



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 2.8 VOC Polyurethane
- LK40 Polyurethane LIC Activator
- X01 Exempt Reducer
- X02 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-reversible 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
To Tape	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

RTS REGULATORY DATA	4:1		4:1:25%	
	(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