

LIC50 - LIC Low VOC Polyurethane (for USA only)



GENERAL INFORMATION

LIC50 is a general purpose polyurethane enamel formulated to give outstanding gloss, depth, chemical resistance, and durability. This product is recommended for use where 2.8 VOC is required.



1. COMPONENTS

LIC50
LK40
NOT
NOT
NOT
Exempt Reducer
NOT
Exempt Reducer Medium

LVBF100 Fast Reducer - up to 80°F (24°C)
LVBM100 Medium Reducer - 80°F-90°F (24°C-32°C)
LVBS100 Slow Reducer - 90°F (32°C) and above



2. MIXING RATIO

LIC50 Color must be activated. Mix 4 parts LIC50 Base Color to one part LK40 Activator.

Use unreduced for brush, roll, or airless spray. For airspray, reduce up to 25% with X01 or X02.



3. POT LIFE @ 77°F (25°C)

2 - 3 Hours



4. CLEAN UP

Uni-Solvent 171-174 or Exempt Reducer X01, X02 (check local regulations).



5. SURFACE PREPARATION

USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES.



- Abrade with P320 grit dry sandpaper.
- Wipe with AquaClean 170.
- For best results apply anti-corrosive primer such as LIC P Series epoxy primer.



6. SUBSTRATES

- LIC Epoxy Primer
- Non-reversable existing finishes in good condition
- Properly Prepared Steel and Aluminum
- 380 Series Primers



7. APPLICATION

Number of coats: 1-2

Application Density: Medium-wet to wet

Overlap: 50%

Flash: Follow directions in "Dry Time" section

Film Thickness Range:

Dry 1 mil-6 mils/25-150 μm Wet 3 mils-6 mils/75-150 μm

Application Conditions:

-Minimum Temp 50°F/10°C (Substrate Temp.) -Max Temp 100°F/38°C (Substrate Temp.) -Ambient Humidity Less than 80% preferred



8. FLASH / DRY TIMES AIR DRY @ 77°F AND 80% R.H.

Flash Time	10-15 min. between coats			
Tack Free	2 Hours			
То Таре	6 Hours			
To Recoat	Overnight			



9. GUN SET UP CONVENTIONAL

Gravity Feed 1.3 mm - 1.5 mm Siphon Feed 1.6 mm - 1.8 mm

HVLP

Gravity Feed 1.3 mm - 1.5 mm

AIR PRESSURES

 Gravity Feed
 35-40 psi (2.5-2.8 bar)

 Siphon Feed
 35-45 psi (2.5-3.1 bar)

 HVLP Inlet Air
 30 psi (2.0 bar)

See spray gun manufacturer info



10. PHYSICAL DATA

	4:1		4:1:25%	
RTS REGULATORY DATA	(No Reduction)		(Exempt Reducer Line)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
Actual VOC	2.8 Max.	340 Max.	2.55 Max.	306 Max.
Regulatory VOC (less water and exempt solvents)	2.8 Max.	340 Max.	2.8 Max.	340 Max.
Density	8 - 12	960 - 1440	8 - 12	960 - 1440
	WT.%	VOL.%	WT.%	VOL. %
Total Volatile Content	20 - 50	30 - 55	20 - 50	30 - 55
Water Content	0	0	0	0
Exempt Compound Content	0 - 10	0 - 10	10 - 30	10 - 25

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