



GENERAL INFORMATION

LIC 20 is a general purpose epoxy enamel formulated to give outstanding gloss, chemical resistance, and adhesion over a variety of substrates. LIC20 is not recommended for applications requiring extended exterior exposure.



1. COMPONENTS

- LIC20 Epoxy Enamel Color
- EK20 Epoxy LIC Activator
- X01/ X02 Exempt Uni-Solvent
- 171-174 Urethane Uni-Solvent



2. MIXING RATIO

LIC20 Epoxy Enamel must be activated. Mix 1 part LIC20 Base Color to one (1) part EK-20 Activator. Use unreduced for brush, roll, or airless spray. For air spray, reduce 25% with urethane reducer (171-174) or X01/X02 in 3.5 VOC compliant areas.



3. POT LIFE @ 77°F (25°C)

6 hours



4. CLEAN UP

Valspar Refinish 100 Thinner or X01 (Check local regulations)



5. SURFACE PREPARATION

USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES.

- Abrade with 240 grit dry sandpaper or equivalent.
- 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

May be applied by brush, roll, or spray. Brushing or rolling recommended only on small areas. Use unreduced for brush, roll, and airless spray. Apply with a foam or cigar roller. Load roller with paint and apply with a gentle surface pressure. (Do not press the roller firmly on the surface.) Use airless spray tips between .013" and .017" in diameter, depending on spray pressure and job conditions.

For Air Spray:

- Spray 2 - 3 medium wet coats
- Allow 10 -15 minutes flash time between coats



AIR DRY @ 77°F AND 85% R.H.

Tack Free	2 Hours
To Tape	6 Hours
To Recoat	16 Hours



9. GUN SET UP

CONVENTIONAL

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



AIR PRESSURES

HVLP @ Cap

	PANEL	OVERALL
Gravity Feed	8-10 psi	8-10 psi
Siphon Feed	8-10 psi	8-10 psi

10. PHYSICAL DATA



VOC (Volatile Organic Content)	3.5 lbs/gal (420 g/L) max
Volume Solids	52% Average
Flash Point	55° F
Theoretical Coverage	833 F2/gal @ 1 mil thickness

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