

## Limco Low VOC Industrial Urethane Single Stage (Limco 7) 420 gms/liter (3.5 lbs/gal) VOC

**Description:** Limco Low VOC Industrial Urethane Single Stage 420 gms/liter (3.5 lbs/gal) VOC is a specially formulated polyurethane with hardener and accelerator which produces a superior high gloss durable finish. Limco Low VOC Industrial Urethane Single Stage 420 gms/liter (3.5 lbs/gal) VOC also available in Quick Mix colors.

**Materials:**

Limco Bases:	LB Bases
Quick Mix Colors:	Q Bases
CV Mixing Clear:	LMC7 *
Hardeners:	LHF LHM LHS
Reducers:	LR21 LR25

Substrates:	Finish Sanding	Cleaner
Well cured old paint work	400 grit	R-M 909 Final Wipe
Primer Surfacer H1000	320 - 400 grit (dry sand only)	R-M 909 Final Wipe
Primer Surfacer LP20	320 - 500 grit	
Primer Surfacer LP610	320 - 500 grit	
Primer Sealer LP20	Sanding not required	

**Clearcoats:** N/A

**Remarks:**

- \* LMC7 available in 5 gallon container only.
- Always check local VOC laws to ensure that the use of these Limco products is compliant in your area.
- For custom Limco Low VOC Industrial Urethane Single Stage (420 gms/liter) colors, the color (LB, Q bases) must be mixed 2 parts to 1 part of LMC7 by volume prior to addition of hardener and reducer.

# T E C H N I C A L   D A T A

## Limco Low VOC Industrial Urethane Single Stage (Limco 7) 420 gms/liter (3.5 lbs/gal) VOC

	<b>Mixing ratio:</b>	4:1:2
	<b>Color</b>	4 parts Color
	<b>Hardener</b>	1 part LHF, LHM or LHS
	<b>Reducer</b>	2 parts LR21 or LR25
<b>Potlife at 68°F/20°C</b>		4 hours
	<b>Spray viscosity Ford #4 @ 68°F/20°C</b>	14 - 16 seconds
	<b>Gravity gun nozzle HVLP</b>	1.5 - 1.7 mm
<b>Spray pressure HVLP at the cap</b>		10 psi
	<b>Application</b>	2 coats (additional mist coat may be required for some metallics)
	<b>Flash-off time @ 68°F/20°C</b>	5 to 10 minutes between coats
<b>Film build</b>		2.0 - 3.0 mils
<b>Coverage</b>		420 sq. ft./gal @ 2.0 mils
<b>Drying:</b>		
	<b>68°F/20°C</b>	2 - 3 hours dust free, 8 hours to handle
	<b>140°F/60°C</b>	30 minutes
	<b>Infra red short wave</b>	15 - 20 minutes
	<b>Infra red medium wave</b>	40 minutes
<b>Sanding:</b>		
	<b>Wet by Hand</b>	N/A
	<b>Dry by Hand</b>	N/A
	<b>Dry by Machine</b>	N/A
<b>VOC as packaged</b>		Varies, dependent on color
<b>VOC as applied</b>		383 - 419 gms/liter (3.2 - 3.5 lbs/gal)
<b>Comments</b>		<p>Mix all tinting bases for 10 - 15 minutes using a mechanical paint shaker before using or placing on a mixing rack.</p> <p>Tinting bases on a mixing rack need to be agitated for 15 minutes at the start of the work day and every 4 hours during the day to ensure good color matching.</p>