

# Technical Data\*

## Mixing ratio

2:1

 Color 2 parts color


Reducer 1 part LBR1370 or LBR1380

## VOC

As packaged lbs/gal (gms/ltr) 3.9 - 6.1 (467-731)

As applied lbs/gal (gms/ltr) 5.5 (659)

## Technical Data

 Viscosity Ford #4 68°F/20°C 12-14 sec.

 Fluid Tip (Gravity) 1.3-1.5 mm or .051"-.059"

 Fluid Tip (Suction) 1.6-1.8 mm or .063"-.071"

 Fluid Tip (Gravity HVLP) 1.3-1.5 mm or .051"-.059"

 Air Pressure 40-50 psi (6-10 psi HVLP)

 Number of Coats 2 or 3

 Film thickness 0.6 - 1.0 mils.


 Coverage 350 sq. ft./gal. @ 1.0 mils

 Flash off 5-10 mins. between coats


 Pot Life @ 68°F/20°C 5 mins. before force dry

N/A

## Dry Times

 68°F/20°C 15 mins.

 140°F/60°C 10 mins.

 Infra red short wave N/A

 Infra red med. wave 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.

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# LIMCO®

## Supreme



**BASF**  
The Chemical Company

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The Chemical Company

AD3123L 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 Supreme

## Description

Limco Supreme is an acrylic enamel basecoat developed specifically for use in automotive and production shop facilities which require a durable basecoat / clearcoat finish.

## Characteristics



- **Fast-drying**
- **Excellent hiding**
- **Durable clearcoat**
- **Available in low-VOC**
- **Referenced in COLOR-MAX™2**

It can be sprayed in the repair of original basecoat/clearcoat finishes, as well as complete paint jobs.

Limco Supreme features high-strength, fast-hiding basecoat colors and very durable clearcoats. It uses a unique set of mixing bases and reducers, while utilizing the same hardeners and clearcoats as used with Limco.

It's a fast-drying basecoat that sprays on easily, offers excellent metal control and provides great coverage in all colors.

When combined with the Limco clears, Limco Supreme basecoat provides a long-lasting coating that will retain its luster and gloss for many years. For certain low-VOC areas, Limco Supreme Basecoat can be clearcoated with LC4200 or LC4800 Low VOC clearcoat.

## Product Usage



- **Automotive**



- **Industrial**



- **Repair**

## 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

### 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**

## Basecoat



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.

## Clearcoat



Clearcoat is the final coat when applying a basecoat/clearcoat. Clearcoat provides a final protective coating over the colored basecoat. In addition to resisting damage from scratches, chemicals and other foreign objects, the clearcoat also incorporates added UV protection.

As with color coats, the first coat of clear must be applied **ONLY** after the specified flash time as detailed on the products technical data sheet.

For optimal results, clear should be applied immediately after the flash time for the colorcoat has elapsed.

The first coat should be medium wet. After the appropriate flash time, a second and possibly a third coat (see product recommendations) should be applied full wet. It is critical to apply the clearcoat after the appropriate flash time.

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