

# Technical Data\*










<b>Mixing ratio</b>	4:1:1
<b>Color*</b>	4 parts color
<b>Hardener</b>	1 part LHF, LHM, LHS or LH710
<b>Reducer</b>	1 part LR10, LR11, LR12, LR13 or LR15

\* 1 Part Base + 1 Part LMC5 Mixing Clear


## VOC

As packaged lbs/gl (gms/ltr)	3.4 (407)
As applied lbs/gl (gms/ltr)	3.8-4.1 (455-491)

## Technical Data

 <b>Viscosity Ford #4 68°F/20°C</b>	16-20 secs.
 <b>Fluid Tip (Gravity)</b>	1.5 mm or .059"
 <b>Fluid Tip (Suction)</b>	1.5 mm or .059"
 <b>Fluid Tip (Gravity HVLP)</b>	1.5 mm or .059"
 <b>Air Pressure</b>	55-60 psi (9-10 psi HVLP)
 <b>Number of Coats</b>	2 to 3 medium wet coats
 <b>Film thickness</b>	2.0 to 3.0 mils.
 <b>Coverage</b>	343 sq. ft. at 2.0 mils.
 <b>Flash off</b>	5 mins. between coats
<b>Pot Life @ 68°F/20°C</b>	4 - 5 hrs.

## Dry Times

 <b>68°F/20°C</b>	1.5 to 2 hrs. dust free
<b>140°F/60°C</b>	30 mins.
<b>Infra red short wave</b>	N/A
<b>Infra red med. wave</b>	N/A



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.

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.

**BASF Corporation**  
Automotive Refinish  
26701 Telegraph Rd.  
Southfield, MI 48033

**BASF Canada Inc.**  
100 Milverton Drive, 5th Floor  
Mississauga, Ontario, Canada  
L5R 4H1

**BASF Mexicana, S.A. de C.V. Division Coatings**  
Avenida Uno No. 9  
Parque Industrial Cartagena  
C.P. 54900 Tultitlan, Edo de México

**Website Address:** [www.basfrefinish.com](http://www.basfrefinish.com)  
**Phone:** 1-800-758-2273

[www.basfrefinish.com](http://www.basfrefinish.com)

# LIMCO®

## Direct-to-Metal

### Light Industrial Topcoat



**BASF**  
The Chemical Company

**BASF**  
The Chemical Company

AD3121L 150408 (H/H)  
Printed in USA

\* Always refer to [www.basfrefinish.com](http://www.basfrefinish.com) or your latest Technical Data Sheet for the most up-to-date product information

# Limco Direct-to-Metal

## Description

Limco DTM Light Industrial Topcoat is a revolutionary product that eliminates the need for a primer step – thus increasing throughput while at the same time decreasing material expense and reducing the impact to the environment.

## Characteristics

- **Direct to Metal application options**
- **Improved productivity**
- **Excellent flow**
- **Durable, chemical resistant finish**
- **Good sag resistance**



Limco DTM has been successfully used in a wide range of industries such as trailer, construction and service vehicle manufacturing as well as equipment repair.

Limco DTM is created by mixing LMC5 DTM Mixing Clear with Limco Mixing Bases.

Limco DTM Light Industrial Topcoat is another economical solution in the Limco line of products designed to help you be more productive.

## Product Usage



### • Industrial Application for Bare Metal:

- Aluminum
- Steel
- Zinc or galvanized

### Suggested uses:

- Construction and Farm Implements
- Industrial Equipment
- Maintenance
- Trailers
- Chassis

## 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.

## 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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