,
8 hrs. to handle
140°F/60°C 35 mins. (allow 20 mins.
flash before force dry)
10 to 15 mins.
Infra red short wave 35 mins.



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use—read product label for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use.

Always refer to www.basrefinish.com or your latest Technical Data Sheet for the most up-to-date product information

The LIMCO product line is engineered to provide simplicity and economy wrapped into a user friendly system. LIMCO offers many characteristics of an expensive system at an economical price.

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The Chemical Company

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LIMCO® Synthetic Enamel



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Limco Synthetic Enamel

Description

Limco Synthetic Enamel is a single-stage finish developed specifically for use in automotive and fleet repair facilities, construction and implement dealers, and in job shops which require synthetic economy.

Characteristics



- Quick drying
- Good gloss
- Enhanced performance with hardener

Limco Synthetic Enamel is a fast-drying enamel that sprays on easily and provides excellent coverage and durability. Limco Synthetic Enamel utilizes Limco mixing bases and LMC1 Synthetic Mixing Clear, plus the same universal reducers as the rest of the Limco system for ease of use and reduced inventory. Limco Synthetic Enamel will dry quickly and give good gloss when used without a hardener.

Product Usage



- **Industrial**
 - Signs/Mailboxes
 - Trailers
 - Construction Equipment
 - Farm Implements

Surface Preparation



- Wash all surfaces with soap and water, then degrease using *Clesol 203* prior to sanding.
- Finish sand all areas with U.S. 320-400 grit paper.
- Clean all surfaces with *Final Wash 139* before painting.

Note: Primer sealer may be applied prior to topcoat to increase color holdout and gloss.

Priming



The undercoat acts as the paint system foundation. Starting with a quality undercoat will help ensure a long-lasting, attractive finish. Undercoats can generally be placed into two major categories; primer-surfacer and sealer.

- Primers must be cured and then sanded before recoating.
- Sealers are applied over the prepared substrate, are not sanded and are re-coated relatively quickly.

Precoat

Apply 1 or 2 coats of etch primer or epoxy to all bare metal areas. Allow sufficient flash time between coats. Do not sand. Allow to dry for 15 minutes before applying primer surfacer.

R-M DE17 Chromate Free Etch Primer
Limco 834 Zip Zinc Phosphate Primer
Limco LP20 Epoxy Primer

Primer Surfacer

Build up any damaged areas with 2 or 3 coats of primer surfacer. After drying, sand dry with 320 grit or finer sandpaper or sand wet with 400 grit or finer sandpaper.

*Limco H1000 1K Waterborne Primer **
Limco 800K 2K Primer Surfacer
Limco 846 1K Acrylic Primer
Limco LP20 Epoxy Primer

* Dry sand only

Priming (continued)

Sealer

A Sealer can improve holdout, maximize adhesion and minimize sandscratch swelling. Apply 1 or 2 coats over cleaned and sanded areas. Allow to dry 30 minutes to 1 hour before topcoating. Remove dust nibs with fine sandpaper.

Limco PS21nr Griptite Gray Sealer
Limco LS46 1K Production Sealer
Limco LP20 Epoxy Primer
Limco LS800 2K Sealer

Topcoat



Always apply a light to medium first coat to build a base and ensure there are no contamination issues.

Once the first color coat has flashed off, apply full wet coats as per recommendations for the specific products you are using. Be sure to allow proper flash time as stated on the product's technical data sheet.

In the event the color you are spraying is a metallic or pearl color, be sure to spray even coats so that you do not get the appearance of any "stripes". This is caused by uneven material flow or too heavy an application.

Typically the last coat or two is done in a crisscross pattern to minimize this problem. Sometimes a final coat is "misted" on to ensure good even metallic flow. Misting is a light coat of color at a greater rate of speed and at a slightly further distance from the surface than a full wet coat.

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