

# Technical Data\*










<b>Mixing ratio</b>	4:1:2
<b>Color*</b>	4 parts color
<b>Hardener</b>	1 part LHS, LHM or LHF
<b>Reducer</b>	2 parts VR0 or LR0

\* 2 Parts Base + 1 Part LMC7 Mixing Clear


## VOC

As packaged lbs/gal (gms/ltr)	3.6 - 4.1 (431-491)
As applied lbs/gal (gms/ltr)	3.20 - 3.50 (383-419)

## Technical Data

	<b>Viscosity Ford #4 68°F/20°C</b>	14 - 16 secs.
	<b>Fluid Tip (Gravity)</b>	1.5 - 1.7 mm or .059" - .067"
	<b>Fluid Tip (Suction)</b>	1.8 - 2.0 mm or .071" - .079"
	<b>Fluid Tip (Gravity HVLP)</b>	1.5 - 1.7 mm or .059" - .067"
	<b>Fluid Tip (Suction HVLP)</b>	2.0 - 2.2 mm or .079" - .087"
	<b>Air Pressure</b>	50 - 65 psi (10 psi HVLP)
	<b>Number of Coats</b>	2 coats (additional mist coat may be required for certain metallics)
	<b>Film thickness Coverage</b>	2.0 to 3.0 mils. 420 sq. ft. at 2.0 mils.
	<b>Flash off Pot Life @ 68°F/20°C</b>	5 to 10 mins. between coats 4 hrs.

## Dry Times

	<b>68°F/20°C</b>	2 to 3 hrs. dust free, 8 hrs. to handle
	<b>140°F/60°C</b>	30 mins.
	<b>Infra red short wave</b>	15 to 20 mins.
	<b>Infra red med. wave</b>	40 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.

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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# LIMCO®

## Industrial Urethane Single Stage



**BASF**  
The Chemical Company

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The Chemical Company

AD3122L 150408 (H/H)  
Printed in USA

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

# Limco Industrial Urethane Single Stage

## Description

Limco Industrial Urethane Single Stage is a specially formulated polyurethane with hardener and accelerator which produces a superior high gloss durable finish.

## Characteristics



- Low VOC
- Improved productivity
- Excellent flow
- Durable, chemical resistant finish
- Good sag resistance

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

Limco Industrial Urethane Single Stage is created by mixing LMC7 CV Mixing Clear with Limco Mixing Bases. Limco Industrial Urethane Single Stage is another economical solution in the Limco line of products designed to help you be more productive.

## Product Usage



- **Industrial**
  - Signs/Mailboxes
  - Trailers
  - Equipment
  - Maintenance

## 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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